


**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.: 307

Date Issued: 20 10 01

Customer	EMORI	Attention To	Mr. Gerald De Guzman
Item Code	HP01D2200C	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	20 09 29
Job Order Number	WO-DRS-20-M-01183-61	Section Detected	QA - IN LINE

**ILLUSTRATION OF THE PROBLEM**
☐ Major

☒ Minor


Lot Quantity (pcs.)

3,020

Reject Quantity (pcs.)

26

Reject Percentage

0.86 %

Nature of Defect:

POOR PRINT

Requirement:

There should be no lining on the logo of the item

Actual:

W/ lining on the logo

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: <u>2</u> Date: <u>20 09 29</u>	<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 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 Cereda QA Supervisor	 Mr. Rexel Almaro 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****OUTFLOW ROOTCAUSE**

- NOT ENOUGH DRY CYREL

- VISIBLE WHEN THE PRINT IS FULLY DRIED

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		
Idees	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 10 06

PIC: A. Vergara

**Identified Rootcause****Recommendation**

Presence of water on the surface of the cyrel because the operator does not dried properly the rubber die

Clean the cyrel using of 2 rags to assure that the cyrel is totally dry.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 10 12	[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 11 26	[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**

<b>QUALITY ASSURANCE DEPARTMENT</b>		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
Status:	Remarks:	QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input checked="" type="checkbox"/> Closed	<b>CLOSED</b>	Date: 2/01/11	Date: 2/01/11	Date: 2/01/11	Date: 2/01/11
<input type="checkbox"/> Still Open					
<input type="checkbox"/> Re-Issue IRF					
DATE AND SIGNATURE					



## KANEPACKAGE PHILIPPINE, INC.

SO No.: Work Order #WO-DRS-20-M-01183-61  
 JO No.: WO-DRS-20-M-01183-61A  
 ISSUED BY: Jhoana de Guzman  
 DATE ISSUED: 19-SEPTEMBER-2020  
 CUSTOMER: EMORI PHILS.

NETSUITE  
 QA TRANSFER TO FG  
 BY: JUNNAIL 940  
 DATE: 10/23/20  
 TIME: 1300



Light Industry Science Park II,  
 National Highway, Calamba, 4027 Laguna  
 Tel: (049) 545 7168/67  
 Fax: (049) 544-0010

Item Description: HP01D2200C.C1 CARTON BOX  
 Quantity: 1000 Piece  
 Delivery Date: 24-SEPTEMBER-2020

Memo :  
 BK Code : HP01D2200C.C1  
 Blades :

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
885X1035MM BF TX200/CM125/TX200	1000	0	0	0pcs	140486	QW		JUMP 9/24

PROCESS	Finished Date	Time	GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
					In-house	Supplier		
1.EQOS	9/24		1000	2			CTM HD	
2.ETERNA	9/24		1000	2			ESTIME	
3.CONVEYOR 1	9/27		1000	1			GUD	
4.CONVEYOR 3	9/27		294 706				Ana, Rose Maer. JAN	
5.LOT NUMBERING	9/27		1000				Pinel Pinin	
6.SCREENING	9/27		500				Forin	
7.QA BUNDLE	9/29		440		73	1	JARREL	

940 PCS

## REJECTION HISTORY

BALANCED!!

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). Kallan: 11/4/2019, (B). Problema: MISALIGN GLUE, (C). Ilan: 50 PCS., (D) Bakit: Ang ilalim na parte ng box ay hindi level ito ay nagmula dahil nung
4. (A). Kallan: 2/12/2020, (B). Problema: MISALIGN GLUE, (C). Ilan: 164 PCS., (D) Bakit: Ang ilalim na parte ng box ay hindi level ito 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 gluing operato ay dapat laging tingnan ang nickmark ng glueta
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- 5.

PR-001-F07 REV00

JO Received By (WHSE):

Signature over printed name/Date/Time

JO Returned to (QA):

Signature over printed name/Date/Time

DATE: 9/29



## INVESTIGATION REPORT FOR POOR PRINT OF EMORI HP01D2200C CARTON BOX

<b>DIRECT CAUSE PROCESS/MATERIAL</b>	W1- Only 26/3,020pcs are affected and this is the 1st process that time with red print, so ink might still be fresh
	W2- Possible it happened after the Eqos operator clean the cyrel due to sudden machine stop.
	W3- Possible that after cleaning of cyrel, operator was not able to completely dry the cyrel using dry rags, leaving water residue on the cyrel

B-	C-	D-	E-	Date:	Shift:
1186.119	1183.61/60	1183.85	1315.2		
DEMO1	EMORI	EMORI	TRC		
0096269801	D2200	HP01D0500	511558100		
634	3020	419	175		
BLACK	RED	RED	D. BLUE		
170 skip on	150 skip on	130 skip on	125 skip on		
600 X 136 8	685 X 1035	497 X 138 4	533 X 1598		
CB	BF	CBF	CF		
<input type="checkbox"/> IPD <input type="checkbox"/> Sample	<input type="checkbox"/> IPD <input type="checkbox"/> Sample	<input type="checkbox"/> IPD <input type="checkbox"/> Sample	<input type="checkbox"/> IPD <input type="checkbox"/> Sample		
<input type="checkbox"/> Overhang Only	<input type="checkbox"/> Overhang Only	<input type="checkbox"/> Overhang Only	<input type="checkbox"/> Overhang Only		
Time		Time		Time	
Start	Finish	Start	Finish	Start	Finish

<b>INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL</b>	W1- Possible its more visible when the print is fully dried, why the operator didn't trap the occurrence lining appearance in print.
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## PRODUCTION CORRECTIVE ACTION

Orient the operator to make sure that cyrel is totally dried after cleaning by using a dry rags.

<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>201008</b>
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PREPARED BY:

for:  
**GERALD DE GUZMAN**  
PROD ASST. SUPERVISOR

APPROVED BY:

**WEENA D. APALLA**  
SR. SUPERVISOR