


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.: 394

Date Issued: 21 03 08

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman / Mr Rexel Almario
Item Code	00415456-01	Department	PRD / QA
Item Description	PACKAGE	Date of Detection	21 03 05
Job Order Number	WO-DRS-20-M-01882.-11	Section Detected	CUSTOMER - SDP

ILLUSTRATION OF THE PROBLEM


Major



Minor



Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
797	129	16.19%

Nature of Defect:

MISALIGN PRINT

Requirement:

Print should not exceed on the creasing line

Actual:

The print exceeded on the creasing line

NO. OF OCCURRENCE		DISPOSITION		AREA OF OCCURRENCE / ORIGIN		CONTENT	
☐ First	No.: <u>2</u> Date: <u>21 03 05</u>	☐ Hold	☐ Special Acceptance ☐ For Rework ☒ Reject / Disposal	☐ Slotter	☐ Gluing	☐ Material	☒ Dimension ☒ Appearance ☐ Process / Method
☒ Recurrence		☐ EQOS		☐ Vertical	☒ Dimension		
		☐ Diecut		☐ Others:	☒ Appearance		
		☐ Detaching			☐ Process / Method		
Issued by		Checked by		Approved by		Received by (Receiving Section)	
 Adrian Vergara QA-IE Staff		 Ms. Nepmi Cepeda QA Supervisor		 Mr. Rexel Almario QA Asst. Manager		 Mr. Gerald De Guzman / Mr Rexel Almario 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 1:	
	Why 2:			Why 2:	
	Why 3:	N/A		Why 3:	N/A
	Why 4:			Why 4:	
	Why 5:			Why 5:	
Design / Toolings	Why 1:			Why 1:	
	Why 2:			Why 2:	
	Why 3:	N/A		Why 3:	N/A
	Why 4:			Why 4:	
	Why 5:			Why 5:	
Process / Material	Why 1:			Why 1:	
	Why 2:			Why 2:	
	Why 3:	PLS. SEE ATTACHED		Why 3:	PLS. SEE ATTACHED
	Why 4:			Why 4:	
	Why 5:			Why 5:	

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

- SHEET SIZE BELOW 500mm IN HEIGHT

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**

	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	
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B. Orientation

Date	N/A	Time	N/A
Title	N/A		
dees	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	PLS. SEE ATTACHED	
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II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 21 03 10 PIC: A. Vergara

Identified Rootcause**Recommendation**

> The size of the sheet is below 500mm
> No suteban on the ends of the mylar

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 03 13	☒ Yes ☐ No	Mylar has suteban
2nd Verification of Action	A. Vergara	21 08 09	☐ Yes ☒ No	Adjustment in print dimension is not approved
3rd Verification of Action			☐ Yes ☐ No	
Effectiveness of Action	A. Vergara	21 05 26	☒ Yes ☐ 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

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
☒ Closed	CLOSED	QA Supervisor	QA Asst. Manager	Line Leader	Department Head
		Date: 21 05 26	Date: 21 05 26	Date: 21 05 26	Date: 21 05 26

DATE AND SIGNATURE 21 05 26

INVESTIGATION REPORT FOR MISALIGN PRINT OF SANYO DENKI 00415456-01 PACKAGE

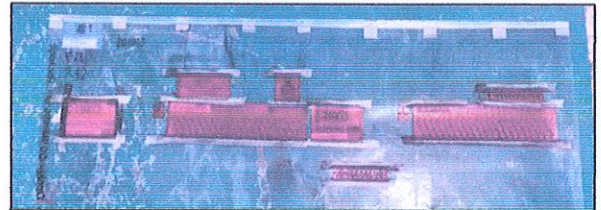
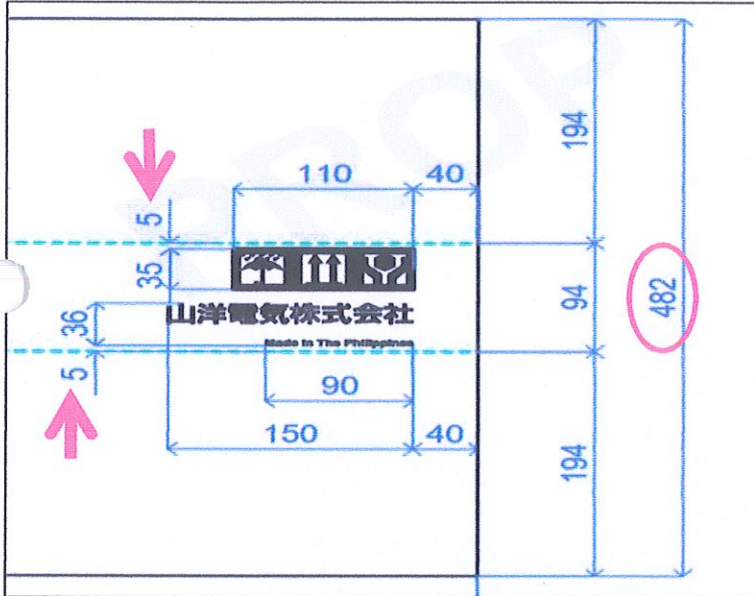
DIRECT CAUSE PROCESS/MATERIAL

W1- Item have critical print dimension of only 5mm distance of print to creasing line.

W2- Also it is prone to movement vertically because the sheet size height is below 500mm.

W3- No Suteban attached in the cyrel mylar, the time that the affected item processed.

(Affected item processed January 11, 2021, attachment of Suteban happened March 3, 2021)



BEFORE



AFTER

INDIRECT CAUSE (OUTFLOW)

W1- Eqos operator did not notice the misalign print during sampling since the occurrence is randomly.

PRODUCTION CORRECTIVE ACTION

- Adjust the print dimension (If applicable).
- For the horizontal implementation incorporate in the Eqos Work instruction the usage of Suteban to the items below 500mm in height.

PIC:	PRODUCTION	TARGET DATE:	ON-GOING
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PREPARED BY:

[Signature] 210309
GERALD DE GUZMAN
PROD-ASST. SUPERVISOR

APPROVED BY:

[Signature]
WEENA V. APALLA
SR. SUPERVISOR



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WORK INSTRUCTION MANUAL

PAGE

2 OF 7

DATE OF EFFECTIVENESS

#REF!

TITLE

WORK AND SAFETY INSTRUCTION FOR EQOS MACHINE

CONTROL NUMBER

WI-PR-002-029

REVISION NUMBER

07

PREPARED BY

CHECKED BY

APPROVED BY

A. PPE REQUIREMENT

- 1) Gloves
- 2) Safety Shoes
- 3) Rubber Gloves (during cyrel cleaning)



B. GENERAL SAFETY REQUIREMENT

- 1) Make sure that the machine is "turned off" before doing cleaning or maintenance.
- 2) Know the emergency stop button.
- 3) Report any incident, accident, or near miss.
- 4) Observe proper hygiene during break time and after work.
- 5) Conduct daily machine inspection before start of operation

C. IN CASE OF EMERGENCY

- 1) Immediately press the "emergency stop" button in case of emergency.
- 2) Immediately inform supervisor.
- 3) Immediately inform Health Team in case of injury-related emergencies.
- 4) Immediately inform ERT/ Safety Team in case of fire-related emergencies.

D. ENVIRONMENT

- 1) Always follow the waste segregation scheme (corrugated, plastic, eperan, hazardous).
- 2) Always observe energy conservation - Turn-off light, machine, electric fan, etc. when not in use.

11. Go to the feeding unit to put the materials to be used. Provide at least 2-3mm clearance on the side for proper feeding of the material. Operators in feeder should conduct fast browsing during mass production to sort out Warp, Washboard and other visible rejects in materials, but need to consider not to stop or downtime the feeding of materials.

Pumunta sa feeding unit upang ilagay ang materyales. Siguraduhin na may 2-3mm na pagitan sa gilid upang maging maayos ang posisyon ng materyales. Kailangan din na magsagawa ng mabilisang pagpili at pagtanggap sa mga reject na materyales gaya ng warp, washboard at iba pang biswal na reject, ngunit dapat ay hindi mada-downtime sa paglalagay ng materyales.

12. Use the Material Condition Sheet (PR-002-F04) if there are material issues encountered. This will be filled out by the Operator E of EQOS.

Gamitin ang Material Condition Sheet (PR-002-F04) kapag may mga problema sa materyales na gagamitin. Ang gagawa nito ay ang Operator E ng EQOS.

13. Select unit to use for printing. There are two printing units that can be selected.

Piliin sa monitor kung aling printing unit ang gagamitin.

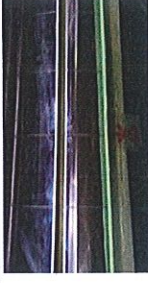
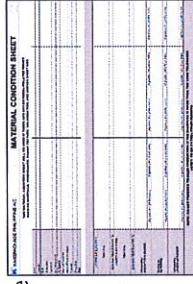
1-C = 1ST PRINTING UNIT
2-C = 2ND PRINTING UNIT

14. Go to the selected printing unit and press the **AUTO OPEN SET** to open the unit.

Piliin at pindutin sa monitor ang AUTO OPEN SET upang buksan ang printing unit.

15. When the operator enters within the printing unit, the safety switch light up as an indication for the operator's security.

Kapag pumasok ang operator sa printing unit, ang safety switch ay ilaw para sa kaligtasan ng operator.



16. In cyrel setting, there are three (3) drum divisions that can be used depending on size of the Mylar.

Sa setting ng cyrel, may tatlo itong pagkakahati-hati na maaaring gamitin ayon sa sukat ng Mylar.

- 1 - 500mm
- 2 - 1,000mm
- 3 - 1,290 mm

17. Attach the mylar in cylinder canal and make sure that it is at the center of the cylinder.

Ilagay ang mylar sa cylinder at siguraduhin na nasa gitna ito.
Note: Always use rubber suteban for those items with less than 500 mm in width and also for those items included in the form MASTERLIST OF ITEMS WITH SUTEBAN (PR-002-F03) to be posted in EQOS with more than 500 mm in width. Also, place the magnetic suteban on the other printing unit if only one unit is being used.

Tandaan: Laging lagyan ng suteban ang mga item na may sukat na mas mababa sa 500 mm ang lapad at ang mag item na naka lista sa MASTERLIST OF ITEMS WITH SUTEBAN (PR-002-F03) na nakalagay sa EQOS na may sukat na higit sa 500 mm ang lapad. Ilagay din ang magnetic suteban sa kabilang printing unit kapag isang unit lang ang gagamitin.

18. Use the foot pedal to rotate the cylinder to locate the other cylinder canal.

Gamitin ang foot pedal upang iikot ang cylinder at makita ang isa pang cylinder canal.

19. Insert the other end of the cyrel to the grip and tighten it using the wrench placed beside the cylinder.

Ilagay ang kabilang bahagi ng cyrel sa grip at higitan ito gamit ang wrench na nasa gilid ng cylinder.

