

**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.: 158

Date Issued: 20 01 30

Customer	EPSON VP
Item Code	5150434-00
Item Description	CARTON BOX
Job Order Number	WO-20-L-0019-10

Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Department	PRODUCTION
Date of Detection	20 01 28
Section Detected	QA - SCREENING

**ILLUSTRATION OF THE PROBLEM**☒ Major ☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
88	61	69.32%

Nature of Defect:

POOR PRINT

Requirement:

As long as no Text or Image affected

Actual:

EPSON Logo has poor print

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ Date: _____	<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 checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by  Adrian Vergara QA-IE Staff	Checked by  Mr. Roderick Ramos QA Supervisor	Approved by  Mr. Rexel Almario QA Asst. Manager	Received by (Receiving Section) 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:
Design / Toolings	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:
Process / Material	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:

NOT A FACTOR

NOT A FACTOR

NOT A FACTOR

PLS. SEE ATTACHED

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## INVESTIGATION REPORT FORM (IRF)

### FINAL CONCLUSION

#### OCCURRENCE ROOTCAUSE

→ THERE IS MATERIAL IMPRESSION IN THE AFFECTED CHARACTER OF POOR PRINT, DUE TO DEEP IMPRESSION OF MAGNETIC SUTEBAN.

#### OUTFLOW ROOTCAUSE

→ NOT DETECTED UPON SAMPLING BECAUSE THE TIME IS NOT ENOUGH TO CONDUCT MORE 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	88	61	27

#### Actions to be done to eliminate recurrence

#### Who / When

#### B. Orientation

Date	20 01 31	Time	2:00 P.M. - 2:10 P.M.
Title	EQOS ORIENTATION REGARDING SETTING OF PRINT IMPRESSION OR PULL NIP IF PRINTING UNIT 2 FOR THE CYREL AND PRINTING UNIT 1 FOR MAGNETIC SUTEBAN		
Attendees	EQOS OPERATORS		

#### Design / Tools

#### Process

#### C. Reworking

Rework Quantity	61 PCS.
Total Good	0
Rework Percentage (Good)	0.00%

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

Date Conducted: 20 01 29

PIC: A. Vergara

#### Identified Rootcause

~ The magnetic suteban coincide where the logo is located on the corrugated sheets and suteban compressed the affected portion due to tight impression of printing roller

#### Recommendation

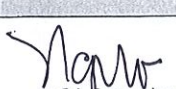
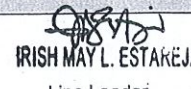
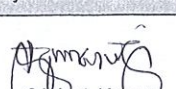
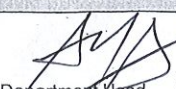
~ If the magnetic suteban will be placed in printing unit 1, it should be 0.5mm loose compare to impression of printing unit 2 w/ rubber plate (e.g.: 1C = 6.0 4, 2C = 4.5)

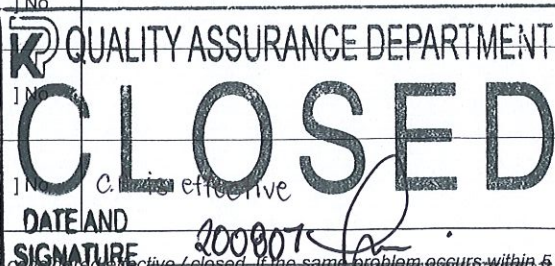
#### III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 01 31	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	CA is implemented (Operators already oriented)
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	20 08 04	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. 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	No occurrence of Poor Print	 QA Supervisor	 Line Leader
<input type="checkbox"/> Still Open		 QA Asst. Manager	 Department Head
<input type="checkbox"/> Re-Issue IRF		Date: 200807	Date: 200825





# INVESTIGATION REPORT FOR POOR PRINT OF EPSON VP 515043400 CARTON BOX

**W1** - Possible the impression of magnetic suteban affected the print quality.

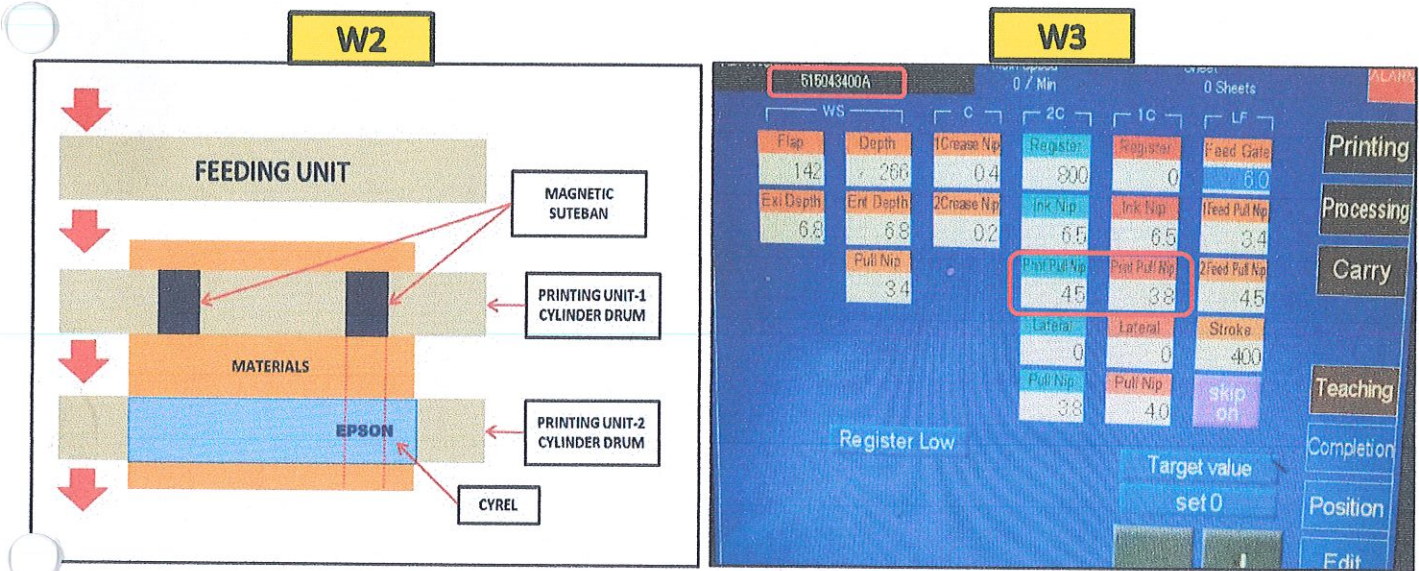
**W2** - The position of magnetic suteban and the affected character is in the same direction.

## DIRECT CAUSE PROCESS / MATERIAL

**W3** - The impression of magnetic suteban in Printing unit-1 is more deeper than the impression of cyrel in printing unit-2.

Based to monitor record Printing unit-1 ( with suteban ) 1C = 3.8 Pull Nip more deeper than Printing unit-2 ( with cyrel ) 2C = 4.5 Pull Nip.

**W4** - Operator missed to consider dis scenario.



**W1** - Trial Run approved by QA Patrol before proceed to mass production.

## INDIRECT CAUSED PROCESS / MATERIAL

**W1** - Not detected upon sampling, because not enough time to conduct more sampling.

Based to Record the speed is **110bpm** why the running of this item with **88pcs** quantity is less than 1minute only.

## CORRECTIVE ACTION PROCESS

Orientation to operator to consider if they process Printing in unit-2 and there is suteban in Printing unit-1, the impression of printing unit 1 is Higher of 0.5mm than Printing unit-2.

EXAMPLE: Printing unit-1 ( 1C = 5.0 Pull Nip )

Printing unit-2 ( 2C = 4.5 Pull Nip )

PIC: Production Leader

TARGET: 200131