

**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

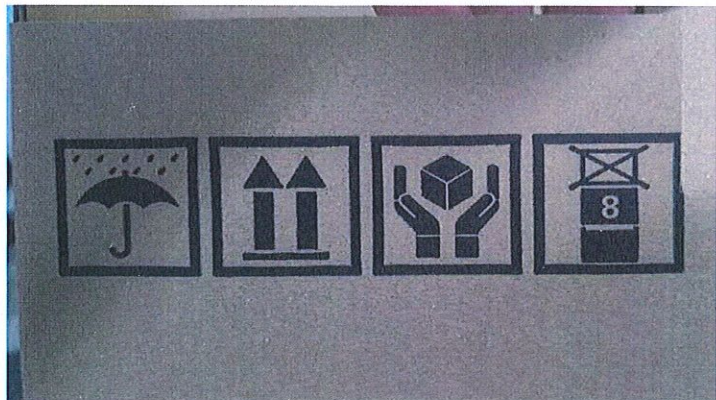
**INVESTIGATION REPORT FORM (IRF)**☒ Inhouse Detection☐ Customer Claim

Control No.: 415

Date Issued: 21 04 20

Customer	SANYO DENKI
Item Code	00949347-01
Item Description	BOX PRINT SPECIFICATION
Job Order Number	JO21-M-00463-65

Attention To	Ms. Weena Apalla
Department	PRODUCTION
Date of Detection	21 04 19
Section Detected	QA - SCREENING

**ILLUSTRATION OF THE PROBLEM**

<input type="checkbox"/> Major	<input checked="" type="checkbox"/> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1000	227	22.70%

**Nature of Defect:**

MISALIGN PRINT

**Requirement:**

Caremark image should not be cut

**Actual:**

The caremark image was cut

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ Date: _____	<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 type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
 Adrian Vergara QA-IE Staff	 Mr. Roderick Ramos QA Supervisor	 Mr. Rexel Almario QA Asst. Manager	 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: pls. see attached Why 4: Why 5:	Why 1: Why 2: Why 3: pls. see attached Why 4: Why 5:
Design / Toolings	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:
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**

Printing movement inherent from machine

**OUTFLOW ROOTCAUSE**

Misalign print is not visible during printing

**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

pk. see attached

**B. Orientation**

Date	21 04 30	Time	1:00 P.M. - 1:10 P.M.
Title	See attendance sheet		
Attendees	EQOS Operators		

Design / Tools

pk. see attached

**C. Reworking**

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

Process

pk. see attached

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

Date Conducted: 21 04 10

PIC: A. Vergara

**Identified Rootcause****Recommendation**

>The layout print was cut by the die cut blade because the print moved by 4mm (lateral) since there is print movement from printing machine that it is inherent

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 04 30	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. 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 06 24	<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.

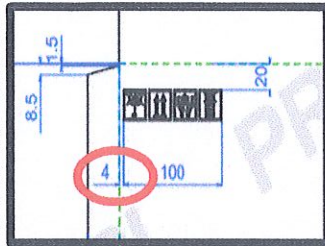
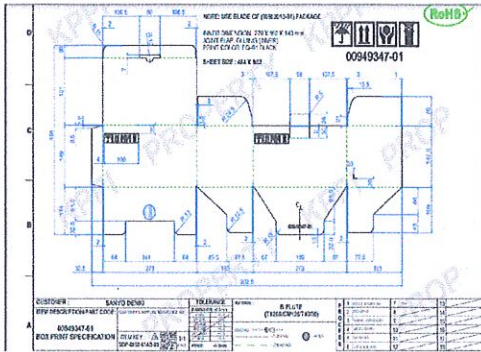
**IV. CLOSURE**

Status: <input checked="" type="checkbox"/> Closed	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)	
<b>QUALITY ASSURANCE DEPARTMENT</b> <b>CLOSED</b>		QA Supervisor	QA Asst. Manager	Line Leader
		IRISH MAY L. ESTAREJA		
DATE AND SIGNATURE	Date: 21 06 24	Date: 21 06 24	Date: 21 06 24	Date: 21 06 24

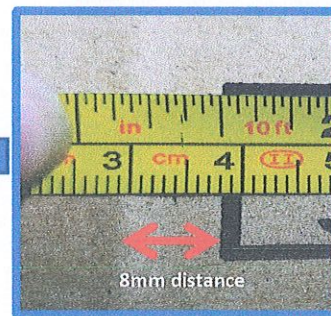
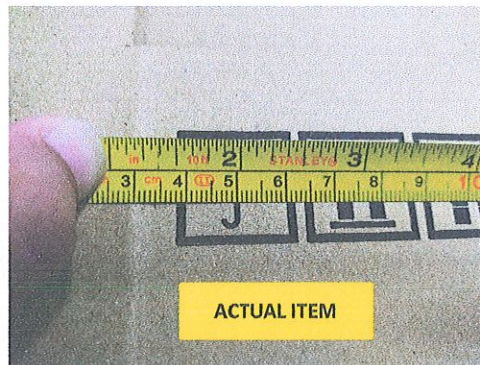
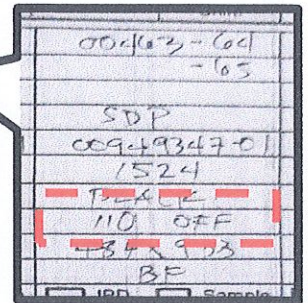


## INVESTIGATION REPORT FOR MISALIGNED PRINT

<b>DIRECT CAUSE</b> PROCESS/MATERIAL	W1- The dimension from print to creasing has 8mm distance from the original dimension of 4mm.
	W2- The inherent machine movement during running that caused misalign print.
	W3- Machine speed was in Skip-OFF mode that caused of print movement.



ITEM	QTY	UNIT	DATE
1	1	PC	10/10/20
2	1	PC	10/10/20
3	1	PC	10/10/20
4	1	PC	10/10/20
5	1	PC	10/10/20
6	1	PC	10/10/20
7	1	PC	10/10/20
8	1	PC	10/10/20
9	1	PC	10/10/20
10	1	PC	10/10/20
11	1	PC	10/10/20
12	1	PC	10/10/20
13	1	PC	10/10/20
14	1	PC	10/10/20
15	1	PC	10/10/20
16	1	PC	10/10/20
17	1	PC	10/10/20
18	1	PC	10/10/20
19	1	PC	10/10/20
20	1	PC	10/10/20



<b>INDIRECT CAUSE</b> (OUTFLOW) PROCESS/MATERIAL	W1- Operators made print adjustments during running and checked item randomly.
	W2- Misalign print is hard to notice during sampling since the item is not yet die-cutted and the machine speed is quite fast.

### PRODUCTION CORRECTIVE ACTION

>Orient to operators of do not make print adjustments if the print movement during running was 1-2mm as long as the print adjustments is within tolerance. (Applicable for die-cutted items)

PIC:	PRODUCTION	TARGET DATE:	210421
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PREPARED BY:

JUDY ANN SARMIENTO  
PROD STAFF

APPROVED BY:

WEENA K. APALLA  
SR. SUPERVISOR





KANEPACKAGE PHILIPPINE, INC.

## ATTENDANCE SHEET

Submitted by:

J. Samiento

Date:

210430

### ACTIVITY

Orientation regarding 00949347-01 Misalign Print Issue  
Corrective action: Print adjustments and Print Movements

### Attendees

	FIRST NAME	LAST NAME	DIV. / DEPT.	SIGNATURE
1.	Henry	CLAVE	EQOS Prod	
2.	PEDRO	CHAVEZ	EQOS / PROD'n	
3.	Marvin	Pamulakin	" "	
4.	Jolito	ACEYO	" "	
5.	Eric Neil	Ballesteros	PROD	
6.	ROBERT	DEAN	"	
7.	Jessie James	Calva	Prod	
8.	ANTHONY	BETA	Prod'n	
9.	Charlven	Tamala	Prod	
10.				
11.				
12.				
13.				
14.				
15.				
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