

**KANEPACKAGE PHILIPPINE INC.**

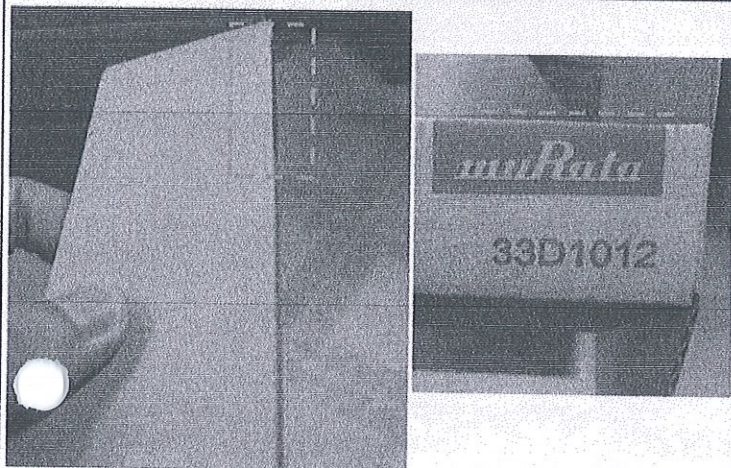
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 265

Date Issued: 20 08 10

Customer	EMORI	Attention To	Mr. Gerald De Guzman
Item Code	HP33D1012	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	20 08 09
Job Order Number	WO-20-M-01043-10	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
2,002	74	3.70%

Nature of Defect:

MISALIGN PRINT

Requirement:

Print should not exceed on the creasing line

Actual:

The print exceeded on the print

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: <u>3</u> Date: <u>20 08 10</u>	<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 checked="" type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching	<input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others:	<input type="checkbox"/> Material <input checked="" type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by Ms. Npemi Cepeda QA Supervisor	Approved by Mr. Rexel Almarino 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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INVESTIGATION REPORT FORM (IRF)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

- DUE TO WARP MATERIALS MORE THAN 13mm.

OUTFLOW ROOTCAUSE

- THEY DIDN'T SEPARATE 100% ALL WARP MATERIALS BECAUSE ONLY FAST BROWSING ARE REQUIRED IN ERDS.

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		
Issues	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 08 12**PIC:** A. Vergara**Identified Rootcause**

> The printing on the item is slant because the materials used are warp.

Recommendation

> Use paper jig weights to reduce/ prevent warping of materials
> Segregate warp boards & flat boards

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 12	<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 09 10	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is effective





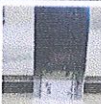

Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department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

IV. CLOSURE

STATUS <input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-Issue IRF	QUALITY ASSURANCE DEPARTMENT CLOSED DATE AND SIGNATURE: <u>20 01 09</u>	Approved by: QA Supervisor: <u>[Signature]</u> Date: <u>21 01 11</u> QA Asst. Manager: <u>[Signature]</u> Date: <u>21 01 11</u>	Process Owner Acknowledgment (Receiving Section) Line Leader: <u>[Signature]</u> Date: <u>21 01 11</u> Department Head: <u>[Signature]</u> Date: <u>21 01 11</u>
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EMORI HP33D1012 CARTON BOX.

DIRECT CAUSE PROCESS/MATERIAL	W1- Possible the caused of misalign print is due to warp materials more than 13mm.
	W2- Operator found random of warp material during feeding of board in Eqos.

PRODUCTION STUDY FOR WARP MATERIALS IN EQOS PROCESS			
WARP MEASUREMENT	PICTURE		CONCLUSION
18mm			First measurement upward (Required was 25mm vs Actual 17mm)
13mm			First measurement upward (Required was 25mm vs Actual 13mm)
10mm			Measurement in grid (required was 25mm vs Actual 10mm)

Print move 3mm upward
(Requirement 25mm vs.
Actual 22mm)

The image shows a document titled "PERFORMANCE RATIO AND CONDITION INDEX". A red box highlights a section of the table, specifically the rows for "1974" and "1975" under the "1974" column. The table has columns for "Year", "Performance Ratio", and "Condition Index". The highlighted section shows the following data:

Year	Performance Ratio	Condition Index
1974	1.00	1.00
1975	1.00	1.00

(NOTE)
645X810 BF
FOR EMORI D1012
W/RANDOM WARP
MATERIALS



**OPERATOR SEPERATE THE
DETECTED WARP MATERIALS**

INDIRECT CAUSE PROCESS/MATERIAL	W1- Possible that during feeding still there is warp more than 13mm, they didn't separate 100% all warp materials.
	W2- Only fast browsing are required during feeding in Eqos.

CORRECTIVE ACTION

Continues the recondition and usage of Paper weight Jig.

PIC:	WAREHOUSE & QA	TARGET DATE:	ON-GOING
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Continues the detection, segregation of warp more than 13mm and recording of warp materials encounter.

PIC:	PRODUCTION	TARGET DATE:	ON-GOING
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PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
SR. SUPERVISOR