

**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.: 252

Date Issued: 20 07 20

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	5154377-01	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	20 07 17
Job Order Number	WO-DRS-20-L-0055-86	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

1,806

32

1.77%

Nature of Defect:

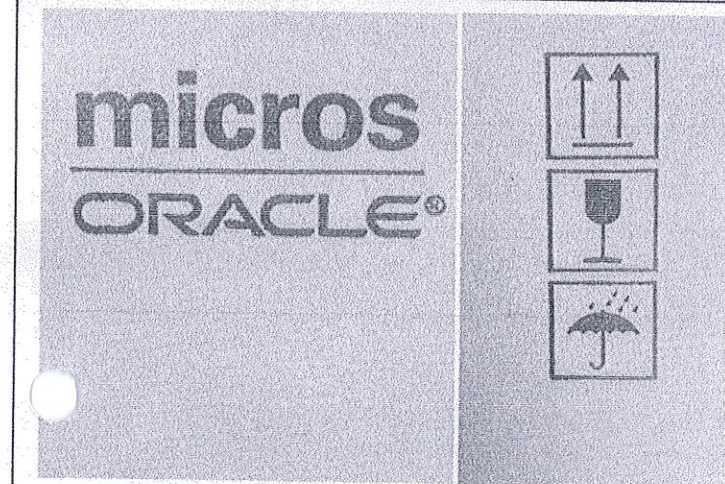
POOR PRINT

Requirement:

Line marks on the texts and images should not be visible

Actual:

Line marks on the texts and images is visible

**NO. OF OCCURRENCE****DISPOSITION****AREA OF OCCURRENCE / ORIGIN****CONTENT**☒ First☐ Hold☐ Slotter☐ Gluing☐ Material☐ Recurrence☐ Special Acceptance☒ EQOS☐ Vertical☐ Dimension

No.: _____

☐ For Rework☐ Diecut☐ Others: _____☒ Appearance

Date: _____

☒ Reject / Disposal☐ Detaching☐ Process / Method

Issued by

Checked by

Approved by

Received by
(Receiving Section)
Adrian Vergara
QA-IE Staff

QA Supervisor

Mr. Rexel Almario
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**

- INK NOT PENETRATE WELL IN THE CYREL BECAUSE FROM SKIP ON MODE THEY SWITCH TO SKIP-OFF BECAUSE THERE ARE OCCURRENCE OF BLOTTED PRINT.

OUTFLOW ROOTCAUSE

- OPERATOR THINK THAT THE AFFECTED OF POOR PRINT IS REWORKABLE OR ACCEPTED.

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	20 07 23	Time	11:00 ~ 11:05 H
Title	ORIENTATION REGARDING POOR PRINT OF EPSON 10P 8154377-01 INDIVIDUAL BOX		
tees	EQDS OPERATORS		

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 21

PIC: A. Vergara

Identified Rootcause

~ Poor application of ink on the substrate because because the operator change the mode of printing from skip-on to skip-off (due to blotted print)

Recommendation

~ Once blotted print encountered, do not change the setup mode instead stop the machine & clean the rubber die

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 23	<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 10 07	<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.

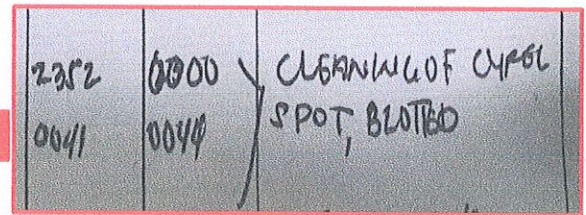
IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> QUALITY ASSURANCE DEPARTMENT			
CLOSED			
DATE AND SIGNATURE	DATE	DATE	DATE
21 04 14	21 04 14	21 04 14	21 04 14

INVESTIGATION REPORT FOR POOR PRINT OF EPSON IJP 5154377-01 INDIVIDUAL BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- Ink not penetrate well in cyrel.
	W2- Operator encountered blotted print during mass production why they try the Skip-off mode.
	W3- Due to machine speed of 122bpm, the split second they try the Skip-Off mode there are few occurrence of poor print.

OPERATION RATIO AND CONDITION SHEET



EPSON	5154377-01	CF	HP	BLK	9	6.5	0.8	SKIP
COND	CALL 10/30/2007	CE	NON	BLK	2	1.4	1.0	PRINT

No abnormality found in Setup

Actual Anilox Impression 6.5mm (requirement 6.5 ± 0.2 mm)

Actual Printing Impression 1.4mm (Requirement 2 ± 1 mm)

**Machine Ratio show Skip-on mode and
downtime due to blotted print**

INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator think that the affected of poor print is reworkable or accepted.
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CORRECTIVE ACTION

Operator immediate back the machine setting in Skip-On mode and stop the machine to clean the cyrel.

PIC:	PRODUCTION	TARGET DATE:	200716
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Orient the operator regarding this problem. Once they encounter blotted print do not change the machine settings, try first to clean the cyrel.

PIC:	PRODUCTION	TARGET DATE:	200723
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PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR

200721