



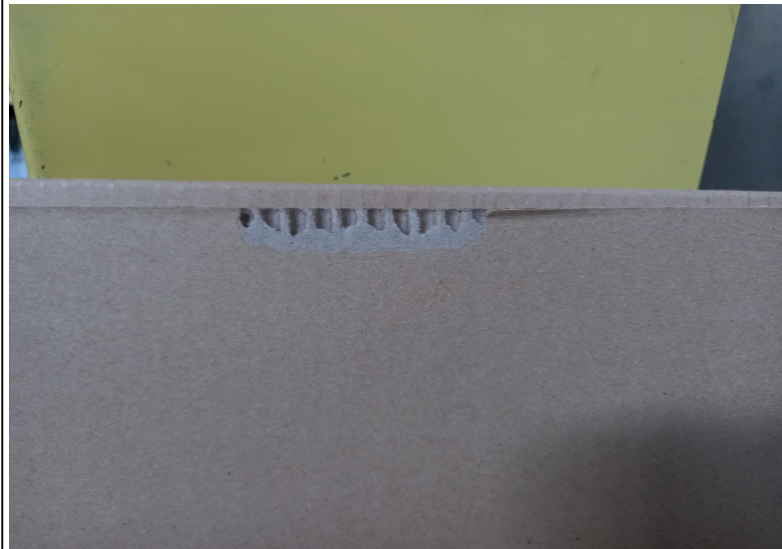
KANEPACKAGE PHILIPPINE INC.
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 5457-7166 to 69
Fax No. (049) 545-6302

WHY-WHY ANALYSIS AND ACTION REPORT

Control No.: LA-0169 Date Issued: 250429

External Provider	SUNPACK CONTAINER AND PACKAGING CORPORATION	Attention:	GEMMA FABIANA
Part Code:	492X2175 CF TX200-C	Part Name:	TX200/CM125/TX200 with creasing
Received Date of KPPI:	250411	DR No:	356777

ILLUSTRATION OF THE PROBLEM



DETAILS

Lot Quantity	Reject Qty	Reject %	Reject Limit
500	216	43.20%	0.04%
Nature of Defect:			
PEEL OFF			
Requirement:			
NO PEEL OFF			
Actual:			
IT HAS EXCESS LINER THAT CAUSE PEEL OFF			

NO. OF OCCURRENCE:	DISPOSITION:	DEFECT RANKING:	PLACE OF OCCURRENCE:	CONTENT:
<input checked="" type="checkbox"/> First <input type="checkbox"/> Second <input type="checkbox"/> Recurrence No.: -	<input type="checkbox"/> RTS <input type="checkbox"/> Replace <input type="checkbox"/> Hold <input type="checkbox"/> Rework <input type="checkbox"/> Special Acceptance <input checked="" type="checkbox"/> Sort	<input checked="" type="checkbox"/> Major <input type="checkbox"/> Minor	<input type="checkbox"/> IQA <input checked="" type="checkbox"/> Others <input type="checkbox"/> OQA KPPI - PRODUCTION <input type="checkbox"/> Screening <input type="checkbox"/> Customer	<input type="checkbox"/> RoHS <input type="checkbox"/> 4M Violation <input checked="" type="checkbox"/> Material <input type="checkbox"/> Others <input type="checkbox"/> Dimension <input type="checkbox"/> Appearance

Issued by	Checked by	Approved by		Why-Why Reply Due Date	
MARK REYES 2025-04-29 10:38:18	BRYAN MALABANAN 2025-04-29 10:40:06	MICHAEL CASILLANO 2025-04-30 09:26:17	KOHEI ISHII 2025-05-05 09:50:31	KPPI Customer Claim (max. 3 working days)	Why-Why Report (max. 5 working days) 250513

INSTRUCTION TO EXTERNAL PROVIDER FOR IMMEDIATE ACTION

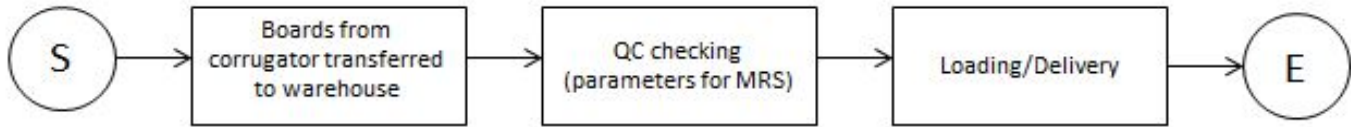
1. Need to Sort all Stocks that includes WIP and All FG (External Provider's Site)
2. Submit Sorting Report Results immediately to KPPI (max. of 2 days upon info)
3. Need to Attach "Initial Part Tag" for First Lot produced as per Action done
4. Strictly comply submission due date for this form

WHY-WHY ANALYSIS DETAILS (To be accomplished by external provider)

DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)	INDIRECT CAUSE: (Analyze the reason why it reached KPPI, why outflow?)
1. WHY: An edge bond is formed in the double backer section during the cutting process	1. WHY: Boards were not noticed to have edge bond
2. WHY: After cutting process the end of the hanging paper adheres to the other boards (uncontrollable)	2. WHY: The boards that come out of the double backer automatically stacked and piled on the pallet for the conversion process.
3. WHY: The adhered liner becomes stronger as it passes through a hot plate by gelling the glue and removing moisture	3. WHY: N/A
4. WHY: N/A	4. WHY: N/A
5. WHY: N/A	5. WHY: N/A



PROCESS FLOW CHART DETAILS: (Process identification where problem occurred)



IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

A. Sorting Result (External Provider Side)					B. Orientation			
Sorting Date: 250510	Lot Nos. Affected	Total Stock	NG	Total Good	Date	250510	Time	13:30
WIP	0	0	0	0	Title	Non-conformity due to peel off (due to excess paper)		
FG	0	0	0	0	Attendees	Corrugator/QC inspectors		
Delivery Guaranteed Lot:	schedule delivery of may onwards				GUARANTEED LOT(S) START OF IMPROVEMENT ACTIVITIES All deliveries starting May 2025			
C. Reworking (External Provider Side)								
Rework Quantity	0							
Total Goods	0							

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

Actions to be done to eliminate recurrence		Who	When
Since edge bond was one of the problem encountered at single facer remind operator at conveyor to check the output while piling		J. Melegrito	2025-05-23
Actions to be done to eliminate outflow		Who	When
During inspection QC inspector to check the appearance of the boards before laoding at the truck		G. Fabiana	2025-05-25
CORRECTIVE ACTION APPLICABLE TO:		Person In-Charge	Date
MRS board		J. Melegrito/G. Fabiana	2025-05-25
STANDARDIZATION: (Related Documents need to establish, review and revise)		Person In-Charge	Date
No excess liner on MRS		J. Melegrito/G. Fabiana	2025-05-28
Prepared by / Date and Designation		Checked by / Date and Designation	
DUTCHEE ANN SANORJO 250519 03:44:46		GEMMA FABIANA 250519 03:44:46	
		Approved by / Date and Designation	
		GEMMA FABIANA 250519 03:44:46	

REVIEW AND APPROVAL (To be accomplished by KPPI)

JUDGEMENT				REMARKS AND SUGGESTIONS
SATISFACTORY (Report is accepted, For verification of 5 consecutive deliveries thru QASEM)				N/A
UNSATISFACTORY (For Revision of whywhy)				
Reviewed by:	Checked by:	Approved by:	Final Approved by:	
BRYAN MALABANAN 2025-05-20 09:56:31	BRYAN MALABANAN 2025-05-20 09:56:31	MICHAEL CASILLANO 2025-05-20 14:12:19	KOHEI ISHII 2025-05-21 15:11:59	

Note: Closure or status of issued whywhy can be viewed in QASEM.

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