


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 FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 142

Date Issued: 200106

Customer	EMORI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	HP33D1016	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	191228
Job Order Number	WO-19-M-02412-125 U2290 - 10	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM
☒ Major

☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

820

243

29.63%

Nature of Defect:

MISALIGN PRINT

Requirement:

4mm distance from the rectangular hole w/ +5/-2mm tolerance

Actual:

The print of the item hit by the diecut

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
☐ First	☐ Hold	☐ Slotter	☐ Gluing	☐ Material
☒ Recurrence	☐ Special Acceptance	☒ EQOS	☐ Vertical	☐ Dimension
No.: 4th	☐ For Rework	☒ Diecut 51702	☐ Others:	☒ Appearance
Date: 191228	☒ Reject / Disposal	☐ Detaching		☐ Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)	
Adrian Vergara QA-IE Staff	Mr. Roderick Ramos QA Supervisor	Mr. Rexel Almario QA Asst. Manager	Mr. Gerald De Guzman / Ms. Weena Apalla Head/ Supervisor	

I. INVESTIGATION / ANALYSIS

DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)

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

	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:
System / Training	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:
	NOT A FACTOR				
Design / Toolings	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:
	THE PRINT TOLERANCE OF +5/-2mm IS NOT APPLICABLE FOR THIS ITEM DUE TO MINIMAL DISTANCE BETWEEN MURATA LOGO, CREASING LINE AND HOLE,				
Process / Material	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:
	- THERE IS INHERENT MOVEMENT BOTH EQOS AND DIECUT 1mm TO 3mm SPECIALLY IF THE MATERIALS IS WARP.				
	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:
	- PRINT MOVEMENT IS NOT SO VISIBLE IN EQOS BECAUSE ITEM ARE NOT YET DIE-CUTTED. - ITEM WAS DIE-CUTTED IN ROUGH SURFACE ON TOP WHY NOT SO VISIBLE IF THERE IS OCCURENCE OF MISALIGN PRINT, EVEN THEY CONDUCTED SAMPLING OCCURENCE OF MISALIGN PRINT IS RANDOMLY.				

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INVESTIGATION REPORT FORM (IRF)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE****OUTFLOW ROOTCAUSE**

THE PRINT TOLERANCE OF $\pm 5/-2\text{mm}$ IS NOT APPLICABLE VS. INHERENT MOVEMENT IN MACHINE.

ITEM WAS DIECUTTED IN ROUGH SURFACE ON TOP WHY THE MISALIGN PRINT IS NOT VISIBLE.

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

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

A. Sorting Result**Actions to be done to eliminate recurrence****Who / When**

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	QA-SCREENING	820	243	577
FG	N/A			

System	Who / When
NA	NA

B. Orientation

Date	Time
N/A	N/A
Title	N/A
Issues	N/A

Design / Tools	Who / When
- REDUCE THE DIMENSION OF MURATA LOGO	WAITING FOR APPROVAL

C. Reworking

Rework Quantity	N/A
Total Good	N/A
Rework Percentage (Good)	N/A

Process	Who / When
- CHANGE THE ORIENTATION OF FEEDING IN DIECUT.	PRODUCTION NEXT RUNNING

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

Date Conducted: 20 01 10 PIC: A. Vergara

Identified Rootcause**Recommendation**

~ The sheets was move sideways inside the printing unit of the machine and diecut machine this movement is inherent on the machines (Mis-align printing occur due to accumulated lateral movement from 2 machines

~ Put suteban on both ends of the mylar to reduce the lateral movement in printing process
~ Side guide reference of both machine (S1700 & Eqsas) should be align to reduce the accumulated lateral movement

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 01 10	☒ Yes ☐ No	- change orientation of dieblade is not applicable - the stated corrective action in recommendation is implemented already
2nd Verification of Action	A Vergara	20 01 10	☒ Yes ☐ No	Recommendation is effective
3rd Verification of Action			☐ Yes	
Effectiveness of Action	A. Vergara	20 06 16	☒ Yes ☐ No	C.A. & Recommendation is effective

Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be RE-OPENED to the affected department for new improvement action.

IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
☒ Closed ☐ Still Open ☐ Re-Issue IRF	No occurrence of misalign print	NOEMI VICEPENA QA Supervisor Date: 20 08 05	IRISH MAY L. ESTANEJA Line Leader Date: 20 08 25 Department Head Date: 20 08 25