



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.: 261

Date Issued: 20 08 04

| | | | |
|------------------|------------------|-------------------|----------------------|
| Customer | EPSON IJP | Attention To | Mr. Gerald De Guzman |
| Item Code | 5150864-01 | Department | PRODUCTION |
| Item Description | INDIVIDUAL BOX | Date of Detection | 20 07 29 |
| Job Order Number | WO-20-L-0055-114 | Section Detected | QA - IN LINE |

ILLUSTRATION OF THE PROBLEM

☐ Major

☒ Minor

| Lot Quantity (pcs.) | Reject Quantity (pcs.) | Reject Percentage |
|---------------------|------------------------|-------------------|
| 4,420 | 118 | 2.67% |

Nature of Defect:

CLOSE GAP

Requirement:

±3mm slot width and no glue tab overlapping

Actual:

Glue tab is overlapping and slot gap is <3mm

| 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 type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input checked="" type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others: _____ | <input type="checkbox"/> Material <input checked="" type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input type="checkbox"/> Process / Method |

| | | | |
|------------------------------------------------|----------------------------------------------------|----------------------------------------------------------|------------------------------------------------------------------------------------|
| Issued by Adrian Vergara QA-IE Staff | Checked by Ms. Nemi Cepeda QA Supervisor | Approved by Mr. Rexel Almario QA Asst. Manager | Received by (Receiving Section) Mr. Gerald De Guzman 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 ATTACHED | Why 1: Why 2: Why 3: Why 4: Why 5: PLS. SEE ATTACHED |

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FINAL CONCLUSION

OCCURRENCE ROOTCAUSE

THE CREASING LINE DIDN'T HIT THE CENTER OF GRAIN DIRECTION

OUTFLOW ROOTCAUSE

OPERATOR IN STACKER DID NOT NOTICE THE WIDE GAP, BECAUSE HE ONLY ONE FOR TWO MACHINE.

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 08 06 | Time | 15:11 ~ 15:16 |
| Title | ORIENTATION REGARDING CLOSE GAP OF PERSON INP 8100864-DI INDIVIDUAL BOX | | |
| Attendees | SEMI-AUTO GLUING 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 08 06 PIC: A. Vergara

Identified Rootcause

Recommendation

> The creasing line was not fell on the m in between of the tip of the corrugated medium, instead it was fell near on the tip of the cm.
> The gluing operator did not pre-fold the item properly



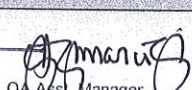
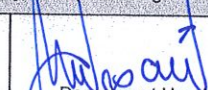
> Allocate another 1 manpower on the machine to correct the glue tab of the item

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

| | Checked by | Date | Implemented? | Remarks |
|----------------------------|------------|----------|---------------------------------------------------------------------|---------------------|
| 1st Verification of Action | A. Vergara | 20 08 06 | <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 27 | <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

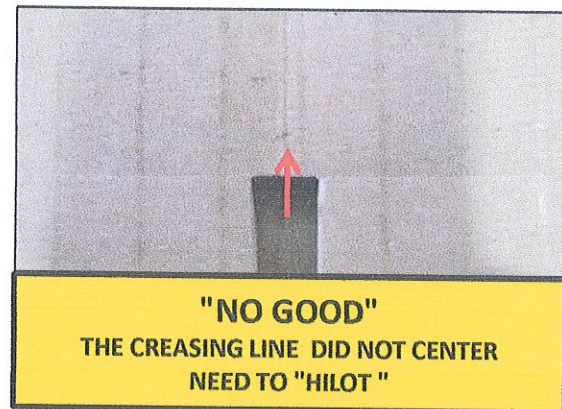
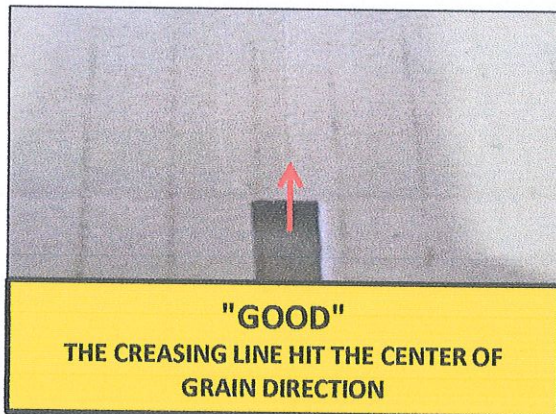
| Status | Remarks | Approved by: | Process Owner Acknowledgment: (Receiving Section) |
|--------------------------------------------|------------------------------|--------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| <input checked="" type="checkbox"/> Closed | QUALITY ASSURANCE DEPARTMENT |  |  |
| <input type="checkbox"/> Still Open | |  |  |
| <input type="checkbox"/> Re-Issue IRF | | | |
| | Date: 21 01 11 | Date: 21 01 11 | Date: 21 01 11 |

DATE AND SIGNATURE

21 01 09

INVESTIGATION REPORT FOR CLOSE GAP OF EPSON IJP 5150864-01 INDIVIDUAL BOX

| | |
|-----------------------------------------|--------------------------------------------------------------------------------------------------------|
| DIRECT CAUSE PROCESS/MATERIAL | W1- Close gap occurs because the creasing blade didn't hit the center of grain direction. |
| | W1- Possible operator did not "HILOT" well the affected items why after feeding it back to closed gap. |
| | W3- Because only air blower hold the items after feeding in Semi-Auto Gluing. |



| | |
|-------------------------------------------|------------------------------------------------------------------------------------------------------------------------|
| INDIRECT CAUSE PROCESS/MATERIAL | W1- Operator in stacker did not notice the wide gap. |
| | W2 - Because now only 1 operator assign in stacker for both Semi-Auto Gluing Machine 1 & 2, why the checking has skip. |
| | W3 - Before upon detection of Wide & Close Gap during process, the operator assign in stacker immediately rework it. |

CORRECTIVE ACTION

| | | | |
|------------------------------------------------------------------------------------------------------------------------------|-------------------|---------------------|---------------|
| Last July 30, 2020 meeting with Semi-Auto Gluing Operator together with sir Yagi the 4 persons in Semi-Auto Gluing is final. | | | |
| PIC: | PRODUCTION | TARGET DATE: | 200803 |

| | | | |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|---------------------|---------------|
| Orient the Semi-Auto gluing operator regarding this problem and remind them what they explain to sir Yagi that the person in stacker is 100% check the item, so they immediate rework if there is occurrence of Wide or Close Gap before the glue will totally dried. | | | |
| PIC: | PRODUCTION | TARGET DATE: | 200806 |

PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA A. APALLA
SR. SUPERVISOR