

**KANEPACKAGE PHILIPPINE INC.**

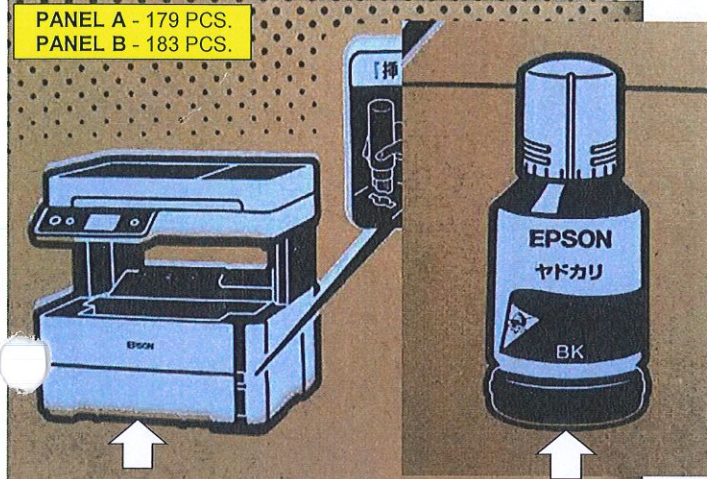
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 286

Date Issued: 20 09 12

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman
Item Code	5154356-00	Department	PRODUCTION
Item Description	5154356-00 LIONEL FGY JAPAN (PANEL A & B)	Date of Detection	20 09 10
Job Order Number	WO-TO-IPD-405-1	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
900	362	40.22%

Nature of Defect:

OFF SHOOT

Requirement:

Kraftliner should not be visible on the image

Actual:

Kraftliner is visible on the image

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 4 Date: 20 09 12	<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 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 checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by QA Supervisor	Approved by Mr. Rexel Almario QA Asst. Manager	Received by (Receiving Section) 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**

- MORE THAN 10mm WARP MATERIALS
- INHERENT MOVEMENT OF PRINT IN EDS.

OUTFLOW ROOTCAUSE

NO CHOICE BUT TO CONTINUE THE PROCESS BECAUSE WHITE PRINT ALREADY PRINTED.

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

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	N/A			

Actions to be done to eliminate recurrence**Who / When**

System

N/A

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Indees	N/A		

Design / Tools

N/A

C. Reworking

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

Process

PLS. SEE ATTACHED

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

Date Conducted: 20 09 14

PIC: A. Vergara

Identified Rootcause

- > Warp material
- > Inherent printing movement
- > Machine speed is slow < 120 bpm

Recommendation

- > Recondition materials with or without warp w/ 3 pcs. of weight digs
- > Machine speed should be 120 bpm
- > Rework offshoot WIP

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 09 18	[✓] Yes [] No	Recommendation is implemented
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	20 09 30	[✓] Yes [] No	C.A. is effective ; 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

STATUS	QUALITY ASSURANCE DEPARTMENT	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed	CLOSED		
<input type="checkbox"/> Still Open		QA Supervisor	Line Leader
<input type="checkbox"/> Re-issue IRF		QA Asst. Manager	Department Head
		Date: 21 10 01	Date: 21 10 01

DATE AND SIGNATURE

21 10 01

INVESTIGATION REPORT FOR OFF SHOOT OF EPSON LIONEL 5154356-00 LIONEL MGY JAPAN

DIRECT CAUSE PROCESS/MATERIAL	W1- Random of more than 10mm warp materials.
	W2- Base on our study acceptable warp for this item is below 10mm only due to criticality of print.
	W1- Another factor is the inherent print movement.
	W2- Even the materials is not warp we notice that there is random movement of print during 1st printing process of white color.
	W3- According to operator the inherent movement of print in Eqos is 1-2mm vs. \pm 1mm tolerance of Lionel Box why its to prone to Off Shoot even the board is not warp.
	W4- Base in our conclusion this kind of print criticality is not ideal in Eqos machine.

INDIRECT CAUSE PROCESS/MATERIAL	W1- Off Shoot is visible only after 2nd printing process of black print.
	W2- Operator don't have a choice, but to continues the process even there is random of Off Shoot, because the white print is already printed. They just make some adjustment every time they trap Off Shoot during sampling.

CORRECTIVE ACTION

"NO WARP MATERIALS MORE THAN 10MM" use for Lionel Box, because the print of this item is too critical.			
PIC:	QA, Warehouse & Production	TARGET DATE:	

Look for white ink gel pen and try to rework the affected of Off Shoot.			
PIC:	4pm Team & Production	TARGET DATE:	

Orient the operator to don't give up and give their Best for this item. Because as of now their felt surrender due to print criticality of those Lionel Boxes.			
PIC:	Production	TARGET DATE:	200916

Coordinate in Epson and try if can adjust the criticality of Off Shoot print.			
PIC:	Sales	TARGET DATE:	

PREPARED BY:


GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR