



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

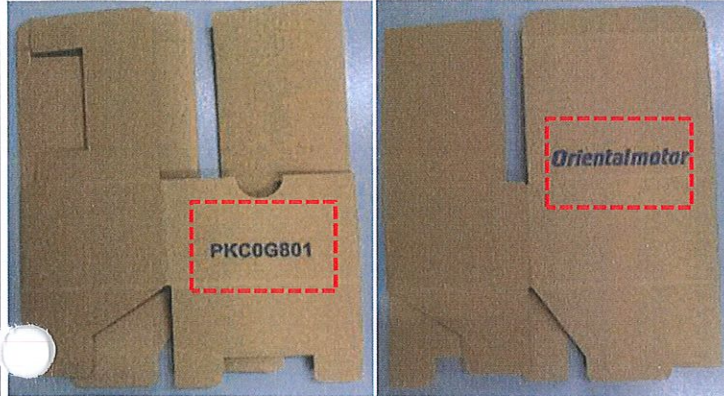
INVESTIGATION REPORT FORM (IRF)

Inhouse Detection Customer Claim
 Control No.: 379 Date Issued: 21 02 15

Customer	KOYAMA	Attention To	Mr. Gerald De Guzman
Item Code	PKC0G801	Department	PRODUCTION
Item Description	INNER BOX	Date of Detection	21 02 10
Job Order Number	JO-21-M-00067-1	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM

Major Minor



Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
2,037	73	3.58%

Nature of Defect:
 MISALIGN PRINT

Requirement:
 Printing movement should be within ±3mm tolerance

Actual:
 Printing movement is greater than ±3mm tolerance

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: <u>4th</u> Date: <u>21 02 10</u>	<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"/> Gluing <input checked="" type="checkbox"/> EQOS <input type="checkbox"/> Vertical <input checked="" type="checkbox"/> Diecut <input type="checkbox"/> Others: <input type="checkbox"/> Detaching	<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. Rexel Almario 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: <u>N/A</u> Why 4: Why 5:	Why 1: Why 2: Why 3: <u>N/A</u> Why 4: Why 5:
Design / Toolings	Why 1: Why 2: Why 3: <u>N/A</u> Why 4: Why 5:	Why 1: Why 2: Why 3: <u>N/A</u> Why 4: Why 5:
Process / Material	Why 1: Why 2: Why 3: <u>PLS. SEE ATTACHED</u> Why 4: Why 5:	Why 1: Why 2: Why 3: <u>PLS. SEE ATTACHED</u> Why 4: Why 5:

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

OCCURRENCE ROOTCAUSE

OUTFLOW ROOTCAUSE

- WARP MATERIALS

- MISALIGN PRINT NOT VISIBLE SINCE THE ITEM IS NOT YET DISMOUNTED

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				System	N/A
WIP	N/A					
FG	N/A					

B. Orientation

Design / Tools

Date	Time		
N/A	N/A		
Title	N/A		
Issues	N/A		

C. Reworking

Process

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

PLS. SEE ATTACHED

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

Date Conducted: 21 02 16

PIC: A. Vergara

Identified Rootcause

Recommendation

> The materials bump on the unit rollers because the materials are warp.
 > The origin of warp is overlapping pads

> The pads on the pallet should be flat & no 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 20	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. & recommendation is implemented.
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 05 05	<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

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed			<i>M. MEER</i> Line Leader	<i>AM</i> Department Head
<input type="checkbox"/> Still Open		<i>[Signature]</i> QA Supervisor	<i>[Signature]</i> QA Asst. Manager	
<input type="checkbox"/> Re-issue IRF		Date: 21 05 05	Date: 21 05 05	Date: 21 05 05

DATE AND SIGNATURE

[Signature]
21 05 05

INVESTIGATION REPORT FOR MISALIGN PRINT OF KOYAMA PKC0G801 INNER BOX

DIRECT CAUSE PROCESS/MATERIAL	<p>W1- Operator got problem regarding paper jam and misalign feeding during mass production.</p> <p>W2- There is warp materials issued in Eqos for this item.</p>
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Shift		Time		Machine Breakdown / Downtime / Others	
Start	Finish	Start	Finish		
2306	2334			NAG PABAGSAK SA ETERNA	EF 695X767
0030	0049			NAG PABAGSAK SA ETERNA KOYAMA	PKC 0G801
0050	0100			CLEANING OF CYREL	BLOTTER, DIRT
0102	0105			INAYOS SA FEEDER	NAG JAM
0105	0109			WARP MATERIAL	NAG SET UP ULIT
0110	0112			LAGING NAG SAJAM	STOP RUNNING
0113	0112			DUE TO MATERIAL	WARP
0118	0140			NATAGI LID ANG LABAS,	SAKANG PRINT
0150	0151			WAITING MATERIAL	PINALITAN

WARP MATERIAL

0049 NAG PABAGSAK SA ETERNA KOYAMA PKC 0G801

0100 CLEANING OF CYREL BLOTTER, DIRT

0105 INAYOS SA FEEDER NAG JAM

0109 WARP MATERIAL NAG SET UP ULIT

0112 LAGING NAG SAJAM STOP RUNNING

DUE TO MATERIAL WARP

NATAGI LID ANG LABAS, SAKANG PRINT

WAITING MATERIAL

PINALITAN

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	<p>W1- Operator missed to trap some of the misalign print during sampling since it is not so visible because the item is not yet die-cutted and small box with 4outs in sheets.</p>
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PRODUCTION CORRECTIVE ACTION

<ul style="list-style-type: none"> > Eqos operator inform the leader in-charge that time > Leader in-charge immediate stop the process and asked to Warehouse for not warp materials of 695x767 EF > Immediate replacement of warp materials to avoid long machine downtime. 				
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;">PIC:</td> <td style="width: 35%; text-align: center;">PRODUCTION</td> <td style="width: 25%;">TARGET DATE:</td> <td style="width: 15%; text-align: center;">DONE</td> </tr> </table>	PIC:	PRODUCTION	TARGET DATE:	DONE
PIC:	PRODUCTION	TARGET DATE:	DONE	

PREPARED BY: 210215
GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY: **WEENA V. APALLA**
 SR. SUPERVISOR