

**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.: 166

Date Issued: 20 02 12

Customer	P.IMES	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	N / A	Department	PRODUCTION
Item Description	WARMER BAG BOX	Date of Detection	20 02 10
Job Order Number	WO-20-R-046-1	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

402

11

2.74%

Nature of Defect:

Misalign Print / DIECUT

Requirement:

The text of the item should not be inclined

Actual:

The printed text is incline and touch the creasing line

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
☒ First ☐ Recurrence No.: _____ Date: _____	☐ Hold ☐ Special Acceptance ☐ For Rework ☒ Reject / Disposal	☐ Slotter ☒ EQOS ☐ Diecut ☐ Detaching ☐ Gluing ☐ Vertical ☐ Others: _____	☐ Material ☐ Dimension ☒ Appearance ☐ Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by Mr. Roderick Ramos QA Supervisor	Approved by Mr. Rexel Almario QA Asst. Manager	Received by (Receiving Section) Mr. Gerald De Guzman / Ms. Weena Apalla 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: NOT A FACTOR	Why 1: Why 2: Why 3: Why 4: Why 5: NOT A FACTOR
Design / Toolings	Why 1: Why 2: Why 3: Why 4: Why 5: NOT A FACTOR	Why 1: Why 2: Why 3: Why 4: Why 5: NOT A FACTOR
Process / Material	Why 1: - THERE IS RANDOM OF WARP MATERIALS PROCESS IN ETERNA. Why 2: - MISALIGN DIECUT OCCURS DUE TO WARP MATERIALS. Why 3: - ETERNA CAN'T GRIP WELL THE WARP MATERIALS THAT CAUSED MACHINE ERROR. Why 4: Why 5:	Why 1: - RANDOM OCCURENCE OF WARP MATERIALS. Why 2: - THE AFFECTED OF MACHINE ERROR DID NOT CHECK 100%. Why 3: - AFTER APPROVED THE TRIAL RUN ONLY SAMPLING IN THE TOP PORTION PER BATCH (25PCS) ARE REQUIRED. Why 4: Why 5:

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

- DUE TO WARP MATERIALS MACHINE GOT ERROR AND CAUSED MISALIGN DRECT

- THE AFFECTED OF MACHINE ERROR DID NOT CHECK 100%

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			
WIP	N/A			
FG	QA - SCREENING	402	11	391

System	N/A	
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B. Orientation

Date	N/A	Time	N/A
T	N/A		
Attendees	N/A		

Design / Tools	N/A	
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C. Reworking

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

Process	- RECONDITION OF WARP MATERIALS - THE BATCH (25PG) THAT AFFECTED OF MACHINE ERROR WILL BE SEPERATE AND NEED TO CHECK 100%	PRODUCTION, QA & WAREHOUSE PRODUCTION & QA IF OK
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II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 20 02 15 PIC: A. Vergara

Identified Rootcause**Recommendation**

~ there was difficulty for gripping the materials from feeding to cutting because the boards are warp (this warp materials cause downtime to the affected process and it was recorded on their monitoring)

~ Separate the flat boards to warp boards and process in separate setup since the setup of flat boards is not appropriate w/ warp materials

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 02 14	☒ Yes ☐ No	See CA. & recommendation
2nd Verification of Action			☐ Yes ☐ No	
3rd Verification of Action			☐ Yes ☐ No	
Effectiveness of Action	A. Vergara	20 08 28	☒ Yes ☐ No	No running for 6 months and the item is EOL

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

Stamps	Remarks	Approved by:	Process Owner Acknowledgment: (Receiving Section)
☒ Closed	QUALITY ASSURANCE DEPARTMENT		
☐ Still Open	CLOSED	QA Supervisor	Line Leader
☐ Re-Issue IRF		QA Asst. Manager	Department Head
	Date: 20 08 28	Date: 20 08 28	Date: 20 08 28
DATE AND SIGNATURE			

OPERATION RATIO & CONDITION SHEET DIE-CUT/ETERNA MACHINE

MACHINE: ETERNA

OPERATOR: SHERVIN, LEO, OTTO

DATE: 20-02-08

SHIFT: N/S

JOB ORDER #	20-R-04U-1	20-M-00109-1U13	20-M-00101-5	20-M-00104-1	W0-S0-1PD-747-3-1
CUSTOMER	P. IMES CORP.	Sanyo Denki	Epson ASP	Epson	Epson
ITEM DESCRIPTION	WARMER BAG BOX	0010105-01/0010102-01	5147300-00 Pad	511085300 Part n	5130155400 PAD C
QUANTITY	420	2-072	505	3000-A	232
CONDITION SHEET					
Actual Machine Speed	1800	3000	1600	3000	1700
Actual Machine Pressure	2	2	1-5	2	2
Sheet size	475 x 1470	650 x 475	1200 x 1310	705 x 565	1200 x 1365
Material	BF	CF	BF	CF	CF

00:07-00:01
Looking of
Pattern
(Missplaced)

ACTIVITY	TIME		TIME		TIME		TIME	
	Start	Finished	Start	Finished	Start	Finished	Start	Finished
Warm-up time / 5s	10:10	20:25						
Meeting	20:00	20:10						
Material Waiting / JO								
Machine Breakdown								
Breaktime					23:00	23:15		
Updating (JO, P. Sched, M. Ratio)								
Machine Set-up								
1. Take out previous blade			21:15	21:21	22:40	22:51	00:00	00:07
2. Set up new blade	20:25	20:31	21:21	21:27	22:51	23:00	00:15	00:21
3. Set up stripper								
4. Take out stripper								
5. Trial Run	20:31	20:45	21:27	21:33	23:15	23:23	00:21	00:27
6. QA Checking/Approval	20:45	20:47	21:33	21:34	23:23	23:24	00:27	00:28
Mass Production								
1	20:47	20:50	21:34	21:41	23:24	23:30	00:28	00:31
2	20:51	20:57	21:43	22:01	23:32	23:36	00:34	00:40
3	21:02	21:08	22:03	22:17	23:36	23:43		
4	21:06	21:15	22:20	22:31	23:47	00:00		
5			22:34	22:44				
6								
Downtime	20:50 - 20:55	21:43	21:41 - 21:43	23:30 - 23:32	23:30 - 23:32	23:30 - 23:32	00:32 - 00:34	
Machine Error	20:59 - 21:02	21:02	22:01 - 22:03	23:30 - 23:32	23:30 - 23:32	23:30 - 23:32		
	21:05 - 21:08	21:08	22:17 - 22:20	23:40 - 23:47	23:40 - 23:47	23:40 - 23:47		