No. 5 Ring F	EPACKAGE toad LISP II, Brgy. La lo. (049) 545-7166 to 6 b) 545-6302	INVESTIGATION REPORT FORM (IRF)  Inhouse Detection Customer Claim  Control No.: 474 Date Issued: 21 pp							
Customer EPSON IJP				n To		Mr. Gerald De Guzman			
Item Code				nent	PRODUCTION				
	5162340-00			Detection	21 10 18				
Item Description	INDIVIDUAL BOX			Detected	QA - IN LINE				
Job Order Number JO-DRS21-L-00178-11-18			Section						
	LUSTRATION OF		Major	Deignt Oug	Minor	Poinct Parcentage			
EXCEED YOUR VISION			Lo	t Quantity (pcs.)	Reject Qua		Reject Percentage		
				3000	11	3	3.77%		
				Nature of Defect:  OFF SHOOT					
	58	Requirement:							
		Off shoot is acceptable up to 2mm only							
		Actual: Off shoot is 4mm							
NO. OF OCCUR	RENCE	DISPOSITION		AREA OF OCC	URRENCE / ORIGIN CONTENT				
First		Hold	П	Slotter	Gluing	Gluing Material			
Recurrence		Special Acceptance	EQOS		Vertica	Vertical Dimension			
No.:		For Rework	Diecut		Others	s:	Appearance		
Date:		Reject / Disposal	Detaching			_	Process / Method		
Issued by		Checked by	Appr		ed by		Received by		
Adrian Vergara QA-IE Staff		Mr. Roderick Ramos QA Supervisor	Mr. Rexel A QA Asst. Ma		malio Mr inager		(Receiving Section)  2 / (o)  Gerald De Guzman  Head/ Supervisor		
		I. INVESTIGA	TION / AN						
DIRECT CAUSE:	(Analyze the reasor		INDIRECT CAUS	SE: (Analyze the re	ason of occurr	ence, why it leaked?)			
Why 1: Why 2: Why 3: Why 4: Why 5:			Why 1: Why 2: Why 3: Why 4: Why 5:						
Why 1:		**************************************	Why 1:						
				Why 2:					
Why 2:  Why 3:  Why 4:			Why 3:	Why 3: P/A Why 4:					
			Why 4:						
a) Why 5:			Why 5:						
	Α		Why 1:						
Why 1: Why 2: Why 3: Why 4:									
				Why 3: PLS. SEE ATTACHED					
				Why 4:					
Why 4:		0000000.74	Why 5:						



DATE AND

SIGNATURE

21 12 DG

#### 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)

	Fax No. (049) 5	15-6302	5 69								
					ICLUSION						
OCCURRENCE ROOTCAUSE						OUTFLOW ROOTCAUSE					
- DELAYED MOVEMENT OF BOARD SINCE THE HEIGHT OF BOARD IS ONLY 422mm.					- NOT NOTICED IMMEDIATELY SINCE ONLY SAMPLING IS CONDUCTED						
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					
	Loca	ation	Total Stock	NG	Total Good						
RM	N/	A				System		NS/A			
WIP	NI	A				Oystem		, -			
FG	N	A A									
B. Orientation										t0	
Date	N	/ A	Time	N/	A	Design /	P/A				
Title	•		N/A			Tools					
Attendees			NA		,						
C. Reworking										V To	
Rework Quantity			A		Process	PLS. SEE ATTACHED	UFD.				
Total Good											
Rework Perce	entage (Good)		N/F	)		¥					
II. QA R	OOTCAUSE	ERIFICATION	N (To be filled	out by QA In-	charge)	Date Conduc	ted: 11 10 20	PIC: A. Vero	garo		
			Rootcause					Recommendation			
because	e the sh	neet siz			DE 2000 DE SOUDE		led out by QA l	n-charge)			
Checked by			Date		nented?	Remarks					
1st Verification of Action		A.Vergara		21 11 09	[-]Yes	[ ] No	C.A. is implemented (White image moved by 2mm)				
2nd Verification of Action		*			[]Yes	[ ] No					
3rd Verification of Action			[ ] Yes	[ ] No							
Effectiveness of Action A. Vergara		21 12 03	[/Yes	[ ] No	C.A. is effective						
Note: If no s deliveries or	ame defects / ¡ 3rd verification	oroblems occu n of action still	rs for 5 consec not yet implem	cutive deliverie nented, Investi	s, corrective ac gation Report s	tion is conside hall be re-issu	ered effective / o	closed. If the same problem o ed department to provide new	ccurs within 5 v improvement	consecutive action.	
					IV. CLC	DSURE					
Status:		Remarks:		1	Appro	ved by:		Process Owner Acknowled	dgment: (Rece	ving Section)	
QUALITY ASSURANCE DEPARTMENT OF SUPERVISOR					ipervisor	IRISH MAY L. ESTAREJA Line Leader Department					
Reassue IRF				21 1	Date: 11 12	. 06	Date: 21 12 06	Date: 21 H	.06		

## INVESTIGATION REPORT FOR OFF SHOOT OF EPSON IJP 5162340-00 INDIVIDUAL BOX

 $\mathbf{W1}$ - Upon mass production operator notice the random 2mm movement of print upward in the 2nd unit (black).

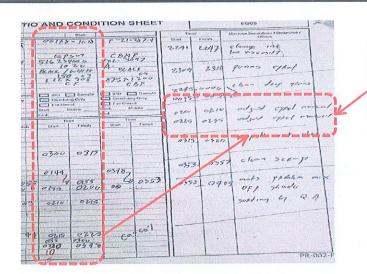
#### DIRECT CAUSE PROCESS/MATERIAL

W2- This is due to delayed movement of board since the height of board is only 422mm.

**W3**- due to 500mm distance of roller to roller of Eqos, after the next roller grip the 422mm height of board it is already un-grip by 1st roller that caused print movement.

# INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL

**W1**- Operator did not noticed immediately the Off Shoot since they only conduct sampling checking and when they trap the Off shoot they immediately stop the process and made some adjustment in the cyrel.



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OPERATOR MANUALLY ADJUST THE CYREL
UPON DETECTION OF RANDOM
OCCURRENCE OF OFF SHOOT

#### PRODUCTION CORRECTIVE ACTION

- \* Adjust the black image cyrel to 2mm downward, so if the delay movement happened due to 422mm height of board it is within the tolerance without Off Shoot. (TD: Done by Operator)
- \* Closely monitor this item next running. (TD: TBA since no open schedule)

PIC:

**PRODUCTION** 

PREPARED BY:

GERALD DE GUZMAN PRODASST. SUPERVISOR

211020

APPROVED BY:

WEENA V. ARALLA SR. SUPERVISOR