

**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.: 362

Date Issued: 21 01 12

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman
Item Code	5150864-01	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	21 01 11
Job Order Number	WO-DRS-20-L-0165-7	Section Detected	QA - SCREENING

**ILLUSTRATION OF THE PROBLEM**☐ Major☒ Minor

Lot Quantity (pcs.):

Reject Quantity (pcs.):

Reject Percentage

4500

43

0.96%

Nature of Defect:

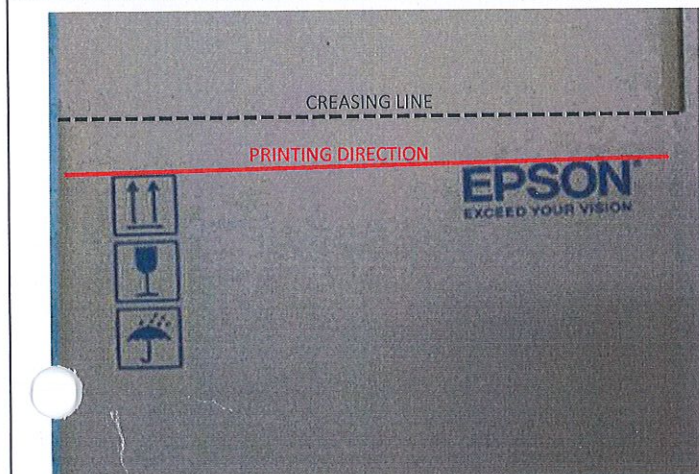
MISALIGN PRINT

Requirement:

Printing position should not be inclined

Actual:

Inclined printing



NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.: 6	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Appearance
Date: 21 01 11	<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**

- POSSIBLE RANDOM OF WARP MATERIALS ARE INCLUDED IN THE MATERIALS ISSUED IN ERDS.

**OUTFLOW ROOTCAUSE**

- MISALIGN PRINT OCCURED RANDOMLY

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			
Issues			

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: 21 01 14 PIC: A. Vergara

**Identified Rootcause**

> Warp materials  
> Worn-out rubber rollers in feeding unit

**Recommendation**

> Replacement of rubber roller in feeding unit.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 01 17	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation is implemented
2nd Verification of Action	A. Vergara	21 01 18	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is implemented
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 02 15	<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: <input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-Issue IRF	<b>QUALITY ASSURANCE DEPARTMENT</b> <b>CLOSED</b> DATE: 21 04 14 SIGNATURE: [Signature]	Approved by: [Signature] QA Supervisor Date: 21 04 14	Process Owner Acknowledgment: (Receiving Section) [Signature] Line Leader Date: 21 04 14	[Signature] Department Head Date: 21 04 14
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DATE AND  
SIGNATURE





Light Industry Science Park II,  
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Fax:(049)544-0010

1079

refox

## ANEPACKAGE PHILIPPINE, INC.

A-10-270

1000x4

No. :  
No. :  
SUED BY :  
ISSUED :  
CUSTOMER :  
EPSON PRECISION PHILIPPINES INCORPORATED - IJP

-2B-L-  
WO-DRS-L-20-0165-7  
Jecille Tuiza  
22-DECEMBER-2020

FR. JIM

Item Description: 515086401 Individual Box, PA1  
Quantity: 4500 Piece  
Delivery Date: 11-JANUARY-2021

Memo :  
BK Code : 515086401  
Blades :

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
4X918MM CF TX200/CM125/TX200 0	2260	0	0	0pcs	2260	TS		1/11

PROCESS	Finished		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
	Date	Time			In-house	Supplier		
EQOS	1/11		2259	5	1		CEBBT	
ETERNA	1/11		1038 1221	5			BLD SSB nam/ranc	
SEMI AUTO GLUING	1-11		4452					
LOT NUMBERING	01/11		450				Dante Jimwell	
SCREENING	01/11		3900 405		91		IMMEDIATE final notes del.	
QA BUNDLE	01/11				55			

KAN - Kanepackage Phil. Inc.-IJP

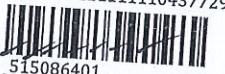
RoHS



Ref. No.:



Partcode:



Lot No.:



Qty.:



Remarks:



QA PASSED -

Part R4141691  
Name: 4 (SILANE)  
INDIVIDUAL

Model: N/A

REJECT

(A). Occurrence Date: 7/29/2020, (B). Problem: CLOSING maayos ng gluing operator ang creasing pa

(A). Occurrence Date: 8/8/2020, (B). Problem: GLUE glue on the glue tab overflowed because the applied applicator controller is worn-out

(A). Occurrence Date: 8/11/2020, (B). Problem: DO Rootcause: PRD: The tooling custodian accidentally dispose immediately QA: The in-process QA did not

(A). Occurrence Date: 8/14/2020, (B). Problem: MIS The print of the item is slant because the materials feeding unit exceeded on the guide height

(A). Occurrence Date: 8/27/2020, (B). Problem: MIS The materials used are warp and the paper weight jig used is not and the applied weight jig for not warp is 1 PC. Only

NOTES

1. itupi ng maigi ang creasing ng aytem at ang agwat ng flap ay 6mm

2. Clean immediately the applicator once the glue is overflowing

3. PRD: Include in EQOS WI to check 1 by 1 the print characters QA: Conduct Proof checking on the sample produce

4. 1. Recondition the warp boards using paper weight jigs 2. Separate warp & flat boards 3. Stacking height limit is 600mm

5. 1. Separate the warp boards to not warp boards for separate setup 2. Weight jigs should not be applied on the center of the boards also consider the both ends

R-001-F07 REV.00

JO Received By (WHSE):

JO Returned to (QA):

4452 TRANSFERRED TO QA - Charlotte



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

<b>DIRECT CAUSE PROCESS/MATERIAL</b>	<b>W1-</b> During mass production misalign print occurs randomly since only 43pcs out of 4,500pcs or 0.96% are affected.
	<b>W2-</b> Possible random of warp materials are included in the materials that was issued in Eqos.
	<b>W3-</b> Warp materials bumps into the feeder gate and roller of EQOS that causes delay in timing and misalign during feeding of materials.

<b>INDIRECT CAUSE (OUTFLOW)</b>	<b>W1 -</b> Operator did not trap the misalign print during sampling since it occurred randomly and only sampling are required during Eqos printing.
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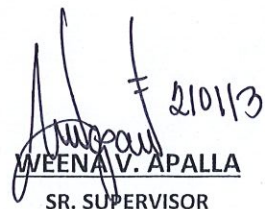
## PRODUCTION CORRECTIVE ACTION

<p>Orient the Eqos operator that once they trap warp material:</p> <ul style="list-style-type: none"> <li>- Immediate separate the raw materials once have warpage.</li> <li>- Recondition the warp materials using paper weight jig.</li> <li>- Inform the Leader in-charge regarding warp materials to spread out the information to the concern department.</li> </ul>			
<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>210114</b>

PREPARED BY:

  
 GERALD DE GUZMAN  
 PROD ASST. SUPERVISOR

APPROVED BY:

  
 WEENA V. APALLA  
 SR. SUPERVISOR