


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

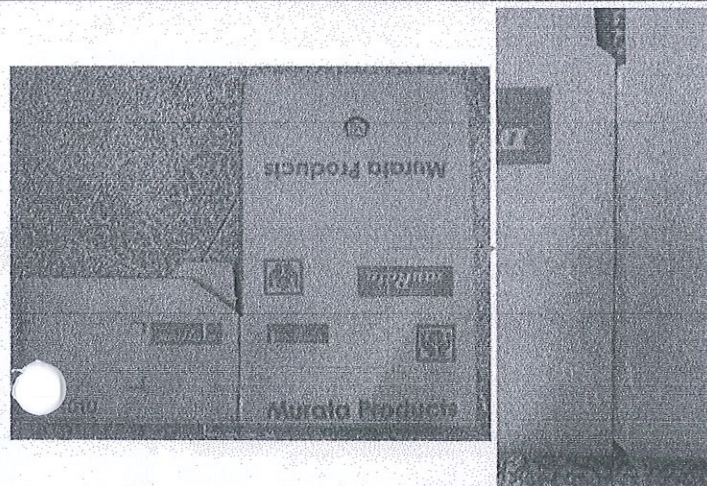
☐ Customer Claim

Control No.: 230

Date Issued: 20 06 25

Customer	EMORI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	HP33D1010	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	20 06 24
Job Order Number	WO-20-M-00748-23	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM
☐ Major

☒ Minor


Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1,500	57	3.80%

Nature of Defect:

MISALIGN GLUE

Requirement:

Bottom part of the item should be align

Actual:

The bottom part is not align

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 type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching	<input checked="" type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others: _____	<input type="checkbox"/> Material <input checked="" type="checkbox"/> Dimension <input 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 Almaria 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:	N/A	Why 1:	N/A
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:	N/A	Why 1:	N/A
	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**

- 2-3mm MISALIGN GLUE IS WITHIN TOLERANCE
- THE CREASING LINE OF LOWER FLAP IS NOT SO VISIBLE.

OUTFLOW ROOTCAUSE

- OPERATOR THINK THE 2-3mm MISALIGN IS GOOD BECAUSE WITHIN TOLERANCE.

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	QA-SCREENING	1,500	57	1,443
FG	N/A			

System	N/A	
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B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Files	N/A		

Design / Tools	N/A	
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C. Reworking

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

Process	PLS. SEE ATTACHED	
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II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 20 06 26

PIC: A. Vergara

Identified Rootcause**Recommendation**

~ The bottom creasing was not aligned because the operator aligned the creasing on the upper part (height difference is 2mm)

~ Machine transfer from S1700 to ETERNA
~ Put Nick mark as alignment reference

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 07 09	[] Yes [X] No	4m was applied waiting for next running already coordinated to PRD, MPD & Planning
2nd Verification of Action	A. Vergara	20 07 21	[X] Yes [] No	Already transferred to ETERNA & w/ creasing matrix on the steel plate
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	20 08 28	[X] Yes [] 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	Remarks	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed			
<input type="checkbox"/> Still Open			
<input type="checkbox"/> Re-Issue IRF			
CLOSED		QA Supervisor	QA Ass. Manager
Date: 21 04 14		Date: 21 04 14	Date: 21 04 14
		Line Leader	Department Head
		Date: 21 04 14	Date: 21 04 14

DATE AND
SIGNATURE

[Signature] 21 04 14

INVESTIGATION REPORT FOR MISALIGN GLUE OF EMORI HP33D1010

DIRECT CAUSE PROCESS/MATERIAL	W1- The lower flap glue tab is misalign of 2-3mm and within tolerance.
	W2- The effect of 2-3mm misalign glue in 1st gluing process is visible only during 2nd gluing process.
	W3- There is an effect to the lock of bottom part upon checking in 2nd gluing process.
	W1- The creasing line of lower flap for this item is not so visible during 1st gluing process.
	W2- Unlike to D2000 & D2200 this item have no creasing matrix in lower flap, because the process of this item is in Diecut S1700. (Consume an Hour of downtime if the items have creasing matrix in Diecut S1700 or S1400)

INDIRECT CAUSE PROCESS/MATERIAL	W1- The operator in 1st gluing process think that the 2-3mm misalign glue is good, because within tolerance.
	W2- The effect of 2-3mm misalign glue is not visible in 1st gluing process.

CORRECTIVE ACTION

1. Conduct pre-folding of lower flap during 1st gluing process to make it visible and easy to align.			
PIC:	Production	TARGET DATE:	If selected corrective action

2. Transfer the process of this item in Eterna and use separate plate for creasing matrix in lower flap.			
PIC:	Production	TARGET DATE:	If selected corrective action