

**KANEPACKAGE PHILIPPINE INC.**

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

Telephone No. (049) 545-7166 to 69

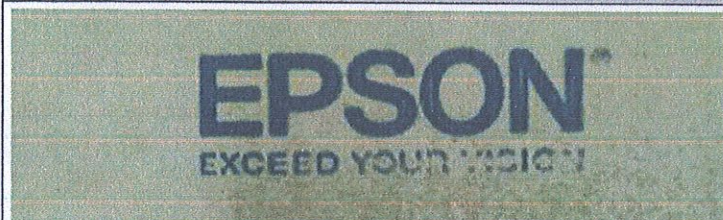
Fax No. (049) 545-6302

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

Control No.: 346

Date Issued: 20 12 10

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman
Item Code	5150864-01	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	20 12 09
Job Order Number	WO-DRS-20-L-0151-5	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

9,460

Reject Quantity (pcs.)

35

Reject Percentage

0.36%

Nature of Defect:

POOR PRINT

Requirement:

No missing text and line marks on the text

Actual:

With missing text and line marks on the print

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 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. Bexel 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**

- OPERATOR ACCIDENTALLY SKIP TO WIRE OUT THE AFFECTED PORTION AND IT CAUSED POOR PRINT.

OUTFLOW ROOTCAUSE

- OPERATOR MISSED SOME AFFECTED ITEM BECAUSE THEY IMMEDIATELY CLEAN THE CYREL UPON DETECTION.

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		Time	
Title			
Asses			

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 12

PIC: A. Vergara

Identified Rootcause

> Incomplete ink application on the boards because the affected cyrel was not cleaned after machine stoppage

Recommendation**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 15	<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	21 01 11	<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			
<input type="checkbox"/> Still Open			
<input type="checkbox"/> Re-Issue IRF			
		QA Supervisor	QA Asst. Manager
		Date: 210414	Date: 210414
			Line Leader
			Date: 210414
			Department Head
			Date: 210414

DATE AND
SIGNATURE

21 04 14

INVESTIGATION REPORT FOR POOR PRINT OF EPSON IJP 5150864-01 INDIVIDUAL BOX

DIRECT CAUSE PROCESS/MATERIAL

W1- Operator stop to clean the cyrel once they encounter abnormality in print quality.

W2- Operator accidentally skip to wipe out the affected portion and it caused poor print.

EPOS			
Time	Start	Finish	Machine Breakdown / Downside / Others
0930	0930	0940	Waiting at order, make, start, waiting.
0940	0940	0950	cleaning cyrel
0950	0950	1000	Id: 515086401
1000	1000	1006	marking warp
1006	1006	1010	marking mag-misalign
1010	1010	1015	print
1015	1015	1020	cleaning cyrel
1020	1020	1025	cleaning cyrel
1025	1025	1030	Breaktime
1030	1030	1035	Id: 515086401
1035	1035	1040	warp materials.
1040	1040	1045	cleaning cyrel
1045	1045	1050	cleaning cyrel

Note! 515086401 marking warp. marking mag-misalign print.		
1000	1006	→ cleaning cyrel
1106	1110	→ cleaning cyrel
1130	1150	→ Breaktime
OPERATOR IMMEDIATELY CLEAN AGAIN THE CYREL WHEN THEY TRAP THE POOR PRINT UPON SAMPLING		

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL

W1- Operator separate the affected of poor print that they trap during sampling.

W2- They did not think that they missed some affected item because they immediately clean the cyrel upon detection.

PRODUCTION CORRECTIVE ACTION

- Immediately stop the process and clean the affected portion of cyrel.
- Orient the Epos operator regarding this problem.

PIC:

PRODUCTION

TARGET DATE:

201215

PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR