

DATE: 2021 12 05
CONTROL NO. 21-05-001

JUSTIFICATION REPORT
KP LIMA

I. PROBLEM DESCRIPTION

1.1. ISSUE:

MIXING OF PANEL A AND PANEL B IN ONE PALLET

1.2. ITEM DESCRIPTION:

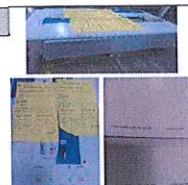
PART CODE:	5163339-00
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PART NAME:	LOUVRE 2 MDX ICB FOR CHINA
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1.3. BACKGROUND:

~ Last January 15, 2022, KP Lima encountered mixing of Panel A and Panel B in one pallet.

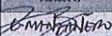
~ 37 pieces of Panel A, located on the middle and on the bottom of the palletization, were found mixed with the rest of Panel B.



II. PROBLEM ANALYSIS

QA Onsite Inspection Report:

QA ON-SITE SCREENING INSPECTION REPORT										Center No.				
KANEPAANG PHILIPPINES INC.														
I. Item Information														
General Printer		HUPC		Inspection Date		12-02-12		Shift		Day <input checked="" type="checkbox"/> Night <input type="checkbox"/>				
Item Description		GUSP99-00 LOUVE 2 MAX ETC Q1C		Inspection Method		<input checked="" type="checkbox"/> 100%		<input type="checkbox"/> 50%		<input type="checkbox"/> Spotting				
Model		LOUVE 2		Inspected by: [Signature]										
Customer		EPCAL		Inspected by										
Job Order No.		170001 0001		Reason										
Job Order Quantity		17000												
II. Details & Inspection														
Multiple Observation														
Panel #	Sheet Type	End Time	Length			Width			Height	Thickness	Grain Direction	Type of Material	LSD	Acceptance
			Top	Bottom	Left	Right	Top	Bottom						
1			903			647			N/A	QAL18		Long		<input checked="" type="checkbox"/> Good
2												Short		<input type="checkbox"/> No Good
3												Short		<input type="checkbox"/> Good
4												Short		<input type="checkbox"/> No Good
5												Short		<input type="checkbox"/> Good
6												Long		<input type="checkbox"/> Good
III. Inspection Summary														
Type of Defect		Quantity	Type of Defect	Quantity	Type of Defect	Quantity	Type of Defect	Quantity						
Bleeding Print	Like Marks		Panel Off		Panel Off		Panel Off							
Burning	Misaligned Die-cut		Panel Print		Panel Print		Panel Print							
Damage	Misaligned Glue		Panel Print		Panel Print		Panel Print							
Discoloration	Misaligned Print		Panel Print		Panel Print		Panel Print							
Dist	Misaligned Varnish		Panel Print		Panel Print		Panel Print							
Dist & Blain	Missing Print (Total Image)		Panel Print		Panel Print		Panel Print							
Fish Eye	Muffled Print		Panel Print		Panel Print		Panel Print							
Glueless	Off Color		Panel Print		Panel Print		Panel Print							
Impure Die-cut	Off-shoot		Panel Print		Panel Print		Panel Print							
Total City Inspected		2,031	Total Quantity NG		1,623	Good		<input checked="" type="checkbox"/>						
Total City Inspected		2,000	Inspection Rate		1,62	No Good		<input type="checkbox"/>						
IV. Inspection Summary														
Inspected by		Checked by		Approved by		Verified by		Acknowledged by						
[Signature]		[Signature]		[Signature]		[Signature]		[Signature]						
QA Unit		QA Unit		QA Unit		QA Unit		QA Unit						

K&N KAPPAEPAK PHILIPPINE INC.		QA ON-SITE INSPECTION REPORT		Control No.						
I. Basic Information										
External Provider	JVC		Inspection Date	21-02-12	Shift <input type="checkbox"/> Day <input type="checkbox"/> Night <input type="checkbox"/>					
Part Code	LOWE 2 - 00		Inspection Method	100%	<input type="checkbox"/> Flaming					
Item Description	LOWE 2 - 00		Each Part Inspection Method							
Model	LOWE 2 - 00									
Customer	MAYAN		Inspected by							
JOB Order No.	M2707 - 0001		Reason							
JOB Order Quantity	10,000									
II. Detailed Inspection										
Part No.	Start Time	End Time	Material Condition			Grain Direction	Type of Material	LSC	Appearance	
			<input type="checkbox"/> Good <input type="checkbox"/> Defect	<input type="checkbox"/> Printed Good <input type="checkbox"/> Poor	Length					Width
1			Good	Good	1/4"	0.18	Cl/Lang	ANNUAL STD	Good	
2			Good	Good			Cl/Lang		Good	
3			Good	Good			Cl/Lang		Good	
4			Good	Good			Cl/Lang		Good	
5			Good	Good			Cl/Lang		Good	
6			Good	Good			Cl/Lang		Good	
III. Material Inspection Results										
Type of Defect	Quantity	Type of Defect	Quantity	Type of Defect	Quantity	Type of Defect	Quantity			
Busted Pin		Line Marks		Peel Off		Stain (Blue)				
Burning		Misaligned Die-out		Poor Print		Stain (Red)				
Damaged		Misaligned Die		Punctured		Stain (Oil)				
Discoloration		Misaligned Pin		Scratching		Stain (Plastic)				
Dist		Misaligned Varnish		Scratches	13	Tea Off				
Dist/Strain		Mixing Print (Teal image)		Scumming		Whisking				
Fish Eye		Mottled Print		Short Single Face		Wrinkle				
Flowing		Oil Coat		Strained Print		Others				
Inverted Die		Oil-Shoot		Spots		Others				
IV. Inspection Summary										
Total Qty Inspected	3,013	Total Quantity NG	13	<input checked="" type="checkbox"/> Good	<input type="checkbox"/> On Hold	<input type="checkbox"/> For Re-Work				
Total Qty Good	2,000	Rejection Rate	0.4%	<input type="checkbox"/> No Good	<input type="checkbox"/> For Rejected	<input type="checkbox"/> For Rework				
V. Signatures										
Inspected by	Checked by	Approved by	Verified by	Acknowledged by						
										
QA Inspector	QA Inspector	QA Inspector	QA Inspector	Internal Provider						
QA Inspector										

Remarks:

Red Markings: Both Panel B and Panel A underwent 100% inspection method with QA Onsite and one of their checkpoints is to check the item code and which panel the inspector is inspecting.



Orange Markings: Only one person inspected Panel A and Panel B and as per our line clearance standard, we cannot inspect the same item code with difference panels simultaneously to avoid any mixing of panels. Inspection tables are provided for inspection. Also on that day, there was not much item for inspection and QA Area was not congested.


Green Markings: During the inspection of Panel A, 31 pieces of NG is found and was replenished by Printwell to complete the 2,000 pieces needed. It is impossible that those 31 pieces is placed with the Panel B since the replenished quantity is always placed on top, far from where the mixed Panel A were actually found - bottom and middle, of the pallet and if ever that happens, it will be detected immediately and two pallets will have the same Panel on top. Also, pallet for Panel A will then have discrepancies with its quantity.

Repalletizing: Repalletizing with Printwell is only done if the item will be delivered partially and is intended to be processed as samples only. In this case, output of QA Onsite is 2,000 pieces and Printwell delivered as is since this item is already existing.

III. CLOSURE

With the Inspection Report as well as repalletizing conditions presented above, it is then impossible for mixing to happen in Printwell as well as so to be mixed during inspection process of QA On-site.

PREPARED BY	APPROVED BY
 C. Flores	 R. Alvario

KANEPACKAGE PHILIPPINE INC.		QA ON-SITE SCREENING INSPECTION REPORT				Control No.				
I. Item Information										
External Provider	PAPC		Inspection Date	22-02-12	Shift:	<input checked="" type="checkbox"/> Day	<input type="checkbox"/> Night			
Item Code	SL63339-00		Delivery Date	A-P-A						
Item Description	LOWKE 2 MDX ECC CN, C		Inspection Method	<input checked="" type="checkbox"/> 100% <input type="checkbox"/> Browsing						
Model	LOWKE 2		Panel:	A						
Customer	EPSON		Instructed by							
Job Order No.	M7202-0001		Reason							
Job Order Quantity	10,000									
II. Detailed Inspection										
Pallet #	Start Time	End Time	Material Dimension				Grain Direction	Type of Material	LSD	Appearance
			<input type="checkbox"/> Board Length	<input type="checkbox"/> Printed Sheet Width	<input type="checkbox"/> Box Height	Thickness				
1			903	667	N/A	VAL.18	<input checked="" type="checkbox"/> Long <input type="checkbox"/> Short	1mm SOL	STD	<input checked="" type="checkbox"/> Good <input type="checkbox"/> No Good
2							<input type="checkbox"/> Long <input type="checkbox"/> Short			<input type="checkbox"/> Good <input type="checkbox"/> No Good
3							<input type="checkbox"/> Long <input type="checkbox"/> Short			<input type="checkbox"/> Good <input type="checkbox"/> No Good
4							<input type="checkbox"/> Long <input type="checkbox"/> Short			<input type="checkbox"/> Good <input type="checkbox"/> No Good
5							<input type="checkbox"/> Long <input type="checkbox"/> Short			<input type="checkbox"/> Good <input type="checkbox"/> No Good
III. Visual Inspection (Leave cell blank if no detection on Applicable Criteria. Ensure to put actual quantity of defect based on classification)										
Type of Defect	Quantity	Type of Defect	Quantity	Type of Defect	Quantity	Type of Defect	Quantity			
Blotted Print		Line Marks		Peel Off		Stain (Glue)				
Bursting		Misaligned Die-cut		Poor Print		Stain (Ink)				
Damaged		Misaligned Glue		Punctured		Stain (Oil)				
Delamination		Misaligned Print		Scoring		Stain (Paper)				
Dent		Misaligned Varnish		Scratches	17	Tear Off				
Dirt / Stain		Missing Print (Text/ Image)		Scurriming		Whitening				
Fish Eye		Mottled Print		Short Single Face		Worn out				
Ghosting		Off-Color		Smeared Print	14	Wrinkled				
Inverted Die-cut		Off-Shoot		Spots		Others:				
IV. Inspection Result										
Total Qty Inspected	2,031	Total Quantity NG	152	31	<input checked="" type="checkbox"/> Good <input type="checkbox"/> On Hold <input type="checkbox"/> For Sorting					
Total Qty Good	2,000	Rejection Rate	152	31	<input type="checkbox"/> No Good <input type="checkbox"/> For Backload <input type="checkbox"/> For Rework					
Remarks:										
Inspected by		Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)	Acknowledged by					
										
ON-SITE QA Inspector		QA Line leader	QA Supervisor	QA Head	External Provider					

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KANEPACKAGE PHILIPPINE INC.		QA ON-SITE SCREENING INSPECTION REPORT				Control No.																
I. Item Information																						
External Provider	POPC	Inspection Date	22-02-12	Shift:	<input checked="" type="checkbox"/> Day	<input type="checkbox"/> Night																
Item Code	5103339-00	Delivery Date	A-Y-A	Inspection Method	<input checked="" type="checkbox"/> 100%	<input type="checkbox"/> Browsing																
Item Description	LOWRER MDX for CH, C	Panel:	B	For Browsing Inspection Method:																		
Model	LOWRER	Instructed by																				
Customer	EPSON	Reason																				
Job Order No.	M2202-0001																					
Job Order Quantity	10,000																					
II. Detailed Inspection																						
Pallet #	Start Time	End Time	Material Dimension				Grain Direction	Type of Material	LSD	Appearance												
			<input type="checkbox"/> Board Length	<input type="checkbox"/> Printed Sheet Width	<input type="checkbox"/> Box Height	Thickness																
1			903	667	N/A	CH.18	<input checked="" type="checkbox"/> Long <input type="checkbox"/> Short	Hand Sol	STD	<input checked="" type="checkbox"/> Good <input type="checkbox"/> No Good												
2							<input type="checkbox"/> Long <input type="checkbox"/> Short			<input type="checkbox"/> Good <input type="checkbox"/> No Good												
3							<input type="checkbox"/> Long <input type="checkbox"/> Short			<input type="checkbox"/> Good <input type="checkbox"/> No Good												
4							<input type="checkbox"/> Long <input type="checkbox"/> Short			<input type="checkbox"/> Good <input type="checkbox"/> No Good												
5							<input type="checkbox"/> Long <input type="checkbox"/> Short			<input type="checkbox"/> Good <input type="checkbox"/> No Good												
III. Visual Inspection (Leave cell blank if no detection on Applicable Criteria. Ensure to put actual quantity of defect based on classification)																						
Type of Defect	Quantity	Type of Defect	Quantity	Type of Defect	Quantity	Type of Defect	Quantity															
Blotted Print		Line Marks		Peel Off		Stain (Glue)																
Bursting		Misaligned Die-cut		Poor Print		Stain (Ink)																
Damaged		Misaligned Glue		Punctured		Stain (Oil)																
Delamination		Misaligned Print		Scoring		Stain (Paper)																
Dent		Misaligned Varnish		Scratches	13	Tear Off																
Dirt / Stain		Missing Print (Text/ Image)		Scrimming		Whitening																
Fish Eye		Mottled Print		Short Single Face		Worn out																
Ghosting		Off-Color		Smeared Print		Wrinkled																
Inverted Die-cut		Off-Shoot		Spots		Others:																
IV. Inspection Result																						
Total Qty Inspected	2,013	Total Quantity NG	134	<input checked="" type="checkbox"/> Good <input type="checkbox"/> On Hold <input type="checkbox"/> For Sorting																		
Total Qty Good	2,000	Rejection Rate	0.064	<input type="checkbox"/> No Good <input type="checkbox"/> For Backload <input type="checkbox"/> For Rework																		
Remarks:																						
<table border="1"> <thead> <tr> <th>Inspected by</th> <th>Checked by</th> <th>Approved by (if there are major concerns)</th> <th>Verified by (if there are major concerns)</th> <th>Acknowledged by</th> </tr> </thead> <tbody> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>ON-SITE QA Inspector</td> <td>QA Line leader</td> <td>QA Supervisor</td> <td>QA Head</td> <td>External Provider</td> </tr> </tbody> </table>								Inspected by	Checked by	Approved by (if there are major concerns)	Verified by (if there are major concerns)	Acknowledged by						ON-SITE QA Inspector	QA Line leader	QA Supervisor	QA Head	External Provider
Inspected by	Checked by	Approved by (if there are major concerns)	Verified by (if there are major concerns)	Acknowledged by																		
ON-SITE QA Inspector	QA Line leader	QA Supervisor	QA Head	External Provider																		

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**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-00243

Date Issued: FEBRUARY 17, 2022

Customer	EPSON IJP	Attention To	Mr. RAMOS, RODERICK
Item Code	5163339-00	Department	KPLAGUNA QA
Item Description	LOUVRE 2 MDX ICB FOR CHINA	Date of Detection	FEBRUARY 15, 2022
Job Order Number	DR:5434	Section Detected	LAMINATION-PRODUCTION

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

2,000

37

1.85%

Nature of Defect:

MIXING OF PRINTED SHEETS IN ONE PALLET

Requirement:

ITEM REQUIREMENT : 5163339-00 LOUVRE 2 CHINA)PS-B

Actual:

5163339-00 LOUVRE 2 CHINA PRINTED SHEETS (A) MIXED WITH PRINTED SHEETS (B)

NO. OF OCCURRENCE

☒ First
☐ Recurrence
No.:
Date:

DISPOSITION

☒ Hold
☐ Special Acceptance
☐ For Rework
☐ Reject / Disposal

AREA OF OCCURRENCE / ORIGIN

☐ Slotter
☐ EQOS
☐ Diecut
☐ Detaching
☐ Gluing
☐ Vertical
☒ Others:
EXTERNAL PROVIDER

CONTENT

☐ Material
☐ Dimension
☐ Appearance
☒ Process / Method

Issued by

Checked by

Approved by

Received by
(Receiving Section)

M. ANONUEVO
QA-IE Staff

Quizon
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 1:
	Why 2:	Why 2:
	Why 3:	Why 3:
	Why 4:	Why 4:
	Why 5:	Why 5:
Design / Toolings	Why 1:	Why 1:
	Why 2:	Why 2:
	Why 3:	Why 3:
	Why 4:	Why 4:
	Why 5:	Why 5:
Process / Material	Why 1:	Why 1:
	Why 2:	Why 2:
	Why 3:	Why 3:
	Why 4:	Why 4:
	Why 5:	Why 5:

**KANEPACKAGE PHILIPPINE INC.**

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

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:



KANEPACKAGE PHILIPPINE INC.

LWHA WAREHOUSE
ABNORMALITY REPORT

LWHSE - 001

I. Item Information

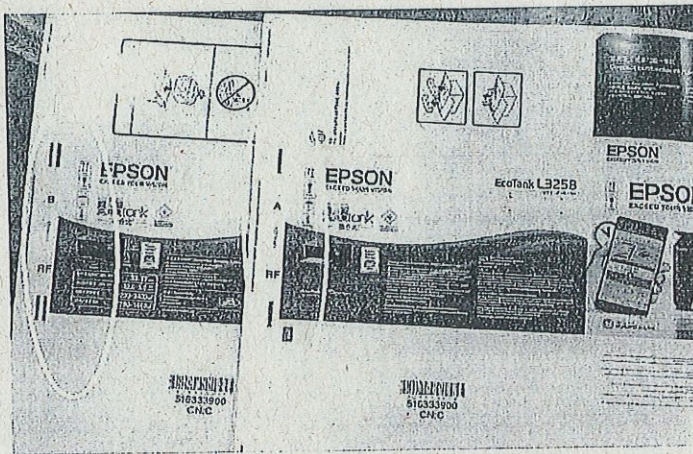
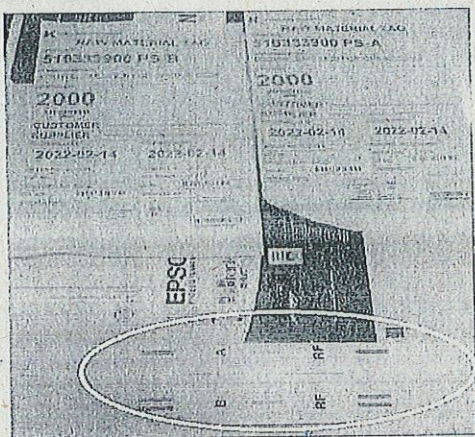
Item Code	516333900	Delivery Date	February 14, 2022
Item Description	LOUVRE 2 MDX ICB FOR CHINA;C CC350	Job Order Number	
Detection (Section / Area)	Production Area -during machine running	External Provider	PRINTWELL PACKAGING CORPORATION
Inspection Date	February 15, 2022	Date Received	February 14, 2022
Affected Quantity	2000sets	Delivery Receipt Number	5434
Problem Description	PS-A/B MIXED IN 1 PALLET	Issued to	KPLIMA QA

II. Visual Reference (Defect Illustration)

Netsuite Received Details

al Receiv	o Delivery	DR N	volet	Hur	hase Desc	BK Code	Cur	Unit Pri	Quant	Amount	RR No.	Triller/Cu	racking	Locali	Date Created	tsuite	Received	Item (N)
14/02/2022	10-FEB/DRS	5434	5767	57878	LOUVRE 2 MI	516333900 PS-A	US Dollar	0.3186	2000	\$637.20	RR-43358254	PRINTWE	160914	KPPI Limi	14/02/2022 12:18	2312864E	21/01/2022	PRINTWE
14/02/2022	10-FEB/DRS	5434	5767	57878	LOUVRE 2 MI	516333900 PS-B	US Dollar	0.3186	2000	\$637.20	RR-43358254	PRINTWE	160914	KPPI Limi	14/02/2022 12:18	2312864E	21/01/2022	PRINTWE

Actual Item



Remarks: PSA mixed with PS-B (37)

REQ. B (PS)

III. Disposition

☐ Rejected☐ Conditional (Please indicate details)☐ Backload☒ For Sorting

remaining stock undergo sorting before machine running

☐ For Rework

Remarks

Request QA for Checking /Sorting of Stocks at Warehouse before issuance.

Prepared by	Checked by	Approved by	Noted by
Ramel Obong	Suzette Dimayuga	Stela Ortega	
Warehouse Leader	Warehouse Asst. Supv.	Warehouse Asst. Mgr.	GM Operations

Received by: J. Morales

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

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