11/0		/					
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				Ms. Weena Apal	la		
Item Code			Attention To Department				
Item Description	INDIVIDUAL	ROY	Date of Detection				
			Section Detected				
Job Order Number	WO-DRS21-I			Major Minor			
经验证证据	ILLUSTRATION	OF THE PROBLEM		Paicat Oventi		Reject Percentage	
			Lot Quantity (ity (pcs.)	Reject Percentage	
		MANIER AVEC SOIN	3360	460		13.69%	
		VORSICHTIG BEHANDELNI	Nature of Defect:	Nature of Defect:			
				MISALIGN PRINT			
			Requirement:				
	EPSON	EPSON'	Print should not be oblique				
子			Actual:				
				Print position i	s oblique		
NO. OF OCCU	JRRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN CONTENT				
First		Hold	Slotter	Gluing	110000000000000000000000000000000000000	Material	
Recurrence		Special Acceptance	EQOS	Vertical		Dimension	
No.: 8		For Rework	Diecut	Others:		Appearance	
Date: 21 04 27	7	Reject / Disposal	Detaching			Process / Method	
Issued		©hecked by	App	proved by		Received by (Receiving Section)	
		Malu	1	w		(necessing decount)	
	Mon	/ Mlalu-		Frmar of	To	Ay .	
Adrian Ve	2	Mr. Roderick Ramos QA Supervisor		exe Almario	He	Weena Apalla ad/Supervisor	
0			TION / ANALYSIS				
DIRECT CAUSI	E: (Analyze the reas	son of occurrence, why it happened?)	INDIRECT	CAUSE: (Analyze the reas	on of occurre	nce, why it leaked?)	
Why 1:			Why 1:				
1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1			Why 2:				
Why 3:	why 3: pls. see attached			Why 3: PK. See attached			
Why 2: Why 3: Why 4: Why 5:			Why 4:				
			Why 5:				
Why 1:			Why 1:				
			Why 2:				
Why 3:	ols. sec	e attached	Why 3:				
Ubjsed Why 4:			Why 4:	ps. sec avectica			
			Why 5:				
Why 5:		To the first	Why 1:			ty for Jay	
why 1:			Why 2:			over 1 Mar	
Tam viny 2.	pls-see	attoched		-le (co 14	ا موامد	10 1 1 1 1 10 Fellop Johns	
My 3: My 3: My 4:	40.000		100	pk. See atta	acrica		
			Why 4:				
Why 5:		<u> </u>	Why 5:				

SIGNATURE

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)

. Fa	Fax No. (049) 545-6302								
				FINAL CON	CLUSION				
	OCCURRENCE ROOTCAUSE				OUTFLOW ROOTCAUSE				
Warp corrugated boards					Warp boards are random				
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	ple. see attached			
WIP	N/A				oyotom				
FG	N/A								
B. Orientation									
Date	N/A	Time	N/A		Design /	plc. see attached	201		
Title	NIA		Tools	pig. Get outering					
Attendees	ittendees N/A					25			
C. Reworking									
Rework Quantity		N/A	N/A			tole, can obtained			
Total Good		N/A	N/A			pls. see attached			
Rework Percentage (Good) N/A									
II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)				-charge)	Date Conducted: 21 04 30 PIC: A Nergara				
	Identified Rootcause			Recommendation					
> The materis slant o	xials' orien due to war	ntation of th plooards,	e prin	ting unit					
					ļ.				

III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)							
y y	Checked by Date Implemented?		nented?	Remarks			
1st Verification of Action	A. Vengara	य ०४ २९	[Y Yes	[] No	> Material condition is included in machine ratio. > Pneumatic machine will not pursue		
2nd Verification of Action			[]Yes	[] No			
3rd Verification of Action			[]Yes	[] No			
Effectiveness of Action	A. Vergara	21 09 03	[🗸 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								
TO POLICE ITY ASSIBILITY ASSIBILI	Approved by:	Process Owner Acknowledgment: (Receiving Section)						
CiNed Spil Open	A Supervisor OA Ass. Manager	IRISH MAY L ESTAKEJA Line Leader Department/Head						
Re Issue RF Date:	21 09 06 Date: 21 09 06	Date: 11 09 06 Date: 109 06						
DATE AND								

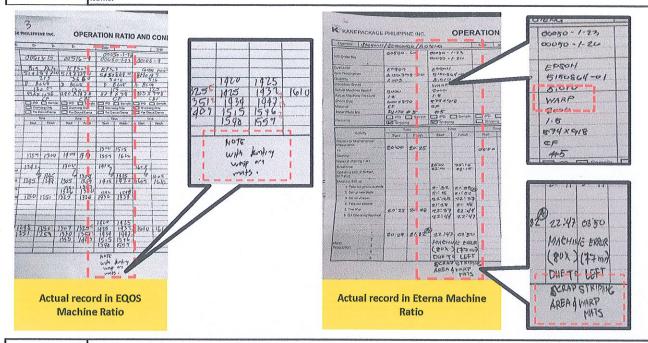
INVESTIGATION REPORT FOR MISALIGN PRINT

DIRECT CAUSE PROCESS/MATERIAL

4

W1- Due to warp materials of items.

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.



INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL

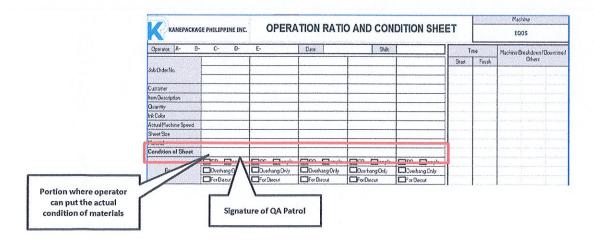
W1- Operator did not notice the occurrence of misalign print due to random warp materials since it has 460 out of 3360pcs of reject only. Also the item has 2 outs.

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



PREPARED BY:

JUDY ANN SARMIENTO

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR