

DATE: CONTROL NO. 2021 12 05 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
PART NAME: LOUVRE 2 MDX ICB FOR CHINA

1.3. BACKGROUND:

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

External Provider item Code item Description Model Customer Job Order No.	LOUNE	3301-00							
item Description Model Customer	LOUNE		1		Inspection Date	22-02	12 sh	S Day	□ Night
Model Customer			For City	. [Inspection Method	10	A Section 1	☐ Brow	and the same
Qualatter		WARE 2 MAX ECC CH , C			Property Method	-	And the last of th		
Job Order No.	EPG				instructed by			100000	OK NOW
	Maas	02-0001			Resson	14 (15)		STATE OF THE PARTY	
Job Order Duarsty	10/	000		1	ALCOHOLD DOT	100000	war to the first	200	A RAMES
		A CONTRACTOR OF THE PARTY OF TH	()	S Octabed	bin profession		ESSENCE OF THE PARTY OF THE PAR		Contractor of the
Panel Start Tim	End Time	C) Board	LI Prime		C But	Christian Direction	Type of Make Not	LEO	Acceptance
		Length	VA:th	Holys	Thickness		- CASALI		
1	100000	903	467	NA	Q4L,18	[3 red	Hadsd	SID	CS, Cress
	and the	,0	9913	14		D tens	[m//zer	-10	☐ No Good
.2	State .	NAME OF THE OWNER, OWNE	111			D Stort			☐ No Good
10 mg	1000	100				[] term	District Co.	No.	□ Good
3			12 3			[] Short	the Lates	NAME OF	☐ No Good
	S. Sales	TO SECURE	100000000000000000000000000000000000000	Approx		□ Long		PERSONAL PROPERTY.	□ Good
	1200	10-82-63		SWIE ES		[] Short			I No Good
5	TANKS OF T	THE REAL PROPERTY.	1 2005/14/00/03/03		ASSESS TO A STREET, SALES	[] Long	102100000000000000000000000000000000000		☐ Good
					Chiefa Chiavity		orginal to		Lone
Type of Defect Butted Print Bushed	Que.	Ty Live Ma	on of Defect	O.oray	Type of Detect Peel Off 1 Pour Print	O.act		e of Defect	Que
Type of Defect Blutted Print		Py Ty Line Ma Mealig Mealig	pa of Defect who ned Die-cut ned Dius		Peel Off 1 Poor Print Purchased		Brain (CE) Stain (CE) Stain (Inc) Stain (CE)	e of Defect	Quirk
Type of Defect Butted Print Bursting Demaged Detamination	Quen	Dy Ty Line Ma Unaday Maniay Maniay	pe of Defect who ned Dis-cut ned Dise ned Print		Post Off 1 Post Print Post Print Purchased Booking	0.83	Brain (CA Stain (CA Stain (CA Stain (CA Stain (CA	e of Defect	Qinq
Type of Diefect Blutted Print Bursting Damaged Determination Dent	Quen	Ty Ty Live Ma Unsalg Massly Massly Massly	pe of Defect whs med Die-cut med Die-cut med Die-cut med Print med Varnish		Type of Detect Peel Off 1 Poor Print Purchased Scoting Scretches		Brain (CA Stain (CA Stain (CA Stain (CA Stain (CA Stain (CA Stain (CA Stain (CA Stain (CA	of Defect	Que
Type of Diffect Butted Print Bursting Damaged Detarrington Det	Quen	Ty Ty Live Ma Unsalg Massly Massly Massly	pe of Defect whs med Die-cut med Die-cut med Prive med Varnish i Priot (Text) Image)		Post Off 1 Post Print Post Print Purchased Booking	17	Brain (CA Stain (CA Stain (CA Stain (CA Stain (CA	e of Defect (e))) per)	One
Type of Defect Bushing Bushing Demaged Detamination Dent	Quen	Ty Ty Live Ma Maslip Maslip Maslip Maslip Maslip Maslip Maslip Maslip Maslip	pa of Defect wha and Die-cut and Die-cut and Die-cut and Dius and Prive and Varniah p Péré (Teuti Image) Péré		Type of Detect Peel Off 1 Poor Print Purchased Scoting Scretches Scurming	17	Type State (CR) State	e of Defect (e))) (e) (e) (e) (e) (f) (f)	Q.mV
Type of Defect Butted Pinet Bursting Damaged Detamination Oest Cit / Stain Fish Eye	Quen	Ty Ty Line Ma Maning Ma	pa of Defect wha med Die-out med Die-out med Glas med Priva med Varniah Priot (Text Image) Friot or sot		Type of Defect Peel Off Poor Print Purchased Sooting Scretches Scumming Short Single Face	17	Typ Typ Stain (Cit Vin) Vin) Vin) Vin) Cit	e of Defect	Q my
Type of Defect Bushed Print Bushed Print Bushed Desamination Dest Cited Stain Fish Bye Chosting Inverted De cut	Own	Ty Ty Une My Mailign M	pe of Defect wha ned Die-out ned Die-out ned Die- ned Print ned Varniah Print (Text Image) Print or oot CCCCC (Egypta)	Occup	Type of Detect Peel Off. 7 Poor Print Purchased Scoting Screening Short Single Face Smeared Print Epots	17	Extra Control	d of Defect	
Type of Direct Blutted Print Bursting Damaged Detamination Dent Dirt Stain Fish Eye Ghosting) Ours	Ty Ty Line Ma Maning Ma	pa of Defect wha med Die-out med Die-out med Glas med Priva med Varniah Priot (Text Image) Friot or sot	Occup	Type of Detect Peel Off 1 Poor Print Purchard Scoting Scrittnes Sourning Short Single Face Smeared Print	17	System (GL) State (GL)	(CIDefect ()))) pert) d	Guera For Bursing For Revork

KANE	PACKAGE	PHLIPPI	NE INC.	DA ON-SITE	SCRE		PECTION	REPORT	C	ontel Na
External I flem Coo flom Des	122			x too cal	,c					□ Night
Motel Custome Job Orde Job Orde		EVS	107-00	Paret B	# October	Instructed by Resson	1			
Palet #	Dist Trat	End Time	D Board	Material C D Prints	Directors .	C) Pox Distores	Grain Directors	Type of State (a	LSO	Apperarca
,			900	UUF	1/2	CH.	9 Diene	HONSUL	SID	Ø Good ☐ No Good ☐ Good
2							□ Short □ Long			☐ No Good
•					77		C Short		1.9	☐ Na Good ☐ Good ☐ No Good
5	- 0/4	Title State Sta	on allowance control	ex ansome selection	Ace ion	Colora Ensain la	D too	p or detect parties	in the state of	G Good
Type o	(Dated	O.ave		rpe of Defect	Questly	Type of Detec			gared Darlect	Quete
Bursting Damage Determine	1	.,	Missig Missig	ned Die Gut ned Glue ned Print		Peor Print Punctured Scoring		Stain D Stain N	nio	
Dett Did/Sta	in '		Missilg	ned Varrish Print (Text' image)		Scretches Southning Short Single Fa	13	Tear O Whiten	e ing	0 (0)
Ghostro Inverted		75	Off-Co	er .		Smeared Print Spota		Votelo Others	d .	
Total Qt	Inapected Good	2,0	13	Teta Quantity Rejection Rate		0.34	€1 Good	D 011	teld 🗆	For Borting For Rework
-2	inspected b		Ch	round by	th grant w	proved by sugge concurred)	Vedice of there are the	d by jor concerns)	Adire	wledged by
		tono			THE SHAPE	NEW PROSPECTOR STORY		27-45-10075		

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. Albaria

					in in the second		1			\$. \ !! \ !
	KANEPACKAGI	E PHILIPPINE I	NC. C	A ON-SITE	SCRE	ENING INSPE	CTION F	REPORT	Contro	il No.
	External Provider Item Code Item Description / Model Customer Job Order No. Job Order Quantity	PLOOPE SILVERTO LOUNGE LOUNGE EPSON MYROL 10,000	2 - 0001	Panel: A	J. Item Info	Inspection Date Delivery Date Inspection Method Instructed by Reason	1	-12 Shin: A	☐ Browsing	4 1 1 -
	Railet # Start Time	217 The Control of th	Board Leingth	Material D Printe Width UU7	NAME OF TAXABLE PARTY AND	Hox Thickness CAL.18	Grain Direction Long Short	Type of Material		Appearan Good No Go
	3						Long Short Long Short Long Long Long		\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	No Good No Go
	5	ual Inspection (La	eave cell blar	nk if no detection or	Applicable (Crilena Ensure lo pul a	Short Long Short Short	of defect based o	n clasification)	Good
6	Blotted Print Bursting Damaged Delamination Dent Dirt / Stain Fish Eye Ghosting Inverted Die-cut	Quantiy	Line Mar Misaligne Misaligne Misaligne Misaligne Missing F Mottled F Off-Color	ed Die-cut ed Glue, ed Print ed Vamish Print (Text/Image) Print r	Quantity	Peel Off Poor Print Punctured Scoring Scratches Scuriaming Short Single Face Smeared Print Spots	14	Stain (Gi Stain, (ini Stain (Oi Stain (Pa Tear Off Whitenin Worn ou Wrinkled Others:	k) II) saper) tt	Cluster of the control of the contro
ri, ri, ri, ri, ri,	Total Qty Inspected / Total Qty Good Remarks:	2,031 2,000		tion Result Total Quantity N Rejection Rate	NG V	 \$2 31 'C2	Good No Go	□ On Ho		r Sorting r Rework
	Inspected by Inspe	ntero	(1) (1) (2) (1) (1) (1) (1) (1) (1) (1) (1) (1) (1	ked by	The state of the s	proved by s major concerns) (() Supervisor	Verified there are major QA Hee	CONTROL OF THE PARTY	Acknowledg	

External Provider Item Code Item Description Model Customer Job Order No.	FYOUR LOUVILLE PSO	E2.	Fanel: B	Litem (in	Ins De Ins Ins	pection Date livery Date pection Method tructed by	11, 11	2-12 Shm:	☐ Brow	1
Job Order Quantity Pallet # Start Time	End Time	O	Matérial (Inspe	ason stion Box	Grain Direction	Type of Material	LSD	Appearance
1		Length 905	With	Heigh		Thickness CH.18	□ ∠ sing	HAM SUC	SID	Good Good No Good No Good
3		: :			- 1		☐ Long ☐ Short ☐ Long ☐ Short		1	Good No Good No Good No Good
5 III. Vis	ual Inspection	CHARGOS SECURIOS SECU	k if no detection on	Applicable	SECURE TEXTS	Ensure lo pul a		CONTRACTOR OF STREET		correction produced accordance and
Blotted Print Bursting Damaged Delamination		Line Mari Misaligne Misaligne Misaligne	d Die-cut	Statistics of the state of the	Po Po Pu	el Off or Print outured outling .	Quanti	Stain (Gi Stain (Ini Stain (Oi Stain (Pa	0	Quantity
Dent Dirt / Stain Fish Eye Ghosting		Missing P Mottled P Off-Color			Sca	atches unming ort Single Face eared Print	3	Tear Off Whitenin Worn ou Wrinkled		
Total Qty Inspected Total Qty Good	2.01	Off-Shoot	The second secon	IG i.	Spo 12	ats ,	☐ Good	□ On Ho		For Sorting For Rework
Remarks:		1 17 17								

A STANCE

Charles of the Anna County

		E PHILIPPINE INC. a Mesa, Calamba City, Laguna	INVESTIGA	TION REPORT				
Telepho	ne No. (049) 545-7166 to (049) 545-6302		Inhouse Detection Customer Claim Control No.: IRF-00243 Date Issued: FEBRUARY 17, 2022					
Customer	EPSON IJP		Attention To	Mr. RAMOS, RODERICK				
Item Code	ode 5163339-00			KPLAGUNA QA				
tem Description	LOUVRE 2 MC	OX ICB FOR CHINA	Date of Detection	FEBRUARY 15, 2022				
Job Order Number	DR:5434		Section Detected	LAMINATION-PRODUCTION	1.			
	ILLUSTRATION OF	THE PROBLEM	Major	Minor				
ATTACHMENT OF PICTURE:			Lot Quantity (pcs.) 2,000 Nature of Defect:	Reject Quantity (pcs.)	Reject Percentage 1.85%			
Pion I pron		O STORY OF MANUAL PROPERTY OF THE PROPERTY OF	- XXXXXXX	G OF PRINTED SHEETS IN ON	E PALLET			
	PRO I	13 May 1		REMENT : 5163339-00 LOUVRI	E 2 CHINA)PS-B			
Best Control			Actual: 5163339-00 LOUVRE	E 2 CHINA PRINTED SHEETS (A SHEETS (B)) MIXED WITH PRINTED			
NO. OF OCC	URRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN CONTENT					
First		Hold	Slotter	Gluing	Material			
Recurrence		Special Acceptance	EQOS	Vertical	Dimension			
No.:		For Rework	Diecut	Others:	Appearance			
Date:		Reject / Disposal	Detaching	EXTERNAL PROVIDER	Process / Method			
· Issue	ed by	Checked by	Approved	l by	Received by (Receiving Section)			
M. ANONU		QA Supervisor	QA Asst. Ma	anager	Head/ Supervisor			
	7	I. INVESTIGA	ATION / ANALYSIS					
DIRECT CAU	SE: (Analyze the reas	on of occurrence, why it happened?)	INDIRECT CAU	SE: (Analyze the reason of occu	rrence, why it leaked?)			
Why 1:		16 15 50	Why 1:		17-11-11-11			
My 4:			Why 2:					
Why 3:			Why 3:					
why 4:			Why 4:					
Why 5:			Why 5:					
Why 1:			Why 1:	0.36.				
Sbu Why 2:	21-1-1-5		Why 2:					
Why 3:			Why 3:					
Sbujioo / Why 2: Why 3: Why 4:			Why 4:					
Why 5:			Why 5:		X. Valence			
Why 1:			/ Why 1:					
ig Why 2:			Why 2:					
My 3: Why 4:			Why 3:		17 1 18 1 19 M			
S			Why 4:					
Q Wily 4.	17.10		Why 6:					

R

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)

Pax No. (049) 5			FINAL CON	CLUSION		
UNIX CO	CCURRENCE ROOTCAUSE				OUTFLOW ROOTCAUSE	
IMMEDIATE ACTION: (A	ction to be done to contain/ tempora	ary correct the prob	lem found)	CORRECTIVE	ACTION: (Actions to be done to ensure that the pro-	oblem will not happen again)
Sorting Result				Ac	tions to be done to eliminate recurrence	Who / When
Loc	ation Total Stock	NG	Total Good			
RM -			100	System		
WIP	· · · · · · · · · · · · · · · · · · ·		17.6	System		
G						
Orientation						sale i Sing
Date ()	Time	34 × 5	1 . T	Design /		
Γitle		4		Tools		
Attendees						
Reworking	× 2 1					Co. 8 1. 20 1.
Rework Quantity	profit of the second			Process		
olal Good	in the state of the state of	1, 1, 1, 1, 1, 1, 1, 1, 1, 1, 1, 1, 1, 1			为为为 多种多种	1777
Rework Percentage (Good)				1. 1. 1.		· · · · · · · · · · · · · · · · · · ·
II. QA ROOTCAUSE	VERIFICATION (To be filled	out by QA In-o	harge)	Date Conducted	PIC:	<u> </u>
	Identified Rootcause				Recommendation	
	III. CORF	RECTIVE ACTION	ON VERIFICAT	ION (To be filled	out by QA In-charge)	
	Checked by	Date		nented?	Remarks	
1st Verification of Action			[]Yes	[j No		
2nd Verification of Action			[]Yes	[] No		
3rd Verification of Action			[]Yes	[] No		
Effectiveness of Action			[] Yes	[] No		
Note: If no same defects deliveries or 3rd verificati	problems occurs for 5 conse on of action still not yet imple	ecutive deliverie mented, Investig	s, corrective ac gation Report s	ation is considered hall be re-issued	d effective / closed. If the same problem occ to the affected department to provide new in	curs within 5 consecutive improvement action.
	entre de la companya		A STATE OF THE PARTY OF	OSURE		
Status:	Remarks:		Appro	oved by:	Process Owner Acknowled	gment: (Receiving Section
Closed						
Still Open		QA S	upervisor	QA Asst. M		Department Head
Re-Issue IRF		Date:		Date:	Date:	Date:

ABNORMALITY REPORT

LWHSE - 001

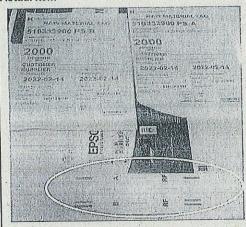
i. Item Information		TO STATE OF THE ST	February 14, 2022
Item Code	516333900	Delivery Date	repluary 14, 2022
Item Description	LOUVRE 2 MDX ICB FOR CHINA;C CC350	Job Order Number	
Detection (Section / Area)	Production Area -during machine running	External Provider	PRINTWELL PACKAGING CORPORATION
	February 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

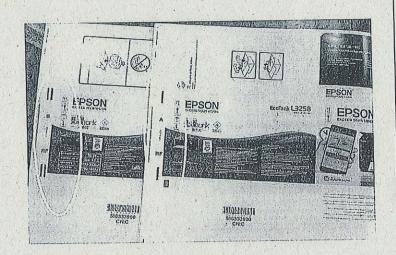
II. Visual Reference (Defect Illustration)

Netsuite Received Details

BK Code | TCurren | Unit Pr | Quanti | Amoun | RR No. | Tillericu | Frackind | Locatil | Date Created | Tisuite | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | Tillericu | Tirackind | Locatil | Date Created | Tisuite | Tillericu | 14/02/2022 10-FEB/DRS

Actual item





Remarks! PSA mixed with PS-B

Rtq. B (PS)

		Remarks			
III. Disposition		Remarks			
Rejected Cor	nditional (Please indicate details)	Request QA for Checki	ng /Sorting of Stocks at		
Backload	A CONTRACTOR OF THE STATE OF TH	Warehouse before issue	Warehouse before issuance.		
For Sorting remaining	stock undergo sorting before machine i	running			
For Rework					
Prepared by	Checked by	Approved by	, Noted by		
	/ MN/ /	Jan Sall			
Ramel Obong	Suzette Olmayuga	Stela Ortegal	<u> </u>		
Warehouse Leader	Warehouse Asst.Supv.	Warehouse Asst.Mgr.	GM Operations		
		F 100			
and the second second	Racevied by	; O, W. BLANDARY	er the the the think is		

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