

**KANE PACKAGE PHILIPPINE INC.**

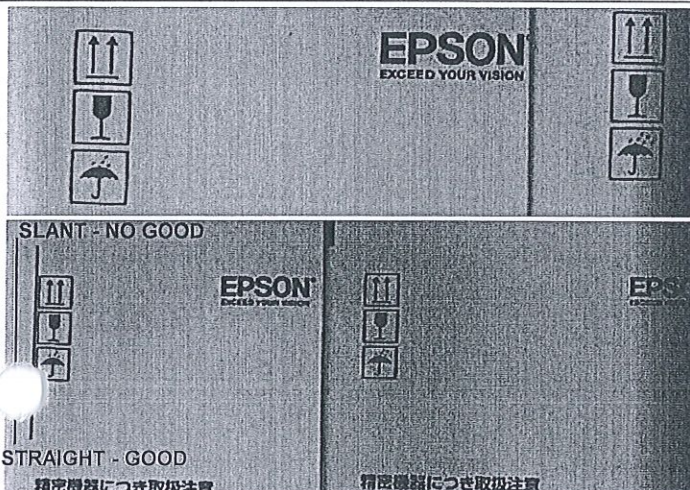
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
Telephone No. (049) 545-7166 to 69  
Fax No. (049) 545-6302

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

Control No.: 281

Date Issued: 20 08 27

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman
Item Code	5150864-01	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	20 08 27
Job Order Number	WO-DRS-20-L-0068-94	Section Detected	QA - IN LINE

**ILLUSTRATION OF THE PROBLEM**☒ Major☐ Minor

Lot Quantity (pcs.)

6,490

Reject Quantity (pcs.)

183

Reject Percentage

2.81 %

Nature of Defect:

MISALIGN PRINT

Requirement:

Print should not be in slant position and should not be cut by the die cut blade

Actual:

The print is slanting and cut by diecut blade

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input checked="" type="checkbox"/> Dimension
No.: 4	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Appearance
Date: 20 08 27	<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 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**

WARP MATERIALS

**OUTFLOW ROOTCAUSE**

RANDOM OCCURRENCE

**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 09 01

PIC: H. Vergara

**Identified Rootcause**

~ The material used are warp  
~ The paper weight jig used is not enough (The warp can develop in KPPI & the applied weight jig for not warp is 1 piece only)

**Recommendation**

~ Separate the warp boards to not warp for separate Setup.  
~ Weight jigs should not be applied on the center of the boards also consider the both ends.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 09 02	[X] Yes [ ] No	Recommendation is implemented
2nd Verification of Action	A. Vergara	20 09 03	[ ] Yes [ ] No	C.A. #2 will not be pursue
3rd Verification of Action	A. Vergara	20 09 09	[X] Yes [ ] No	Additional weight jigs is done
Effectiveness of Action	A. Vergara	20 09 14	[X] Yes [ ] No	Recommendation 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	<b>QUALITY ASSURANCE DEPARTMENT</b>	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed	<b>CLOSED</b>		
<input type="checkbox"/> Still Open		QA Supervisor	Line Leader
<input type="checkbox"/> Re-Issue		QA Asst. Manager	Department Head
Date: 20 09 11	Date: 20 09 11	Date: 21 01 11	Date: 21 01 11

DATE AND  
SIGNATURE

21 01 09



## INVESTIGATION REPORT FOR MISALIGN PRINT OF EPSON IJP 5150864-01 INDIVIDUAL BOX

<b>DIRECT CAUSE</b> PROCESS/MATERIAL	W1- Eqos operator report to Leader in-charge regarding misalign print they encountered.
	W2- Materials bump to the machine roller that caused misalign print.
	W2- There's a random of warp materials.
	W3 - Upon checking almost no paper weight Jig on the top of materials issued in Eqos, there is one paper weight jig but the position is useless.




<b>INDIRECT CAUSE</b> PROCESS/MATERIAL	W1- Operator sort the affected of warp materials
	W2- Because of random occurrence possible that they didn't trap all the affected of misalign print.

## CORRECTIVE ACTION

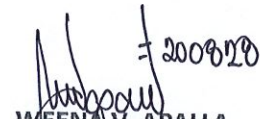
Make additional Weight Jig			
<b>PIC:</b>	Concern Department	<b>TARGET DATE:</b>	On-going as of 200827

Orient the proper usage and study the effectivity of weight jig to warp materials.			
<b>PIC:</b>	Concern Department	<b>TARGET DATE:</b>	

PREPARED BY:

  
**GERALD DE GUZMAN**  
 PROD ASST. SUPERVISOR

APPROVED BY:

  
**WEENA V. APALLA**  
 SR. SUPERVISOR