

**KANEPACKAGE PHILIPPINE INC.**

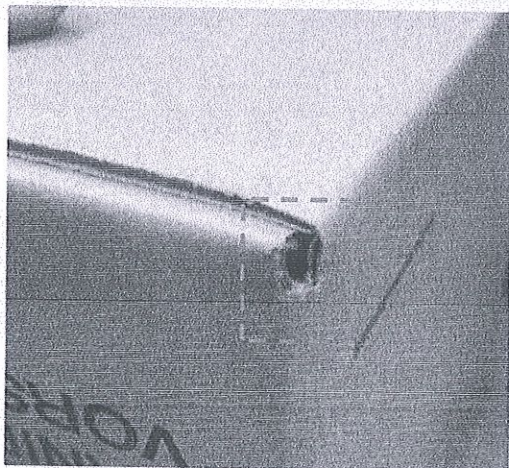
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 274

Date Issued: 20 08 17

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman
Item Code	5150863-01	Department	PRODUCTION
Item Description	OUTER BOX	Date of Detection	20 08 14
Job Order Number	WO-20-L-0068-61	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

6,504

Reject Quantity (pcs.)

34

Reject Percentage

0.52%

Nature of Defect:

MISALIGN SLOT

Requirement:

Slot depth tolerance should be within 3mm only

Actual:

Slot depth is 8mm

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"/> Gluing	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input checked="" type="checkbox"/> Dimension
No.: _____	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Others: _____	<input 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. Noemi Cepeda QA Supervisor	 Mr. Rexel Almario QA Asst. Manager	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 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****OUTFLOW ROOTCAUSE**

— WARP MATERIALS CAUSED
OF MISALIGN SLOT

— RANDOMLY OCCURRENCE WHY
OPERATOR DID NOT TRAP ALL
THE 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**Actions to be done to eliminate recurrence****Who / When**

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	N/A			

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 18

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The corrugated boards jam for a moment in
slitting unit, because the edge of the board is
not captured by the rollers easily since the condi-
tion of the boards are warp

> Recondition the warp materials using paper
weight jigs.
> Separate warp & 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 18	<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 18	<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	QUALITY ASSURANCE DEPARTMENT		Approved by:	Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	CLOSED		QA Supervisor	Line Leader	Department Head
<input type="checkbox"/> Still Open			QA Asst. Manager		
<input type="checkbox"/> Re-Issue IRF					
DATE AND SIGNATURE			Date: 20/01/11	Date: 21 01 11	Date: 21 01 11

INVESTIGATION REPORT FOR MISALIGN SLOT OF EPSON IJP 5150863-01 OUTER BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- Based on investigation Eqos operator encounter random of warp materials of 648 X 1828 CF
	W2- They notice that the materials randomly bump in the roller near in the slotting unit of Eqos.
	W3 - Once the warp materials bump the machine roller it caused delay timing of materials and the possible problem is misalign Print & misalign Slot.

Note: warp materials
648 X 1828 CF
5150863-01

**EQOS OPERATOR PUT NOTE IN THE
MACHINE RATIO ONCE THEY ENCOUNTER
WARP MATERIALS**

INDIRECT CAUSE PROCESS/MATERIAL	W1- Not 100% all materials are brows, and sort out the warp because they need to consider not to stop or downtime the feeding of materials in Eqos.
	W2- Possible the Warp occurrence are randomly because almost 34pcs out of 6,504pcs Lot Qty are affected.

CORRECTIVE ACTION

Continues the recondition and usage of Paper weight Jig.			
PIC:	WAREHOUSE & QA	TARGET DATE:	ON-GOING

Separate and recondition once the operator encounter warp materials.			
PIC:	PRODUCTION	TARGET DATE:	ON-GOING

PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR