


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

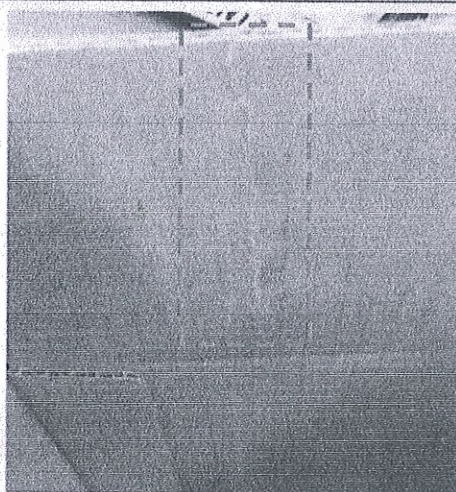
☐ Customer Claim

Control No.: 254

Date Issued: 20 07 23

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	5150864-01	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	20 07 22
Job Order Number	WO-DRS-20-L-0055-44	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM
☒ Major

☐ Minor


Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

2,982

71

2.38%

Nature of Defect:

BURSTING

Requirement:

No occurrence of bursting on the item

Actual:

Occurrence of bursting inside the box

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ 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 <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	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:		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**

THE CORRUGATED TRIMMING DID NOT EJECT
OR STUCK UP IN THE FEEDER STRIPPER.

OUTFLOW ROOTCAUSE

OPERATOR DIDN'T NOTICE THE BURSTING
BECAUSE ONLY SAMPLING ARE REQUIRED AFTER
THE QA PATROL APPROVED THE TRIAL RUN.

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		
Asses	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 27

PIC: A. Vergara

Identified Rootcause

occurrence of additional pressure from the
stripper of the item, because the scrap was
stuck on the stripper

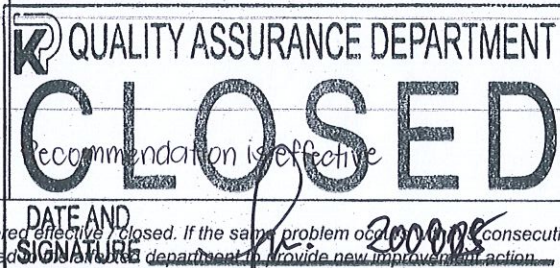
Recommendation

Monitor the stripper, if the scrap stuck on the strip-
per the operator should stop the machine to remove
the scrap

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 30	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation 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	Recommendation is effective

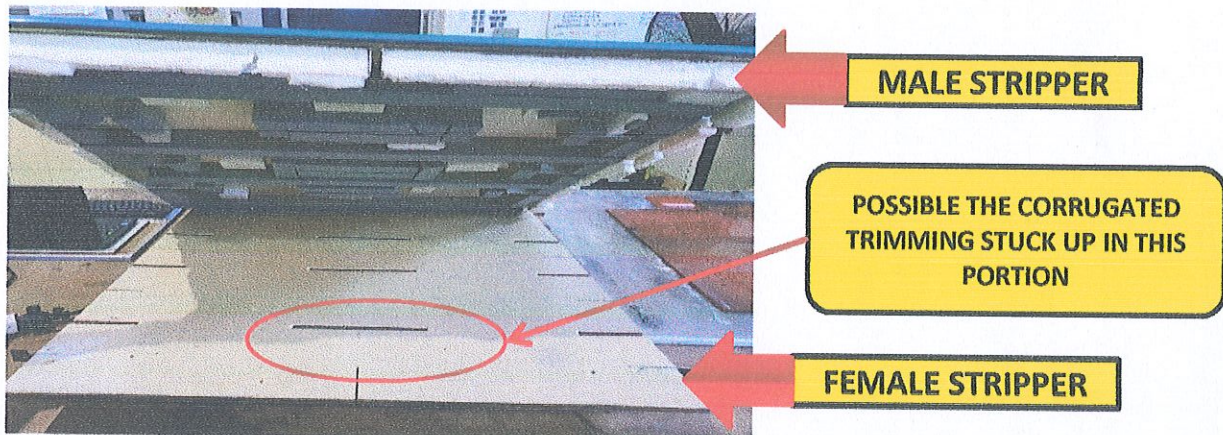
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs for 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the relevant department to provide new improvement 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: 20 08 25 Department Head Date: 20 08 25

INVESTIGATION REPORT FOR BURSTING OF EPSON IJP 5150864-01 INDIVIDUAL BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- Possible that there is corrugated trimming did not eject or stuck up in the female stripper.
	W2- Due to corrugated trimming stuck up in the female stripper and the pressure during impression of male stripper to female stripper, the effect of this in the items is bursting.
	W1- Another factor that there is bursting in raw materials before the process.



INDIRECT CAUSE PROCESS/MATERIAL	W1 - Operator did not notice the bursting, because only sampling are required after the QA patrol approved the trial run.
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CORRECTIVE ACTION

Ask for the advice of ME if there is possible improvement in stripper blade, because operator notice that this stripper blade is prone in stuck up of corrugated trimming.

PIC:	PRODUCTION & ME	TARGET DATE:	200729
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PREPARED BY:

[Signature]
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature] #200724
WEENA V. APALLA
SR. SUPERVISOR