


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

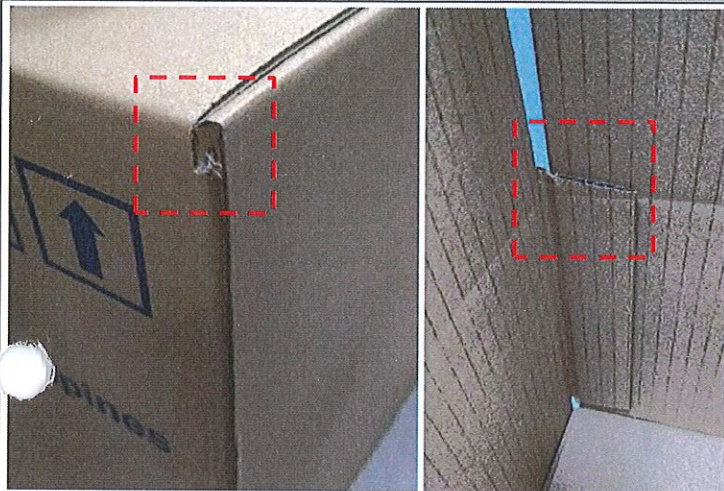
☐ Customer Claim

Control No.: 298

Date Issued: 20 09 21

Customer	EPSON TP	Attention To	Mr. Gerald De Guzman
Item Code	5116596-00	Department	PRODUCTION
Item Description	OUTER CARTON BOX	Date of Detection	20 09 18
Job Order Number	WO-20-M-01223-41	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM
☒ Major

☐ Minor


Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

2,448

100

4.08%

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"/> 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 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		 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**

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	20 09 25	Time	12:00NN - 12:05NN
Title	ORIENTATION REGARDING MISALIGN SLOT OF SANYO DENKI 00415456-01 PACKAGE 4 PERSON TP 5116596-00 OUTER CARTON BY		
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 21

PIC: A. Vergara

Identified Rootcause

> The materials have delay timing on the slitting because the edge of the boards bump on the rollers since boards are warp

Recommendation

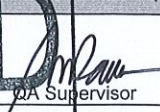
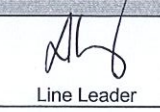
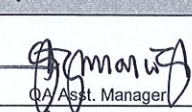
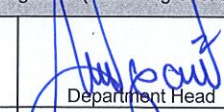
> Recondition warp materials, top should be covered by weight jigs
> Pre-fold the flap prior feeding on the machine

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

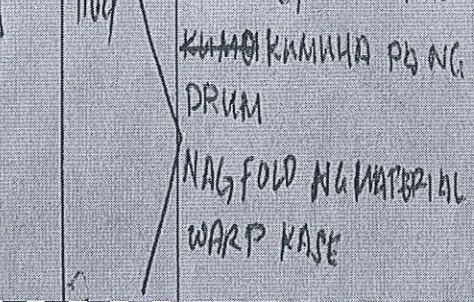
	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 09 25	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is implemented
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	20 10 29	<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	Remarks	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed	CLOSED	 QA Supervisor	 Line Leader
<input type="checkbox"/> Still Open		 QA Asst. Manager	 Department Head
<input type="checkbox"/> Re-issued		Date: 21 01 11	Date: 21 01 11

DIRECT CAUSE PROCESS/MATERIAL	W1- Upon investigation operator said that they encountered random of warp materials that time recorded in their Machine Ratio.
	W2- Warp materials bump in the roller that caused misalign slot.




1035

1104

DRAIN OF USE INK
KUMU KUMUHA PONG
DRUM
NAG FOLD NG MATERIAL
WARP KASE

**PROOF THAT THE OPERATOR
CONDUCTED PRE-FOLDING DUE
TO WARP MATERIALS**

 INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator in-charge in feeding of materials cant Pre-fold all the affected of warp due to bulky quantity of this item, and because they need to consider not to downtime the feeding of materials in Eqos.
	W2- Eqos operator and QA patrol that time didn't trap the misalign print during sampling because the occurrence is randomly.

Orient the operator that next time they encounter warp materials specially bulky quantity immediately inform the Leader In-charge to ask help in QA for the pre-folding.			
PIC:	PRODUCTION	TARGET DATE:	200925

WEENA V. APALLA
SR. SUPERVISOR