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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

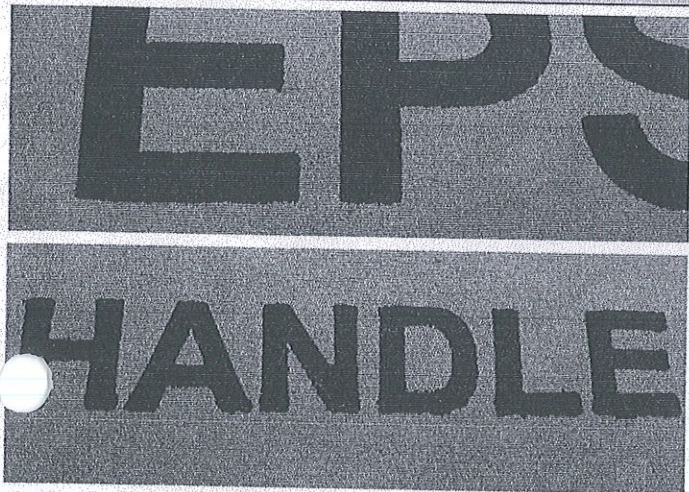
☐ Customer Claim

Control No.: 196

Date Issued: 20 03 02

Customer	EPSON TP
Item Code	5115835-00
Item Description	OUTER CARTON BOX
Job Order Number	WO-20-M-00303-3

Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Department	PRODUCTION
Date of Detection	20 02 28
Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM

☐ Major

☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

212

42

19.81%

Nature of Defect:

SMEARED PRINT

Requirement:

Acceptable smeared print is 1mm only

Actual:

Smeared print is >1mm

NO. OF OCCURRENCE
DISPOSITION
AREA OF OCCURRENCE / ORIGIN
CONTENT
☒ First
☐ Recurrence

No.: _____

Date: _____

☐ 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:
 Why 4:
 Why 5:

NOT A FACTOR

Design / Toolings

 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:

NOT A FACTOR

 Why 1:
 Why 2:
 Why 3:
 Why 4:
 Why 5:

NOT A FACTOR

 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**

- NO STANDARD TON MANY HOUR THE
LIFESPAN OF PROCESSED INK.

OUTFLOW ROOTCAUSE

- OPERATOR DID NOT NOTICE THE SMEARED PRINT BECAUSE
POSSIBLE THE OCCURRENCE IS RANDOMLY, THATS WHY NOT
OF IT WAS TRAPPED DURING SAMPLING CHECKING.

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	212	42	170

System

N/A

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Asses	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 03 03

PIC: A. Vergara

Identified Rootcause**Recommendation**

~ High ink viscosity because volume of the water mixed
on the ink reduced because the ink uses for long time
(Almost 5,000 + output)

~ standardize ink life span

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 03 13	[] Yes [X] No	standardizing ink life span will cause downtime
2nd Verification of Action	A. Vergara	20 06 25	[X] Yes [] No	Ink life span is 2hrs (As long as continuous running & no ink replacement)
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	20 08 08	[X] Yes [] No	is implemented

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	No occurrence of smeared print	QA Supervisor Date: 2008 25 QA Asst. Manager Date: 2008 25	IRISH MAY L. ESTAREJA Line Leader Date: 2008 25 Department Head Date: 2008 25

INVESTIGATION REPORT FOR SMEARED PRINT OF EPSON TP 511583500 OUTER CARTON BOX

DIRECT CAUSE PROCESS/MATERIAL	W1 - Possible that the ink viscosity change due to long hours usage of ink.
	W2 - Based in investigation they start to used the Dark Blue ink (EQ-02) around 1320H up to 1640H time when they finished process this item. In that time total of 3.33hrs Eqos finished 6 items of Epson Outer Carton Box.
	W3 - No Standard how many hour the lifespan of processed ink.

DIRECT CAUSE PROCESS/MATERIAL	W1 - Trial run approved by QA Patrol, that's why they proceed in mass production.
	W2 - Operator did not notice the smeared print because possible the occurrence is randomly, that's why not of it was trapped during sampling checking.



**CYREL GOOD CONDITION
(NOT A FACTOR)**

EPSON	511583500	CA	4PPC	D-Blue	9	6.35	6.5	1.5	5.0
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MACHINE SETTING		
Flute Type	Ani Impression	Printing Impress
A (5mm)	6.5 ±0.2mm	2 ±1mm
B (3mm)	6.5 ±0.2mm	2 ±1mm
C (4mm)	6.5 ±0.2mm	2 ±1mm
CB (5mm)	6.5 ±0.2mm	2 ±1mm

**ACTUAL SETTING VS. STANDARD "NO CHANGES"
(NOT A FACTOR)**

ITEM	DATE	TIME	INK	QUANTITY	REMARKS
EPSON	200314	1320	D-Blue	6	1320
EPSON	200314	1325	D-Blue	6	1325
EPSON	200314	1330	D-Blue	6	1330
EPSON	200314	1335	D-Blue	6	1335
EPSON	200314	1340	D-Blue	6	1340
EPSON	200314	1345	D-Blue	6	1345
EPSON	200314	1350	D-Blue	6	1350
EPSON	200314	1355	D-Blue	6	1355
EPSON	200314	1400	D-Blue	6	1400
EPSON	200314	1405	D-Blue	6	1405
EPSON	200314	1410	D-Blue	6	1410
EPSON	200314	1415	D-Blue	6	1415
EPSON	200314	1420	D-Blue	6	1420
EPSON	200314	1425	D-Blue	6	1425
EPSON	200314	1430	D-Blue	6	1430
EPSON	200314	1435	D-Blue	6	1435
EPSON	200314	1440	D-Blue	6	1440
EPSON	200314	1445	D-Blue	6	1445
EPSON	200314	1450	D-Blue	6	1450
EPSON	200314	1455	D-Blue	6	1455
EPSON	200314	1500	D-Blue	6	1500
EPSON	200314	1505	D-Blue	6	1505
EPSON	200314	1510	D-Blue	6	1510
EPSON	200314	1515	D-Blue	6	1515
EPSON	200314	1520	D-Blue	6	1520
EPSON	200314	1525	D-Blue	6	1525
EPSON	200314	1530	D-Blue	6	1530
EPSON	200314	1535	D-Blue	6	1535
EPSON	200314	1540	D-Blue	6	1540
EPSON	200314	1545	D-Blue	6	1545
EPSON	200314	1550	D-Blue	6	1550
EPSON	200314	1555	D-Blue	6	1555
EPSON	200314	1600	D-Blue	6	1600
EPSON	200314	1605	D-Blue	6	1605
EPSON	200314	1610	D-Blue	6	1610
EPSON	200314	1615	D-Blue	6	1615
EPSON	200314	1620	D-Blue	6	1620
EPSON	200314	1625	D-Blue	6	1625
EPSON	200314	1630	D-Blue	6	1630
EPSON	200314	1635	D-Blue	6	1635
EPSON	200314	1640	D-Blue	6	1640

OPERATION RATIO & CONDITION SHEET		EPOS Machine	
ITEM	DATE	TIME	INK
EPSON	200314	1320	D-Blue
EPSON	200314	1325	D-Blue
EPSON	200314	1330	D-Blue
EPSON	200314	1335	D-Blue
EPSON	200314	1340	D-Blue
EPSON	200314	1345	D-Blue
EPSON	200314	1350	D-Blue
EPSON	200314	1355	D-Blue
EPSON	200314	1400	D-Blue
EPSON	200314	1405	D-Blue
EPSON	200314	1410	D-Blue
EPSON	200314	1415	D-Blue
EPSON	200314	1420	D-Blue
EPSON	200314	1425	D-Blue
EPSON	200314	1430	D-Blue
EPSON	200314	1435	D-Blue
EPSON	200314	1440	D-Blue
EPSON	200314	1445	D-Blue
EPSON	200314	1450	D-Blue
EPSON	200314	1455	D-Blue
EPSON	200314	1500	D-Blue
EPSON	200314	1505	D-Blue
EPSON	200314	1510	D-Blue
EPSON	200314	1515	D-Blue
EPSON	200314	1520	D-Blue
EPSON	200314	1525	D-Blue
EPSON	200314	1530	D-Blue
EPSON	200314	1535	D-Blue
EPSON	200314	1540	D-Blue
EPSON	200314	1545	D-Blue
EPSON	200314	1550	D-Blue
EPSON	200314	1555	D-Blue
EPSON	200314	1600	D-Blue
EPSON	200314	1605	D-Blue
EPSON	200314	1610	D-Blue
EPSON	200314	1615	D-Blue
EPSON	200314	1620	D-Blue
EPSON	200314	1625	D-Blue
EPSON	200314	1630	D-Blue
EPSON	200314	1635	D-Blue
EPSON	200314	1640	D-Blue

OPERATION RATIO & CONDITION SHEET		EPOS Machine	
ITEM	DATE	TIME	INK
EPSON	200314	1320	D-Blue
EPSON	200314	1325	D-Blue
EPSON	200314	1330	D-Blue
EPSON	200314	1335	D-Blue
EPSON	200314	1340	D-Blue
EPSON	200314	1345	D-Blue
EPSON	200314	1350	D-Blue
EPSON	200314	1355	D-Blue
EPSON	200314	1400	D-Blue
EPSON	200314	1405	D-Blue
EPSON	200314	1410	D-Blue
EPSON	200314	1415	D-Blue
EPSON	200314	1420	D-Blue
EPSON	200314	1425	D-Blue
EPSON	200314	1430	D-Blue
EPSON	200314	1435	D-Blue
EPSON	200314	1440	D-Blue
EPSON	200314	1445	D-Blue
EPSON	200314	1450	D-Blue
EPSON	200314	1455	D-Blue
EPSON	200314	1500	D-Blue
EPSON	200314	1505	D-Blue
EPSON	200314	1510	D-Blue
EPSON	200314	1515	D-Blue
EPSON	200314	1520	D-Blue
EPSON	200314	1525	D-Blue
EPSON	200314	1530	D-Blue
EPSON	200314	1535	D-Blue
EPSON	200314	1540	D-Blue
EPSON	200314	1545	D-Blue
EPSON	200314	1550	D-Blue
EPSON	200314	1555	D-Blue
EPSON	200314	1600	D-Blue
EPSON	200314	1605	D-Blue
EPSON	200314	1610	D-Blue
EPSON	200314	1615	D-Blue
EPSON	200314	1620	D-Blue
EPSON	200314	1625	D-Blue
EPSON	200314	1630	D-Blue
EPSON	200314	1635	D-Blue
EPSON	200314	1640	D-Blue

BASED I N DATA GATHERED THEY USED THE DARK BLUE INK (EQ-02) IN 3.33hrs FOR 6 ITEMS OF EPSON OUTER CARTON BOX

CORRECTIVE ACTION

> Study how many hour or sheets process the lifespan of processed ink.

PIC: Production

Target Date: 200314

A



U

SHIFT: DS

REMARKS

1409-1414 ✓ cleaning cycle

✓ 1127-1034 ✓

1488-1500 ✓ cleaning and box

1533-1541 ✓ drain tank
2 units

EQOS DEVELOPMENT REMARKS SHEET

DATE	CUSTOMER	ITEM CODE	MATERIAL/SHEET	INK COLOR/VISCOSITY	CYREL-R-BACK	ANILOX-PRINTING IMPRESSION	REMARKS DIFFICULTY, ACTION
200227	SDP	0102269401	CBF UPPE	Black 9	0.35	0.5 4.6	skip 170
CLEMAIR	SDP			Black 9	0.35	0.5 4.4	skip 10
	SDP	00902269801	CBF UPPE	Black 9	0.35	0.5 4.8	skip 20
EPSON		8151437701	CF UPPE	Black 9	0.35	0.5 1.4	skip
Emami		EM0000501802	BF UPPE	Red 9	0.35	0.3 1.4	
EPSON		51514135 A	CBF AKITA	Black 9	0.35	0.5 4.8	
		B	CBF AKITA	Black 9	0.35	0.5 4.8	
EPSON		51514139 A	CBF AKITA	Black 9	0.35	0.5 4.9	
		B	CBF AKITA	Black 9	0.35	0.5 4.9	
EPSON		515143166 A	CBF AKITA	Black 9	0.35	0.5 5.0	
		B	CBF AKITA	Black 9	0.35	0.5 5.0	
EPSON		515143200 A	CBF AKITA	Black 9	0.35	0.5 5.0	
		B	CBF AKITA	Black 9	0.35	0.5 5.0	
EPSON		515141800 A	CBF AKITA	Black 9	0.35	0.5 5.0	
		B	CBF AKITA	Black 9	0.35	0.5 5.0	Print only 1 PCS.
EPSON		513583700	CF UPPE	D. Blue 9	0.35	0.5 1.6	81 PCS
EPSON		515086001	CF UPPE	D. Blue 9	0.35	0.3 1.7	
EMORI		EM0000701413	CBF UPPE	Red 9	0.35	0.3 4.6	skip
EPSON		511452200	CF UPPE	D. Blue 9	0.35	0.5 1.7	skip
EPSON		514904301	CBF UPPE	D. Blue 9	0.35	0.5 4.2	
EPSON		511504300	CF UPPE	D. Blue 9	0.35	0.5 1.7	skip
EPSON		511583500	CF UPPE	D. Blue 9	0.35	0.5 1.9	skip
EPSON		513236900	CF UPPE	D. Blue 9	0.35	0.3 1.4	skip