

1588


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

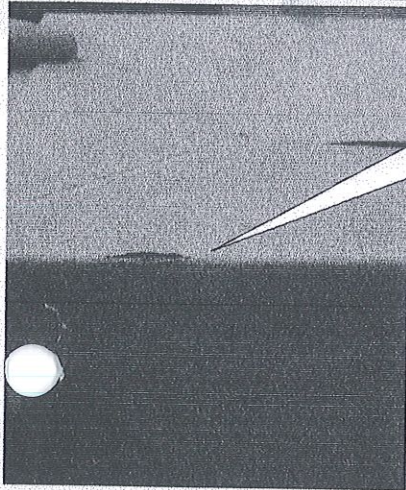
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 148

Date Issued: 20 01 20

Customer	EMORI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	HP01D2000	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	20 01 16
Job Order Number	WO-19-M-02290-37	Section Detected	PRD - GLUING

ILLUSTRATION OF THE PROBLEM


10 ~ 20mm
Bursting

☒ Major

☐ Minor

Lot Quantity (pcs.)

9000

Reject Quantity (pcs.)

19

Reject Percentage

0.21

Nature of Defect:

BURSTING

Requirement:

Bursting is not allowable on the item

Actual:

10 ~ 20mm bursting length on the bottom of the item

NO. OF OCCURRENCE		DISPOSITION		AREA OF OCCURRENCE / ORIGIN		CONTENT	
☒ First		☐ Hold		☐ Slotter	☐ Gluing	☐ Material	
☐ Recurrence		☐ Special Acceptance		☐ EQOS	☐ Vertical	☐ Dimension	
No.: _____		☐ For Rework		☒ Diecur ETERNA	☐ Others:	☒ Appearance	
Date: _____		☒ 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?)

System / Training

Why 1:
Why 2:
Why 3: NOT A FACTOR
Why 4:
Why 5:

Why 1:
Why 2:
Why 3: NOT A FACTOR
Why 4:
Why 5:

Design / Toolings

Why 1:
Why 2:
Why 3: NOT A FACTOR
Why 4:
Why 5:

Why 1:
Why 2:
Why 3: NOT A FACTOR
Why 4:
Why 5:

Process / Material

Why 1: - POSSIBLE THAT THERE IS SCRAP TRIMMINGS LEFT IN THE CUTTING PLATE OF ETERNA.
 Why 2: - THIS IS INHERENT SITUATION IN ETERNA PROCESS.
 Why 3: - BECAUSE THE MATERIALS IS LITTLE BIT INCLINE DURING IMPRESSION DUE TO GRIPPER.
 Why 4:
 Why 5:

Why 1: - APPROVED MASS PRODUCTION BY QA PATROL.
 Why 2:
 Why 3: - NO DETECTED BURSTING UPON SAMPLING.
 Why 4:
 Why 5:

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

LEFT SCRAP TRIMMINGS IN THE CUTTING
PLATE OF ETERNA.

NO DETECTED BURSTING UPON
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 - INLINE	9,000	19	8,981

Actions to be done to eliminate recurrence

Who / When

System

N/A

N/A

B. Orientation

Date	20 01 23	Time	12:00NN ~ 1:00 PM.
Title	ORIENTATION REGARDING BURSTING AND MISALIGN DIECUT IN ETERNA PROCESS		
Attendees	ETERNA Operator		

Design /
Tools

N/A

N/A

C. Reworking

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

Process

ORIENTATION TO
OPERATOR REGARDING
THIS PROBLEM.

Production
200123

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

Date Conducted: 20 01 18

PIC: A. Vergara

Identified Rootcause**Recommendation**

-Over impression on the cut creasing since there was material was overlapped on the scrap, the corrugated scrap was left behind on the steel plate (inside the machine). Because the scrap was detached on the item during diecut process

-If possible put additional nickmarks on the diecut blade to hold the item very well during diecut process and prevent detached trimmings inside the machine

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	☒ Yes ☐ No	Orientation to ETERNA Operators were conducted
2nd Verification of Action			☐ Yes ☐ No	
3rd Verification of Action			☐ Yes ☐ No	
Effectiveness of Action	A. Vergara	20 02 10	☒ Yes ☐ No	is implemented 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)
☒ Closed			
☐ Still Open			
☐ Re-Issue IRF			
		QA Supervisor	Line Leader
		QA Asst. Manager	Department Head
		Date: 200805	Date: 200825
		Date: 20 08 05	Date: 200825

