

**KANEPACKAGE PHILIPPINE INC.**

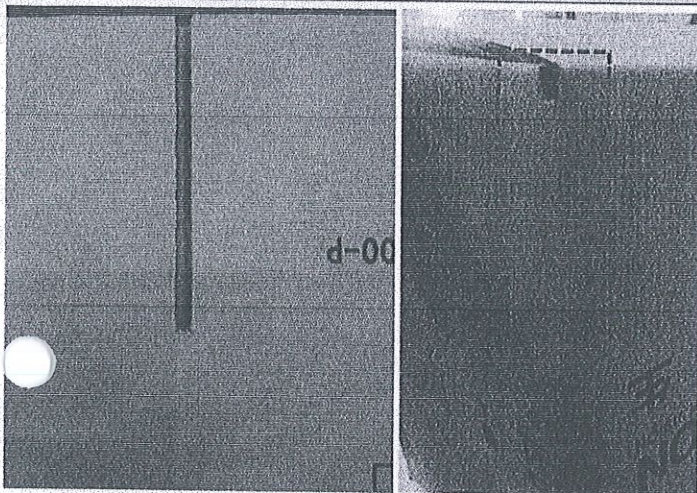
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 147

Date Issued: 20 01 20

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	5147239-00	Department	PRODUCTION
Item Description	OUTER CARTON BOX	Date of Detection	20 01 16
Job Order Number	WO-20-M-00006-17	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

7,262

Reject Quantity (pcs.)

23

Reject Percentage

0.31 %

Nature of Defect:

MISALIGN SLOT

Requirement:

The slot of the item should be within the creasing line and within the tolerance of $\pm 5\text{mm}$

Actual:

The slot exceeded on the creasing line

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Gluing	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension
No.: 2	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Others:	<input checked="" type="checkbox"/> Appearance
Date: 20 01 20	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching		<input type="checkbox"/> 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?)

System / Training	Why 1:	NOT A FACTOR	Why 1:	NOT A FACTOR
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:	NOT A FACTOR	Why 1:	NOT A FACTOR
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:	PLS. SEE ATTACHED	Why 1:	- MISALIGN SLOT CAN'T DETECTED UPON SAMPLING
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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

CREASING LINE EXACTLY HIT THE
CENTER OF ORANGE RUBBER ROLLER
THAT CAUSE DELAY IN FEEDING

NO BOX FORM CHECKING REQUIRED
IN SAMPLING

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-SEMI-AUTO	7,262	23	7,239

Actions to be done to eliminate recurrence**Who / When**

System

N/A

N/A

B. Orientation

Date	N/A	Time	N/A
Attendees	N/A		

Design /
Tools

N/A

N/A

C. Reworking

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

Process

ASK FOR THE ADVICE OF
SIR. SUSUKI BECAUSE THIS
PROBLEM IS POSSIBLE TO
HAPPEN AGAIN.

3pm
Team

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

Date Conducted: 20 01 23

PIC: A. Vergara

Identified Rootcause**Recommendation**

The materials slipped on the feeder rollers
of the feeding unit due to loose impression of
upper & lower roller (Also there was delay timing on
the print location)

adjust the 2 pull nip of the machine to tight
the gripping
1 Pull nip: from 5.3mm to 4.8mm
2 Pull nip: from 5.3mm to 5.4mm
Feed Gate: from 9.0mm to 8.9mm } Feeding Unit

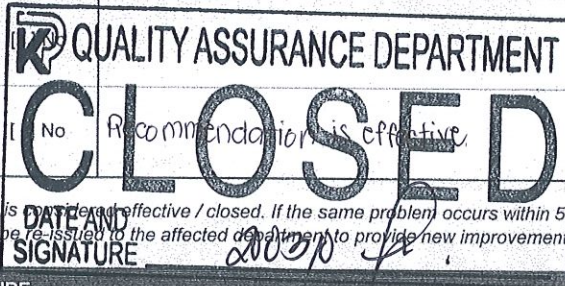
III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 01 23	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Already Implemented (see recommendation)
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
3rd Verification of Action			<input type="checkbox"/> Yes	
Effectiveness of Action	A. Vergara	20 02 14	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	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-issued to the affected department to provide new improvement action.

IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-Issue IRF	lots no archive of same defects.	<div>QA Supervisor Date: 20 07 08</div> <div>QA Asst. Manager Date: 20 07 08</div>	<div>Line Leader Date: 120713</div> <div>Department Head Date: 20 17 13</div>



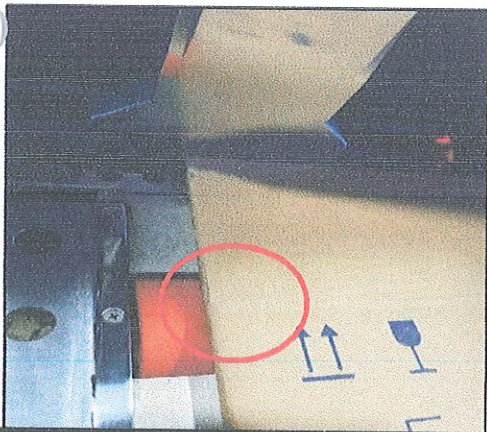
INVESTIGATION REPORT FOR MISALIGN SLOT OF EPSON IJP 514723900 OUTER CARTON BOX

DIRECT CAUSE PROCESS / MATERIALS

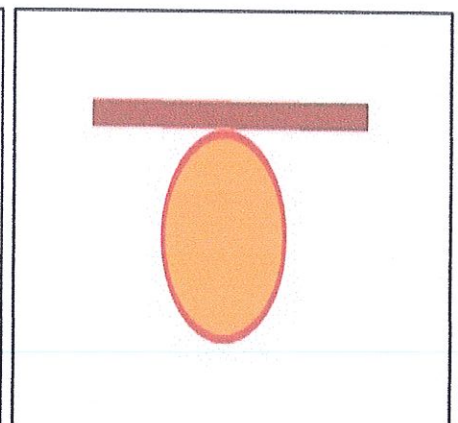
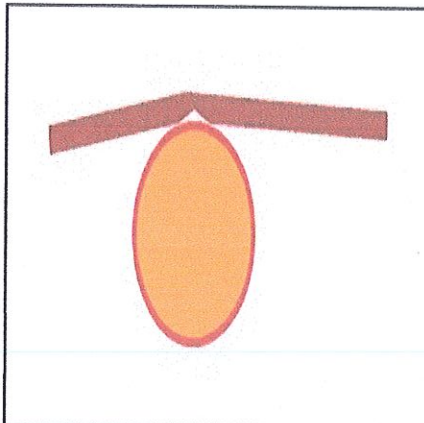
W1 - Upon Investigation there is delay feeding of materials happened in feeding unit because even the print have movement 11mm upward.

W2 - The creasing line exactly hit the center of orange rubber roller who grip or push the materials inside the machine.

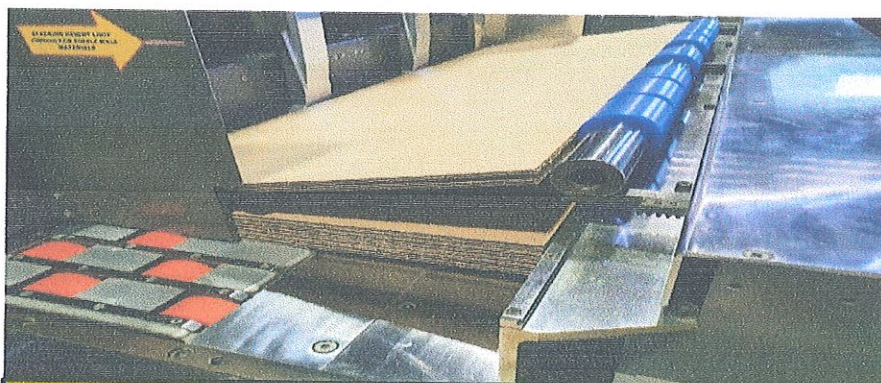
W3 - Possible the occurrence happened in the end portion of process because weight in the bottom material become light.



The orange rubber roller can't grip or push well the materials because of creasing line specially at the end portion of process



Good condition



End portion of process the weight in the bottom materials become light