

**KANEPACKAGE PHILIPPINE INC.**

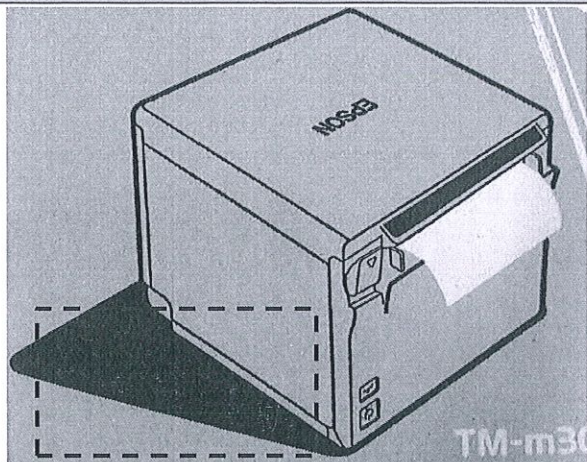
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 445

Date Issued: 21 07 21

Customer	EPSON IJP	Attention To	Mr. Gerald De Guzman
Item Code	5162340-00	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	21 07 19
Job Order Number	JO-DRS21-L-00117-14-17	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM

<input type="checkbox"/> Major	<input type="checkbox"/> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1018	139	13.65%

Nature of Defect:

POOR PRINT

Requirement:

No poor print on the printer image

Actual:

W/ poor print on the printer image

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 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	 210722 Mr. Roderick Ramos QA Supervisor	 Mr. Rexel Almarin QA Asst. Manager	 210721 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: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A Why 4: Why 5:
Design / Toolings	Why 1: Why 2: Why 3: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A 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**

- ROUGH TEXTURE SURFACE OF MATERIALS

OUTFLOW ROOTCAUSE

OPERATOR & QA PATROL FOCUS ON SHOOTING PRINT OF THIS ITEM

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

Date	N/A	Time	N/A	Design / Tools	P/A
Title	N/A				
Attendees	N/A				

C. Reworking

Rework Quantity	N/A					
Total Good	N/A			Process	PLS. SEE ATTACHED	
Rework Percentage (Good)	N/A					

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

Date Conducted: 21 07 21 PIC: A. Vergara

Identified Rootcause**Recommendation**

The materials used have rough surface & the flexoplate is composed of hard plates

Attachment of backing film

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 08 10	[X] Yes [] No	CA is implemented but not effective
2nd Verification of Action	A. Vergara	21 10 26	[X] Yes [] No	CA Recommendation is implemented
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	21 12 03	[X] Yes [] No	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

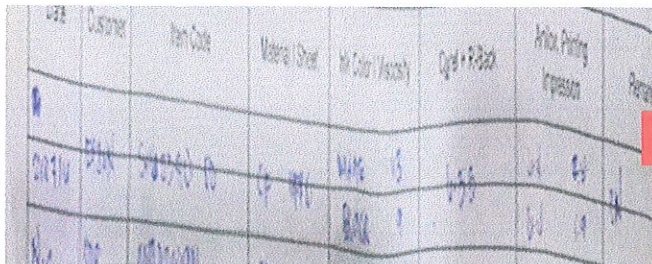
Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed			
<input type="checkbox"/> Still Open			
<input type="checkbox"/> Re-issue IRF			

QUALITY ASSURANCE DEPARTMENT
CLOSED
DATE AND SIGNATURE: [Signature] 21 12 03

QA Supervisor: [Signature] Date: 21 12 03
QA Asst. Manager: [Signature] Date: 21 12 03
Line Leader: IRISH MAY L. ESTAREJA Date: 21 12 03
Department Head: [Signature] Date: 21 12 03

INVESTIGATION REPORT FOR POOR PRINT OF EPSON IJP 5162340-00 INDIVIDUAL BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- The texture of the surface of materials is rough.
	W2- Since the cyrel of this item is composed of hard cyrel the rough texture surface of materials have effect to the print impression that caused of poor print.



	STANDARD	ACTUAL	STATUS
INK VISCOSITY	9sec	9sec	GOOD
ANILOX IMPRESSION	6.5 ± 0.2mm	6.4mm	GOOD
PRINT IMPRESSION	2 ± 1mm	1.9mm	GOOD

NO ABNORMALITY FOUND IN MACHINE SETUP

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Eqos & QA Patrol did not notice the poor print since they more pocus on the Shooting Print because this item is two colors in one passed process.
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PRODUCTION ACTION PLAN

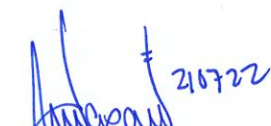
Since we can't control the materials quality from supplier regarding the rough texture surface of corrugated board our proposal is the soft cyrel in the solid image print of this item.

PIC:	PRODUCTION	TARGET DATE:	210726
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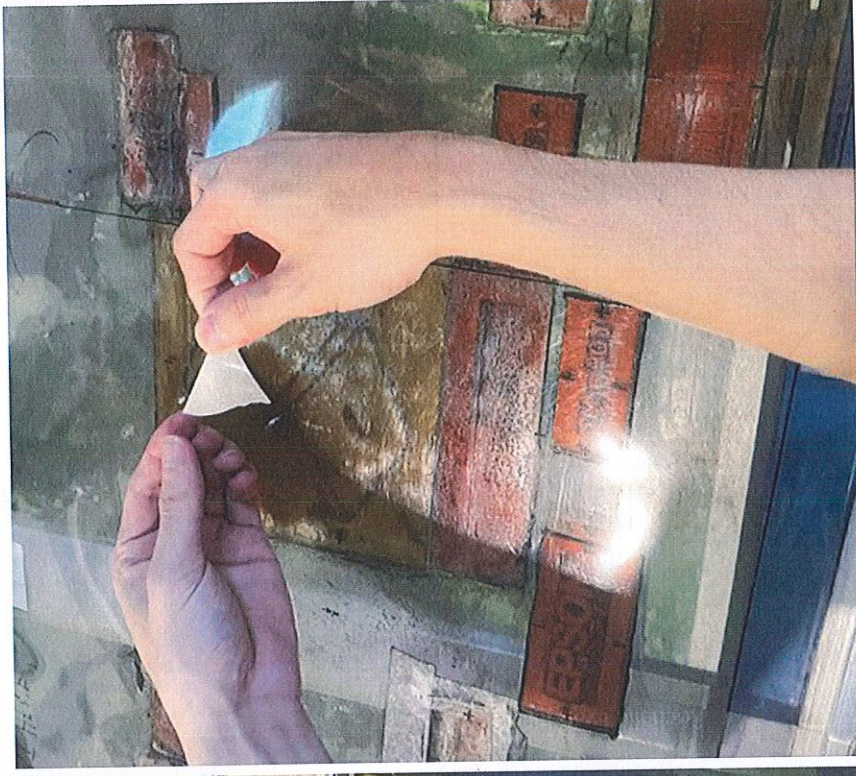
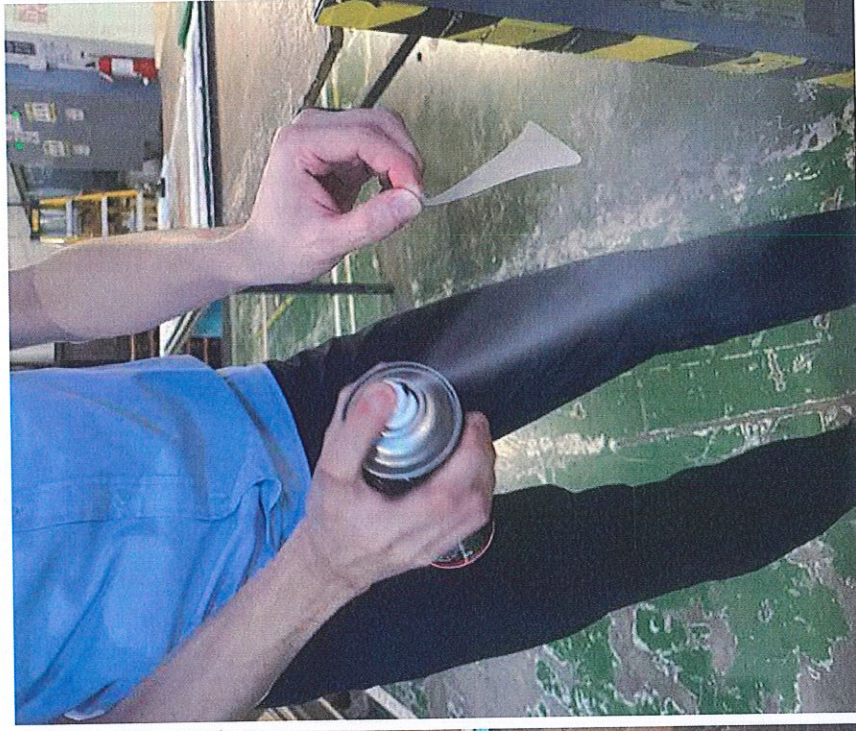
PREPARED BY:


GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
SR. SUPERVISOR

UPDATES:



REMARKS: Applied on the items 5162340-00, 5162341-00 & 5162342-00