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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

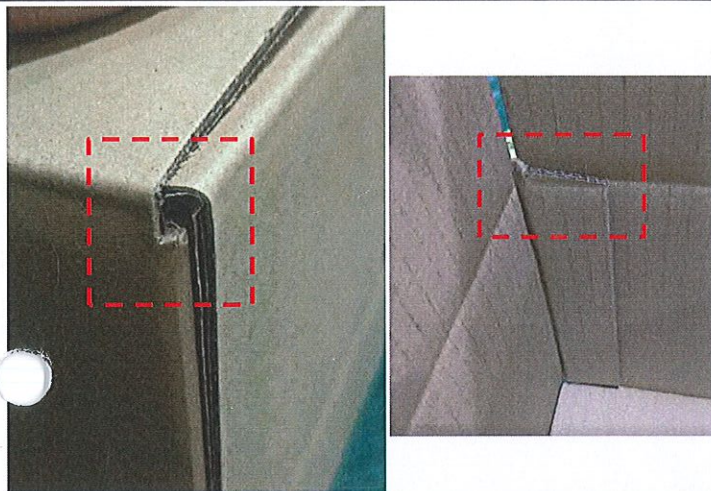
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 289

Date Issued: 20 09 15

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman
Item Code	5149643-01	Department	PRODUCTION
Item Description	OUTER CARTON BOX	Date of Detection	20 09 10
Job Order Number	WO-20-M-01238-7	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM


<input checked="" type="checkbox"/> Major	<input type="checkbox"/> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
3,440	206	5.98%
Nature of Defect:		
MISALIGN SLOT		
Requirement:		
No bulging and slot depth from creasing line should not exceed 3mm		
Actual:		
W/ bulding and deep slot		

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 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	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: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A Why 4: Why 5:	
Design / Toolings	Why 1: Why 2: Why 3: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A Why 4: Why 5:	
Process / Material	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:	

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INVESTIGATION REPORT FORM (IRF)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

- RANDOM OF WARP MATERIALS
- BELOW 500mm HEIGHT OF ITEMS.

OUTFLOW ROOTCAUSE

RANDOM OF OCCURRENCE AND
 MACHINE SPEED.

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	
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B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Issues	N/A		

Design / Tools	N/A	
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C. Reworking

Rework Quantity	N/A
Total Good	N/A
Rework Percentage (Good)	N/A

Process	PLS. SEE ATTACHED	
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II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 20 09 16

PIC: A. Vergara

Identified Rootcause

- > Due to warp materials
- > The material width is 467mm but the distance of the rollers are 500mm

Recommendation

- > Recondition boards, the top should be covered by weight dig
- > Pre-fold the flap of the item if warp prior feeding on the machine

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 16	[X] Yes [] No	C.A. is implemented
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	20 10 12	[X] 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

STATUS: <input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-issue IRF	QUALITY ASSURANCE DEPARTMENT	Approved by:	Process Owner Acknowledgment (Receiving Section)
		QA Supervisor	Line Leader
		QA Asst. Manager	Department Head
		Date: 21 01 11	Date: 21 01 11

DATE AND
 SIGNATURE

[Signature] 20 10 09

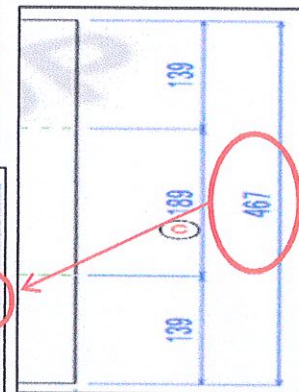
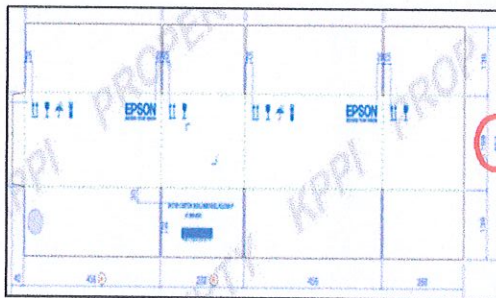
INVESTIGATION REPORT FOR MISALIGN SLOT OF EPSON IJP 5149643-01 OUTER CARTON BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- Base on investigation Eqos operator conduct free folding of flap in Raw materials before feeding in Eqos.
	W2- They trap random of misalign slot because the sheet bump in the roller during mass production.
	W3 - There is a random of warp material found.
	W1- The other factor is the height of this item is only 467mm vs 500mm distance of roller to roller of Eqos machine.
	W2- This condition of item with below 500mm height is prone to misalign slot because there is interval gripping of roller to item happen.

CONDITION SHEET			
Shift	Start	End	Machine Breakdown / Downtime / Other
01	10:00	11:00	0948 0956 FOLDING MATS DUE WARP MAT
02	11:00	12:00	
03	12:00	13:00	
04	13:00	14:00	
05	14:00	15:00	
06	15:00	16:00	
07	16:00	17:00	
08	17:00	18:00	
09	18:00	19:00	
10	19:00	20:00	
11	20:00	21:00	
12	21:00	22:00	
13	22:00	23:00	
14	23:00	24:00	

MACHINE RATIO SHOW THE DOWNTIME DUE TO PRE-FOLDING OF WARP MATERIALS

0948 0956 FOLDING MATS DUE WARP MAT



INDIRECT CAUSE PROCESS/MATERIAL	W1- Possible occurrence of misalign slot are randomly and due to machine speed 110bpm with Skip Off mode why the operator did not trap all the affected.
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PRODUCTION CORRECTIVE ACTION

Continues the pre-folding once the operator encountered random of warp materials in RSC box raw mats with creasing.

PIC:	PRODUCTION	TARGET DATE:	ON-GOING
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PRODUCTION SUGGESTION FOR IMPROVEMENT

Transfer this item in diecut with 2outs in diecut blade.

PIC:	SALES	TARGET DATE:	
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PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR