

**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

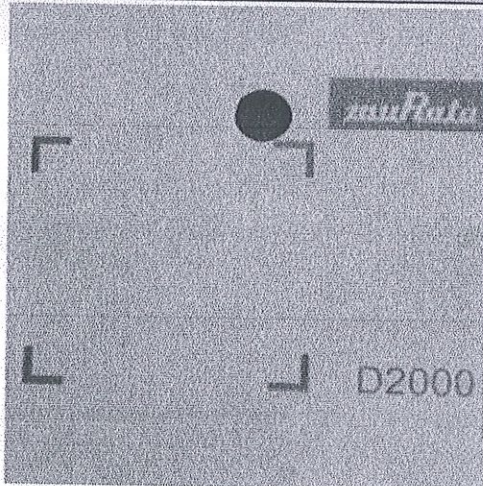
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 197

Date Issued: 20 03 02

Customer	EMORI
Item Code	HP01D2000
Item Description	CARTON BOX
Job Order Number	WO-20-M-00114-43.1 & WO-20-M-00114-72

Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Department	PRODUCTION
Date of Detection	20 02 29
Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

6,091

79

1.30%

Nature of Defect:

MISALIGN PRINT / DIECUT

Requirement:

Sticker guide should be 8.5mm distance from the hole w/ ± 3 mm

Actual:

Sticker guide move up to 10mm upwards

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 Adrian Vergara QA-IE Staff	Checked by Mr. Roderick Ramos QA Supervisor	Approved by Mr. Rexel Almario QA Asst. Manager	Received by (Receiving Section) 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:	NOT A FACTOR	Why 1:	NOT A FACTOR
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:	NOT A FACTOR	Why 1:	NOT A FACTOR
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:	PLS. SEE ATTACHED	Why 1:	PLS. SEE ATTACHED
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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

- DUE TO WARP MATERIALS

- OCCURRENCE IS RANDOMLY WHY
DID NOT DETECTED UPON 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 - IN - LINE	6,091	79	6,012

System

N/A

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Issues	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 04

PIC: A. Vergara

Identified Rootcause**Recommendation**

~ The jammed for a moment in the machine
since machine gripper cannot pulled very well the
material due to warp materials

~ separate the warp materials to flat materials
~ Generation of NG materials segregation Criteria

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 16	☐ Yes	☒ No	NG materials segregation was approved by QA & PRO - for finalizing
2nd Verification of Action	A. Vergara	20 05 11	☒ Yes	☐ No	Guidelines for separating NG Materials is done
3rd Verification of Action			☐ Yes	☐ No	
Effectiveness of Action	A. Vergara	20 07 08	☒ Yes	☐ No	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	NOEMI V. CEPEDA QA Supervisor	 QA Asst. Manager		 Line Leader	
☐ Still Open					
☐ Re-Issue IRF					
	Date: 200806	Date: 20 08 06	Date: 200806	Date: 20 08 25	

CHANGE OF PLATE EMORI
✓ 2200 (22002200) W/PLATING
M/T/DX

✓ EMORI D1200 5 PCS
TRIAL OF GRINDING PROFILES
* (2252 - 2300)

✓ CHANGE OF PLATE
* (0314 - 0322)

OPERATION RATIO & CONDITION SHEET DIE-CUT/ETERNA MACHINE

MACHINE: ETERNA
OPERATOR: FRANCO - BOTTEG. MARK

DATE: 200226
SHIFT: 1/5

JOB ORDER #	100-20-M-00114-72	100-20-M-00114-610	100-20-0322-1.1	100-20-L-0070-23
CUSTOMER	EMORI	EMORI	CBMP	EPSOP - NP
ITEM DESCRIPTION	D2000 BOX	P2200 PRO	12X1-5115-000 APC	515141800 CARTRIDGE
QUANTITY	1200	5117	112	B = 64
CONDITION SHEET				A = 64
Actual Machine Speed	1700	3000	2400	2200
Actual Machine Pressure	1.5 TMS	1.5 TMS	3.5 TMS	1.5 TMS
Sheet size	825 X 730	685 X 1025	1120 X 740	1000 X 975
Material	PF	BF	BF	CBF

ACTIVITY	TIME		TIME		TIME		TIME	
	Start	Finished	Start	Finished	Start	Finished	Start	Finished
Warm-up/ Maintenance/Preparation	2010	2025						
7s								
Meeting	2000	2010					0400	0425
Material Waiting / JO								
Machine Breakdown							0425	0500
Breaktime							6 ASSIST TO DETECTING	
Updating (JO, P. Sched, M. Ratio)								
Machine Set-up								
1. Take out previous blade			2140	2146	0200	0206	0202	0238
2. Set up new blade			2146	2153	0206	0214 *	0208	0245
3. Set up stripper			2153	2200				
4. Take out stripper			2200	2206				
5. Trial Run			2206	2215				
6. QA Checking/Approval			2215	2222 *				
Mass Production			2222	2230	0222	0226	0245	0249
1	2025	2030			0226	0230	0251	0256
2			2310	2323	0230	0232	0256	0300
3	(27: machine's error)		2323	0200				
4	(10: garbage disposal)		0200	0200				
5								

(27 minutes) FOR
MACHINE ERROR (2004)
DUE TO WARE
(2045 - 2055)
(CHANGE THE BLADE)

(2323 - 2345) (22)
STOP RUNNING DUE TO
PEEL OFF CARTRIDGE
ADDITIONAL PEEL MARK
REPAIR WORK

✓ 25 MINUTE FOR
MACHINE
(2004) DELAY SET

INVESTIGATION REPORT FOR MISALIGN PRINT / DIECUT OF EMORI HP01D2000 CARTON BOX

DIRECT CAUSE PROCESS /

- W1** - Did not identify where between Egos and Eterna is the caused of Misalign Print/Diecut, but 1 of the Factor and have a proof that cause of misalign is the random of warp materials.
- W2** - Eterna operator record the machine error downtime around 27minutes (20x) due to warp material. This machine error is one of the big factor of misalign diecut.

MACHINE: ETD2000		DIE-CUT/ETERNA MA		
OPERATOR: FRANCISCO ROTEIRO, ADRI				
JOB ORDER #	10000000000000000000	10000000000000000000	10000000000000000000	
CUSTOMER	EMORI	EMORI	EMORI	
ITEM DESCRIPTION	10000000000000000000	10000000000000000000	10000000000000000000	
QUANTITY	1000	1000	1000	
CONDITION SHEET				
Actual Machine Speed	1300	1300	1300	
Actual Machine Pressure	1.5 TPA	1.5 TPA	1.5 TPA	
Sheet size	6.75 x 7.25	6.75 x 7.25	6.75 x 7.25	
Material	100	100	100	
ACTIVITY	TIME		TIME	
	Start	Finished	Start	Finished
Warm-up/ Maintenance/Preparation	2010	2015		
7. Meeting	2000	2010		
Material Waiting / JO				
Machine Breakdown				
Breaktime			2300 / 0700	2315 / 0715
Updating (JO, P. Sched, M. Ratio)				
Machine Set-up				
1. Take out previous blade			2140	2145
2. Set up new blade			2140	2150
3. Set up stripper			2140	2145
4. Take out stripper			2140 / 2145	2140 / 2145
5. Trial Run	2025	2030	2140	2150
6. QA Checking/Approval			2145	2150
Mass Production				
1	2240	2140	2145	2150
2	2340	2140	2145	2150
3	2440	2140	2145	2150
4				
5				

27 minutes for machine error (20x) due to warp material. This machine error is one of the big factor of misalign diecut.

Eterna operator record the machine error last February 26, 2020. Upon process of Emori D2000 they encounter 20x error with around 27minutes downtime due to warp materials.

INDIRECT CAUSED PROCESS / MATERIAL

- W1** - Warp materials occurrence is randomly.
- W2** - Trial run in both machine are 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 PROCESS

> For arrangement of corrective action regarding warp materials.

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