<b>展開 本語の</b>	NEPACKAGE PHILIPPINE INC.	INVESTIGATION REPORT FORM (IRF)			
Telepho	ing Road LISP II, Brgy. La Mesa, Calamba City, Laguna one No. (049) 545-7166 to 69 (049) 545-6302	Inhouse Detection Customer Claim			
Customor	EPSON IJP	Control No.: 221	(1) (1) (1) (1) (1) (1) (1) (1) (1) (1)	<u> </u>	
Customer		Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla		
Item Code	5150864-01	Department PRODUCTION			
Item Description	INDIVIDUAL BOX	Date of Detection 20 06 10			
Job Order Number	WO-DRS-20-L-0039-29	Section Detected QA - IN LINE			
	ILLUSTRATION OF THE PROBLEM	Major	Mino	or T	
		Lot Quantity (pcs.)	Reject Quantity (pcs.) 92	Réject Percentage 2.03 %	
N. T.		Nature of Defect:	BLOTTED PRINT		
33		Requirement:			
nsiesienni			Register Mark should be read	dable	
		Actual:			
		Register Mark was filled by ink			
NO. OF OCC	DISPOSITION Hold	AREA OF O	CCURRENCE / ORIGIN  Gluing	CONTENT	
Recurrence	Special Acceptance	EQOS	Vertical	Dimension	
No.:	For Rework	Diecut	Others:	Appearance	
Date:	Reject / Disposal	Detaching		Process / Method	
Issue	d by Checked by	Approve	ed by	(Received by	
Adrian V QA-IE	Die Mitstellen von 17. 25 (Er all Deutschleun, auf varietrie aus al einer 1. eur er aussi in	QN (M Mr. Rexe) QA Asst. M		De Gurman / Ms. Weena Apalla Head/ Supervisor	
DIRECT CAUS	I INVESTIGATE: (Analyze the reason of occurrence, why it happened?)	TION / ANALYSIS			
Why 1:	ic. (Analyze the reason of occurrence, why it is appened?)	Why 1:	JSE: (Analyze the reason of occu	irrence, why it leaked?)	
Myhy 3: Why 4:	FACTOR	Why 3: NOT A PACTOR			
tee why 5.	Why 3: NOT A PACTOR				
		Why 4:			
Why 5:		Why 5:			
Why 1:		Why 1:		48	
Why 2: Why 3: Why 4:	LIDT 4 F TO	Why 2: Why 3: NOT A FACTOR			
Why 3:	NOT A FACTOR	Why 3:	Why 3:		
Why 4:		Why 4:			
Why 5:		Why 5:			
Why 1:	· · · · · · · · · · · · · · · · · · ·	Why 1:			
Why 2: Why 4:		Why 2:			
Why 3:	PLS. SEE XTTACHED	Why 3: PLS. SEE ATTACHED			
% Why 4:	1	/ Why 4:	î de la companya de		
Why 5:		Why 5:			



## 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)

	Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302								
FINAL CON OCCURRENCE ROOTCAUSE						NCLUSION OUTFLOW ROOTCAUSE			
BLUNT CYNEL						RANDOM OCCURSENCE  CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)			
IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)									
. Sorting Res	ult						Actions to be done to eliminate recurrence	Who / Whe	
	Loc	cation	Total Stoc	k NG	Total Good				
RM WIP FG		IA I UNE IA	4,512	92	4,420	System	N/A		
Orientation	1		1	_1	1				
Date	lν	/A	Time	NIF	<b>ì</b>	Design /	N/,		
Title			N/A N/A			Tools	P/x		
Reworking									
Rework Quantity  Total Good			N/A	N/A N/A		Process	PLS. SEE ATTACHED	-n	
			NIA						
Rework Perce	entage (Good)		NIA						
II OA E	ROOTCAUSE	VERIEICATION	I /Ta ba fills	double OAL		the transference and a fire	Λ		
DOTT WO	orn rubk	Identified Der die di	Rootcause ve to lor	ng usage (	148,307	~ Establ	Recommendation  ish a standardize rubber of the degree of the recommendation.	lie lifespan	
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DOTT WO	orn rubk	Identified Der die di Oberdie. Of the rep	Rootcause  ve to lor  The ink gistered  III. cor	ng usage ( accumula mark  RECTIVE ACTIO	148,307 te on the	~ Establ ~ Rubber ink on	Recommendation ish & Standardize rubber a	lie lifespan.	
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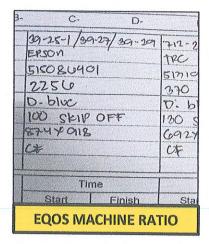
## INVESTIGATION REPORT FOR BLOTTED PRINT OF EPSON IJP 5150864-01 INDIVIDUAL BOX

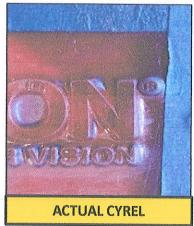
DIRECT CAUSE
PROCESS/MATERIAL

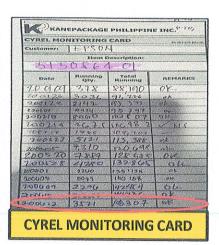
W1. Even the process is in Skip Off mode, operator need to increase the impression why there is occurrence of blotted print specially in very small character.

W2- Cyrel already blunt.

W3- Item is fast moving with high volume Quantity, totally as of June 12, 2020 cyrel already printed 148,307sheets







IN IRECT CAUSE
PROCESS/MATERIAL

W1- Operator proceed to mass production.

**W2** - Trial run approved by QA Patrol.

W3 - Occurrence are randomly and upon detection of blotted print, operator clean the cyrel.

## **CORRECTIVE ACTION**

Request for cyrel replacement.

PIC: Production / Tooling TARGET DATE: 200615

Set standard checking of cyrel condition

(Example: 1st is after 100,000sheets if ok, next is after 150,000sheets if OK, next is after 180,000sheets)

PIC:	Production / Tooling	TARGET DATE:	200629			