

**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.: 184

Date Issued: 20 02 20

Customer	EPSON ASP / EPLB	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	5147239-00	Department	PRODUCTION
Item Description	OUTER CARTON BOX	Date of Detection	20 02 19
Job Order Number	WO-20-M-00294-3	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

6,838

50

0.73 %

Nature of Defect:

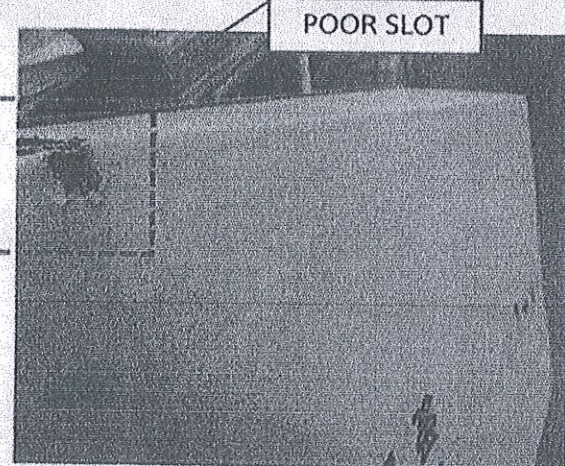
MISALIGN SLOT (POOR SLOT)

Requirement:

The slot of the item should be in horizontal creasing line

Actual:

The slot of the item exceeded the creasing line

**NO. OF OCCURRENCE****DISPOSITION****AREA OF OCCURRENCE / ORIGIN****CONTENT**☐ First☐ Hold☐ Slotter☐ Gluing☐ Material☒ Recurrence☐ Special Acceptance☒ EQOS☐ Vertical☒ Dimension

No.: 3

☐ For Rework☐ Diecut☐ Others:☐ Appearance

Date: 20 02 19

☒ 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:

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**

- SLOT MOVEMENT DUE TO
WARP MATERIAL

OUTFLOW ROOTCAUSE

- RANDOM OCCURENCE OF WARP
MATERIALS.

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 - SCREENING	6,238	50	6,188

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

System

N/A

Design /
Tools

N/A

Process

PLS. SEE ATTACHED

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Issues	N/A		

C. Reworking

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

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

Date Conducted: 20 02 20

PIC: A. Vergara

Identified Rootcause

~ There was a slight delay timing on the slotting process in upper flap because the boards width was reduced since the materials are warp or the impression of the rollers is not tight enough to grip well the materials

Recommendation

~ separate the flat boards to warp boards & process in separate setup
~ Add impression on the 1st unit / 2nd unit since the to improve the gripping

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 20	<input checked="" type="checkbox"/> Yes [] No	CA is already implemented (Recommendation)
2nd Verification of Action			[] Yes [] No	 DATE AND SIGNATURE: 20 06 09
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	20 06 09	<input checked="" type="checkbox"/> 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.

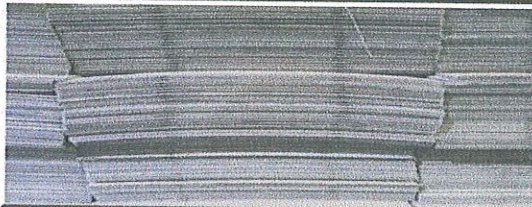
IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed		 QA Supervisor	 QA Asst. Manager
<input type="checkbox"/> Still Open		 Line Leader	 Department Head
<input type="checkbox"/> Re-Issue IRF		Date: 20 02 08	Date: 2007/3

INVESTIGATION REPORT FOR MISALIGN SLOT (POOR SLOT) OF EPSON 514723900 OUTER CARTON BOX

DIRECT CAUSE PROCESS/MATERIAL	W1 - No other factor found except the random of warp materials, because out of 6,838pcs only 50pcs are affected.
	W2 - Because we conducted study in Eqos that the random of warp material have a big effect in Print and Slot movement

STUDY CONDUCTED IN EQOS



RANDOM WARP MATERIALS with 18mm WARPAGE



Print move 8mm upward for warp materials
(Requirement 25mm vs. Actual 17mm)



The lower flap slot move 12mm upward
(Requirement 119mm vs. Actual 131mm)

INDIRECT CAUSE PROCESS/MATERIAL	W1 - Possible that the warp materials occurrence is randomly.
	W2 - Trial run approved by QA patrol why they proceed in mass production.
	W3 - Misalign print did not detected in sampling checking because the occurrence is randomly.

CORRECTIVE ACTION

> For arrangement of corrective action regarding warp materials.

PIC: Sales, Purchasing, MPD, Warehouse, QA and Production.