

**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.: 371

Date Issued: 21 01 25

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman
Item Code	5150864-01	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	21 01 23
Job Order Number	WO-DRS-20-L-0165-16	Section Detected	QA - IN LINE

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

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

14,042

35

0.24%

Nature of Defect:

GLUE STAIN / EXCESS GLUE

Requirement:

Glue stain / excess glue is not allowed in outer surface

Actual:

W/ glue stain in smooth surface

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: <u>2</u> Date: <u>21 01 23</u>	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input checked="" type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others:	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by  Adrian Vergara QA-IE Staff	Checked by  Ms. Noemi Cepeda QA Supervisor	Approved by  Mr. Rexel Almaro QA Asst. Manager	Received by (Receiving Section)  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:	Why 3:	N/A
	Why 4:	Why 4:	
	Why 5:	Why 5:	
Design / Toolings	Why 1:	Why 1:	
	Why 2:	Why 2:	
	Why 3:	Why 3:	N/A
	Why 4:	Why 4:	
	Why 5:	Why 5:	
Process / Material	Why 1:	Why 1:	
	Why 2:	Why 2:	
	Why 3:	Why 3:	PLS. SEE ATTACHED
	Why 4:	Why 4:	
	Why 5:	Why 5:	PLS. SEE ATTACHED



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**INVESTIGATION REPORT FORM (IRF)****FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

- LEAK GLUE FROM GLUE APPLICATOR

**OUTFLOW ROOTCAUSE**

- 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**

	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

Design /  
Tools

N/A

Process

PLS. SEE ATTACHED

**B. Orientation**

Date	N/A	Time	N/A
Title	N/A		
Idees	N/A		

**C. Reworking**

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

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

Date Conducted: 21 01 26

PIC: A. Vergara

**Identified Rootcause****Recommendation**

Contamination of glue from the lower roller because the gluing applicator contaminated it. Because the glue on the applicator leaks when the machine stops.

**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 02 15	[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**

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



## KANEPACKAGE PHILIPPINE, INC.

NET  
QA TRANBY: *DA*DATE: *21*

SO No.:

JO No.:

ISSUED BY:

DATE ISSUED:

CUSTOMER

WO-DRS-201-0165-16

Jecille Tuiza

15-JANUARY-2021

EPSON PRECISION PHILIPPINES INCORP

Item Description: 515086401 Individual Box, PA1

Quantity: *1000 Piece 7000*

Delivery Date: 25-JANUARY-2021

Material Description	Qty To Be Used	Cut Size	No. of Cuts	A Qty
874X918MM CF TX200/CM125/TX200 0	510 <i>1510</i>	0	0	0pcs

KAN - Kanepackage Phil. Inc.-IJP

scr

RoHS

Ref. No.:



IKANPCC21122190832814

Partscore:



515086401

Lot No.:



KAN16516D040002

Qty.:



10

Remarks:



QA PASSED -

Part. R4141691  
Name: 4 (SILANE)  
INDIVIDUA  
L

Model: N/A

PROCESS	Finished		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
	Date	Time			In-house	Supplier		
1.EQOS <i>zando 210121</i>	<i>1/21</i>		1512	6	3		REBCL	
2.ETERNA <i>zando 210121</i>	<i>1/21</i>		500 1012 <del>1412</del>	3 25			SSB GML	BLIND OK
3.SEMI AUTO GLUING	<i>1/22</i>		1740 1044	<i>20 items stuck</i>			MAD YREN/ JAYSON, MARK	PAL.
4.LOT NUMBERING	<i>01/21</i>		3101				Darrel / Rodney	
5.SCREENING			2490 280		33 64		Mark / Darrel	
6.QA BUNDLE	<i>01/22</i>		2770				Jayvee JERICK / RODNEY (bal.)	

## REJECTION HISTORY

- (A). Occurrence Date: 7/29/2020, (B). Problem: CLOSE GAP, (C). NG Quantity: 118 PCS., (D) Rootcause: Hindi itupi ng maayos ng gluing operator ang creasing para mapaliit ang agwat ng flap
- (A). Occurrence Date: 8/8/2020, (B). Problem: GLUE STAIN, (C). NG Quantity: 60 PCS., (D) Rootcause: The glue on the glue tab overflowed because the applied glue by the gluing applicator is thick since the gluing applicator controller is worn-out
- (A). Occurrence Date: 8/11/2020, (B). Problem: DOUBLE CAREMARK SIGN, (C). NG Quantity: 6,275 PCS., (D) Rootcause: PRD: The tooling custodian accidentally placed the damage rubber die on the mylar it was not dispose immediately QA: The in-process QA did not conduct detailed checking
- (A). Occurrence Date: 8/14/2020, (B). Problem: MISALIGN PRINT, (C). NG Quantity: 88 PCS., (D) Rootcause: The print of the item is slant because the materials used are warp and the stacking height of the material in the feeding unit exceeded on the guide height
- (A). Occurrence Date: 8/27/2020, (B). Problem: MISALIGN PRINT, (C). NG Quantity: 183 PCS., (D) Rootcause: The materials used are warp and the paper weight jig used is not enough (The warp can be developed in KPPI and the applied weight jig for not warp is 1 PC. Only)

## NOTES

- itupi ng maigi ang creasing ng aytem at ang agwat ng flap ay 6mm
- Clean immediately the applicator once the glue is overflowing
- PRD: Include in EQOS W.I. to check 1 by 1 the print characters QA: Conduct Proof checking on the sample produce
1. Recondition the warp boards using paper weight jigs 2. Separate warp & flat boards 3. Stacking height limit is 600mm
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 *1/01 Ndyet*

PR-001-F07 REV.00

JO Received By(WHSE):

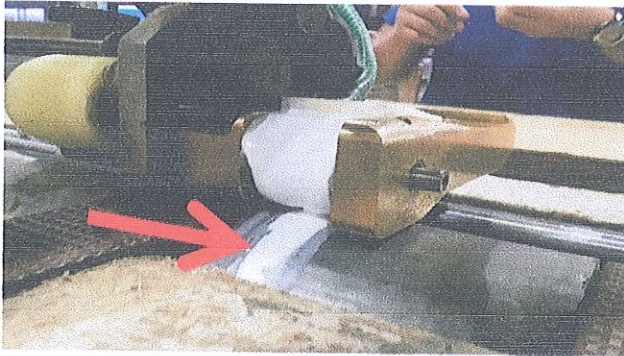
JO Returned to(QA):

27-011 TRANSFERRED to on 01/22



# INVESTIGATION REPORT FOR GLUE STAIN OF EPSON IJP 5150864-01 INDIVIDUAL BOX

<b>DIRECT CAUSE</b> PROCESS/MATERIAL	W1- Possible the glue stain occurs due to the leak glue of glue applicator to the lower roller of Semi-Auto Gluing.
	W2- Leak glue occurs if the materials feeding was stop, like they need to load items in the lifter table or breaktime.



**EXAMPLE**

<b>INDIRECT CAUSE</b> (OUTFLOW) PROCESS/MATERIAL	W1- Operator did not notice the leak glue in the lower roller since it was cover by glue applicator head.
	W2- Occurrence is randomly since out of 14,042pcs lot qty only 35pcs are affected or 0.24%.

## PRODUCTION CORRECTIVE ACTION

> Orient the operator that every time they stop the feeding they need to check and clean first the lower roller before resume to mass production.

<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>210128</b>
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PREPARED BY:

*200126*  
GERALD DE GUZMAN  
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA  
SR. SUPERVISOR