

**KANEPACKAGE PHILIPPINE INC.**

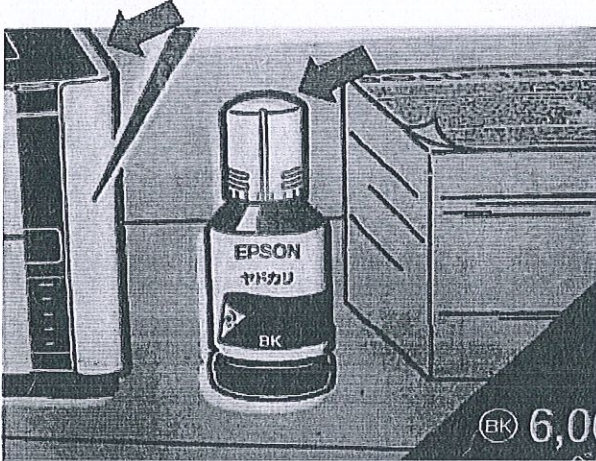
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 231

Date Issued: 20 06 29

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	5154358-00	Department	PRODUCTION
Item Description	LIONEL INDIVIDUAL BOX	Date of Detection	20 06 27
Job Order Number	WO-20-L-0039-101	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
200	127	63.50%

Nature of Defect:

OFF SHOOT

Requirement:

±1mm tolerance on the off shoot

Actual:

3mm deviation on the black printing

NO. OF OCCURRENCE☐ First
☒ Recurrence

No.: 2nd

Date: 20 06 29

DISPOSITION☐ Hold
☐ Special Acceptance
☐ For Rework
☒ Reject / Disposal**AREA OF OCCURRENCE / ORIGIN**☐ Slotter
☒ EQOS
☐ Diecut
☐ Detaching
☐ Gluing
☐ Vertical
☐ Others:**CONTENT**☐ Material
☐ Dimension
☒ Appearance
☐ Process / Method

Issued by

Adrian Vergara
QA-IE Staff

Checked by

QA Supervisor

Approved by

Mr. Rexel Almario
QA Asst. Manager

Received by

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: Why 4: Why 5:	N/A	Why 1: Why 2: Why 3: Why 4: Why 5:	N/A
Design / Toolings	Why 1: Why 2: Why 3: Why 4: Why 5:	N/A	Why 1: Why 2: Why 3: Why 4: Why 5:	N/A
Process / Material	Why 1: Why 2: Why 3: Why 4: Why 5:	PLS. SEE ATTACHED	Why 1: Why 2: Why 3: Why 4: Why 5:	PLS. SEE ATTACHED

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

- DUE TO INHERENT PRINT MOVEMENT
IN EQOS.

- OCCURRENCE IS RANDOMLY

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	N/A			

System	N/A	
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B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Indees	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 07 01

PIC: A. Vergara

Identified Rootcause**Recommendation**

~ The black print is not matching on the location of white solid print, because there was a lateral and registration movement both white & black print. This deviation is inherent in the printing machine ranging from 1mm ~ 2mm

~ Mounting of additional rubber die as shooting 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 01	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	CA is implemented (For checking of effectiveness)
2nd Verification of Action	A. Vergara	20 07 04	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation is implemented
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	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

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	<input type="checkbox"/> Still Open	<input type="checkbox"/> Re-issued			
CLOSED		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
Date: 21 01 11		Date: 21 01 11	Date: 21 01 11	Date: 21 01 11	Date: 21 01 11

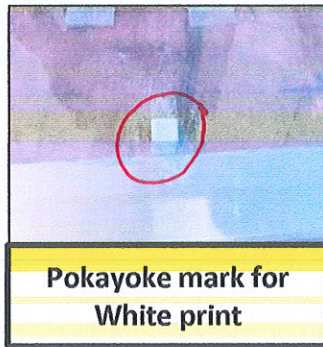
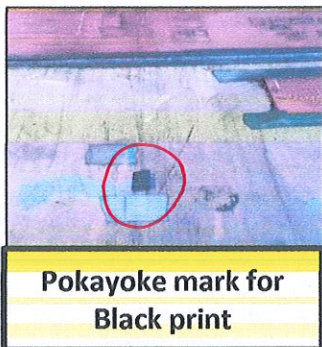
DATE AND
SIGNATURE

[Signature] 21 01 09

INVESTIGATION REPORT FOR OFF SHOOT OF 5154358-00 LIONEL INDIVIDUAL BOX.

DIRECT CAUSE PROCESS/MATERIAL	W1- Off shoot occurs due to inherent printing movement in Eqos.
	W2- Item have shooting print (Black & White) and two pass process in Eqos why this item is prone in off shoot.
	W3- Operator cant control the inherent print movement in 1st printing and 2nd printing process.

REMARKS	According to operator even there is pokayoke mark (suteban) it is not the solution to off shoot. They know that pokayoke mark is for easy visual checking purpose but the problem is, once they trap 1pc off shoot during mass production the occurrence are almost 30-40pcs due to machine speed. Also they try to reduce the minimum of 120bpm speed to 93bpm speed but still off shoot occurrence is remain.
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C-	D-	E-
0039101		0039-101
EPSON		EPSON
515435800		515435800
A 230		B 237
Black		White
93 skip		93 skip
8580920		8580920
CBF		CBF
<input type="checkbox"/> IPD <input type="checkbox"/> Sample		<input type="checkbox"/> IPD <input type="checkbox"/> Sample
<input type="checkbox"/> Overhang Only		<input type="checkbox"/> Overhang Only

Machine ratio with 93bpm/skip on mode

INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator proceed to mass production.
	W2 - Trial run approved by QA Patrol.
	W3 - Off shoot occurrence is randomly. (There is listed reject in Job Order trap by Eqos operator)

CORRECTIVE ACTION

Any proposal improvement from 3pm team.			
PIC:	3pm Team	TARGET DATE:	
100% checking of WIP after Eqos process to segregate the effected of Off shoot. This corrective action is to prevent the joining during Manual Gluing process of Good part and Reject part due to off shoot.			
PIC:	QA	TARGET DATE:	If approve