

**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

INVESTIGATION REPORT FORM (IRF)

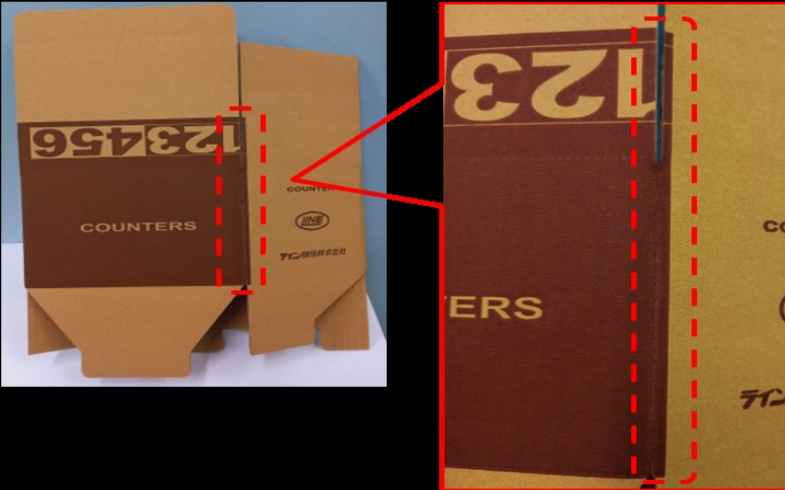
Control No.:

Date Issued

0001

240507

Customer	LINE SEIKI PHILIPPINES, INC.	Attention To	WEENA APALLA
Item Code	RM-ZRY002C	Department	PRODUCTION
Item Description	STANDARD BOX	Date of Detection	240502
Job Order Number	JO24-R-00075-2	Section Detected	QA SCREENING 2

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2000	81	4.05

Nature of Defect:

MISALIGN PRINT

Requirement:

Should be within ± 3 printing tolerance

Actual

Above ± 3 printing tolerance

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN		CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240502</u>	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input checked="" type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching	<input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)	
LESTER JOHN DIOSO 240507	CHARLENE JAN MARIE FLORES 240507	RODERICK RAMOS 240507	GERALD DE GUZMAN 240527	

I. INVESTIGATION / ANALYSIS**DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)****System / Training****Design / Toolings****Process / Material**

WHY 1 : W1 Materials to be used in Eqos has a paper attached it indicates the different material sheet size because it has a discrepancy up to 5mm from the required dimension of 475x635 BF. r n r nW2 Operator set up based on the required dimension of item also adjustment was made to materials with discrepancy accordingly on what sheet sizes will be declared before printing. r n r nW3 The printed boards was piled up at the stacker area and didn't separated the materials with discrepancy according to its sheet sizes. r n r nW4 There is lack of communication since the Eqos Operator B (Stacker) didn't inform regarding uneven board. r n r nW5 Since the uneven board didn't separated the effect during diecut process was a random misalignment



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INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)

System / Training

Design / Toolings

Process / Material

WHY 1 : Diecut operators didn't noticed the misalign print since the occurrence are randomly and the sampling required is one piece in every batch only.

FINAL CONCLUSION

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

WHO / WHEN

Process / Material

WHY 1: Inclusion in Eqos Job Assignment for Eqos Operator r nFeeder 1 (Base on 4 manpower activity) any important notes attached in the materials issued he is the person in charge to relay the information to his colleagues at Eqos.

Production Leaders // 2024-06-28

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

A. Sorting Result

C. Reworking

	Location	Total Stock	NG	Total Good	Rework Quantity	n/a
RM	n/a	0	0	0	Total Good	n/a
WIP	n/a	0	0	0	Rework PPM (Good)	n/a
FG	n/a	0	0	0		

B. Orientation

Date	2024-06-28	Time	16:45
Title	n/a		
Attendees	n/a		

Prepared By:

Approved By:

GERALD DE GUZMAN | 240611

WEENA APALLA | 240702

Department Head



II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 2024-06-28	PIC: L. Dioso
Identified Rootcause Encountered uneven boards.	Recommendation Coordinate to QA regarding on the uneven boards, for issuance of why-why to supplier

III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked By:	Date	Implemented?	Running	JO Number	Date	NG Qty	Lot Qty
1st Verification of Action	L. Dioso	2024-06-28	[/] Yes [] No	1st				
2nd Verification of Action			[] Yes [] No	2nd				
3rd Verification of Action			[] Yes [] No	3rd				
Effectiveness of Action	L. Dioso	2024-07-01	[/] Yes [] No	4th				
Remarks: This is a slow moving item, still no production schedule for this item.				5th				

IV. CLOSURE

Status	Remarks
Closed IRF	Corrective action is implemented. This is a slow moving item, still no production schedule for this item.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 241015 08:13 QA Head	KOHEI ISHII 250226 02:32 Top Management	GERALD DE GUZMAN 250303 03:13 Line Leader	REXEL ALMARIO 250507 11:28 Department Head
Date: 24242424-10-15	Date: 25252525-02-26	Date: 25252525-03-03	Date: 25252525-05-07