


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.: 187

Date Issued: 20 02 26

Customer	KOYAMA	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	PKC0G801	Department	PRODUCTION
Item Description	INNER BOX	Date of Detection	20 02 20
Job Order Number	WO-20-M-00241-10	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM
☒ Major

☐ Minor


Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
2,000	120	6.00%

Nature of Defect:

Blotted Print

Requirement:

No blotted on any text

Actual:

The letter "a" text clogged on the hole

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	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: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:

**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)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

THERE IS ACCUMULATED INK IN THE CYREL
BECAUSE MACHINE CANT RUN WITH SKIP
OFF MODE OR FAST DUE TO WARP MATERIALS.

OUTFLOW ROOTCAUSE

NOT DETECTED 100% ALL THE
AFFECTED, BECAUSE ONLY SAMPLING
ARE REQUIRED TO THEM.

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	2,000	120	1,880

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
Attendees	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 27 PIC: A. Vergara

Identified Rootcause

over application of ink on the corrugated boards
because the ink accumulated on the rubber die

Recommendation

~ clean the affected rubber die to remove too much
ink on the affected rubber die

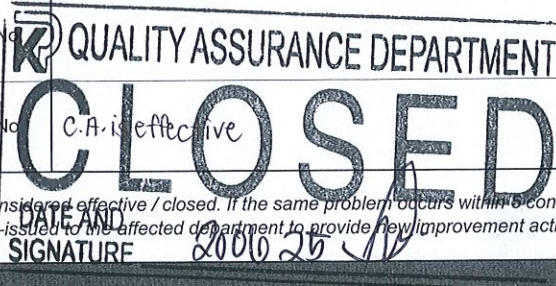
III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 02 28	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	CA is fully implemented
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 06 12	<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 <input type="checkbox"/> Still Open <input type="checkbox"/> Re-Issue IRF		<div>QA Supervisor Date: 20 02 28</div> <div>QA Asst. Manager Date: 20 02 28</div>	<div>Line Leader Date: 200713</div> <div>Department Head Date: 20 07 13</div>



INVESTIGATION REPORT FOR BLOTTED PRINT OF KOYAMA PKCOG801 INNER BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- Over application of ink on the substrate.
	W2- The ink fills the small cavity and spaces on the rubber die.
	W3- Ink from anilox roller accumulated on the affected rubber die.
	W4- Based on the monitoring the machine stop 3 times due to blotted print.
	W5- Because they cant run with skip-off mode or fast due to random of warp materials.
INDIRECT CAUSE PROCESS/MATERIAL	W1 - Operator found 61sheets reject in trial run out of 505sheets.
	W2- The operator conducts only sampling checking why not 100% detected all the affected and make adjustment on the settings once problem detected.

OPERATION RATIO & CONDITION SHEET EQOS Machine										
OPERATORS	A	B	C	D	E	DATE		SHIFT		
JOB ORDER #	410-4135	410-4135	410-4135	410-4135	410-4135	2002 4-12	2002 4-12	2002 4-12	2002 4-12	REMARKS
CUSTOMER	KOYAMA	KOYAMA	KOYAMA	KOYAMA	KOYAMA	410	410	410	410	
ITEM CODE	PKCOG801	PKCOG801	PKCOG801	PKCOG801	PKCOG801	00 444055	00 444055	00 444055	00 444055	
QUANTITY	505	505	505	505	505	12	12	12	12	
INK COLOR	0-0000	0-0000	0-0000	0-0000	0-0000	0000	0000	0000	0000	
Actual Machine Speed	21.115	21.115	21.115	21.115	21.115	100.000	100.000	100.000	100.000	
Sheet Size	215 X 124	215 X 124	215 X 124	215 X 124	215 X 124	215 X 124	215 X 124	215 X 124	215 X 124	
Material	PK	PK	PK	PK	PK	PK	PK	PK	PK	
ACTIVITY	TIME	TIME	TIME	TIME	TIME	TIME	TIME	TIME	TIME	
	Start	Finished	Start	Finished	Start	Finished	Start	Finished	Start	Finished
Maintenance										
Setup										
Breakdown										
Updating										
Assist Other Section										
Change color										
Change size										
Change material										
Change from job										
Take out finished sheet										
Set up new color										
Test machine running										
Mass production										
1	15:02	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11
2	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11
3	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11
4	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11	15:11

EQOS MACHINE RATIO WITH RECORD OF ALL DOWNTIME REASON

CORRECTIVE ACTION

> Clean immediately the affected rubber die that has blotted print using brush to clean the narrow space in cyrel to remove the ink bridging.

PIC: Production

Target Date: 200227 (Done)

> For arrangement of corrective action regarding warp materials.

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