

**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

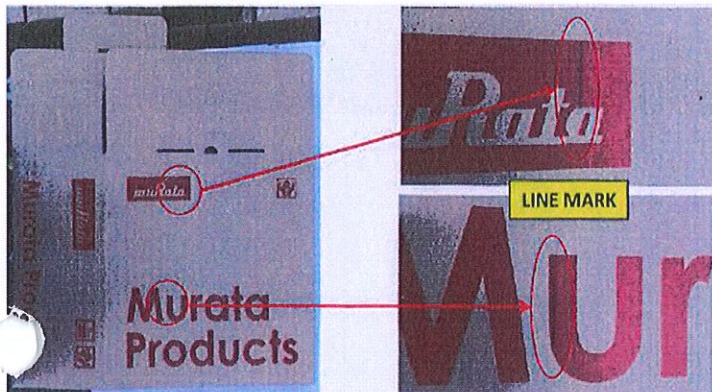
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 285

Date Issued: 20 09 10

Customer	EMORI	Attention To	Mr. Gerald De Guzman
Item Code	HP01D2200C	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	20 09 10
Job Order Number	WO-DRS-20-M-01183-6	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM

☐ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1009	350	34.69%

Nature of Defect:

LINE MARK

Requirement:

No line mark on the logo

Actual:

W/ line mark on the logo

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
☒ First ☐ Recurrence No.: _____ Date: _____	☐ Hold ☐ Special Acceptance ☐ For Rework ☒ Reject / Disposal	☐ Slotter ☒ EQOS ☐ Diecut ☐ Detaching ☐ Gluing ☐ Vertical ☐ Others: _____	☐ Material ☐ Dimension ☒ Appearance ☐ Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by QA Supervisor	Approved by Mr. Rexel Almaro 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 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**

DRIED INK IN ANILOX COVER

OUTFLOW ROOTCAUSE

RANDOMLY 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	20 09 14	Time	1:25 AM ~ 1:29 AM
Title	ORIENTATION REGARDING LINE MARK OF EMORI HP61D2200C CARTON BOX		
Attendees	EQOS 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 09 12

PIC: A. Vergara

Identified Rootcause

- Ink from the anilox roller got contaminated because the stuck ink fell down on the roller. The dried ink was not removed from the machine

Recommendation

- Clean the anilox roller once the it was contaminated
- Stop immediately the machine once it was encountered

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	19 09 14	☒ Yes ☐ No	C.A. is implemented
2nd Verification of Action			☐ Yes ☐ No	
3rd Verification of Action			☐ Yes ☐ No	
Effectiveness of Action	A. Vergara	20 09 29	☒ Yes ☐ 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

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner/Acknowledgment: (Receiving Section)	
☒ Closed	CLOSED	☒ Re-Issue			
☐ Still Open		QA Supervisor	QA Ass. Manager	Line Leader	Department Head
☐ Re-Issue IRF		Date: 20/01/11	Date: 21/01/11	Date: 21/01/11	Date: 21/01/11
DATE AND SIGNATURE 21 01 09					

REPACKAGE PHILIPPINE, INC.

6

Albert



SO No. :	Work Order #WO-DRS-20-M-01183-6
JO No. :	WO-DRS-20-M-01183-6A
ISSUED BY :	Nene Villanueva
DATE ISSUED :	28-AUGUST-2020
CUSTOMER :	EMORI PHILS.

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

Item Description: HP01D2200C.C1 CARTON BOX	Memo :
Quantity: 1000 Piece	BK Code : HP01D2200C.C1
Delivery Date: 8-SEPTEMBER-2020	Blades :

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
685X1035MM BF TX200/CM125/TX200	1020	0	0	0pcs	1020	0139898 PW		ELMER 9/7

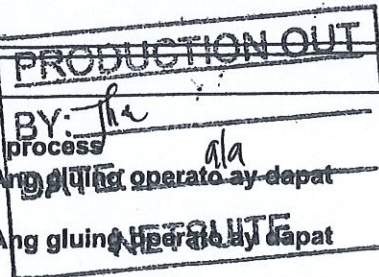
PROCESS	Finished Date Time		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
	Date	Time			In-house	Supplier		
1.EQDS 0907	9/7		1009	3			PERIL	
2.ETERNA 0908			1006	3			SAE	
3.CONVEYOR 1	9/8		160 840	3	2 3	1	MARTIN/RELEBY MILO/Dexter/Rick	
4.CONVEYOR 3	9/9		136 864				MAR, MAR ROSE, ANA	
5.LOT NUMBERING	9/10		100				Fare/Albert	
6.SCREENING	9/10		500		350		Albert/Glen	
7.QA BUNDLE								

REJECTION HISTORY

1. (A). Kallan: 05/24/19, (B). Problema: Overlap, (C). Ilan: 502 PCS., (D) Bakit: Ang creasing rule ay natamaan ang tip ng corrugated medium
2. (A). Kallan 06/07/19, (B). Problema: Bursting, (C). Ilan: 1,876 PCS., (D) Bakit: Malalim ang creasing line ng item
3. (A). Kailan: 11/4/2019, (B). Problema: MISALIGN GLUE, (C). Ilan: 50 PCS., (D) Bakit: Ang ilalim na parte ng box ay hindi level lto ay nagmula dahil nung
4. (A). Kailan: 2/12/2020, (B). Problema: MISALIGN GLUE, (C). Ilan: 164 PCS., (D) Bakit: Ang ilalim na parte ng box ay hindi level lto ay nagmula dahil nung
- 5.

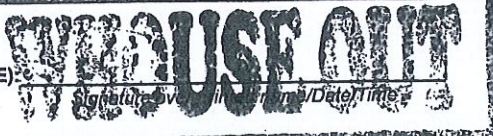
NOTES

1. Ang operator dapat laging install ang steel plate with creasing matrix
2. Ang diecut operator ay dapat mag trial run ng 5 pcs at icheck ng kasunod na process
3. 1.Lagyan ng nickmark ang glueta ng item para sa reference ng operator 2. Ang glue operator ay dapat laging tingnan ang nickmark ng glueta
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- 5.



PR-001-F07 REV.00

JO Received By (WSE):



JO Returned to (QA):

Signature over printed name/Date/Time

NAME: [Signature] DATE: 9/7

8/28/2020

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KANEPACKAGE PHILIPPINE, INC.

SO No.:
JO No.:
ISSUED BY:
DATE ISSUED:
CUSTOMER

Work Order #WO-DRS-20-M-01183-6
WO-DRS-20-M-01183-6A
Nene Villanueva
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EMORI PHILS.



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PROCESS	Finished		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
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2.ETERNA 0908			1000	3			SAE	
3.CONVEYOR 1	9/8		160 840	3	2 3	1	MORJAY/RELEBY MILLO/DEXTER/RIC	
4.CONVEYOR 3	9/9		176 864				MAE, NARD ROSE, ANA	
5.LOT NUMBERING	9/10		100				Fare/Albert	
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- 5.

PRODUCTION OUT

BY: the
DATE: ala
NETSUITE

PR-001-F07 REV.00

JO Received By (WSE):

WSE USE OUT
Signature over printed name/Date/Time

JO Returned to (QA):

Signature over printed name/Date/Time

NAME: you DATE: 9/7

INVESTIGATION REPORT FOR LINE MARK OF EMORI HP01D2200C CARTON BOX

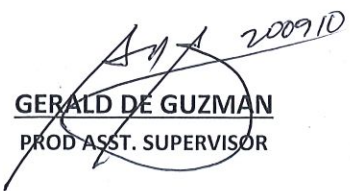
DIRECT CAUSE PROCESS/MATERIAL	W1- There is dried ink left in the anilox cover that can't clean during "AUTO WASHUP" or Automatic Anilox Cleaning. (The anilox cover cleaning schedule is during Half and Month End maintenance)
	W2- That dried ink in the anilox cover accidentally fell down in the anilox during mass production.
	W3- Dried ink made stain in the anilox, then transferred in the cyrel.

INDIRECT CAUSE PROCESS/MATERIAL	W1- Dried ink is not easy to dissolve why its move in different location.
	W2- Possible the occurrence is randomly and because the Line Mark appears in different location, why the Operator and QA patrol didn't trap the problem during sampling.

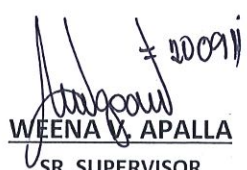
CORRECTIVE ACTION

This problem is inherent even in the long way printing before and we cant clean the anilox cover daily because its take long hours. The corrective action we can do is to orient the operator once they encounter or trap this problem immediately stop the process and clean the anilox by " AUTO WASHUP".			
PIC:	PRODUCTION	TARGET DATE:	200914

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
 SR. SUPERVISOR