


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

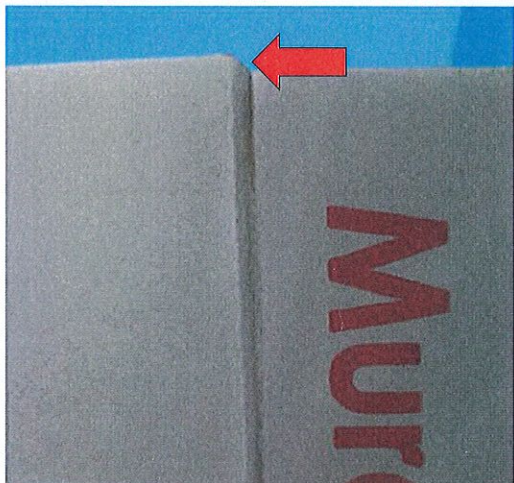
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 375

Date Issued: 21 02 01

Customer	EMORI	Attention To	Mr. Gerald De Guzman
Item Code	HP01D2200	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	21 01 30
Job Order Number	JODRS21-M-00095-2	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM

☐ Major

☒ Minor

Lot Quantity (pcs.)

2,520

Reject Quantity (pcs.)

49

Reject Percentage

1.94%

Nature of Defect:

MSALIGN GLUING

Requirement:

The bottom part of the box should be even

Actual:

The bottom part of the box is not even the it is not locking

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 5 Date: 21 01 30	<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 type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input checked="" 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	Checked by	Approved by	Received by (Receiving Section)
 Adrian Vergara QA-IE Staff	 Ms. Noemi Cepeda QA Supervisor	 Mr. Rekel Almarino QA Asst. Manager	 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**

- ITEM SLIDE DURING FEEDING IN
CONVEYOR-1

OUTFLOW ROOTCAUSE

- RANDOMLY OCCURRENCE

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

Date	N/A	Time	N/A
Title	N/A		
Issues	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: 21 02 02 PIC: A. Vergara

Identified Rootcause**Recommendation**

> The end part of the box slipped because the glue is not quick dry.
> The glue tab slipped from end part of the panel because the wip fed to the machine in overlapping manner.

> WIP feeding orientation is left & right (avoid overlapping)

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

	Checked by	Date	Implemented?		Remarks
1st Verification of Action	A. Vergara	21 02 08	<input type="checkbox"/> Yes	<input checked="" type="checkbox"/> No	4m for customer's approval
2nd Verification of Action	A. Vergara	21 03 10	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	4m is cancelled; recommendation is implemented
3rd Verification of Action	A. Vergara	21 07 12	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	4m is approved (changing of gluing process)
Effectiveness of Action	A. Vergara	21 09 13	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	C.A. & Recommendation 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

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	CLOSED	<input checked="" type="checkbox"/> Still Open			
<input type="checkbox"/> Re-issue IRF		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
		Date: 21 09 14	Date: 21 09 14	Date: 21 09 14	Date: 21 09 14
DATE AND SIGNATURE			21 09 14		

INVESTIGATION REPORT FOR MISALIGN GLUING OF EMORI HP01D2200 CARTON BOX


DIRECT CAUSE PROCESS/MATERIAL	W1- All gluing operator already oriented regarding guideline for gluing alignment of Emori D2200 & D2000.
	W2- Possible that the item was slide during feeding in Conveyor-1 because the glue not yet dry or absorb by the items.
	W3- Because the glue for manual gluing WG-8078 <u>is</u> not fast dry unlike WG 9554i

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Operator did not notice the misalign gluing since the occurrence is randomly with 49pcs reject out of 2,520pcs lot qty or 1.94% reject percentage.
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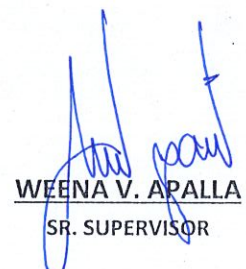
PRODUCTION CORRECTIVE ACTION

<p>> Alert the gluing operator regarding this issue.</p> <p>> Transfer of 1st gluing process in SD-1800 Semi-Auto Gluer (waiting for the 4m approval).</p>			
PIC:	PRODUCTION	TARGET DATE:	210204

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
 SR. SUPERVISOR



MINUTES OF THE MEETING

Date: 210310 Time Start: 1325H Time Finished: 1332H Venue: CONVEYOR-1 AREA

ATTENDEES:

Name	Section	Sign	Name	Section	Sign
JACKIE BALISI	GLUING				
MARCIN PASJE	GLUING				

AGENDA:

ORIENTATION REGARDING MISALIGN GLUING OF
EMORI HP01D2000 & HP01D2200 CARTON BOX

MINUTES:

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ROOTCAUSE:

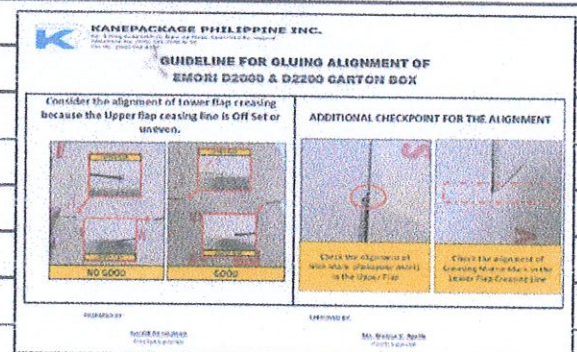
Possible that the item was slide during feeding in Conveyor-1 because the glue not yet dry or absorb by the items because the glue for manual gluing WG-8078 Glue is not fast dry unlike WG 9554i.

CORRECTIVE ACTION:

> The old version waiting for the end of life why did not consider the transfer of gluing in SD-1800.

> Always follow the existing guideline for gluing alignment of Emori D2000 & D2200.

> Avoid overlap feeding in conveyor instead make it left and right feeding, because one of the possible caused of misalign gluing is the overlap feeding.



FOLLOW UP MEETING:

(date & time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:

GERALD DE GUZMAN