


**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

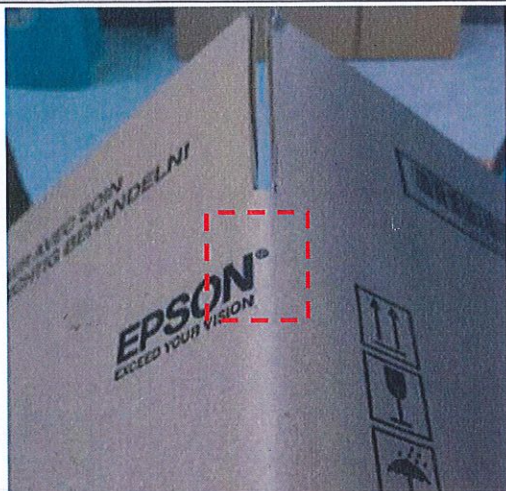
**INVESTIGATION REPORT FORM (IRF)**
☒ Inhouse Detection

☐ Customer Claim

Control No.: 391

Date Issued: 21 03 03

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman
Item Code	5153460-01	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	21 03 02
Job Order Number	WO-DRS21-L-00034-2-4	Section Detected	QA - IN LINE

**ILLUSTRATION OF THE PROBLEM**

☐ Major ☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

6,098

53

0.86 %

Nature of Defect:

MISALIGN PRINT

Requirement:

 Print movement tolerance is  $\pm 5\text{mm}$ 

Actual:

Registered mark exceeded on the creasing line

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ Date: _____	<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 checked="" type="checkbox"/> EQOS <input checked="" type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others: _____	<input type="checkbox"/> Material <input checked="" type="checkbox"/> Dimension <input type="checkbox"/> Appearance <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 2: Why 3: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A Why 4: Why 5:
Design / Toolings	Why 1: Why 2: Why 3: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A Why 4: Why 5:
Process / Material	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:



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

— WARP MATERIALS

— RANDOM 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				System	N/A	
WIP	N/A						
FG	N/A						

**B. Orientation**

Date	21 03 08	Time	09:45H ~ 09:57H	Design / Tools	N/A
Title	ORIENTATION REGARDING MISALIGN PRINT OF EPSON IJP 5153460-01 INDIVIDUAL BOX				
Idees	EQOS & ETERNA OPERATORS				

**C. Reworking**

Rework Quantity	N/A	Process	PLS. SEE ATTACHED	
Total Good	N/A			
Rework Percentage (Good)	N/A			

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

Date Conducted: 21 03 04

PIC: A. Vergara

**Identified Rootcause****Recommendation**

Corrugated sheets bumped on the roller since the affected 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 03 08	<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 03 23	<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	Line Leader
Date: 21 03 23		Date: 21 03 23	Date: 21 03 23

DATE AND  
SIGNATURE

21 03 23





Kanepackage Philippine Inc.

PREVIEW  
PR-001-F04-REV.01

Memo:

# JOB ORDER

SO #: DRS21-L-00034

279

Customer: EPSON PRECISION PHILIPPINES INCORPORATED - IJP

ITEM CODE: **515346001**

JOB ORDER:

WO-DRS21-L-00034-2-3

Item Description: INDIVIDUAL BOX PA3

QTY: **1000**

DELIVERY DATE:  
2021-03-03

CREATED BY:  
De guzman, Jhoana Mantos

DATE RELEASED:  
2021-02-24

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
874X918 CF TX200	500	10 per		500		TS

Tooling Reference #

Control/Batch #:

RM Issued By:

Am 3/1

PROCESS / MACHINE	DATE	TIME		GOOD QTY	TRIAL RUN		REJECTED QTY		INCHARGE
		START	FINISH		G	R	INHOUSE	SUPPLIER	
1. EQOS <i>20 andro 2/10/30/1</i>	3/1			500	G	R			EBEJC
2. DIECUT ETERNA <i>20 andro 2/10/30/1</i>	3/1			500	G	R			SSB
3. DETACHING 1					G	R			
4. GLUING SD1800	3/1			1000	G	R			MAO JUMPHAL
5. LOT NUMBERING	3/2			1000	G	R			KIM KENNETH
6. SCREENING	3/2			991	G	R	55	4	RHAN / DARR JERICK / CEPALU
7.					G	R			
8.									
9.									
10.									

NETSUITE  
QA TRANSFER TO FG

BY: *Glenn*  
DATE: *3/2*  
TIME: *12:10*

KAN - Kanepackage Phil. Inc.-IJP

RoHS



Ref. No.:



IKANPCC21302064054686

Partcode:



515346001

Lot No.:



KAN03423D040002

Qty.:



10

Remarks:



QA PASSED -

Part (PENTAS)  
Name: INDIVIDUA  
L BOX, PA3

Model: N/A

REMARKS

WHOUSE

NAME: *by* DATE: *3/2*

NETSUITE



# INVESTIGATION REPORT FOR MISALIGN PRINT OF EPSON JP 5153460-01 INDIVIDUAL BOX

## DIRECT CAUSE PROCESS/MATERIAL

W1- Upon checking of actual reject the print was misalign in slanted position.

W2- Possible there is random of warp materials bumps into the feeder gate or roller of EQOS or even on Eterna that caused of slanted feeding of sheets since the affected is 53pcs out of 6,098pcs lot qty or 0.86%.

Sample	Start Time	Finish Time
1930	20:45	21:05
1930		
1933		19:34
1934	20:45	21:35

**EQOS**

Sample	Start Time	Finish Time
20:45	21:00	
19:52	19:52	20:15
19:53	20:03	20:21
20:21	20:29	20:45
20:29	20:45	20:55
20:55	21:00	21:05

**ETERNA**

No record of warp encountered in Eqos because possible they not notice due to machine speed of 120bpm, unlike in Eterna there are triggering in warpage due to machine error.

## INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL

W1- Eqos operator did not notice the misalign print during sampling since the occurrence is randomly.

## PRODUCTION ACTION PLAN

Since the raw materials warpage is not control of Production, our action plan is to orient and alert the Eqos & Eterna operator regarding this issue

PIC:

PRODUCTION

TARGET DATE:

210308

PREPARED BY:

*[Signature]*  
GERALD DE GUZMAN  
PROD ASST. SUPERVISOR

APPROVED BY:

*[Signature]*  
WEENA A. APALLA  
SR. SUPERVISOR





KANEPACKAGE PHILIPPINE INC.

**MINUTES OF THE MEETING**

Date: 210308 Time Start: 0945 H Time Finished: 0957H Venue: EQOS & ETERNA AREA

**ATTENDEES:**

Name	Section	Sign	Name	Section	Sign
CLEMER BELARDO	EQOS				
EDD S. DEVELLES	"				
ANTHONY PETCO	"				
ROBERG DEWID	"				
JESSIE JAMES CALVA	"				
SEGUNDO BUÑO	ETERNA				
SHERWIN MALABARAN	"				
PAULISTA ERNESTO	"				

**AGENDA:****ORIENTATION REGARDING MISALIGN PRINT OF  
EPSON JP 5153460-01 INDIVIDUAL BOX****MINUTES:**page 1 of 1**ROOTCAUSE:**

Possible there is random of warp materials bumps into the feeder gate or roller of EQOS or even on Eterna that caused of slanted feeding of sheets since the affected is 53pcs out of 6,098pcs lot qty or 0.86%.

**CORRECTIVE ACTION:**

- Temporarily hold the raw materials if there is visible warpage.
- Immediately inform the leader in-charge for the coordination to the concern department.
- If the warpage is randomly, separate the warp materials trap.
- If there is problem encounter in materials please record the problem in the Machine Ratio.

**FOLLOW UP MEETING:**

(date &amp; time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:

  
GERALD DE GUZMAN