

2179



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

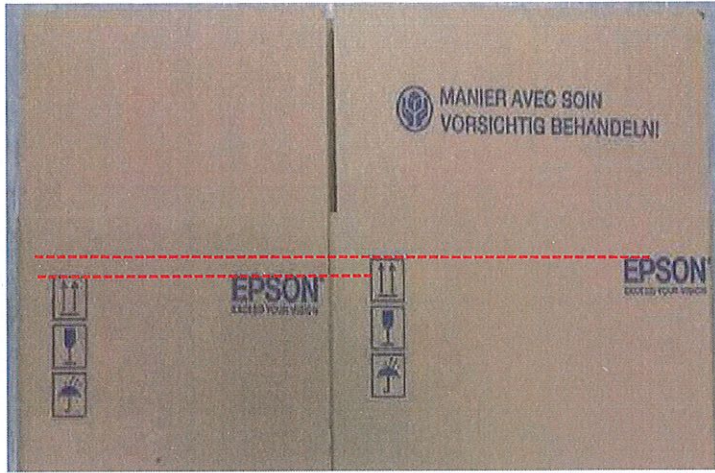
INVESTIGATION REPORT FORM (IRF)

Inhouse Detection Customer Claim

Control No.: 418 Date Issued: 21 04 28

Customer	EPSON IJP	Attention To	Ms. Weena Apalla
Item Code	5150864-01	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	21 04 27
Job Order Number	WO-DRS21-L-00050-1-23	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
3360	460	13.69%

Nature of Defect:
 MISALIGN PRINT

Requirement:
 Print should not be oblique

Actual:
 Print position is oblique

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Gluing	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input checked="" type="checkbox"/> Dimension
No.: 8	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Others:	<input type="checkbox"/> Appearance
Date: 21 04 27	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching		<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 Almarico 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:	

INVESTIGATION REPORT FOR MISALIGN PRINT

DIRECT CAUSE	W1- Due to warp materials of items.
PROCESS/MATERIAL	W2- The warp materials have not the same orientation, it has an opposite warpage of materials that caused slightly slanting of sheets during printing process of items.

Actual record in EQOS Machine Ratio

1920	1925
325	1932
351	1934
207	1546
1548	1597

NOTE with daily warp mats.

Actual record in Eterna Machine Ratio

00950 - 1-23
00950 - 1-26
EPSON
5150864-01
51010
WARP
2006
1.5
574X918
CF
#5

22:47	08:50
MACHING ERROR	(80X) (77mm)
DUE TO LEFT	
SCRAP STRIPING	AREA & WARP MATS

INDIRECT CAUSE (OUTFLOW)	W1- Operator did not notice the occurrence of misalign print due to random warp materials since it has 460 out of 3360pcs of reject only. Also the item has 2 outs.
PROCESS/MATERIAL	

PRODUCTION CORRECTIVE ACTION

>Pneumatic Pressing Machine for reconditioning warp materials
 >Add Condition Sheet in the EQOS Machine Ratio wherein operator can put the actual condition of materials together with the signature of Q.A Patrol as an indication that the warp can be process.

PIC:	PRODUCTION	TARGET DATE:	210429
------	------------	--------------	--------

KANEPACKAGE PHILIPPINE INC. OPERATION RATIO AND CONDITION SHEET							Machine		
							EQOS		
Operator	A-	B-	C-	D-	E-	Date	Shift	Time	Machine Breakdown / Downtime / Other
								Start	Finish
Job Order No.									
Customer									
Item Description									
Quantity									
Ink Color									
Actual Machine Speed									
Sheet Size									
Material									
Condition of Sheet	<input type="checkbox"/> OK <input type="checkbox"/> OK <input type="checkbox"/> OK <input type="checkbox"/> OK <input type="checkbox"/> OK								
	<input type="checkbox"/> Overhang Only <input type="checkbox"/> Overhang Only <input type="checkbox"/> Overhang Only <input type="checkbox"/> Overhang Only <input type="checkbox"/> Overhang Only								
	<input type="checkbox"/> For Discut <input type="checkbox"/> For Discut <input type="checkbox"/> For Discut <input type="checkbox"/> For Discut <input type="checkbox"/> For Discut								

Portion where operator can put the actual condition of materials

Signature of QA Patrol

PREPARED BY:
 JUDY ANN SARMIENTO
 PROD STAFF

APPROVED BY:
 WEENA V. APALLA
 SR. SUPERVISOR