


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

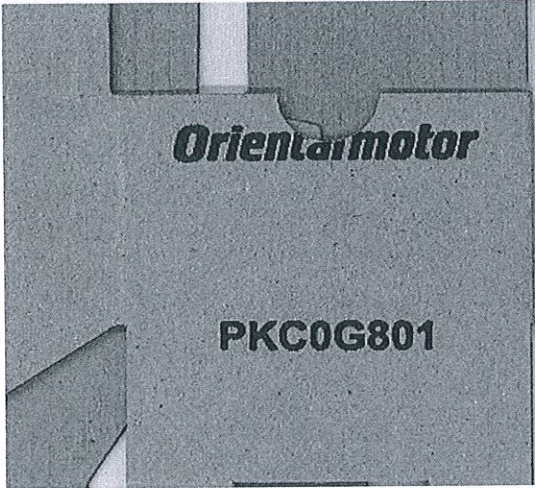
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 189

Date Issued: 20 02 20

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	26	1.30%

Nature of Defect:

Misalign Print

Requirement:

 Printing movement tolerance is $\pm 3\text{mm}$
Actual:

 The printing movement of the item is $>20\text{mm}$

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
☐ First ☒ Recurrence No.: 2nd Date: 20 02 20	☐ Hold ☐ Special Acceptance ☐ For Rework ☒ Reject / Disposal	☐ Slotter ☒ EQOS ☐ Diecut ☐ Detaching ☐ Gluing ☐ Vertical ☐ Others:	☐ Material ☐ Dimension ☒ Appearance ☐ 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:

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

- ENCOUNTER SEVERAL DOWNTIME
BECAUSE OF MISALIGN PRINT
DUE TO RANDOM OF WARP MATS.

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**

Actions to be done to eliminate recurrence

Who / When

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	QA - SCREENING	2,000	26	1,974

System

N/A

B. Orientation

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

Design /
Tools

N/A

C. Reworking

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

Process

PLS. SEE ATTACHED

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

Date Conducted: 20 02 27

PIC: A. Vergara

Identified Rootcause

Recommendation

~ The materials delay on the printing unit timing
because the materials slipped inside, because the
condition of the materials are warp

~ Attachment of Pokayoke mark on the edge to
monitor the Misalign Print

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 27	☒ Yes ☐ No	Warp improvement was already coordinated to the 3 affected supplier (replied as of 20 02 26) ~ Pokayoke was applied already last 20 02 20
2nd Verification of Action	A. Vergara	20 02 27	☒ Yes ☐ No	Recommendation is implemented
3rd Verification of Action			☐ Yes ☐ No	
Effectiveness of Action	A. Vergara	20 06 12	☒ Yes ☐ No	C.A. & Recommendation 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)
☒ Closed ☐ Still Open ☐ Re-Issue IRF		QA Supervisor QA Asst. Manager Date: 20 07 06 Date: 20 07 08	Line Leader Department Head Date: 2007/3 Date: 10 07 13

KANEPACKAGE PHILIPPINE, INC.

https://3389427.a

KANERACKAG PHILIPPINE, INC.		FORM QA 19 REV. 3
CUSTOMER	KOYAMA TRADING PHIL., INC.	
ITEM CODE	PKC0G801	
ITEM DESCRIPTION	INNER BOX	
LOT NO.	200220 - WO-20-M-00241-10	
QUANTITY	20 pcs.	MP
		QA-CG508
		QA PASSED

SO No.: Sales Order #SO-20-M-00241
 JO No.: WO-20-M-00241-10
 ISSUED BY: Julieta Banguaga
 DATE ISSUED: 11-FEBRUARY-2020
 CUSTOMER: KOYAMA TRADING PHIL., INC.

Item Description: PKC0G801 INNER BOX
 Quantity: 2000 Piece
 Delivery Date: 20-FEBRUARY-2020

Memo:
 BK Code: PKC0G801
 Blades: Rack 19-32

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
695 X 767 EF TX200/CM125/TX200 0	505	0	0	0pcs 505	0134295	PACKAGEWORLD		JOHN 2/18

PROCESS	Finished Date	Time	GOOD QTY	REJECT QTY		OPERATOR	Remarks
				Trial run	In-house		
200210 1.EQOS JUNMAN	02/18		507 493	01		J.R. ANE	
2.DIECUT S1700	02/19		489	4		GILY DAR	
3.DETACH	02/19		1956				83 sheets, misalign print
4.MANUAL GLUING			1313 524		47 - Poor DRIAT 4 - Mis ALIGN PRINT	TOM, SUDY, ISWETH DINA, IHEA	
5.LOT NUMBERING	2/20		2000			LIM KENNED	
6.SCREENING							
7.QA BUNDLE	2/20		1700 (incl 300)	174		Amma benard	

REJECTION HISTORY

1. (A). Occurrence Date: 11/20/2019, (B). Problem: MISALIGN PRINT, (C). NG Quantity: 83 PCS., (D) Rootcause: Misalign Print occur due to warp materials
- 2.
- 3.
- 4.
- 5.

NOTES

1. Separate the warp boards to good materials. Warp Board should be process on 120B/M below speed setup
2. 1889 PCC TRANSFERRED TO QA - CMC - 200220
- 3.
- 4.
- 5.

PR-007-F07

JO Received By(WHSE):

JO Returned to(QA):

Signature over printed name/Date/Time

WILHOUSE OUT

DATE: 2/18

Signature over printed name/Date/Time

PRODUCTION OUT

BY: CMC

DATE: 200220

NETCUTE

INVESTIGATION REPORT FOR MISALIGN PRINT OF KOYAMA PKC0G801 INNER BOX

DIRECT CAUSE	W1 - Encounter several downtime.
PROCESS/MATERIAL	W2 - Because there is random of warp materials mixed why the print got misalign.

INDIRECT CAUSE PROCESS/MATERIAL	W1 - Operator found 61 sheets reject in trial run out of 505 sheets
	W2 - Not detected 100% all the affected because only sampling are required to them.

[illegible]

CORRECTIVE ACTION

> For arrangement of corrective action regarding warp materials.

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

OPERATION RATIO & CONDITION SHEET

DATE: 200218
SHIFT: D/S

A B C D E
ACE DENVER J.J. EDU ~~EDU~~ NINO

JOB ORDER #	M-002470	0010-36	001012	00084-12	00084-13
CUSTOMER	KOYAMA	FRCON	FRCON	SJP	SJP
ITEM CODE	PFCOC1801	515086301	513197900	0099988	0099988
QUANTITY	505	120	80	12	12
INK COLOR	D-BLUE	D-BLUE	D-BLUE	BLACK	BLACK
Actual Machine Speed	90 SKIP	130 SKIP	120 SKIP	100 SKIP	90 SKIP
Sheet Size	CA5X 767	648 X 1828	691 X 1878	805 X 2374	805 X 2274
Material	F#	(F)	(F)	CBF	CBT
ACTIVITY	TIME	TIME	TIME	TIME	TIME
	Start	Finished	Start	Finished	Start
	Finished	Start	Finished	Start	Finished
Maintenance					
7's					
Meeting					
Breake time					
Updating		1500	1515		
Assist Other Section					
Scrap cleaning(during/after running)			✓ 1515	1524	1555 - 1600
Cyrel cleaning(during running)					
Material Preparing/Waiting					
Machine Breakdown					
Meeting(during mass pro)					
Change color				✓ 1533	1537
Cleaning of nozzle					
Input item key	1259	1416	1524	1537	1554
Take out previous cyrel					
Set-up new cyrel					
Trial run/QA checking	1302	1311	1419	1539	1600
Mass production					
1	1311	1318	1425	1533	1620
2	1340	1416	1500	1554	1618
3					
4					

REMARKS

✓ 1313-1315 JUMP DUE TO WARP

*1310-1340 MIS align problem due to
WARP AND DELAY WAITING TO
SORTING 22

clean cytochrome b (13-42 - 1344) ✓

* Stop again due to this
(1396-1398) ✓

* steam engine due to bluffed & ✓
✓ 1350-1357 ✓

* Clear cycle photo blurred print
135a-1407 ✓

✓ HOPF-COPI
this align print DUE TO WART MARKS

A1438-1442 cleaning machine scrap stop #

*1539-1546 DETECT & CORING WAITING TO APPROVE GA

✓ 602-1612 NAG PALET KAME INK
MALABANAW NA