			E PHILIPPINE INC.	INVESTIGATION REPORT FORM (IRF)						
	Telephone No.	(049) 545-7166 to	a Mesa, Calamba City, Laguna o 69	Inhouse Detection Customer Claim						
	Fax No. (049)	545~6302		Control No.: 187	Date Issued:	20 02 26				
Custom	er	KOYAMA		Attention To	Mr. Gerald De Guzman / Ms	. Weena Apalla				
Item Co	de	PKC0G801		Department	PRODUCTION					
Item De	scription	INNER BOX		Date of Detection	20 02 20	5				
Job Ord	ler Number	WO-20-M-002	41-10	Section Detected QA - SCREENING						
	ILL	USTRATION O	F THE PROBLEM	Major	Minor					
	MARTIN	-: W.K.		Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage				
	<u> </u>			2,000	120	6.00%				
				Nature of Defect:						
					Diette d Deint					
11		Ī	Oriental motor		Blotted Print					
		L.	Orientalmotor	Requirement:						
					No blotted on any text					
			PKC0G801	Actual						
			, recombo	Actual:						
				īΛ	The letter "a" text clogged on the	hole				
	NO. OF OCCURRE	ENCE	DISPOSITION	AREA OF OCC	CURRENCE / ORIGIN	CONTENT				
	First		Hold	Slotter	Gluing	Material Material				
	Recurrence		Special Acceptance	EQOS	Vertical	Dimension				
	No.:		For Rework	Diecut	Others:	Appearance				
	Date:		Reject / Disposal	Detaching	-	Process / Method				
	Issued by		Checked by	Approved	by	Received by (Receiving Section)				
NAME OF TAXABLE PARTY.	do.		An Cau	for last all		112				
	Adrian Vergara		Mr. Roderick Ramos	Mr. Rexel Alr	mario Mr. Gerald D	Guzman / Ms. Weena Apalla				
	QA-IE Staff		QA Supervisor	QA Asst. Mar	/	lead/Supervisor				
			I. INVESTIGAT	TION / ANALYSIS						
	DIRECT CAUSE: (Ar	nalyze the reaso	on of occurrence, why it happened?)	INDIRECT CAUS	E: (Analyze the reason of occur	rence, why it leaked?)				
1	Why 1:			Why 1:						
System / Training	Why 2:			Why 2:						
/Tra	Why 3:	NOT.	A FAGOR	Why 3:	UOT A FA	CTOR				
ysterr	Why 4:			Why 4:						
100000	Why 5:			Why 5:						
	Why 1:			Why 1:						
lings	Why 2:			Why 2:		10 0 0 - 210 22				
/ Too	Why 3:	NOT	A PACTOR	Why 3:	UDT A FA	CTOPS				
Design / Toolings	Why 4:	,		Why 4:						
	Why 5:			Why 5:						
	Why 1:			Why 1:		8				
	Why 2:			Why 2:						
/ Mat	BR 7400-1.00000	S. St	E ATTACHED		S. SEE ATTA	CALED				
ess	Why 4:		, , , , , , , , , , , , , , , , , , , ,	Why 4:	170					
				Why 5:						
	Why 5:			TVIIIy O.						

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)

	Fax No. (049) 54	5-6302	CONTRACTOR OF THE PARTY OF THE		7-1 (150 Sept.) (150 Sept.)		ON THE STATE OF TH	STATE STATE OF THE		
					FINAL CON	CLUSION				
	0	CCURRENCE	ROOTCAUSE					OUTFLOW ROOTCAUSE		
1 2000	is tewn				- Aller Anna Aller			ED 100% ALL		
	USE W				the same of the sa	ANT NEQUINED TO THEM.				
OFF M	une on i	AST DUE	to WAIC	+ WWIET						
IMMEDIA	TE ACTION: (Ad	ction to be done t	o contain/ tempora	ry correct the prob	lem found)	CORRECT		ctions to be done to ensure that the	oroblem will not h	
A. Sorting Res	ult		I				Actions to be de	one to eliminate recurrence		Who / When
	Loca	tion	Total Stock	NG	Total Good			,		
RM	η/	Pi			- 11	System	P/A			
WIP	N	'A								
FG	QA-SCRE	ENING	2,000	120	1,880					
B. Orientation				i					7	
Date N/		A	Time	N/A		Design / Tools	N/X			
			N/A			10013	/ P			
Attendees			N/A							
C. Reworking										
Rework Quar	ntity		14	A		Process	PLS. SEE XTTALLED			
Total Good			11	A			,			
Rework Perc	entage (Good)	- william that hims the sine	4.	/A	MACHER SHAPE STATE					
II. QA I	ROOTCAUSE \	ERIFICATIO	N (To be filled	out by QA In-c	harge)	Date Conduct	ted: <u>20 02 2</u>	7 PIC: A. Vexo	jara	
		and the control of the control of	Rootcause					Recommendation		
because	plication the tak	accumula	n the con ated on t	he rubber	oogras cdie	ink on	the affected	d rubber die to	remove	too much
			III. CORRI	ECTIVE ACTIO	N VERIFICAT	ION (To be fill	led out by QA In	i-charge)		ed president
		Che	cked by	Date	Impler	nented?		Remarks		
1st Verifica	tion of Action	A. V.evga	21/21	20 02 18	[/] Yes	[] No	CA is full	y implemented		
2nd Verifica	ition of Action				[]Yes	[] No				
3rd Verifica	tion of Action				[]Yes	[] N	QUALITY	ASSURANCE DEF	PARTMEN	IT,
Effectivene	ess of Action	A. Vergo	ara	20 06 12	[/]Yes	[] No	C.A.i. effe	cive C		
Note: If no deliveries of	same defects / por 3rd verification	oroblems occi n of action still	urs for 5 consec I not yet implem	cutive deliveries nented, Investig	s, corrective ac ation Report s	tion is conside hall be re-issue SIG	yed effective / cli ed to Mb affected SNATURE	osed. If the same problem od d department to provide hewli	curs within 5 c	onsecutive action.
						OSURE				
Status:		Remarks:			Appro	oved by:		Process Owner Acknowled	gment: (Rece	ving Section)
Closed				CATA	MEN WED	acm	non vic	LU.	4	
Still Open				QA \$	pervisor	1//	st. Manager	Line Leader		nept Head
Re-Issue IRI	F			Date: ()	N 68	Date: 0	er of	Date: 2007/3	Date://D 0	710

INVESTIGATION REPORT FOR BLOTTED PRINT OF KOYAMA PKC0G801 INNER BOX

	W1 - Over application of ink on the substrate.
	W2 - The ink fills the small cavity and spaces on the rubber die.
DIRECT CAUSE PROCESS/MATERIAL	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	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.

OPERATORS:	n		D				DATE:				
							State!				
TOR GREEK #	STATE OF THE PARTY OF	4100	0010-	90	00100	4000	(A)08 4	412	1 12 2 1 V C	- 15	1 REMARKS
CUSTOMER	SOMETHIN		FELL DAS	NATES SERVICES	ERIDA		JUSE		JVA	CUR OF STREET	A STATE OF THE PARTY OF THE PAR
HEM CODE COANTITY	ENGCE-	501	Signing	30	5,8503	OF E	00 06	A COSE	Bosca	asay	A Chine that were not not proper
The COLOR	50.9 5-8:08				200		1 62		6-2		chairs then but there was been buy to
Actual Machine Speed	The second		9-8-W		D- WINE		61.84		A Shire		LEADER AND PRESENT LIMITARE
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PROBLEM STATE OF THE PROPERTY OF					The second second	-	-	-		-	A Extern cyart, plato planting grass
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			Transfer of			15 1000		1	100000000000000000000000000000000000000		A 1539-1540 Serses & commo cuarrisco
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Set-up every certal		1 202	Branch State	ME THE STREET		1370	Established and	1550	BERTEN SOL	600	+ KINZ WILL HALVALOT WANT INK
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Mass production		Y G	1 7 E 183	120,000	MAYL	1431	15.52	14.4	14 18	1410	
	Marie Control of the			STATE OF THE PARTY AND PERSONS ASSESSED.	-					COMMAND TO SERVICE AND ADDRESS OF THE	
	1546	1000	A STATE OF THE PARTY OF THE PAR								

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.