

**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.: 165

Date Issued: 20 02 12

Customer	EPSON IJP
Item Code	515086401
Item Description	INDIVIDUAL BOX
Job Order Number	WO-DRS-L-0010-20

Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Department	PRODUCTION
Date of Detection	20 02 10
Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

714

24

3.36%

Nature of Defect:

Misalign Print / Diecut

Requirement:

Print Location should not be near on the creasing line

Actual:

Print is 4-5mm from the creasing line

NO. OF OCCURRENCE**DISPOSITION****AREA OF OCCURRENCE / ORIGIN****CONTENT**☒ First
☐ Recurrence☐ Hold
☐ Special Acceptance
☐ 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

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

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

NOT A FACTOR

Process / Material

Why 1: - THERE IS RANDOM OF WARP MATERIALS PROCESS IN ETERNA
Why 2: - MISALIGN DIECUT OCCURS DUE TO WARP MATERIALS
Why 3: - ETERNA CAN'T GRIP WELL THE WARP MATERIALS THAT CAUSED MACHINE ERROR.
Why 4:
Why 5:

Why 1: - RANDOM OCCURRENCE OF WARP MATERIALS
Why 2: - ETERNA OPERATOR DID NOT CONDUCT 100% CHECKING TO ALL AFFECTED OF MACHINE ERROR
Why 3: - AFTER APPROVED THE TRIAL RUN ONLY SAMPLING IN THE TOP PORTION PER BATCH (25PCS) ARE REQUIRED.
Why 4:
Why 5:

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

- DUE TO WARP MATERIALS MACHINE GOT ERROR AND CAUSED MISALIGN DIE CUT

OUTFLOW ROOTCAUSE

- THE AFFECTED OF MACHINE ERROR DID NOT CHECK 100%

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	714	24	690

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

System

N/A

Design / Tools

N/A

B. Orientation

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

C. Reworking

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

Process

- RECONDITION OF WARP MATERIALS
- THE BATCH (25PCS) THAT AFFECTED OF MACHINE ERROR WILL BE SEPERATE AND NEED TO CHECK 100%

PRODUCTION, QA & WAREHOUSE
PRODUCTION & QA IF OK

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

Date Conducted: 20 02 15

PIC: A. Vergara

Identified Rootcause**Recommendation**

~There was difficulty for gripping the materials to from feeding to cutting because the boards are warp (this warp materials cause downtime to the affected process and it was recorded on their monitoring)

~Separate the flat boards to warp boards and process in separate setup since the setup of flat boards is not appropriate w/ warp materials

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 02 14	☒ Yes ☐ No	See C.A. & Recommendation
2nd Verification of Action			☐ Yes ☐ No	
3rd Verification of Action			☐ Yes ☐ No	
Effectiveness of Action	A. Vergara	20 07 23	☒ 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			
☐ Still Open			
☐ Re-Issue IRF			
		Date: 200805	Date: 200825

11-19-1126
 LOOKING FOR MATS
 KIMILANG AND ISSUE
 NICK DOWNS PA 127
 MATS KIMILANG

11-19-1126

11-19-1126
 ADD. NICK BLAD
 DUE TO DETACH
 1152-1200
 FOWELLPT. 1 MATS
 HUBDI AND JACK LEFT
 AND VACATE

OPERATION RATIO & CONDITION SHEET DIE-CUT/ETERNA MACHINE

MACHINE: ETERNA

OPERATOR: FRANCO POTENG MARK

DATE: 200208

SHIFT: D/S

JPD

JOB ORDER #	L-0010-19	L-0010-20	WB-F-20-016-1	WB-DRE-20-1-0007-89	WB-SO-180-747-2
CUSTOMER	EPSON - WP	EPSON - WP	OPM	EPSON - WP	EPSON
ITEM DESCRIPTION	5150864-01	POX	741-5115-000-RMPG	51372800 RUPUS TR4	51372800 PAD
QUANTITY	770		505	702	830
CONDITION SHEET				WARP MATS	WARP MAT SLOW MOVING
Actual Machine Speed	2700		2700	2700	1000-1800
Actual Machine Pressure	1.5 TMS		4 TMS	3 TMS	1.5
Sheet size	874 X 918		1120 X 740	475 X 720	1200 X 1265
Material	CF		10F	10F	CF

ACTIVITY	TIME		TIME		TIME		TIME	
	Start	Finished	Start	Finished	Start	Finished	Start	Finished
Warm-up time / 5s	0600	0615						
Meeting			0800	0830	1015	1035		
Material Waiting / JO								
Machine Breakdown								
Breaktime								
Updating (JO, P, Sched, M, Ratio)					0920	0935	1210	1240
Machine Set-up								
1. Take out previous blade			0720	0727	0902	0909		
2. Set up new blade			0727	0735	0909	0918	1055	1100
3. Set up stripper							1100	1110
4. Take out stripper			0725	0747				
5. Trial Run	0615	0618	0747	0754	0918/0925	0920/0944	1110	1115
6. QA Checking/Approval	0618	0620	0754	0756	0944	0946	1115	1117
Mass Production								
1	0620	0627	0756	0758	0916	0950	1117	1248
2	0628	0633	0820	0828	0955	0958	1119	1251
3	0635	0638	0840	0910	1000	1015	1126	1302
4	0639	0700			1025	1055	1127	1310
5	0702	0720			1035	1055	1148	1315
6							1200	1337
							1240	1347

MACHINE ETERNA
 0627 - 0638
 0633 - 0635

PUT THE PACKING
 TAPE W-CUT
 0750 - 0800

PUT THE PACKING
 TAPE W-CUT
 0950 - 0955

MACHINE ETERNA
 1135 - 1137
 1137 - 1251

1251 - 1254
 1302 - 1304