

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna

Telephone No. (049) 545-7166 to 69

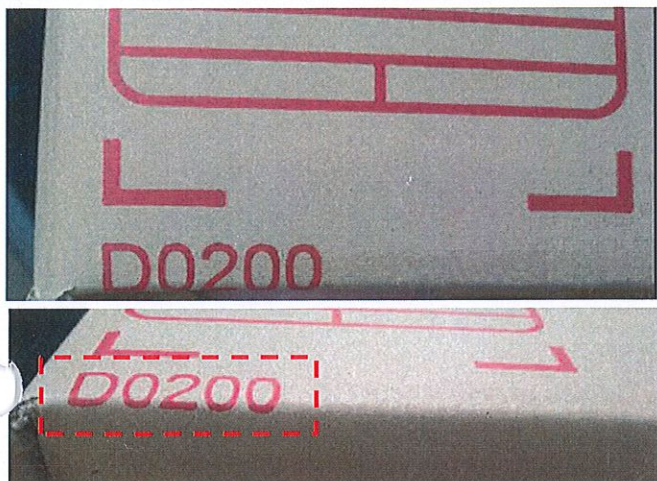
Fax No. (049) 545-6302

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

Control No.: 292

Date Issued: 20 09 18

Customer	EMORI	Attention To	Mr. Gerald De Guzman
Item Code	HP01D0200	Department	PRODUCTION
Item Description	OUTER BOX	Date of Detection	20 09 16
Job Order Number	WO-20-M-00310-40	Section Detected	QA - OQA

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
267	126	47.19%

Nature of Defect:

MISALIGN PRINT

Requirement:

±5mm printing movement

Actual:

Character exceeded on the creasing line

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"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input checked="" type="checkbox"/> Dimension
No.: _____	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input checked="" 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 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****OUTFLOW ROOTCAUSE**

- RANDOM OF WARP MATERIALS?

- RANDOM OF MISALIGN PRINT

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		Who / When
	N/A	

B. Orientation

Date	Time
N/A	N/A
Title	N/A
Idees	N/A

Design / Tools		Who / When
	N/A	

C. Reworking

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

Process		Who / When
	PLS. SEE ATTACHED	

II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 20 09 21 PIC: A. Vergara

Identified Rootcause**Recommendation**

PRD:
Inclined position of boards inside the machine. The materials bump on the rollers in any unit of the machine. Since the material used is warp

QA:
The QA Inspector did not detect the defect, because the QA did not check if the print exceeded on the creasing since they conduct browsing

1. Cover the top pile of the materials w/ paper weight wigs
2. Include in the checkpoint of QA if the characters exceeded on the creasing line

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 21	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation 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 12 11	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> 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:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed			
<input type="checkbox"/> Still Open			
<input type="checkbox"/> Re-Issue IRF			

QUALITY ASSURANCE DEPARTMENT
CLOSED
DATE AND SIGNATURE
21 01 09

KANEPACKAGE PHILIPPINE, INC.

SO No.: Sales Order #DRS-20-M-00310
 JO No.: WO-20-M-00310-40
 ISSUED BY: Julieta Banguaga
 DATE ISSUED: 22-FEBRUARY-2020
 CUSTOMER: EMORI PHILS.

last run 2/21
 200302
 2:37pm



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

Item Description: HP01D0200 BOX
 Quantity: 400 Piece
 Delivery Date: 3-MARCH-2020
 Memo: BK Code: HP01D0200
 Blades:

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
1450 X 1500 CBF TX200/CM125X3 /TX200 0	140	404 X 1248 CBF	420	0pcs 95	600472	104		8/26

PROCESS	Finished Date	Time	GOOD QTY	REJECT QTY	OPERATOR	Remarks
1.SLOTTER BIG	2/28		705 95 GSMC PCS		RG	
2.SLOTTER SMALL	2/28		420		JKW	
3.EGOS 200302	3/2		418		JOEAN	
4.CONVEYOR 1	3/2		418	71	Jan mark	
5.LOT NUMBERING	3/2		400		kim / EDON	
6.SCREENING	3/2		418		DEXTER / EDON	CLOSED
7.QA BUNDLE						

REJECTION HISTORY

1.	
2.	
3.	
4.	
5.	

PRODUCTION OUT
 BY: emc
 DATE: 200302
 NETSUITE

NOTES

1.	
2.	
3.	
4.	
5.	

PR-007-F07

JO Received By(WHSE):

Signature over printed name/

over printed name/Date/Time

HOUSE OUT
 DATE: 2/28

EMORI PHILIPPINES INC.	
Item Code HP01D0200	QUANTITY 10 pcs.
Item Description Carton Box	Supplier's QC PASSED
Lot No. / Ref. No. 200302 - 00310-40	INSPECTION RoHS OK
	QA-CG568
KANEPACKAGE PHILIPPINES INC.	

INVESTIGATION REPORT FOR MISALIGN PRINT OF EMORI HP01D0200 OUTER CARTON BOX

NOTE	Affected items processed in Eqos last March 2, 2020, more than 6months when issued the IRF as of September 18, 2020.
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DIRECT CAUSE PROCESS/MATERIAL	W1- Possible that they encountered random of warp materials that time?
	W2- Random of warp materials bump in the roller that caused misalign print.

INDIRECT CAUSE PROCESS/MATERIAL	W1- Possible the Eqos operator and QA patrol that time didn't trap the misalign print during sampling because the occurrence is randomly.
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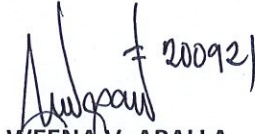
PRODUCTION CORRECTIVE ACTION

Monitor the next running of this item to eliminate some possible cause of misalign print.			
PIC:	PRODUCTION	TARGET DATE:	AS OF 200919 NO SCHEDULE FOR NEXT RUNNING (WAITING FOR THE ADVISE OF JC)

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
 SR. SUPERVISOR