

2808 CANCEL


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

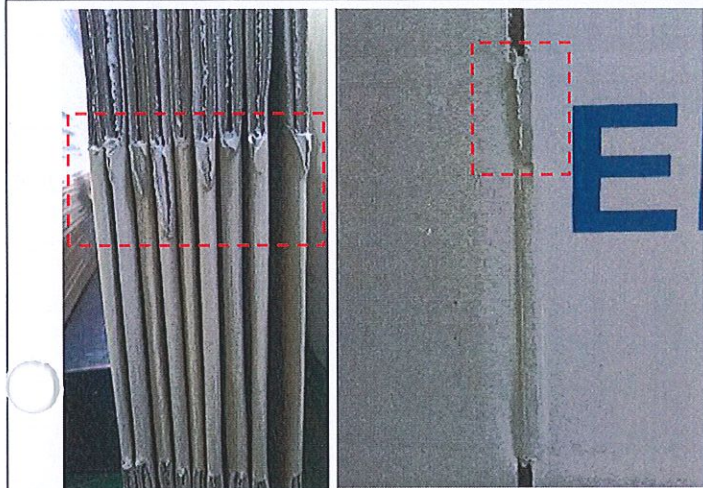
☐ Customer Claim

Control No.: 260

Date Issued: 20 08 03

Customer	EPSON TP	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	5116596-00	Department	PRODUCTION
Item Description	OUTER CARTON BOX	Date of Detection	20 07 29
Job Order Number	WO-20-M-01009-31	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM
☐ Major

☒ Minor


Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
360	39	10.83%

Nature of Defect:

BURSTING

Requirement:

No Bursting on the smooth surface of the item

Actual:

W/ Bursting on the smooth surface

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
☐ First ☒ Recurrence No.: 2 Date: 20 07 29	☐ Hold ☐ Special Acceptance ☐ For Rework ☒ Reject / Disposal	☐ Slotter ☒ EQOS ☐ Diecut ☐ Detaching ☐ Gluing ☐ Vertical ☐ Others:	☐ Material ☐ Dimension ☒ Appearance ☐ Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
 Adrian Vergara QA-IE Staff	 Ms. Noemi 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:	Why 1: Why 2: Why 3: Why 4: Why 5:
Design / Toolings	Why 1: Why 2: Why 3: Why 4: Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:
Process / Material	Why 1: MATERIALS PROBLEM POSSIBLE DUE TO Why 2: BRITTLE, BECAUSE WE DIDN'T Why 3: FIND ANY POSSIBLE FACTOR Why 4: IN PRODUCTION PROCESS Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:

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

MATERIALS PROBLEM

N/A

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					System	N/A	
WIP							
FG							

B. Orientation

Date		Time		Design / Tools	N/A	
Title						
Ideas						

C. Reworking

Rework Quantity		Process	N/A	
Total Good				
Rework Percentage (Good)				

II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: _____ PIC: _____

Identified Rootcause

Recommendation

III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action			[] Yes [] No	
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action			[] Yes [] No	

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

Starts	Remarks	Approved by:	Process Owner Acknowledgment: (Receiving Section)	
☒ Closed				
☐ Still Open				
☐ Re-Issue IRF				

DATE AND SIGNATURE

20109

KANEPACKAGE PHILIPPINE, INC.

SO No. : Sales Order #SO-20-M-01009
 JO No. : WO-20-M-01009-31
 ISSUED BY : Nene Villanueva
 DATE ISSUED : 16-JULY-2020
 CUSTOMER : EPSON PRECISION PHILS. INC.- ASP/EPLB

THOMAS SUITE
 BY: LUM/160
 DATE: 200729
 TIME: 0901



Light Industry Science Park II,
 National Highway, Calamba, 4027 Laguna
 Tel: (049) 545 7166/67
 Fax: (049) 544-0010

Item Description: 511659600 OUTER CARTON BOX
 Quantity: 750 Piece
 Delivery Date: 29-JULY-2020
 Memo : PHEAD F3 PD RECEIVING
 BK Code : 511659600
 Blades :

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
703 x 2412 CF w/CREASING FOR 5116596-00 OCB 0	760	0	0	0pcs 760	255721	SP		Shanny 7/28

PROCESS	Finished Date	Time	GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
					In-house	Supplier		
1. BQOS anan. Jr 200728	7/29		760	2			OVCTH	
2. SEMI AUTO GLUING	7/29	9:54	400 130 230	2			JAYSON Gino/Ana Bay AMREL/GINO	
3. LOT NUMBERING	7/29		320 390				Jay/Drive KIM/THOM	
4. SCREENING	7/29		390 310		10		THOM & JEX RAPH/GERALD/DAWE	
5. QA BUNDLE								

REJECTION HISTORY

1. (A). Occurrence Date: 11/19/2019, (B). Problem: BURSTING, (C). NG Quantity: 28 PCS., (D) Rootcause: The materials used are brittle (During folding bursting starts to occur)

- 2.
- 3.
- 4.
- 5.

NOTES

1. Recondition the materials prior gluing of the item
2. 400 transferred to QA by Judy 7/29
- 3.
- 4.
- 5.

NO MATS 7/20

0706H

ELMEN

PRODUCTION OUT
 BY: ene
 DATE: 200729
 THOMAS SUITE

PR-001-F07 REV.00

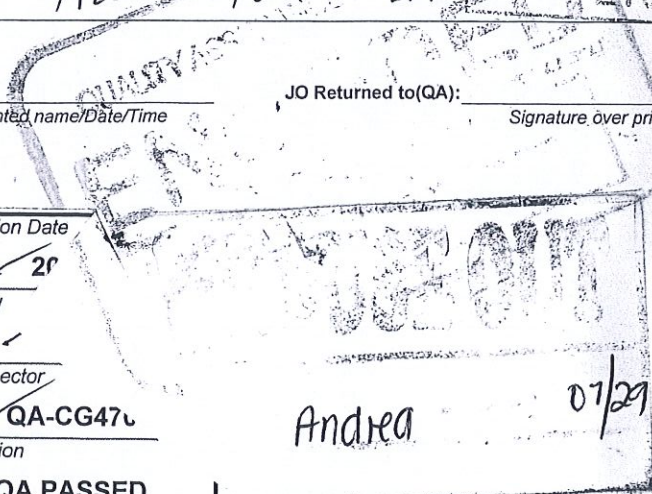
JO Received By(WHSE):

Signature over printed name/Date/Time

JO Returned to(QA):

Signature over printed name/Date/Time

Part Code REV. 04
 Inspection Date 29
 Quantity
 Description 200729
 OUTER CARTON BOX
 QA Inspector QA-CG476
 Job Order Number
 Disposition
 QA PASSED
 MP RoHS OK
 KANEPACKAGE PHILIPPINES INC.



Andrea

07/29

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