



KANEPACKAGE PHILIPPINE INC.

## ABNORMALITY REPORT

Control No.

AR-02-000240

## I. Item Information

Item Code	5159122-00	Customer	EPSON IJP
Item Description	LOUVRE 2 MJX ICB FOR EAL	Delivery Date	FEBRUARY 08, 2022
Detection (Section / Area)	EPSON IJP	Job Order Number	12852
Inspection Date	220207 N/S	External Provider	KPLIMA
Affected Quantity	48/197	Date Received	FEBRUARY 07, 2022
Problem Description	MIXED MODEL	Delivery Receipt Number	220203 NS (Date Produced)
Reject % : 24.37%			

## II. Visual Reference (Defect Illustration)



## III. Documented Information Review (To be filled out by QA Line leader)

Related Doc. Info.	Control Number	Requirement:	
<input type="checkbox"/> Procedure Manual :		Actual:	
<input type="checkbox"/> Technical Drawing :			
<input type="checkbox"/> Work Instruction :		Conclusion and Recommendation:	
<input type="checkbox"/> Job Order :			
<input type="checkbox"/> Reports :			<input type="checkbox"/> Applicable
<input type="checkbox"/> Defect Limit :			<input type="checkbox"/> Not Applicable

## IV. Initial Disposition (To be filled out by ME Department If Needed) V. Final Disposition

<input type="checkbox"/> Good	<input type="checkbox"/> Conditional (Please indicate details)	<input type="checkbox"/> Rejected	<input type="checkbox"/> Conditional (Please indicate details)			
<input type="checkbox"/> Rejected		<input type="checkbox"/> Backload				
<input type="checkbox"/> Backload		<input type="checkbox"/> For Sorting		Person In Charge	Target Date	Signature
		<input type="checkbox"/> For Rework				

Remarks:

Detected by	Checked by	Initial Approved by (If Needed)	Approved by	Noted by
QA Inspector	QA Line Leader	ME Supervisor	QA Supervisor	QA Head

**Important: Backloading Policy (External Provider Rejects)**  
 Rejection rate that is more than 80% of the total quantity shall be approved by Top Management before backloading.

Evaluation	Approved by	Final Disposition
<input type="checkbox"/> <80% No Need		<input type="checkbox"/> Backload
<input type="checkbox"/> >80% Need		<input type="checkbox"/> Accept
	Top Management	<input type="checkbox"/> Other _____

Note: All details must be filled out completely.  
 Submit this form to Line Leader immediately after accomplishment.

QA-003-F13 REV.03

## ABNORMALITY REPORT

## VI. Item Information

Item Code	5159122-00	Customer	EPSON IJP
Item Description	LOUVRE 2 MJX ICB FOR EAL	Delivery Date	FEBRUARY 08, 2022
Detection (Section / Area)	EPSON IJP	Job Order Number	12852
Purchase Order Number	N/A	External Provider	KPLIMA
Delivery Receipt Number	220203 NS (Date Produced)	Item Date Received	FEBRUARY 07, 2022

## VII. Sorting Details/ Instructions

### VIII. Sorting Details/ Instructions

Sorting Date	Sorting Time		No. of Man-power	Lot Number	Sorted Quantity	Reject Quantity	Defect Name	Sorted by
	Start	End						
	Total Sorting Hours			Total No. of Manpower	Total Sorted Quantity	Total Reject Quantity	Total Good Quantity	Rejection Rate (%)
Sorting Result								
R&R Verification								

IX. Reworking Details  
(If Reworkable)

## X. Reworking Result

Reworking Date	Reworking Time		No. of Man-power	Lot Number	Reworked Quantity	Good Quantity	Reject Quantity	Rejection Rate (%)
	Start	End						
Prepared by			Checked by		Approved by		Noted by	
RNR Staff			QA Line Leader		QA Supervisor		QA Head	

*Note: All details must be filled out completely.  
Submit this form to Line Leader immediately after accomplishment.*

QA-003-F13 REV.03



**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.: IRF-00240

Date Issued: FEBRUARY 09, 2022

Customer	EPSON IJP	Attention To	SUZETTE DIMAYUGA/ JOEY MARQUEZ
Item Code	5159122-00	Department	KPLIMA WHSE/ KPLIMA QA
Item Description	LOUVRE 2 MJX ICB FOR EAL	Date of Detection	FEBRUARY 08, 2022
Job Order Number	12852	Section Detected	EPSON IJP

**ILLUSTRATION OF THE PROBLEM**

<input checked="" type="checkbox"/> Major <input type="checkbox"/> Minor		
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
197	48	24.37%
Nature of Defect:		
MIXED MODEL		
Requirement:		
EPSON REQUIREMENT : 5159122-00 LOUVRE 2 MJX EAL -120PCS		
Actual:		
5159122-00 LOUVRE 2 MJX EAL -72PCS		
5159112-00 LOUVRE 2 MDX EPIL -48PCS		

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: Date:	<input checked="" type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input 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 type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)	
 QA-IE Staff	 QA Supervisor	QA Asst. Manager	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: Why 4: Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:	
Design / Toolings	Why 1: Why 2: Why 3: Why 4: Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:	
Process / Material	Why 1: QA inspector was confused by the issued excess item whose Marshall issued in advance all excess item scheduled Why 2: running on Semi Auto Gluing. Why 3: QA inspector put 515911200 (48pcs.) on 515912200 (72pcs.) Why 4: QA inspector create Lot Label based on the attached tag on issued excess (515912200). Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:	

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

**B. Orientation**

Date		Time		Design / Tools		
Title						
Attendees						

**C. Reworking**

Rework Quantity		Process		
Total Good				
Rework Percentage (Good)				

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

Date Conducted: \_\_\_\_\_ PIC: \_\_\_\_\_

Identified Rootcause

Recommendation


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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action			[ ] Yes [ ] No	
2nd Verification of Action			[ ] Yes [ ] No	
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action			[ ] Yes [ ] No	

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 type="checkbox"/> Closed					
<input type="checkbox"/> Still Open		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Re-Issue IRF		Date:	Date:	Date:	Date:



## INLINE TRANSMITAL FORM

DATE	CUSTOMER	JO #	ITEM DESCRIPTION	ITEM CODE	QTY.	RECEIVED BY
2/3/2022	EPSON	12681	Louvre 2 MPX ASIA	516297800	E-68	R-13
					14 120	
					120 120 120	
					120 120 120	
					120 120 120	
					120 120	
					14 84	
				T-	(14 97)	
		12700	Louvre 2 MPX EAI	515912200	120	
					120 120 120	
					120 120 120	
					120 15	
					975	
				T-	(975)	
		12682	Louvre 2 MPX EAI	515912200	115 120	R-13
					120 120 120	
					120 120 120	
					120 120 120	
					120 120 120	
					120 120 72	
					1987	
				T-	(2000)	
		12683	Louvre 2 MPX Forching	515913300	120 82	
					202	
				T-	(202)	
		12702	Louvre 2 MPX Forching	515913400	120 87	
					207	
				T-	(207)	
		12704	Louvre 2 MPX China	516331900	120 120 120	R-8
					120 120 71	
					671	
				T-	(679)	

Broken Qty  
Excess



SHIFT: NS  
MACHINE: # 1

## INLINE TRANSMITTAL FORM

DATE	CUSTOMER	JO #	ITEM DESCRIPTION	ITEM CODE	QTY.	RECEIVED BY
2/7/2022	EPSON	10-012851	lowr 2 mdk Indonesia TOTAL: (483)	515911100	(346) 84 120 120 120 34 6 = 498 (42) 48 120 20 109	(25)
		10-12852	lowr 2 mdk ep1 TOTAL: (203)	515911200	BROKEN ATT: (42) 48 120 20 109	(24)
		10-12864	lowr 2 mdk Asia TOTAL: (2198)	515910906	120 120 120 120 120 120 120 120 120 120 120 120 120 120 120 120 120 120 21 2186	(23) (209)
		10-12865	lowr min Indonesia TOTAL: (1106)	515914900	(108) 12 120 120 120 120 120 120 120 120 120 120 120 120 120 24 1599	(27)
		10-12866	lowr 2 mdk ep1 TOTAL: (1118)	515912200	120 120 120 120 120 120 120 120 120 201 1109	(29)
			REQ. 515912200 - (72)			
			Actual: 515911200 - (48)			