

**KANEPACKAGE PHILIPPINE INC.**

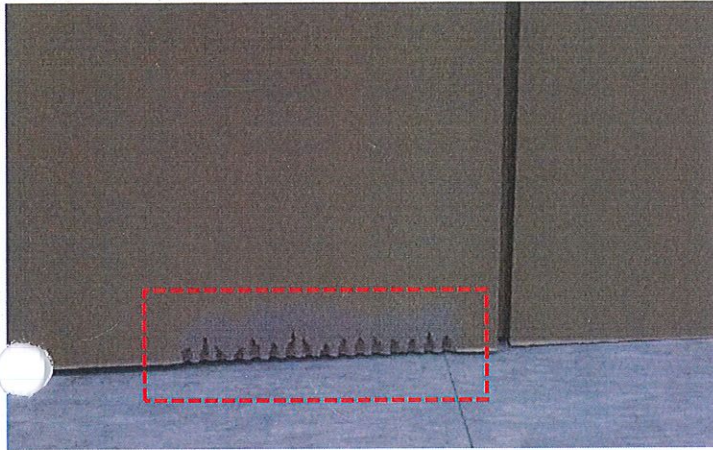
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 370

Date Issued: 21 01 25

Customer	EPSON TP	Attention To	Mr. Gerald De Guzman
Item Code	5116596-00	Department	PRODUCTION
Item Description	OUTER CARTON BOX	Date of Detection	21 01 23
Job Order Number	WO-20-M-01870-72	Section Detected	PRD - SEMI-AUTO GLUING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

2,418

Reject Quantity (pcs.)

70

Reject Percentage

2.89%

Nature of Defect:

PEEL OFF

Requirement:

Peel off should be 25mm diameter only

Actual:

Peel off length is 120mm

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"/> Gluing	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension
No.: _____	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Others: _____	<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. Reke 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**

- WARP MATERIALS

OUTFLOW ROOTCAUSE

OPERATOR DID NOT NOTICE THE PEEL OFF
- OFF SINCE IT WAS LOCATED AT THE
END PORTION OF THE CORRUGATED BOARD WITH
2412mm LONG.

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		
Issues	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: 21 01 26

PIC: A. Vergara

Identified Rootcause**Recommendation**

The kraftliner detached from the corrugated medium because the edge of the boards collided on the machine's feedgate because the materials are warp.

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 02	[X] 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	[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

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	CLOSED				
<input type="checkbox"/> Still Open		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Re-Issue IRF		Date: 21 04 14	Date: 21 04 14	Date: 21 04 14	Date: 21 04 14
DATE AND SIGNATURE					

400 X 3
200 X 3
DATE: 1/23/07
TIME: 1:16
BY: CILIAN
CITIZENSHIP: 1017
Tel: 27
Fax:




Light Industry Science Park II,
National Highway, Calamba, 4027 Laguna
Tel: (049) 545 7166/67
Fax: (049) 544-0010


SO No. : Sales Order #SO-20-M-01870
JO No. : WO-20-M-01870-72
ISSUED BY : Jecille Tuiza
DATE ISSUED : 15-JANUARY-2021
CUSTOMER : EPSON PRECISION PHILS. INC.- ASP/EPLB

Item Description:	511659600 OUTER CARTON BOX	Memo :	PHEAD-METCO (F3 PD RECEIVING)
Quantity:	1400 Piece	BK Code :	511659600
Delivery Date:	25-JANUARY-2021	Blades :	

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
703 x 2412 CF w/CREASING FOR 5116596-00 OCB 0	1415	0	0	0pcs 1415	266469	SP		Cheng

PROCESS	Finished		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
	Date	Time			In-house	Supplier		
1.EQOS <i>randy</i> <i>2/10/22</i>	<i>1/22</i>		<i>1412</i>	<i>0</i>	<i>3</i>		<i>REB/c</i>	
2.SE  JTO GLUING	<i>1/22</i>		<i>593 + 180</i> <i>492</i>		<i>70 - peel off</i> <i>40 - bursting</i>	<i>7 - Delam</i>	<i>WARD / CW</i> <i>AMBER</i> <i>YAN YAN</i>	
3.LOT NUMBERING	<i>6/22</i>		<i>1410</i>				<i>Darrel/Damian</i>	
4.SCREENING								
5.QA BUNDLE	<i>01/22</i>		<i>+580</i> <i>477 / 1057</i>		<i>11</i> <i>14 + 24</i> <i>1</i>	<i>2</i> <i>1</i> <i>3</i>	<i>EXW / G. G. G.</i> <i>Rp / G. G. G.</i>	

1. (A) Occurrence Date: 11/10/2010 (B) Problem: BURSTING (C) MC Quantity: 20 BCS (D) Rootcause: The

	KANEPACKAGE PHILIPPINE INC.	<h1>REJECTION NOTICE</h1>	Control No.:	156677					
			Date:	210129					
Item Description:		Customer:							
Item Code:		Job Order No.:							
Date Received:		D.R. No.:							
Lot Quantity:		External Provider:							
EXTERNAL PROVIDER	Nature of Defects	Quantity	Nature of Defects	Quantity	Total Qty. Rejected				
IN-HOUSE	Nature of Defects	Quantity	Nature of Defects	Quantity	Total Qty. Rejected				
	LEEL OFF	70							
	EURCTALG	43							
Prepared by:		Department / Section		Approved by		Received by		Disposition	
AMER (Signature over printed name)		SEMI-AUTO		L. VILLASCO (Signature over printed name)				<input type="checkbox"/> For Backload <input type="checkbox"/> For Disposal	
Technical Report No.									
Remarks									

PCS., (D) Rootcause
p on the rollers since

ion Date
10/22
pector
-HH222
ity

0 pcs.

feeding on the

MP
ES INC.

over printed name/Date/Time

▶ 542 TRANSFERRED TO Mr Charlotte 01/23
 ▶ 672 TRANSFERRED TO DA - Aneluc/23

INVESTIGATION REPORT FOR PEEL OFF OF EPSON TP 5116596-00 OUTER CARTON BOX

DIRECT CAUSE PROCESS/MATERIAL

W1- Operator conducted pre-folding for those random of warp materials they trap.

W2- Possible they missed to pre-fold some of warp materials.

W3- Warp materials bump in the feeder gate that caused peel off

CT B- BDM	C- LEMAR	D- BETCO
1870-71/72	0165	
EPSON		
511659600	5157	
2418	510	
d-blue	d-bl	
130 on	101	
703 X 2412	1010	
CF	CF	
<input type="checkbox"/> IPD <input type="checkbox"/> Sample	<input type="checkbox"/> IPD	
<input type="checkbox"/> Overhang Only	<input type="checkbox"/> Overhang Only	
Time		
Start	Finish	Sta

N SHEET		Machine
		EQOS
Time		Machine Breakdown / Downtime / Others
Start	Finish	
2157	2203	machine repair due to poor cutting overhang.
		Note: 511659600 warp materials

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL

W1- Operator did not notice the peel off, since it was located at the end portion of the corrugated board with 2,412mm long.

PRODUCTION CORRECTIVE ACTION

Conduct orientation to Eqos operator:

- Continues the pre-folding of warp materials of RSC Box.
- During sampling the long corrugated board within 2,000mm, are need to fold in the middle to check the end portion.

PIC:	PRODUCTION	TARGET DATE:	210128
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PREPARED BY:

[Signature]
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR