



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.: 145

Date Issued: 20 01 20

Customer: EPSON VP

Item Code: 5151419-00

Item Description: CARTON BOX

Job Order Number: WO-20-L-0004-12

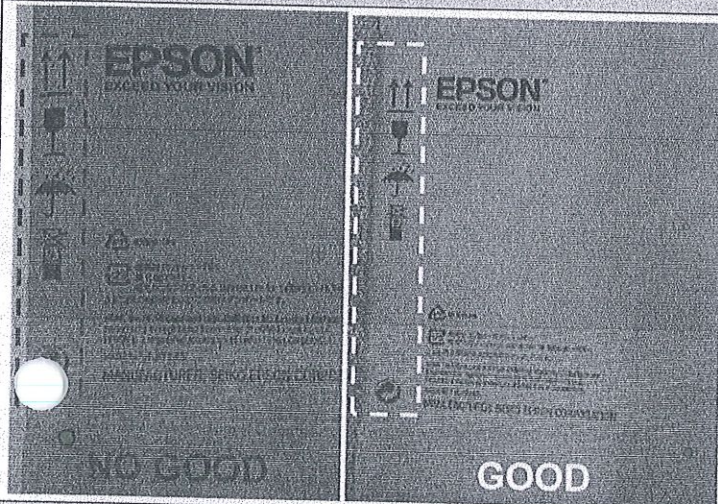
Attention To: Mr. Gerald De Guzman / Ms. Weena Apalla

Department: PRODUCTION

Date of Detection: 20 01 16

Section Detected: QA - SCREENING

ILLUSTRATION OF THE PROBLEM


☒ Major

☐ Minor

Lot Quantity (pcs.): 187

Affected Quantity (pcs.): 83

Reject Percentage: 44.39%

Nature of Defect:

MISALIGN PRINT / DIECUT

Requirement:

Printing / Diecut movement should not exceed on ± 5 mm tolerance

Actual:

Caremark character distance from the creasing line is 4-5mm

NO. OF OCCURRENCE

DISPOSITION

AREA OF OCCURRENCE / ORIGIN

CONTENT

☒ First
☐ Recurrence

No.: _____

Date: _____

☐ Hold
☒ Good
☐ For Rework
☐ Reject / Disposal

☐ Slotter
☐ EQOS
☒ Diecut ETERNA
☐ Detaching

☐ Gluing
☐ Vertical
☐ Others: _____

☐ Material
☒ Dimension
☐ Appearance
☐ Process / Method

Issued by

Checked by

Approved by

Received by
(Receiving Section)Adrian Vergara
QA-IE StaffMr. Roderick Ramos
QA SupervisorMr. Rexel Almario
QA Asst. ManagerMr. 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?)

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:

NOT A FACTOR

Process / Material

Why 1: - POSSIBLE THAT THERE IS SIDE GUIDE DID NOT SET PROPERLY BY OPERATOR.
 Why 2: - THE PIONEER OPERATOR ABSENT THAT TIME DUE TO VOLCANIC ERUPTION.
 Why 3: - TWO REMAINING OPERATOR ARE AUTHORIZED LAST MAY 2019 AND NOV 2019 WHY THE KNOWLEDGE AND EXPERIENCE REGARDING ETERNA OPERATION IS VERY DIFFERENT COMPARE TO PIONEER OPERATOR.

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

NOT A FACTOR

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

NOT A FACTOR

Why 1: - APPROVED MASS PRODUCTION BY QA PATROL.
 Why 2: - MISALIGN PRINT NOT DETECTED UPON SAMPLING CHECKING.

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

POSSIBLE THE SIDE GUIDE DID NOT SET
PROPERLY BECAUSE THE PIONEER
OPERATOR IS ABSENT.

MISALIGN PRINT NOT DETECTED
UPON SAMPLING CHECKING

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

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	QA - In-Line	187	83	187

Actions to be done to eliminate recurrence

Who / When

System

N/A

N/A

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Asses	N/A		

Design /
Tools

N/A

N/A

C. Reworking

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

Process

- WELL DISTRIBUTION OF
PIONEER OPERATOR IN
ETERNA PER SHIFT.

Production
200127

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

Date Conducted: 20 01 20 PIC: A. Vergara

Identified Rootcause

Recommendation

~ There is discrepancy on the side guide setup of the ETERNA Operator instead on 14mm distance of creasing line to characters the actual distance is only 5mm. The said operator has lack of knowledge for operating the machine & needs to monitor

~ Re-shuffle the ETERNA operators so that the distribution of the main operator is even (2 for dayshift & 2 for night shift, before there are 3 pioneer Eterna operator on the other shift)

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 26	[X] Yes [] No	ETERNA operators already shuffled
2nd Verification of Action			[] Yes [] No	QUALITY ASSURANCE DEPARTMENT CLOSED DATE AND SIGNATURE 2006 25 is implemented & effective
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	20 06 16	[X] Yes [] No	

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-issued to the affected department to provide new improvement action.

IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
☒ Closed		QA Supervisor	Line Leader
☐ Still Open		QA Ass. Manager	Department Head
☐ Re-Issue IRF		Date: 20 01 08	Date: 2007/3