

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT

Prepared By:

Check By:

Approved By:

MHVITO

N. CEPEDA

R. MIRANDA

DATE:230421

QA-IE/ Prodn IE

QA/ Prodn SV

KPLIMA Operations Gen. Mngr.

5M REVIEW**DOCUMENT REVIEW**

| MAN | No Changes | Affected Document: | Date Reviewed: | Disposition: | PIC: | Target Date: |
|-------------|--------------------------------|--------------------|----------------|--|---------|--------------|
| MACHINE | No Changes | Procedure Manual | 230420 | <input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision | MH.VITO | N/A |
| MATERIAL | URGENT ITEM | Work Instruction | | <input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision | MH.VITO | N/A |
| METHOD | FAILED TO CHECK GLUE AT ROLLER | Process Flow | | <input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision | MH.VITO | N/A |
| ENVIRONMENT | No Changes | Forms | | <input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision | MH.VITO | N/A |

I. PROBLEM DESCRIPTION**1.1. ISSUE:**

DELAMINATION

1.2. ITEM DESCRIPTION:**PART CODE:**

516588100

PART NAME:

LIONEL 2 MBL

1.3. BACKGROUND:**PICTURE****DETAILS:**

- > IN-HOUSE REJECT
- > DELAMINATION DETECT AT GLUING PROCESS
- > LOT QTY: 797 EA
- > REJECT QTY: 385 EA
- > REJECTION RATE: 48.3%

II. IMMEDIATE ACTION

| ACTION ITEMS | Target Date: | Person In-charge |
|--|--------------|------------------|
| REWORK THE ITEM WITH DELAMINATION FOR RECOVERY | 230420 | OPERATOR |
| ORIENT THE LAMINATION OPERATOR REGARDING THE ISSUE OF DELAMINATION | 230420 | IE STAFF |

III. CAUSE ANALYSIS:

| | |
|---------------|---|
| WHY 1: | DELAMINATION OCCUR AT THE LOWER AND UPPER FLAP OF THE ITEM WITH ITEM CODE OF 516588100-LIONEL 2 MBL AT LAMINATION MACHINE 2. |
| WHY 2: | WHEN THE ITEM ARRIVED (URGENT), THEY CONTINUE RUN THE SF WITH THE SAME SETTING AND VISCOSITY USED AT FIRST TWO ITEM. IT IS POSSIBLE THAT THAT THE GLUE APPLICATION IS INSUFFICIENT WHILE RUNNING. |
| WHY 3: | INSUFFICIENT GLUE APPLICATION DUE TO LACK OF REFILL AT ROLLER PORTION |
| WHY 4: | OPERATOR FAILED TO CHECK THE CONDITION OF GLUE WHILE RUNNING (URGENT ITEM) |
| WHY 5: | |

IV. ACTION PLAN:**V. EVIDENCES:**

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| | | |
|---|--|--------------------------------|
| 1 | ORIENT THE OPERATOR REGARDING TO THE ISSUE OF DELAMINATION OF 51658100 LIONEL 2. | 230419 |
| 2 | CHECKING OF THE NEXT RUN OF LIONEL SF FOR INVESTIGATION OF THE ISSUE OF DELAMINATION | 230425 (NO DELAMINATION OCCUR) |
| 3 | | |