


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

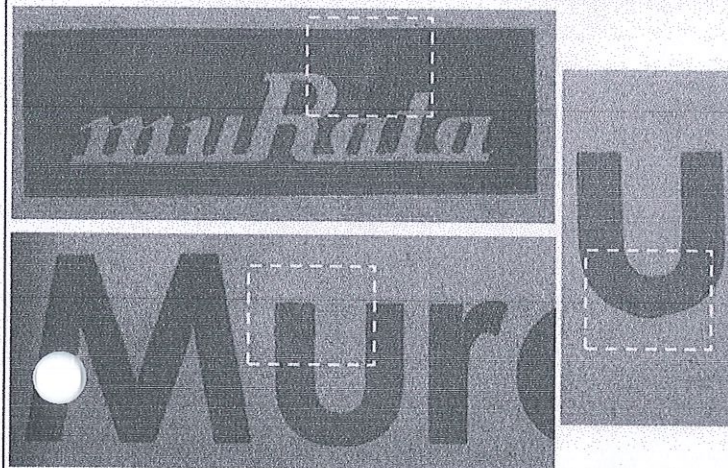
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 257

Date Issued: 20 07 28

Customer	EMORI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	HP01D2200C	Department	PRODUCTION
Item Description	CARTON BOX W/ PRINT	Date of Detection	20 07 27
Job Order Number	WO-DRS-20-M-00887-47A	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM


<input type="checkbox"/>	Major	<input checked="" type="checkbox"/>	Minor
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage	
1000	42	4.2 %	
Nature of Defect:			
SPOT			
Requirement:			
No spot on the Item logo or it should be reworkable			
Actual:			
Spot is visible even after reworked			

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.: _____	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input checked="" 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	Ms. Ngemi Cepeda 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 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 ATTACH	Why 1: Why 2: Why 3: Why 4: Why 5:	PLS. SEE ATTACH

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

CORRUPTED FIBER FROM BOARD STICK IN THE CYREL THAT CAUSED SPOT IN THE PRINT

OUTFLOW ROOTCAUSE

ONCE THEY ENCOUNTER SPOT THEY IMMEDIATELY CLEAN THE CYREL, BUT STILL DUE TO MACHINE SPEED BEFORE THE MACHINE STOP THERE'S A LOT OF AFFECTED.

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 30	Time	12:10 ~ 12:20
Title	ORIENTATION REGARDING SPOT OF EMORI HP0102200 CARTON BOX		
Assignees	E305 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 30**PIC:** A. Vergara**Identified Rootcause**

Incomplete ink transfer from rubber die to materials because the fibers stuck on the rubber die since the materials contain fibers

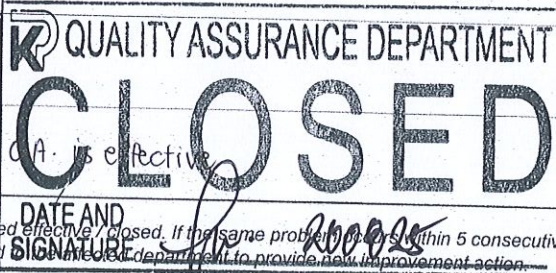
Recommendation

Tap the materials prior feeding on the machine.
Cleaning of rubber die immediately once the defect found.

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	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 19	<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 concerned 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 spot	<div>QA Supervisor</div> <div>QA Asst. Manager</div> <div>Date: 20 08 25</div>	<div>IRISH MAY L. ESTAREJA</div> <div>Line Leader</div> <div>Date: 20 08 25</div> <div>Department Head</div> <div>Date: 20 08 25</div>

INVESTIGATION REPORT FOR SPOT OF EMORI HP01D2200C CARTON BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- Some portion of corrugated board didn't fill by ink.
	W2- There are some corrugated fiber in corrugated board.
	W3- Corrugated fiber from the board stick in the cyrel that caused spot in the print.

INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator conduct fast browsing & tapping but not 100% removed all corrugated fiber from the corrugated board.
	W2- Once they encounter spot they immediate clean the cyrel, but still before the machine stop there's a lot of affected due to machine speed of 145bpm that time with Skip On mode

CORRECTIVE ACTION

Orient & aware the Eqos operator regarding this issue and to continue the fast browsing and tapping before feeding of corrugated board in Eqos.			
PIC:	PRODUCTION	TARGET DATE:	200730

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
 SR. SUPERVISOR