

**KANEPACKAGE PHILIPPINE INC.**

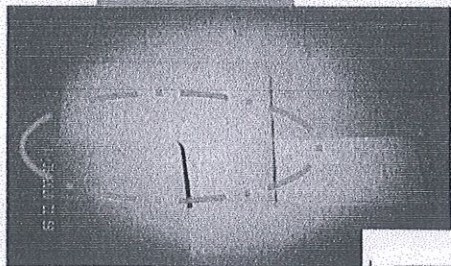
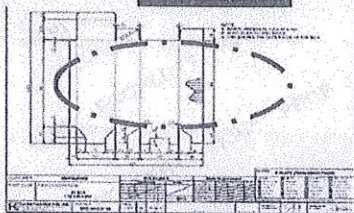
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
Telephone No. (049) 545-7166 to 69  
Fax No. (049) 545-6302

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

Control No.: 223

Date Issued: 20 06 15

Customer	MERASENKO	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	N / A	Department	PRODUCTION
Item Description	A1 BOX	Date of Detection	20 06 12
Job Order Number	WO-20-C-0119-4	Section Detected	QA - OQA

**ILLUSTRATION OF THE PROBLEM**☒ Major☐ Minor**NO GOOD****GOOD**

Lot Quantity (pcs.)

315

Reject Quantity (pcs.)

315

Reject Percentage

100.00%

Nature of Defect:

WRONG GRAIN DIRECTION

Requirement:

Grain Direction should be horizontal

Actual:

Grain Direction is vertical

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 checked="" type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input type="checkbox"/> EQOS <input checked="" type="checkbox"/> Diecut S1700 <input type="checkbox"/> Detaching	<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: 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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## INVESTIGATION REPORT FORM (IRF)

### FINAL CONCLUSION

#### OCCURRENCE ROOTCAUSE

WRONG PILE ORIENTATION OF MATERIALS  
IN DIECUT S1700 FEEDER

#### OUTFLOW ROOTCAUSE

3 ITEMS ARE COMMON IN 1 SHEET SIZE, WHY  
OPERATOR DIDN'T EXPECT THAT THE LAST AND  
3RD ITEM THEY PROCESS IS HORIZONTAL GRAIN  
DIRECTION

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	OQA	315	315	0

System

N/A

#### B. Orientation

Date	20 06 17	Time	09:05 - 09:09
Title	ORIENTATION REGARDING CORRECTIVE ACTION FOR WRONG GRAIN DIRECTION OF MERASSENKO AL BOX		
Issues	S1700 Machine Operators		

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 16

PIC: A. Vergara

#### Identified Rootcause

~ The operator did not refer on the drawing  
attached in the Job Order that resulted to  
wrong orientation of material at the feeding  
unit of the machine

#### Recommendation

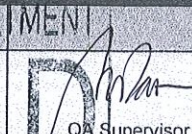
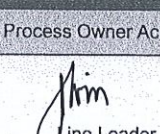

~ Put note on the back of the diecut blade that  
the item grain direction is horizontal

#### 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 17	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	CA 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	21 02 05	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. 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: <input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-Issue IRF		Approved by:  QA Supervisor		Process Owner Acknowledgment: (Receiving Section)  Line Leader	
DATE AND SIGNATURE  21 04 19		Date: 21 04 14		Date: 21 04 14	



# INVESTIGATION REPORT FOR WRONG GRAIN DIRECTION OF MERASENKO A1 BOX

<b>DIRECT CAUSE PROCESS/MATERIAL</b>	W1- Wrong pile orientation of materials in Diecut S1700 feeder.
	W4- They didn't rotate the pile of materials in feeder, because they think its common to 1st two items.
	W2- Because that time the 3items of Merasenکو are common in 1 sheet size 737 X 667 EF ( One time running in slotter using Design Sheets ).
	W3- They didn't expect that one of the 3items is horizontal grain direction, because is unusual to die-cutted boxes.

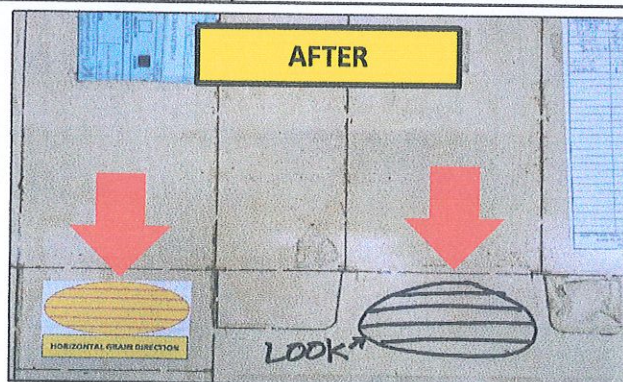
OPERATION RATIO AND CONDITION SHEET				
Date	200610	Shift	DS	
0119-1 MERASENKO C1 BOX-RMFG 312	0119-2 MERASENKO A BOX-RMFG 312	0119-4 MERASENKO A1 BOX-RMFG 312		
1800	1800	1800		
737X667 EF	737X667 EF	737X667 EF		
<input type="checkbox"/> Stripping	<input type="checkbox"/> Stripping	<input type="checkbox"/> Stripping		
MACHINE RATIO SHOW THE 3 ITEMS ARE COMMON SHEET SIZE				

<b>INDIRECT CAUSE PROCESS/MATERIAL</b>	W1- Operator proceed to mass production.
	W2- They skip to check the grain direction of this item.
	W3- Because materials are common in 3items, why they didn't expect that the last and 3rd item they process is horizontal grain direction.

## CORRECTIVE ACTION

Put remarks in diecut blade that this item is horizontal grain direction because its unusual.

PIC:	Production	TARGET DATE:	June 16, 2020 (DONE)
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Orientation to remind the operator regarding checking of actual items vs. drawing.

PIC:	Production	TARGET DATE:	June 17, 2020
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