

**KANEPACKAGE PHILIPPINE INC.**

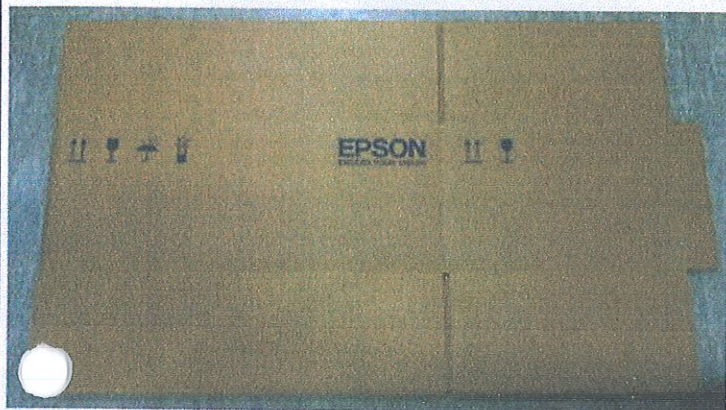
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 366

Date Issued: 21 01 19

Customer	EPSON TP	Attention To	Ms. Weena Apalla
Item Code	5149643-01	Department	PRODUCTION
Item Description	OUTER CARTON BOX	Date of Detection	21 01 18
Job Order Number	JO-21-M-00038-1	Section Detected	PRD - SEMI AUTO

ILLUSTRATION OF THE PROBLEM☐ Major ☒ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
10,900	65	0.59%

Nature of Defect:

INVERTED PRINT

Requirement:

Print should be in the smooth surface

Actual:

Print is on the rough surface

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
☒ First ☐ Recurrence No.: _____ Date: _____	☐ Hold ☐ Special Acceptance ☐ For Rework ☒ Reject / Disposal	☐ Slotter ☒ EQOS ☐ Diecut ☐ Detaching	☐ Gluing ☐ Vertical ☐ Others: _____	☐ Material ☐ Dimension ☒ Appearance ☐ Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)	
 Adrian Vergara QA-IE Staff	 Ms. Noem Cepeda QA Supervisor	 Mr. Rexel Almarie QA Asst. Manager	 Ms. Weena Apalla 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**

-RANDOM OF INVERTED PILE OF
RAW MATERIALS.

-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	Who / When
N/A	

B. Orientation

Date	Time
N/A	N/A
Title	N/A
Asses	N/A

Design / Tools	Who / When
N/A	

C. Reworking

Rework Quantity	N/A
Total Good	N/A
Rework Percentage (Good)	N/A

Process	Who / When
PLS. SEE ATTACHED.	

II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 21 01 20

PIC: A. Vergara

Identified Rootcause**Recommendation**

Boards are in wrong piling orientation (during receiving of raw materials)

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 02 08	☒ Yes ☐ No	C.A. is implemented
2nd Verification of Action			☐ Yes ☐ No	
3rd Verification of Action			☐ Yes ☐ No	
Effectiveness of Action	A. Vergara	21 03 11	☒ 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

Status	Remarks	Approved by:	Process Owner Acknowledgment: (Receiving Section)
☒ Closed	QUALITY ASSURANCE DEPARTMENT		
☐ Still open			
☐ Re-issue IRF			
	Date: 210414	Date: 210414	Date: 210414

TE AM

21 04 14

INVESTIGATION REPORT FOR INVERTED PRINT OF EPSON TP 5149643-01 OUTER CARTON BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- Upon investigation operator concern that they encountered random of inverted pile of raw materials issued in Eqos, possible occurrence during piling in supplier side.
	W2- Only sampling are required in IQA.
	W3- Only sampling and fast browsing are required during feeding of materials in Eqos to avoid delay/downtime in feeding.
	W4- Operator notice in the 10pcs per batch/pile of material sometimes there is a random of 3pcs to 5pcs inverted.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Main operator reduce the machine speed to 105bpm when they encountered difficulty in feeding due to random of inverted pile of materials.
	W2- He did not trap all the outflow during sampling since the lot qty are 10,900pcs.
	W3- Because the occurrence are randomly.

PRODUCTION CORRECTIVE ACTION

Coordinate to QA & Purchasing in 4pm meeting to inform supplier about proper piling of raw materials.			
PIC:	PRODUCTION	TARGET DATE:	200120

PREPARED BY:

[Signature]
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature]
WEENA V. APALLA
SR. SUPERVISOR



PACKAGEWORLD, INC.
Boys' Malls, City of San Jose, Laguna

IMPROVEMENTS

SUBJECT :

I. BACKGROUND

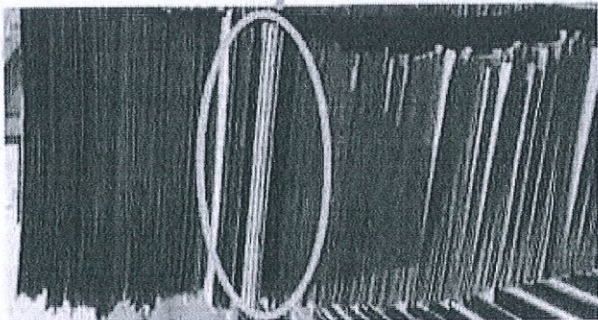
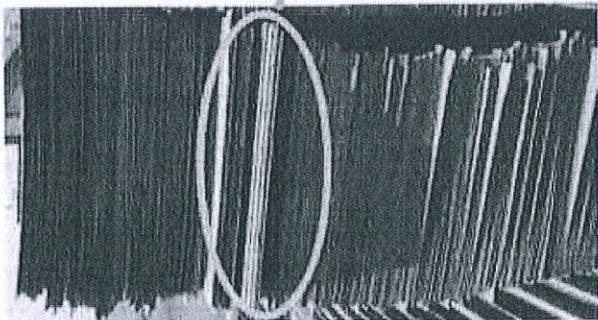
TO PROVIDE COUNTERMEASURE THAT WILL PREVENT THE STACKING AND STORAGE RELATED DEFECTS ON ITEM.

II. DETAILS :

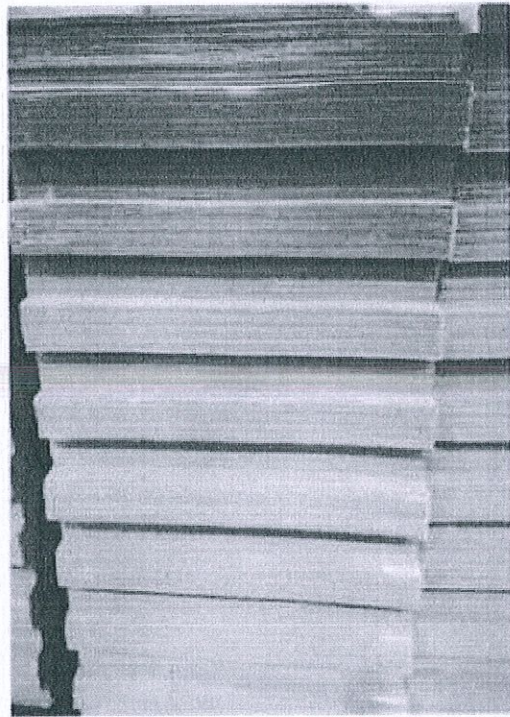
CUSTOMER : KANEPACKAGE PHILIPPINE, INC.
MODEL : APPLICABLE TO ALL CORRUGATED BOARDS

III. ACTION ITEM :

Prepared by: 	Checked by: 	Approved by:
W. Lucido	G. Paraglim	E. Barro

DEPARTMENT		MACHINE	DEFECT CAUSE	IMPROVEMENT		
Corrugating / Quality		Corrugator	INVERTED PILING	1.) Whole stack with warp boards will be automatically place on hold area and attach with hold tag for flip-flop and curing.	PIC	Timeline
Quality / Finish Goods				2.) Aligned and assigned personnel to check the boards before and during loading period.		
Illustration			Potential Root Cause	Correction		
		Insertion of warp boards during downstacking of boards in the dowstacker area.		Whole stack with warp boards will be automatically place on hold area and attach with hold tag for flip-flop and curing. During flip-flop stacking and curing, ensure that there is a gap to the facing of boards during piling. (Pis see attached copy of the proper piling for cured boards.)	Downstacker Operator Quality Inspector	Every run
				Aligned concerned personnel. Conduct Minutes of the Meeting and Attendance for awareness purposes.	Corrugating Supervisor Quality Supervisor	02/08/2021
		Not aware that the stack of boards to be deliver are with inserted flip-flop piling of cured boards.		Assigned personnel to check the boards before and during loading period.	FG Checker Outgoing Quality Inspector	Every delivery schedule
				Aligned concerned personnel. Conduct Minutes of the Meeting and Attendance for awareness purposes.	FG Supervisor Quality Supervisor	02/08/2021

PROPER PILING OF CURED BOARDS



Document No. :	PKG-CO-QMS-FM-002	Revision No. :	02
Effective Date :	September 11, 2019	Page No. :	1 of 1

DATE	2-8-21	FACILITATOR	R. Velasco / G. Panaglilma / W. Lucido
TIME	10:00am	DEPT /SECTION	Corrugating / FG / Quality
VENUE	Corrugating Office	ATTENDEES	Corrugating / FG / Quality Personnels

A OVERVIEW:

Inverted Piling Improvement Plan

B. MINUTES PROPER

[illegible]

