

**KANEPACKAGE PHILIPPINE INC.**

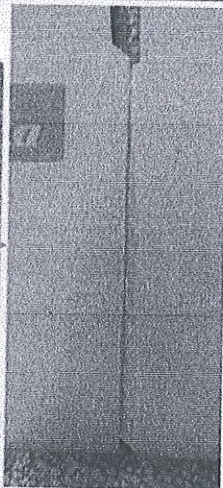
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
Telephone No. (049) 545-7166 to 69  
Fax No. (049) 545-6302

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

Control No.: 240

Date Issued: 20 07 08

Customer	EMORI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	HP33D1010	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	20 07 07
Job Order Number	WO-DRS-20-M-00887-6	Section Detected	QA - IN LINE

**ILLUSTRATION OF THE PROBLEM**☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
986	132	13.39%

**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 type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 2 Date: 20 07 08	<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  Adrian Vergara QA-IE Staff	Checked by  QA Supervisor	Approved by  Mr. Rexel Almario QA Asst. Manager	Received by (Receiving Section)  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**

- THE LOWER FLAP CREASING IS NOT SO VISIBLE DURING 1ST GLUING PROCESS.
- POSSIBLE OF SMALL MOVEMENT DURING FEEDING IN CONVEYOR 1.

**OUTFLOW ROOTCAUSE**

- 2-3mm MISALIGN GWE IS WITHIN TOLERANCE DIMENSION AND NOT VISIBLE THE EFFECT DURING 1ST PROCESS.

**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**

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	N/A			

Actions to be done to eliminate recurrence

Who / When

System

N/A

**B. Orientation**

Date	N/A	Time	N/A
Title	N/A		
Attendees	N/A		

Design / Tools

N/A

**C. Working**

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 09

PIC: A. Vergara

Identified Rootcause

Recommendation

~Wrong alignment reference on the item prior feeding on the gluing conveyor

~Transfer the item to ETERNA machine & provide steel plate for the creasing matrix

**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 Application submitted to M.E. last 20 07 09
2nd Verification of Action	A. Vergara	20 07 23	[x] Yes [ ] No	C.A. is implemented
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	QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	<b>CLOSED</b>					
<input type="checkbox"/> Still Open			QA Supervisor		Line Leader	
<input type="checkbox"/> Re-Issue IRF			QA Asst. Manager		Department Head	
			Date: 21 01 11		Date: 21 01 11	
DATE AND SIGNATURE		21 01 09				



# INVESTIGATION REPORT FOR MISALIGN GLUE OF EMORI HP33D1010 CARTON BOX

<b>DIRECT CAUSE</b> 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- This batch is already pre-fold the lower flap during process as compliance to corrective action on last occurrence, but still there is occurrence of misalign glue.
	W2- Possible that there is small movement during feeding of item in conveyor 1.

<b>INDIRECT CAUSE</b> PROCESS/MATERIAL	W1- The 2-3mm misalign glue in 1st gluing is good based on drawing because within tolerance.
	W2- The effect of 2-3mm misalign glue is not visible in 1st gluing process.

<b>CUSTOMER :</b> EMORI			
<b>ITEM DESCRIPTION/PART CODE:</b> HP33D1010 BOX CASE WITH PRINT		<b>TOLERANCE</b>	
<b>MATERIAL:</b> B FLUTE (TX200/CM125/TX200)		<b>DIMENSION: +/- 3</b>	<b>PRINT:</b>
		>= 50	+/- 1
		51~200	+/- 2
		201~400	+/- 3
		401~700	+/- 4
		701~1000	+/- 5
		1000<	+/- 8
 <b>KANEPACKAGE PHIL. INC.</b> <small>48 Ring Rd. USP 2 Bldg. Lantosa Caramba, Laguna Tel. Nos. (042) 545-7168 to 69 Fax Nos. (042) 545-7170 / (042) 545-6302</small>		<b>ITEM KEY :</b> EMO-0001-01AB-02	<b>PAGE :</b> 1-2 <b>02</b> <small>REV. #</small> <b>18/02/20</b> <small>DATE</small>

## CORRECTIVE ACTION


For temporary immediate action we continues the pre-folding of lower flap during 1st gluing process to make the creasing visible and easy to align,

<b>PIC:</b>	Production	<b>TARGET DATE:</b>	Done but not 100% effective
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Transfer the process of this item in Eterna and use separate plate for creasing matrix in lower flap.

<b>PIC:</b>	MPD & Production	<b>TARGET DATE:</b>	Next Running if possible
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PREPARED BY:

  
GERALD DE GUZMAN  
PROD ASST. SUPERVISOR

APPROVED BY:

  
WHENA V. APALLA  
SR. SUPERVISOR