


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

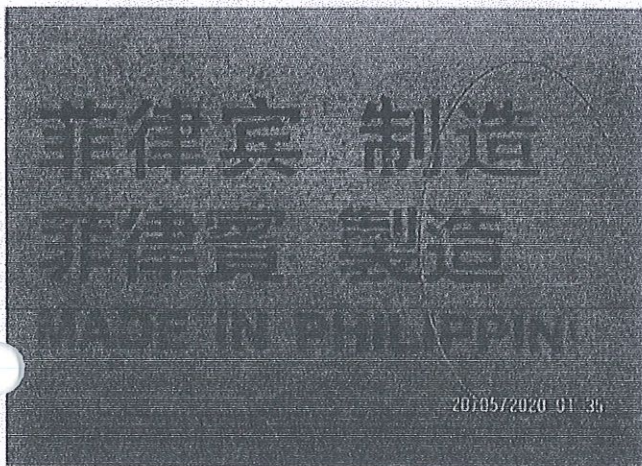
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 217

Date Issued: 20 05 29

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	5143791-00	Department	PRODUCTION
Item Description	MAINTENANCE OUTER BOX	Date of Detection	20 05 28
Job Order Number	WO-20-L-0144-1	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM


<input checked="" type="checkbox"/> Major	<input type="checkbox"/> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
336	96	28.57%
Nature of Defect:		
MISSING PRINT		
Requirement:		
Character should be printed completely		
Actual:		
Letters E and S is missing		

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ Date: _____	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input checked="" type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching	<input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others: <input type="checkbox"/> Material <input type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
 Adrian Vergara QA-IE Staff	 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: PLS. SEE ATTACHED Why 3: Why 4: Why 5:	Why 1: Why 2: PLS. SEE ATTACHED Why 3: Why 4: Why 5:	

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

THE END PORTION OF BOX ARE PRESSED
BY ROLLER (DRIVE COLLAR) WHY THE
IMAGE GOT BROKEN.

OUTFLOW ROOTCAUSE

NO OCCURENCE. OF MISSING PRINT
UPON CHECKING OF TRIAL RUN

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

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	QA- IN LINE	336	96	240
FG	N/A			

Actions to be done to eliminate recurrence**Who / When**

System

N/A

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Indees	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 06 01

PIC: A. Vergara

Identified Rootcause

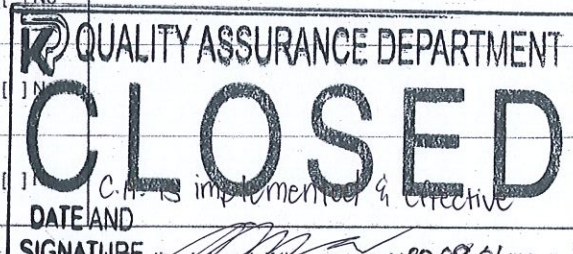
The end portion of boards has long dent and
this dent was acquired due to compression of
the drive collars (The drive collar width is 19mm
while the distance of the print to the end of the
board is 16mm)

Recommendation

Move the drive collars manually prior mass produc-
tion if the print on the end part has a distance
of below 20mm

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 06 01	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Corrective Action is Implemented
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	20 08 26	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	



Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective. 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)
<input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-Issue IRF	No occurrence as per monitoring	<div>QA Supervisor Date: 20 10 12</div> <div>QA Asst. Manager Date: 20 10 12</div>	<div>Line Leader Date: 20 10 12</div> <div>Department Head Date: 20 10 12</div>

INVESTIGATION REPORT FOR MISSING PRINT OF EPSON IJP 5143791-00 MAINTENANCE OUTER BOX

DIRECT CAUSE PROCESS/MATERIAL	W2- The end portion of box are pressed why the image got broken.
	W1- The roller (Drive Collar) hold the end portion of box why it was pressed
	W3- The adjustment of roller (Drive Collar) during machine setting is automatic, 20mm impression at the end portion of box.

INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator proceed to mass production.
	W2 - Trial run approved by QA Patrol.
	W3 - No occurrence of missing print upon checking of Trial Run.

CORRECTIVE ACTION

Manual adjustment of roller (Drive Collar) if the item have 20mm and below, print distance at the end portion of box.

PIC:	Production	TARGET DATE:	200604
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