


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

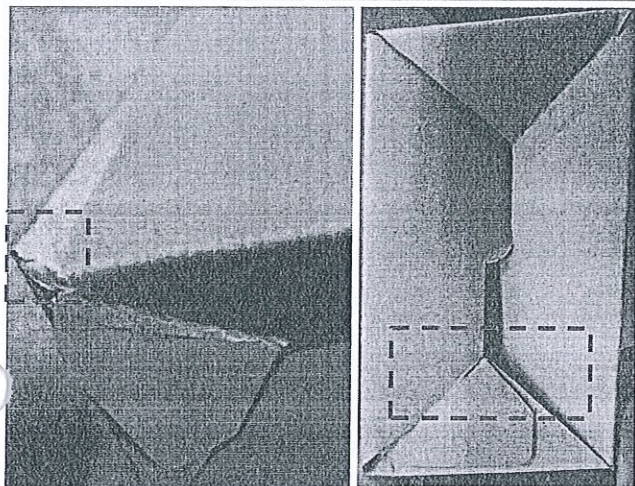
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 235

Date Issued: 20 07 01

Customer	EMORI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	HP01D0030	Department	PRODUCTION
Item Description	BOX CASE	Date of Detection	20 06 30
Job Order Number	WO-SO-IPD-1130-1	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM

☐ Major ☒ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
216	90	41.67%

Nature of Defect:

MISALIGN GLUE

Requirement:

Misalign glue on the bottom should up to +3mm

Actual:

Misalign on the bottom is -3mm

NO. OF OCCURRENCE		DISPOSITION		AREA OF OCCURRENCE / ORIGIN		CONTENT	
<input checked="" type="checkbox"/> First		<input type="checkbox"/> Hold		<input type="checkbox"/> Slotter	<input checked="" type="checkbox"/> Gluing	<input type="checkbox"/> Material	
<input type="checkbox"/> Recurrence		<input type="checkbox"/> Special Acceptance		<input type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input checked="" type="checkbox"/> Dimension	
No.: _____		<input type="checkbox"/> For Rework		<input type="checkbox"/> Diecut	<input type="checkbox"/> Others: _____	<input type="checkbox"/> Appearance	
Date: _____		<input checked="" type="checkbox"/> Reject / Disposal		<input type="checkbox"/> Detaching		<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:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	PLS. SEE ATTACHED	Why 3:	PLS. SEE ATTACHED
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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

- DUE TO MISALIGN FOLDING OF
PERFORATION AT LOWER FLAP

- NOT VISIBLE DURING FEEDING
OF ITEM IN CONVEYOR-3.

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- IN LINE	216	90	126
FG	N/A			

System

N/A

B. Orientation

Date		Time	
Title			
Ideas			

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 07 02

PIC: A. Vergara

Identified Rootcause

Recommendation

~ Misalign glue occurs due to the folding line
was not align on the perforation line because
its flap folding is outwards

~ Conduct pre-folding on the bottom flap prior
gluing process

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 08	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Pre-folding was conducted last 20 07 08
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 26	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	CA. 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

Signature:	Approved by:	Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	<input type="checkbox"/> Still Open	<input type="checkbox"/> Issue IRF	
CLOSED	QA Supervisor	QA Asst. Manager	Line Leader
Date: 21 04 14	Date: 21 04 14	Date: 21 04 14	Date: 21 04 14

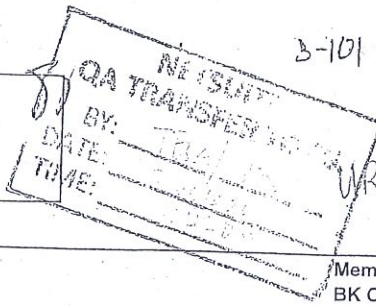
DATE AND
SIGNATURE

21 04 14

KANEPACKAGE PHILIPPINE, INC.

3-101-146

SO No.: Sales Order #SO-IPD-1130
 JO No.: WO-SO-IPD-1130-1
 ISSUED BY: Jecille Tuiza
 DATE ISSUED: 29-JUNE-2020
 CUSTOMER: EMORI PHILS.



Light Industry Science Park II,
 National Highway, Calamba, 4027 Laguna
 Tel: (049) 545 7166/67
 Fax: (049) 544-0010

Item Description: hp01d0030 BOX CASE WITH PRINT
 Quantity: 200 Piece
 Delivery Date: 30-JUNE-2020

Memo :
 BK Code : hp01d0030
 Blades :

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
720X640 BF TX200 0	110	0	0	0pcs 110	353703	EMORI PHILS		EMORI PHILS

PROCESS	Finished		GOOD QTY	REJECT QTY		OPERATOR	Remarks
	Date	Time		Trial run	In-house		
1. EQOS	6/30		108	4	2	PJAN	OK
2. DIECUT S1700	6/30		108	1	-	David/Thiele	
3. DETACH	6/30		216	1	0		
4. CONVEYOR 1	6/30		216	1	-	VJ WARD DEXTER	
5. CONVEYOR 3	6/30		216	1	-	POPE ANGELO REGINE	
6. LOT NUMBERING	6/30		200			(Lem) DARREL	
7. SCREENING	6/30						
8. QA BUNDLE	6/30		130			Paul / Darrel	Balanced

REJECTION HISTORY

1.		EMORI PHILIPPINES INC.	
2.		Item Code	QUANTITY
3.		HP01D0030	10 pcs.
4.		Item Description	Supplier's QC
5.		BOX CASE W/ PRINT	PASSED
		INSPECTION	
		RoHS OK	
		QA-CG590	
		KANEPACKAGE PHILIPPINES INC.	

JO Received By (WHSE):

Signature over printed name/Date/Time

JO Returned to (QA):

Signature over printed name/Date/Time

PR-007-F07

INVESTIGATION REPORT FOR MISALIGN PRINT OF EMORI HP01D0030 BOX CASE

DIRECT CAUSE <small>PROCESS/MATERIAL</small>	W1- Misalign Glue occurs during 2nd gluing in Coveyor-3
	W2- According to investigation the expected fold in Perforation at lower flap become misalign during 2nd process gluing, like what happen before in D2000.
	W3- Due to misalign folding in lower flap the function of lock will be affected.

INDIRECT CAUSE <small>PROCESS/MATERIAL</small>	W1- The misalign glue is not visible during feeding of this item in Conveyor-3.
	W2- Problem notice after feeding in conveyor-3 (Item already glued)
	W3 - Occurrence is randomly and after feeding of item in Conveyor-3 there is Online QA who detected the problem.

CORRECTIVE ACTION

<p>Due to small quantity plan of this item, the recommendation is to conduct reverse pre-folding of lower flap in Conveyor-3.</p> <p>Unlike to Emori D2000 that always big quantity our counter measure is the reverse creasing matrix in lower flap.</p>			
PIC:	Production	TARGET DATE:	200703 (Orientation)