

**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.: 340

Date Issued: 20 12 03

Customer	EMORI	Attention To	Mr. Gerald De Guzman
Item Code	HP01D2200C	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	20 12 03
Job Order Number	WO-DRS-20-M-01723-2	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

3,054

34

1.11 %

Nature of Defect:

POOR PRINT

Requirement:

No mottling on the solid images

Actual:

W/ mottling on the solid image



NO. OF OCCURRENCE		DISPOSITION		AREA OF OCCURRENCE / ORIGIN		CONTENT
<input type="checkbox"/> First		<input type="checkbox"/> Hold		<input type="checkbox"/> Slotter	<input type="checkbox"/> Gluing	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence		<input type="checkbox"/> Special Acceptance		<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension
No.: 3		<input type="checkbox"/> For Rework		<input type="checkbox"/> Diecut	<input type="checkbox"/> Others:	<input checked="" type="checkbox"/> Appearance
Date: 20 12 01		<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 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**

- OPERATOR USE THE ALMOST A MONTH
LEFTOVER INK.

- 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**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

N/A

B. Orientation

Date	20 12 07	Time	11:05 - 11:40 A.M.
Title	ORIENTATION REGARDING TO THE NEW IMPLEMENTATION FOR THE INK ISSUANCE		
Attendees	TOOLING & 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 12 05

PIC: A. Vergara

Identified Rootcause**Recommendation**

The operator used a left over ink which is expire
because FIFO was not followed

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 12 09	<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 01 23	<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	QUALITY ASSURANCE DEPARTMENT	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-issue IRF	Date: 21 04 14	Date: 21 04 14	Date: 21 04 14
DATE AND SIGNATURE			

DIRECT CAUSE PROCESS/MATERIAL	W1- Operator encounter random of poor print during mass production.
	W2- They use the almost a month leftover ink in the white pail.
	W3- They did not perform FIFO since no verification done upon issuance of new pail of ink.
	W4- They notice that even the ink viscosity is within the standard of 9sec, the quality of ink is not good, because the random occurrence of poor print is continues.

[illegible]

Part	Part Number	Material	Color	QTY	Length	Width	Thickness	Notes
EPSON	51173100	BF	UPPL	D-BLUE	9	6.4	1.2	skip
EMORI	EM000201A30	BF	UPPL	RED	9	6.3	1.0	skip
EMORI	EM000501AB02	BF	UPPL	RED	9	6.3	1.6	skip

0034	0047	 CHANGE INK
0041	0049	
0650	0105	

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Operator clean the cyrel and conducted adjustment every time they encountered poor print.
	W2- They immediate separate the affected of poor print once they trap it.
	W3- Possible the outflow is due to random occurrence of poor print.

<ul style="list-style-type: none"> - When operator notice the continues random occurrence of poor print, they immediately change the ink and no more poor print happened until they finish the another items of Emori. - Orient the Tooling custodian & Eqos operator for new implementation that they should return the empty pair of ink, before issuance of new ink to make sure the ink was depleted before issuance of another one. 			
PIC:	PRODUCTION	TARGET DATE:	201204

WEENA V. APALLA
SR. SUPERVISOR