

Investigation Report for Peel Off of Sanyo Denki 00459572-01 Package

CONTROL No:	CAR- 2425-PR-264			REJECT PERCENTAGE:	8.75%
REJECT QTY:	35	LOT QTY:	400		

DIRECT CAUSE	W1	Surface liner of the board was torn during feeding at Eqos machine.
	W2	The board hit the feeder gate of Eqos machine.
	W3	Presence of excess liner and delaminated edges of the boards from Sunpack.

PRODUCTION ACTION PLAN

IMMEDIATE ACTION	Conduct checking and trial run using materials from Sunpack vs. Package World.	PIC:	Production, QA & ME	TARGET DATE:	250525
IMMEDIATE ACTION	Issuance of why-why analysis to Sunpack	PIC:	QA		250429
CORRECTIVE ACTION	Sunpack corrective action response to Why Why Analysis (Pls. see attached document)	PIC:	SUNPACK		250525
CORRECTIVE ACTION	Assign Package world as main supplier for those items with Peel Off issue in Eqos since based on the result of checking using Package world vs. Sunpack, Package World has no occurrence of Peel Off.	PIC:	Production, QA and Purchasing	TARGET DATE:	250616

PREPARED BY:

CHECKED BY:

APPROVED BY:

IRISH MAY ESTAREJA
PROD. LINE LEADER

GERALD DE GUZMAN
PROD. SUPERVISOR

REXEL ALMARIO
PROD. MANAGER

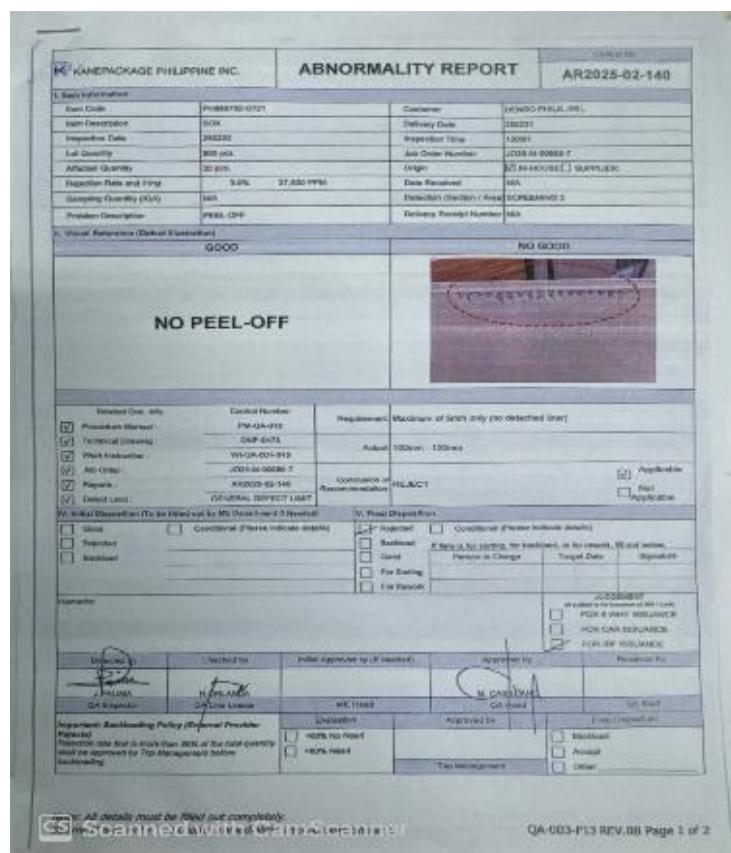
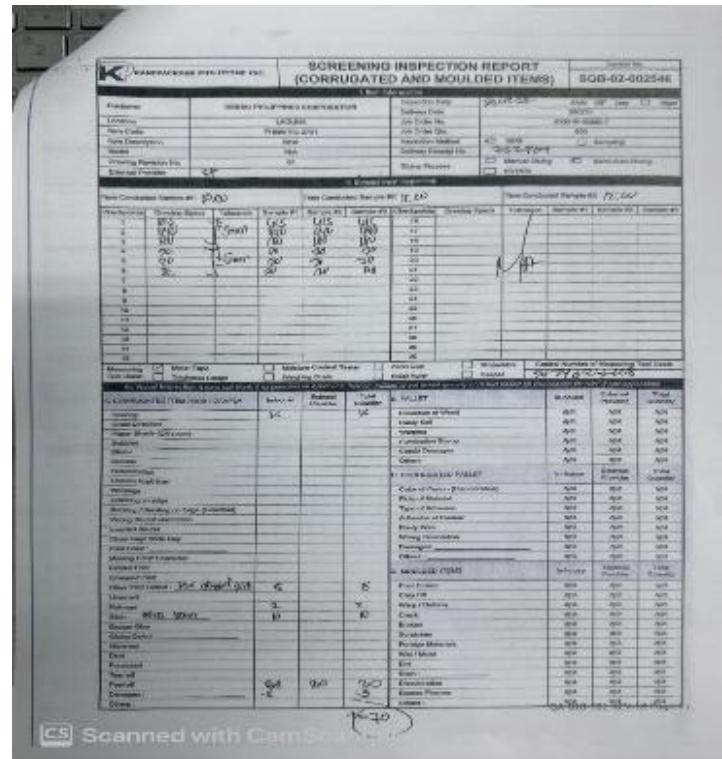
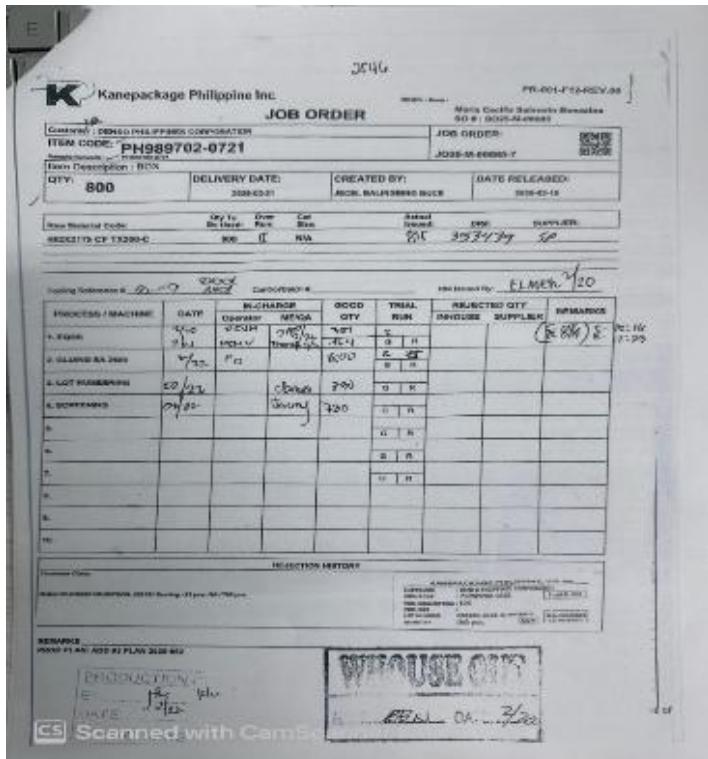
IMMEDIATE ACTION: CHECKING MATERIALS FROM SUNPACK VS. PACKAGE WORLD

ITEMS: Denso PH989702-0721 Box (With same issue of Peel Off)

JO#: JO25-M-00685-7

RESULT: With 30pcs Peel Off out 800pcs Lot Qty, 3.8% rejection rate

MATERIALS: 492x2175 CF from Sunpack



2 details must be filled out completely:

QA-003-F13 REV.00 Page 1 of 2

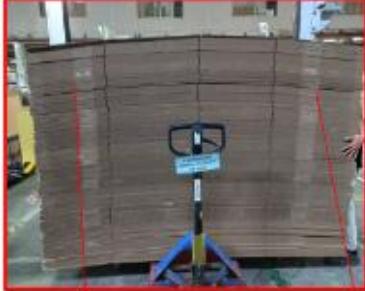
Scanned with CamScanner

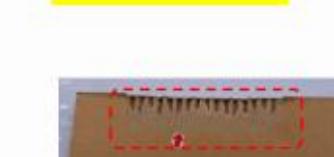
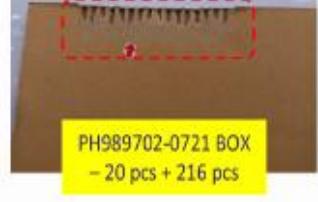
ITEMS: <i>Denso PH989702-0721 Box (With same issue of Peel Off)</i>	JO#: JO25-M-01490-58
RESULT: No Peel Off out 200pcs Lot Qty,	MATERIALS: 722x2409 CF from Package World

ITEMS: <i>Denso PH989702-0721 Box (With same issue of Peel Off)</i>	JO#: JO25-M-01490-38
RESULT: No Peel Off out 600pcs Lot Qty,	MATERIALS: 722x2409 CF from Package World

Kanepackage Philippine Inc.		0911	PR-001-F12-REV.00
ITEM CODE: PH989702-0721		JOB ORDER: JOBB-M-01679-0E	
ITEM DESCRIPTION: BOX		DATE RELEASED: 2001-09-02	
QTY: 600	DELIVERY DATE: 2001-09-07	CREATED BY: Palencia, Arnold Gerardo	LAST RELEASED: 2001-09-02
Raw Material Code: 7282499 CF TX299		Qty To: 600	Date Rate: 0.0000
		Ref. No.: 490231667788 CF 473	ITEM: 20866 PC
Testing Reference: S.E. 110048 V-102 COMMERCIAL P. IN CHARGE: Operator: MRIGS PROD. CITY: BDO TRIAL RUN: 0 / 0 INJECTED QTY: INHOUSE: 360 REMARKS: 6/10 1. GLITTER BIG: 5/9 AL 360 0 / 0 2. GLITTER SMALL: 5/9 CR 360 0 / 0 3. BODS: 5/9 JAVIA 360 0 / 0 4. GLITTER OR 2004: 5/9 H.L. 360 0 / 0 5. LOT NUMBERING: 6/10 D100 360 0 / 0 6. INKPRINTING: 6/10 KC 360 0 / 0 7. 8. 9. DATE: 2001-09-07 10. 11. 12. REMARKS: Balance was not used for PROD. PLAN. ADD 02 PLATES ENCODED Quality Assurance 100% Inspected 100% Tested 100% Approved ScanScanner			

DISCUSSION IN 4PM MEETING REGARDING PEEL OFF STUDY USING SUNPACK VS. PACKAGEWORLD MATERAILS

OBSERVATIONS			
Customer	EPSON	EPSON	ILLUSTRATION
Item Description	511659600 OUTER CARTON BOX	511583500 OUTER CARTON BOX	 
Job Order Number	JO25-M-01314-11	JO25-M-01505-3	
Lot Quantity	1,000 pcs.	350 pcs.	
Rejected Quantity	50 pcs.	-	  
Rejection Rate / PPM	5% / 50,000 PPM	-	
Status	Reject	-	
Supplier	SUNPACK	PACKAGEWORLD	

PEEL OFF		
Customer	DENSO	AFFECTED ITEMS
Item Description	PH989702-0721 BOX	
Job Order Number	JO25-M-01390-13	
Lot Quantity	1000 pcs.	<p>511659600 OUTER CARTON BOX – 16 pcs</p>
Rejected Quantity	216 pcs.	
Rejection Rate / PPM	21.6% / 21,600 PPM	<p>00459572-01 PACKAGE – 35 pcs</p>
Detection date	250423	
Occurrence No.	2 nd (250213)	
Detected by	QA SCREENING	<p>PH989702-0721 BOX – 20 pcs + 216 pcs</p>
Status	REJECT (2425-PR-264)	<p>ACTUAL: With peel off up to 120mm REQUIREMENT: Acceptable up to 25mm only</p>
Supplier	Sunpack	

IMMEDIATE ACTION: WHY WHY ANALYSIS ISSUANCE TO SUNPACK

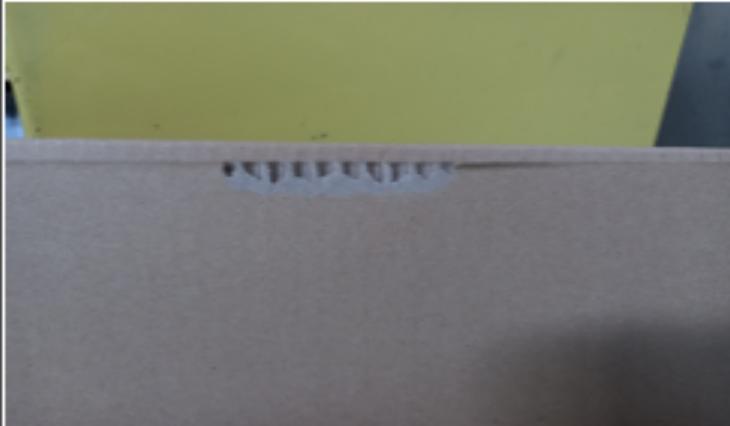
sys01.ph.kane-package.net/qasem/qasem_monitoring_edit.php?id=782

Control No.	Date Issued	Date Target	Reply Date	
LA-0169	04/29/2025	05/13/2025	05/19/2025	
Date Implemented	External Provider	Defect	Place of Occurrence	
mm/dd/yyyy	SUNPACK CONTAINER AND PACKAGING CORPORATION	PEEL OFF	KPPI - PRODUCTION	
Date Received	Delivery Receipt No.	Item Code	Item Name	
04/11/2025	356777	492X2175 CFTQ200-C	TX200/CH125/TX200 with creasing	
Lot Quantity	Reject Quantity	Reject Percent %	Reject Limit	
500	216	43.20	114%	
No. of Occurrence	Disposition	Defect Ranking	Content	
500	Sort	Major	Material	
Requirement	Actual			
NO PEEL OFF	IT HAS EXCESS LINER THAT CAUSE PEEL OFF			
First	Second	Third	Fourth	Fifth
Reply Attachment: LA-0169-Corrective.pdf				
Flowchart Reply Photo: LA-0169-flow chart.JPG				

K QASEM 9 LESTER JOHN DIOSO

KP Laguna	KP Lima	KP FPIP														
Supplier - Laguna 29.79%																
Open 205 Closed 37 Cancelled 18																
Show 7 entries Search: peel off																
<table border="1"> <thead> <tr> <th>Date Implemented</th> <th>Status</th> <th>Defect</th> <th>External Provider</th> </tr> </thead> <tbody> <tr> <td>0000-00-00</td> <td>🔒</td> <td>PEEL OFF</td> <td>SUPERFLEX LOGISTICS INC.</td> <td>EDIT</td> </tr> <tr> <td>0000-00-00</td> <td>🔒</td> <td>PEEL OFF</td> <td>SUNPACK CONTAINER AND PACKAGING CORPORATION</td> <td>EDIT</td> </tr> </tbody> </table>			Date Implemented	Status	Defect	External Provider	0000-00-00	🔒	PEEL OFF	SUPERFLEX LOGISTICS INC.	EDIT	0000-00-00	🔒	PEEL OFF	SUNPACK CONTAINER AND PACKAGING CORPORATION	EDIT
Date Implemented	Status	Defect	External Provider													
0000-00-00	🔒	PEEL OFF	SUPERFLEX LOGISTICS INC.	EDIT												
0000-00-00	🔒	PEEL OFF	SUNPACK CONTAINER AND PACKAGING CORPORATION	EDIT												
Showing 1 to 2 of 2 entries (filtered from 205 total entries) Previous 1 Next																
External Providers List 23																
WOO SUNG PHILS., CO., INC. PACKAGEWORLD, INC. PINKTREASURE PACKAGING CORPORATION PPCM PACKAGING MFG. CORP. SUNPACK CONTAINER AND PACKAGING CORPORATION TRIPLESTAR PACKAGING CORPORATION 818 EAST ASIA GROUP CORPORATION STYRO-LITE MFG. CORPORATION SUPERFLEX LOGISTICS INC. GOLDRICH INDUSTRIAL PACKAGING CORP. SPIRALCORE PACKAGING INC. PRIMEPACK TECHNOLOGIES INC. BASIC BOX INDUSTRIES CORPORATION																
Previous 1 2 Next																

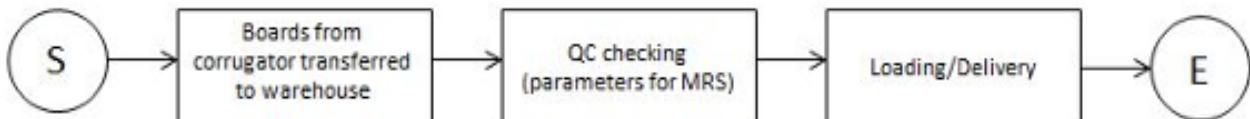
CORRECTIVE ACTION: SUNPACK CORRECTIVE ACTION RESPONSE TO WHY WHY ANALYSIS

 KANE PACKAGE 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										
Part Code:	492XX2175 CF TX200-C										
Received Date of KPPI:	250411										
ILLUSTRATION OF THE PROBLEM 											
DETAILS <table border="1"> <thead> <tr> <th>Lot Quantity</th> <th>Reject Qty</th> <th>Reject %</th> <th>Reject Limit</th> </tr> </thead> <tbody> <tr> <td>500</td> <td>216</td> <td>43.20%</td> <td>0.04%</td> </tr> </tbody> </table> <p>Nature of Defect: PEEL OFF</p> <p>Requirement: NO PEEL OFF</p> <p>Actual: IT HAS EXCESS LINER THAT CAUSE PEEL OFF</p>				Lot Quantity	Reject Qty	Reject %	Reject Limit	500	216	43.20%	0.04%
Lot Quantity	Reject Qty	Reject %	Reject Limit								
500	216	43.20%	0.04%								
NO. OF OCCURRENCE:	DISPOSITION:	DEFECT RANKING:	PLACE OF OCCURRENCE:								
<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								
CONTENT:											
			<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 2529-04-28 10:00:00	BRYAN MALABANAN 2529-04-28 10:00:00	MICHAEL CASILLAND 2529-04-29 09:26:07	KDHEI ISHII 2529-05-05 09:00:31 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)		3. Need to Attach "Initial Part Tag" for First Lot produced as per Action done									
2. Submit Sorting Report Results immediately to KPPI (max. of 2 days upon info)		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 outlier?)									
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									



KANE PACKAGE PHILIPPINE INC. WHY - WHY ANALYSIS AND ACTION REPORT

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						
C. Reworking (External Provider Side)					All deliveries starting May 2025						
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 loading 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	Approved by / Date and Designation	
DUTCHEE ANN SANORJO 250519 03:44:46	GEMMA FABIANA 250519 03:44:46	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)				
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	N/A

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

*** This document is system generated and does not require any wet or digital signature in order to be considered valid.

CORRECTIVE ACTION: 4M (FOR CHANGE SUPPLIER) AND COORDINATION

K KANE PACKAGE PHILIPPINE INC.			4M Control No:		
4M VARIATION APPLICATION AND APPROVED NOTICE					
4M Type:	<input checked="" type="checkbox"/> 4M INTERNAL	<input type="checkbox"/> 4M EXTERNAL	4M Application:	<input type="checkbox"/> TEMPORARY	
4M Severity:	<input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> MAJOR		<input checked="" type="checkbox"/> PERMANENT	
To be filled out by 4M REQUESTOR					
Requestor Name	GERALD DE GUZMAN		Attached Documents:		
Date of Application	250802		<input type="checkbox"/> QC Process Chart	Affected Batch No./ Lot No:	
Customer	SANYO DENKI & EPSON		<input type="checkbox"/> Inspection Data/ Evaluation/ Test Report		
Part Name	N/A		<input type="checkbox"/> Manufacturing Drawing		
Part Code	00459572-01 & 511686000		<input type="checkbox"/> Packaging Specification		
Model	BOX		<input type="checkbox"/> RoHS Test Report (ICP Test) - If new material		
No. of Samples			<input type="checkbox"/> Safety Data Sheet - If new material		
No. of Trial:	<input type="checkbox"/> 1st	<input type="checkbox"/> 2nd	<input type="checkbox"/> 3rd	<input type="checkbox"/> Others	<input type="checkbox"/> Technical Data Sheet (TDS)
Production Schedule Date			<input type="checkbox"/> XRF Analysis Report		
4M Classification:			Factors affected by the change:		
<input type="checkbox"/> MAN			<input type="checkbox"/> Tooling (Diecut blade, Stripper Set, etc.)		
<input type="checkbox"/> MACHINE			<input checked="" type="checkbox"/> Consumables:		
<input checked="" type="checkbox"/> MATERIAL			<input type="checkbox"/> Jigs:		
Content of Changes:					
Reason for Application:					
Change supplier from Sunpack to Package World					
Prepared	Checked	Approved	Assessed by (for KSP) 4M Change	Issue copy to PCO & SD upon approval?	
<i>G. de Guzman</i>	<i>R. Alvarado</i>	<i>Approved</i> <i>R. Alvarado</i>	PCO, SD	<input type="checkbox"/> Yes	<input type="checkbox"/> No
Date: 25/08/02	Date: 25/08/02	Date: 25/08/02	Date:	Note: Approval MUST be Manager level above	
Received by:					
To be filled out by 4M EVALUATOR					
EVALUATION	REQUIRED	RESULT	REFERENCE DOCUMENT		
Appearance	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Dimension	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Paper Combination	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Box Compression Test	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Destructive (Manual)	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Destructive Test	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Rub Test	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Cobb Test	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
XRF Evaluation	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Rain Rate	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Expansion Rate	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
ECT1 / RCT	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Bursting Test	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
CSD / Static / Anti-static	<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Good	<input type="checkbox"/> No Good	
Disposition:					
<input type="checkbox"/> Accept	<input type="checkbox"/> Conditionally Accept	<input type="checkbox"/> Reject	Remarks:		
<input type="checkbox"/> No need customer approval	<input type="checkbox"/> Revision of specification	<input type="checkbox"/> Return to	With 4M Violation? <input type="checkbox"/> Yes <input type="checkbox"/> No		
<input type="checkbox"/> Need customer approval	<input type="checkbox"/> Re-submit samples		Reason of violation:		
Effectivity of 4M Change:					
Prepared by	Checked by	Approved by	Old Stocks Treatment:		
Date:	Date:	Date:	Old Stocks Quantity:		
Lot Identification/ Markings:					
Note: Approval MUST be Manager level above					

thanks po

Today 1:13 PM

Good afternoon m'am, tallow items kasi yung affected ng Peel Off ng Sunpack materials.

1. Denso PI 1909702-0721 Box, etc OK nape Package World na po ginigamit 722x2409 CF. Baka pwedeng i horizontal sa dilawang items m'am.

2. Sanyo Denki U04595/2-01 Package - 57x1708 CF

3. Epson 511659600 Outer - 703x2412 CF

Salamat po

KPPI Lalaine Ramos-Purchasing

good afternoon, check ko din sa QA sir gawa bale ung pang denso pa lang ang nirequest nito salin

balikan kita sir dyan

Cago po m'am, salamat po