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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

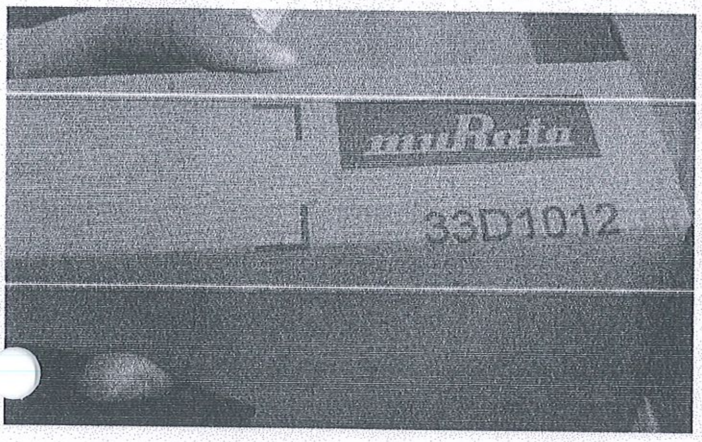
INVESTIGATION REPORT FORM (IRF)

☒ Inhouse Detection ☐ Customer Claim

Control No.: 199 Date Issued: 20 03 05

Customer	EMORI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	HP33D1012	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	20 03 04
Job Order Number	WO-20-M-00310-26	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM



☒ Major ☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1,992	108	5.42%

Nature of Defect:

Misalign Print

Requirement:

Print should not exceeded on the creasing line

Actual:

Printing is inclined and exceeded on the creasing line

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
☐ First	☐ Hold	☐ Slotter	☐ Gluing	☐ Material
☒ Recurrence	☐ Special Acceptance	☒ EQOS	☐ Vertical	☒ Dimension
No.: 5	☐ For Rework	☐ Diecut	☐ Others:	☒ Appearance
Date: 20 03 04	☒ Reject / Disposal	☐ Detaching		☐ Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
Adrian Vergara QA-IE Staff	Mr. Rexel Almario QA Asst. Manager	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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FINAL CONCLUSION

OCCURRENCE ROOTCAUSE	OUTFLOW ROOTCAUSE
- 2 POSSIBLE FACTOR 1ST IS WARP MATERIALS 2ND IS HIGH STACKING OF MATERIALS AT HE FEEDING UNIT.	- OCCURRENCE IS RANDOMLY AND THE ITEM IS NOT YET DIE-CUTTED WHY IS NOT SO VISIBLE.

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

A. Sorting Result

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	QA-SCREENING	1992	108	1884

B. Orientation

Date	20 03 10	Time	10:00 AM - 10:05 AM 7:15 PM - 7:20 PM
Title	Orientation Regarding Misalign Print of HP 600102 Carton Box		
Attendees	EQDS Operator		

C. Reworking

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

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

	Actions to be done to eliminate recurrence	Who / When
System	N/A	
Design / Tools	N/A	
Process	PLS. SEE ATTACHED	

Date Conducted: 20 03 09 PIC: A. Vergara

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

Identified Rootcause	Recommendation
~ Difficulty in feeding unit to draw the materials because of high stacking height ~ Previous countermeasure where stacking height should be reduce to 800mm is not strictly followed	~ standardized the stacking heigh in EQDS Machine feeding unit

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 10	[✓] Yes	[ ] No	orientation is already conducted
2nd Verification of Action			[ ] Yes	[ ] No	
3rd Verification of Action			[ ] Yes	[ ] No	
Effectiveness of Action	A. Vergara	20 07 08	[✓] Yes	[ ] No	C.A. is effective

QUALITY ASSURANCE DEPARTMENT
CLOSED
DATE AND SIGNATURE 200804

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		NOEMI V. OCFEMIA QA Supervisor Date: 200805	QA Asst. Manager Date: 20 08 05	IRISH MAY L. ESTAREJA Line Leader Date: 200821	Department Head Date: 200825

INVESTIGATION REPORT FOR MISALIGN PRINT OF EMORI HP33D1012 CARTON BOX

DIRECT CAUSE PROCESS/MATERIAL	**W1** - This item is prone in misalign print because print is very near in creasing line.
	W2 -Item is already processed and no changes found in the machine setting, why we just analyzed the two possible cause of the problem.
	W3 - 1st is the random of warp materials
	W4 - 2nd is the slight delay on the entry of the materials due to high stacking of materials at the feeding unit.

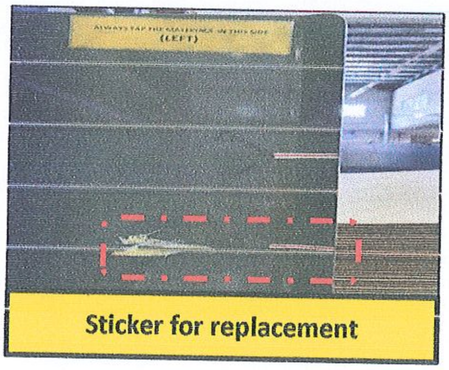
INDIRECT CAUSE PROCESS/MATERIAL	**W1** - Trial run approved by QA Patrol, that's why they proceed in mass production.
	W2- Operator did not notice the misalign print, because possible the occurrence is randomly and the item is not yet die-cutted why is not so visible.

CORRECTIVE ACTION

> Re-orientation regarding 300mm stacking height limit in Eqos feeder for this item.

PIC: Production

Target Date: 2003012



> For arrangement of corrective action regarding warp materials.
PIC: Sales, Purchasing, MPD, Warehouse, QA and Production.

OPERATION RATIO & CONDITION SHEET
EQOS Machine

OPERATORS:
A B C D E

DATE:
SHIFT:

JOB ORDER #										
CUSTOMER	Emori		Emori							
ITEM CODE	HP37D1012		HP37D1014							
QUANTITY	2040		830							
INK COLOR	Red		Red							
Actual Machine Speed	90		120 SKIP							
Sheet Size	645 x 810		1010 x 620							
Material	BF		BF							
ACTIVITY	TIME		TIME		TIME		TIME		TIME	
	Start	Finished	Start	Finished	Start	Finished	Start	Finished	Start	Finished
Maintenance										
7's	1710	1800								
Meeting										
Breaktime										
Updating										
Assist Other Section										
Scrap cleaning(during/after running)										
Cyrel cleaning(during running)										
Material Preparing/Waiting										
Machine Breakdown										
Meeting(during mass pro)										
Change color										
Cleaning of nozzle										
Cleaning of anilox										
Input item key	1537		1633							
Take out previous cyrel										
Set-up new cyrel		1541		1635						
Trial run/QA checking	1541	1544	1635	1640						
Mass production										
1	1540	1633	1640	1710						
2	(6) trial	cyrel	(4) cyrel	cleaning						
3	cleaning		(4) cyrel	cleaning						
4										

REMARKS

* 1547-1557 (trial unit)

* Punas spot, dint.
1625 - 1627
1630 - 1632

* 1645 - 1647
Punas poor print
1701 - 1707
Punas

3

> w/sched 2/11
> last run 2/13
> last run 2/25

1119

KANEPACKAGE PHILIPPINE, INC.

SO No. :	Sales Order #DRS-20-M-00310
JO No. :	WO-20-M-00310-26
ISSUED BY :	Nene Villanueva
DATE ISSUED :	26-FEBRUARY-2020
CUSTOMER	EMORI PHILS.

NETSUITE
QA TRANSFER TO FG
BY: Jesa / 1857
DATE: 200305
TIME: 7:50AM

Light Industry Science Park II.
National Highway, Calamba, 4027 Laguna
Tel:(049) 545 7166/67
Fax:(049)544-0010

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Item Description:	HP33D1012 CARTON BOX	Memo :	
Quantity:	2000 Piece	BK Code :	HP33D1012
Delivery Date:	6-MARCH-2020	Blades :	Rack 31-B-41

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
645 X 810 BF (TX200/CM125/TX200) for HP33D1012 CASE BOX 0	1020	0	0	0pcs 1020	151743	TS		OHAN 3/3

PROCESS	Finished Date	Finished Time	GOOD QTY	REJECT QTY Trial run	REJECT QTY In-house	REJECT QTY Supplier	OPERATOR	Remarks
1.EQOS AP 200303	3/3		1020				JDEAN	
2.DIECUT S1700	3/4		1020				DOMZ MIKE	
3.DETACH	3/4		2040				Jun, Mae, Paje, Mavs Elmar, Bryan, Uway	
4.CONVEYOR 1	3/4	1245 1540	2000				HARDEX RICKSON AD	
5.LOT NUMBERING	3/4		2000				JUM / KENNO	
6.SCREENING			1857	(bal: 143)				
7.QA BUNDLE	3/05		~~(1992)~~ 4	~~(bal 8)~~ 4	135		K.Gallos JIMKALE	continuation

REJECTION HISTORY

1. (A). Occurrence Date: 02/02/19, (B). Problem: Misalign Print, (C). NG Quantity: 58 PCS., (D) Rootcause: Due to warp boards, Uneven size of boards and due to wrong feeding orientation of materials
2. (A). Occurrence Date: 07/19/19, (B). Problem: Misalign Print, (C). NG Quantity: 283 PCS., (D) Rootcause: Worn-out parts of the diecut machine
3. (A). Occurrence Date: 11/9/2019, (B). Problem: MISALIGN PRINT, (C). NG Quantity: 136 PCS., (D) Rootcause: Misalign Print occur due to warp materials
4. (A). Occurrence Date: 12/10/2019, (B). Problem: MISALIGN PRINT, (C). NG Quantity: 289PCS., (D) Rootcause: Slight delay on the entry of the material to the feeding printing unit due to high stacking of materials at the feeding unit
5.

EMORI PHILIPPINES INC.

Item Code	QUANTITY
HP33D1012	10 pcs.
Item Description	Supplier's QC
CASE BOX W/ PRINT	PASSED INSPECTION RoHS OK QA-CG580
Lot No. / Ref. No.	
200304 - 00310-26	

KANEPACKAGE PHILIPPINES INC.

NOTES

1. 1. Warp boards should be recondition by IQA and WH Person... the boards for their guide in feeding orientation
2. The operator should monitor the movement of the print mak...
~~3. Separate the warp boards to good materials. Warp Board sh...~~ ...etup
~~4. The operator should refer on the stacking height limit attac...~~
5.

OUT

PR-007-F07

JO Received By(WHSE): ____ Signature over printed name/Date/Time

JO Returned to(QA): ____ Signature over printed name/Date/Time

200304

RARE 3/3

DATE:

NETSUITE