

**KANEPACKAGE PHILIPPINE INC.**

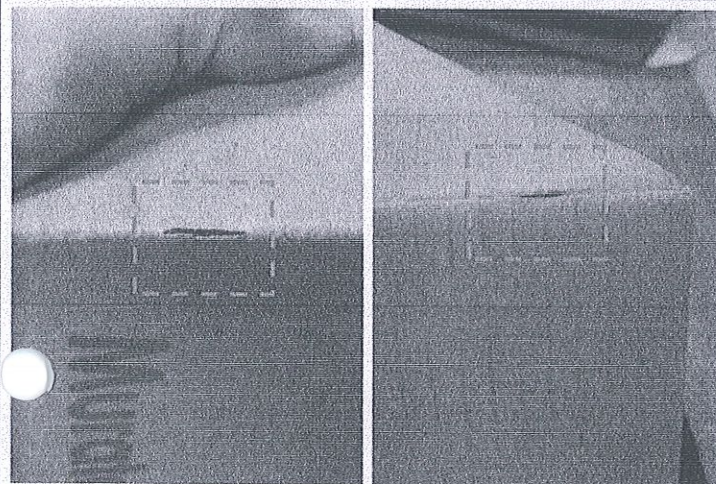
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 249

Date Issued: 20 07 16

Customer	EMORI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	HP01D2000	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	20 07 16
Job Order Number	WO-DRS-20-M-00887-30	Section Detected	PRD - ETERNA

ILLUSTRATION OF THE PROBLEM

<input checked="" type="checkbox"/> Major	<input type="checkbox"/> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
3,000	176	5.87%

Nature of Defect:

BURSTING

Requirement:

Bursting should not be visible and should not penetrate on the other side

Actual:

Bursting occurs on 1 portion only and visible from rough surface to smooth surface

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: <u>2</u> 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 checked="" type="checkbox"/> Diecut: ETERNA <input type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others: _____	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input checked="" 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
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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**

- CREASING MATRIX ACCIDENTALLY
DETACHED AND MOVED THAT CAUSED BURSTING

OUTFLOW ROOTCAUSE

- BURSTING PROBLEM OCCURS IN THE
MIDDLE OF MASS PRODUCTION

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

B. Orientation

Date	Time	
N/A	N/A	
Title	N/A	
Issues	N/A	

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 20

PIC: A. Vergara

Identified Rootcause**Recommendation**

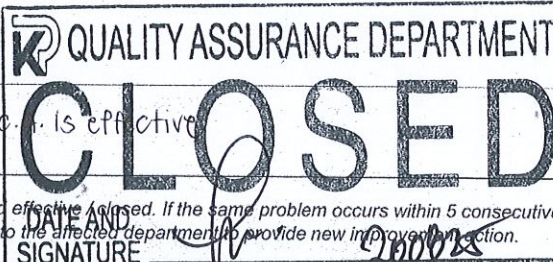
The creasing matrix attached on the steel plate was detached because the fibers accumulate on the steel plate

Replacement of creasing matrix on the steel plate

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 20	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. 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	20 08 08	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is effective

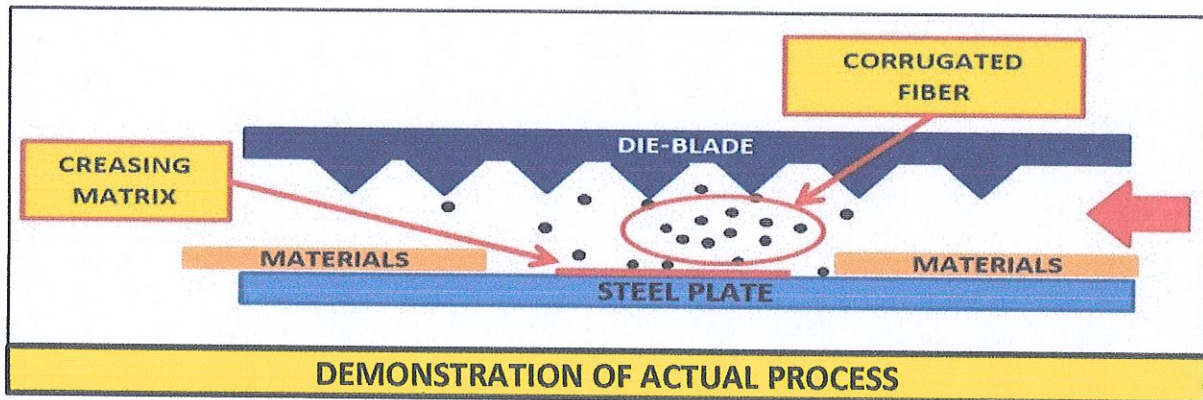
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improved 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	NO occurrence of Bursting	QA Supervisor Date: 20 08 25	IRISH MAY L. ESTAREJA Line Leader Date: 200825 Department Head Date: 200825

INVESTIGATION REPORT FOR BURSTING OF EMORI HP01D2000 CARTON BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- The creasing matrix in the lower flap accidentally detached and moved that caused bursting.
	W2- Naturally there is corrugated fiber came from the cutting portion of this item. The corrugated fiber accumulate in the Steel Plate where the creasing matrix attached and because of that, possible that the adhesive of creasing matrix become weak and at the same time the materials always hit the creasing matrix during process why it was detached and moved.




INDIRECT CAUSE PROCESS/MATERIAL	W1- Bursting problem occurs in the middle of mass production and when operator notice the bursting they immediate report the abnormality happened to Production Leader in-charge.
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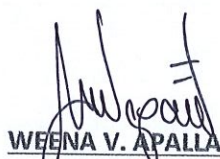
CORRECTIVE ACTION

Immediate replace the Detach creasing matrix and check the condition of other creasing matrix attached in the Steel Plate.			
PIC:	PRODUCTION	TARGET DATE:	200715
Sort the items and separate the affected of bursting.			
PIC:	PRODUCTION	TARGET DATE:	200715

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
 SR. SUPERVISOR