

**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

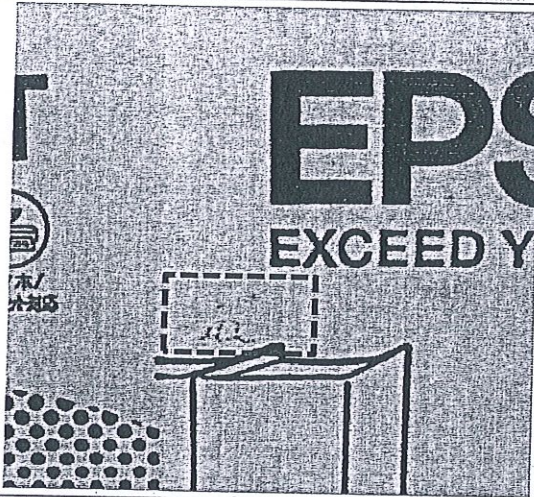
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 359

Date Issued: 20 12 28

Customer: EPSON IJP
Item Code: 5154358-00
Item Description: LIONEL SGY JAPAN;B PANEL B
Job Order Number: WO-DRS-20-L-0152-28

Attention To: Ms. Weena Apalla
Department: PRODUCTION
Date of Detection: 20 12 26
Section Detected: QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.): 500

Reject Quantity (pcs.): 88

Reject Percentage: 17.60%

Nature of Defect:

INK STAIN

Requirement:

No ink stain on the smooth surface of the area

Actual:

W/ ink stain on the smooth surface

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: _____

CONTENT

☐ Material
☐ Dimension
☒ Appearance
☐ Process / Method

Issued by

Adrian Vergara
QA-IE Staff

Checked by

Ms. Noemi Cepeda
QA Supervisor

Approved by

Mr. Rexel Almario
QA Asst. Manager

Received by
(Receiving Section)

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:

N/A

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

N/A

Design / Toolings

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

N/A

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

N/A

Process / Material

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

PLS. SEE ATTACHED

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

PLS. SEE ATTACHED

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

- PAPER TAPE DETACH FROM THE CYREL

OUTFLOW ROOTCAUSE

- OPERATOR FOCUSED ON THE OFF SHOOT ISSUE AND DID NOT NOTICE THE INK STAIN.

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	N/A			

System

N/A

B. Orientation

Design / Tools

N/A

Date	N/A	Time	N/A
Title	N/A		
Attendees	N/A		

C. Reworking

Process

PLS. SEE ATTACHED

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

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

Date Conducted: 20 12 29

PIC: A. Vergara

Identified Rootcause

Recommendation

> The paper tape attached on the cyrel got detached and leaves an ink on the boards' surface

> Change the cyrel of the black image from by parts to one piece to prevent attaching paper tapes.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 01 05	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is implemented
2nd Verification of Action	A. Vergara	21 04 17	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	Based on the observation of recommended action is not effective for off shoot issue to prevent mounting of tapes
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 11 30	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is effective

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 checked="" type="checkbox"/> Closed	CLOSED						
<input type="checkbox"/> Still Open				QA Supervisor		QA Assk Manager	
<input type="checkbox"/> Re-issue IRF				Date: 21 12 01		Date: 21 12 01	
DATE AND SIGNATURE				Date: 21 12 01			
		Date: 21 12 01		Date: 21 12 01		Date: 21 12 01	

INVESTIGATION REPORT FOR INK STAIN OF EPSON IJP LIONEL SGY JAPAN; PANEL B

DIRECT CAUSE PROCESS/MATERIAL	W1- During mass production ink stain occurs randomly since only 88pcs out of 1,020sheets (8.6%) are affected.
	W2- One of the possible cause of ink stain is the paper tape detach from the cyrel.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- They proceeded to mass production since no problem detected during trial run and sampling.
	W2- The ME and QA Patrol approved the trial run sample.
	W3- Operator focused on the off shoot issue and did not noticed the ink stain. >No OFF Shoot rejection was encountered/reported out of 1,020sheets processed simultaneously.

PRODUCTION CORRECTIVE ACTION

- Replace the old paper tape that was attached in the cyrel with new ones to avoid recurrence of ink stain.			
PIC:	PRODUCTION	TARGET DATE:	210105

PREPARED BY:

[Signature] 201024
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature] 201024
WEENA V. APALLA
SR. SUPERVISOR