

**KANEPACKAGE PHILIPPINE INC.**

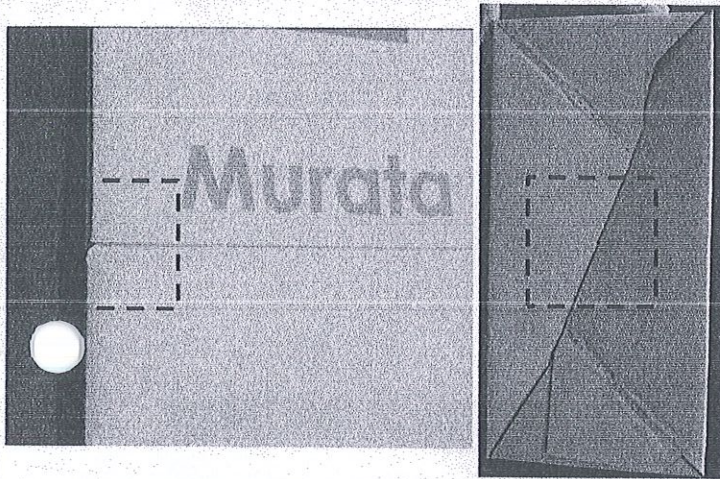
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 168

Date Issued: 20 02 13

Customer	EMORI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	HP01D2200	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	20 02 12
Job Order Number	WO-20-M-00114-36	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM

☒ Major	☐ Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1000	164	16.40%

Nature of Defect:

MISALIGN GLUING

Requirement:

The bottom part of the box should be even

Actual:

The bottom part of the box is not even the it is not locking

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
☐ First ☒ Recurrence No.: 2 Date: 20 02 12	☐ Hold ☐ Special Acceptance ☐ For Rework ☒ Reject / Disposal	☐ Slotter ☐ EQOS ☐ Diecut ☐ Detaching ☒ Gluing ☐ Vertical ☐ Others:	☐ Material ☒ Dimension ☒ Appearance ☐ 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?)	
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: Why 2: Why 3: Why 4: Why 5: PLS. SEE ATTACHED	Why 1: Why 2: Why 3: Why 4: Why 5: PLS. SEE ATTACHED	

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

- THE REQUIRED ALIGNMENT OF CREASING LINE IN THE UPPER FLAP IS UNEVEN, BUT OPERATOR MAKE IT ALIGN STRAIGHT.

OUTFLOW ROOTCAUSE

- OTHER OPERATOR IS NOT FAMILIAR OR AWARE REGARDING THE GLUING ALIGNMENT OF THIS ITEM, BECAUSE THE ROTATION OF USING CONVEYOR START LAST DECEMBER 2019.

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

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	QA - IN LINE	1,000	164	936

System	Who / When
N/A	

B. Orientation

Date	Time
20 02 18	04:28 P.M. ~ 04:33 P.M.
Title	ORIENTATION REGARDING EMORI HP01D2200C CARTON BOX IMPROVEMENT PLAN FOR MISALIGN GLUING DEFECT
Attendees	GLUING OPERATORS

Design / Tools	Who / When
N/A	

C. Reworking

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

Process	Who / When
PLS. SEE ATTACHED	

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

Date Conducted: 20 02 14 PIC: A. Vergara

Identified Rootcause
~ The gluing operator aligned the upper creasing (the upper creasing of the item is not even it has 4mm discrepancy) ~ Work instruction and drawing instruction are not enough as reference for the assembly of the item

Recommendation
~ Additional assembly drawing gluing instruction is included ~ Establishing of guidelines for proper gluing of HP01D2200C & HP01D2000 ~ Nick mark on the glue tab ~ Put creasing matrix on the bottom creasing of the item ~ On first gluing the operator should conduct pre-folding on both end flaps of the item as reference - temporary only

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 19	[] Yes [X] No	Waiting for establishing of guidelines & installation of creasing matrix for the steel plate of the item
2nd Verification of Action	A. Vergara	20 02 19	[X] Yes [] No	CAs were implemented and recommendations
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	20 03 05	[X] Yes [] No	C.A. Recommendation is implemented

Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered 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.

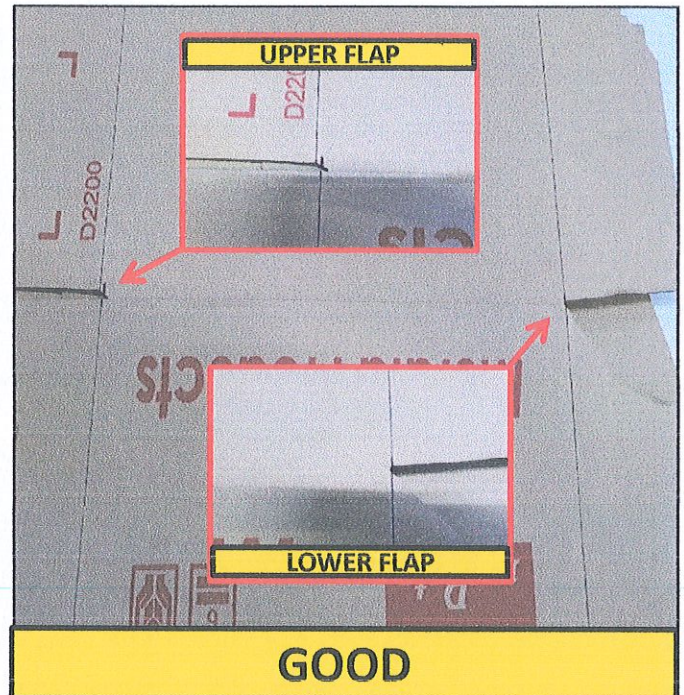
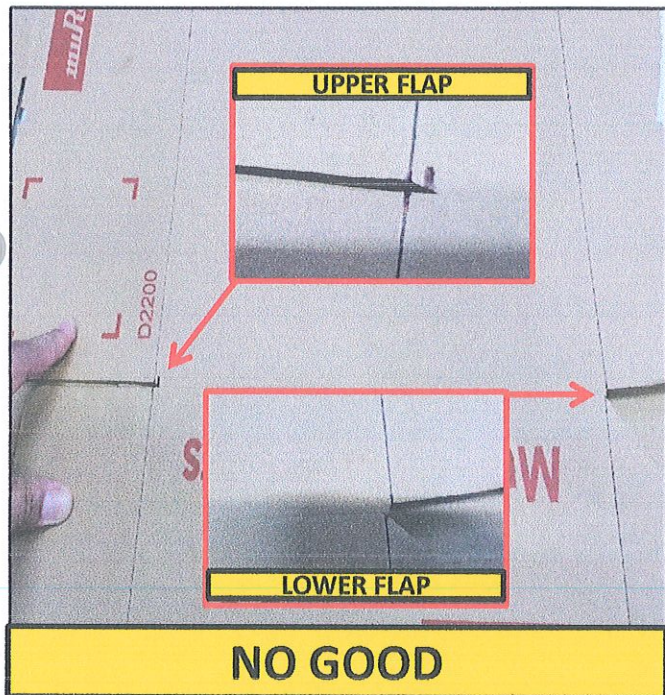
IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
☒ Closed	NO occurrence of Misalign gluing		
☐ Still Open			
☐ Re-Issue IRF			
	Date: 20 07 08	Date: 20 07 08	Date: 2007/3

INVESTIGATION REPORT FOR MISALIGN GLUING OF EMORI HP01D2200 CARTON BOX

DIRECT CAUSE W1 - The required alignment of creasing line in the upper flap is uneven.

PROCESS / MATERIAL W2 - Operator align straight the creasing in the upper flap, because it was facing to operator during feeding of item in Gluing Conveyor.



DIRECT CAUSED W1 - Possible that the other Operator is not familiar or aware regarding the Gluing alignment requirement for this item.

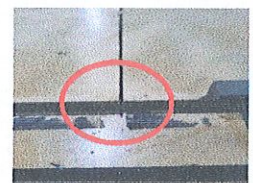
PROCESS / MATERIAL W2 - The man power rotation in Manual Gluing for using Conveyor start last December 2019.

CORRECTIVE ACTION PROCESS

> Put Nick mark as Pokayoke mark for the alignment of gluing.

PIC: Production

Date: 200217 (DONE)



> Orientation regarding the gluing alignment requirement for Emori D2200 Carton Box.

PIC: Production

Date: 200217 (DONE in Day Shift)

HAWAIIAN AIRCRAFT COMPANY, INC.		HAWAIIAN AIRCRAFT COMPANY, INC.		HAWAIIAN AIRCRAFT COMPANY, INC.	
HAWAIIAN AIRCRAFT COMPANY, INC.		HAWAIIAN AIRCRAFT COMPANY, INC.		HAWAIIAN AIRCRAFT COMPANY, INC.	
DATE	200217	DATE	200217	DATE	200217
TIME	14:00	TIME	14:00	TIME	14:00
LOCATION	HP01D2200	LOCATION	HP01D2200	LOCATION	HP01D2200
OPERATOR	W1	OPERATOR	W1	OPERATOR	W1
INSPECTOR	W2	INSPECTOR	W2	INSPECTOR	W2
REMARKS	The required alignment of creasing line in the upper flap is uneven.				
REMARKS	Operator align straight the creasing in the upper flap, because it was facing to operator during feeding of item in Gluing Conveyor.				
REMARKS	Possible that the other Operator is not familiar or aware regarding the Gluing alignment requirement for this item.				
REMARKS	The man power rotation in Manual Gluing for using Conveyor start last December 2019.				



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MINUTES OF THE MEETING

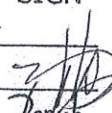
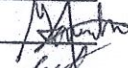
DATE: 200217

TIME START: 1100H

FINISHED: 1105H

VENUE: GLUING AREA

ATTENDEES:

NAME	DEPT.	SIGN	NAME	DEPT.	SIGN
RONALD TORON	GLUING		ANTONIO INTIA	GLUING	
RODRICK ATOLA	GLUING				
DEXTER BALISI					
VEE JAY CAMBAY					
RONALD PAMBAGO					

AGENDA:

ORIENTATION REGARDING THE GLUING ALIGNMENT
REQUIREMENT FOR EMORI HP01D2200 CARTON BOX

MINUTES:

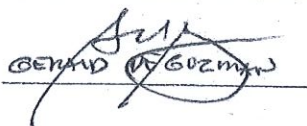
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- 7 THE REQUIRED ALIGNMENT OF CREASING LINE IN THE UPPER FLAP IS UNEVEN (DAPAT HINDI PANTAY)
- 7 MORE FOCUS SA ALIGNMENT - NG LOWER FLAP WHICH IS NAG LAGAY NARIN KAMI ANG POKAYOKE MARK OR NICK MARK AS ADDITIONAL GUIDE SA ALIGNMENT NG 1ST GLUING.

Follow up meeting: (date & time)

for KPPI fill up only

Prepared by:



Reviewed by:

File copy received by: