

**KANEPACKAGE PHILIPPINE INC.**

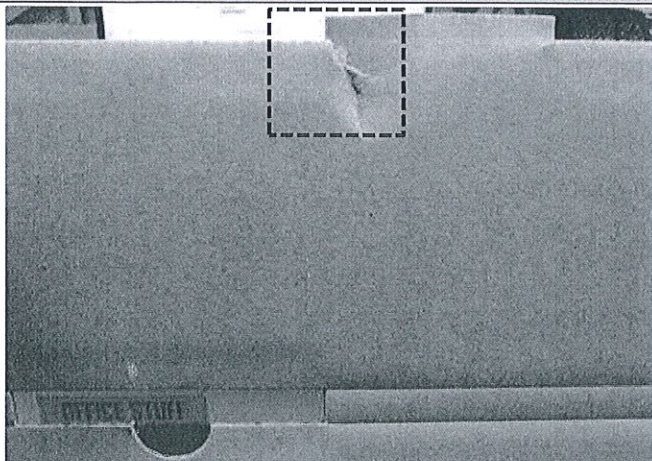
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 477

Date Issued: 21 10 21

Customer	KOWA-EMORI	Attention To	Mr. Gerald De Guzman
Item Code	HP33D1014	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	21 10 21
Job Order Number	JO21-M-01629-66	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
800	67	8.38%

Nature of Defect:

TEAR OFF

Requirement:

Tear off is not acceptable

Actual:

W/ Tear off

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 type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input checked="" 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	 Mr. Roderick Ramos QA Supervisor	 Mr. Rexel Almario QA Asst. Manager	 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 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	PLS. SEE ATTACHED	Why 3:	PLS. SEE ATTACHED
	Why 4:		Why 4:	
	Why 5:		Why 5:	

**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)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE****OUTFLOW ROOTCAUSE**

— UNEVEN LENGTH SIZE OF PRINTED BOARD

— OPERATOR NEED TO CONSIDER THE PRINT DIMENSION.

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	21 10 25	Time	15:35 - 15:42	Design / Tools	N/A
Title	ORIENTATION REGARDING TEAR OFF OF KOWA - EMORI HR33D1014 CARTON BOX				
Attendees	DIECUT OPERATORS				

C. Reworking

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

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

Date Conducted: 21 10 22

PIC: A. Vergara

Identified Rootcause

Recommendation

Uneven sheet size


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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 10 27	<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 12 07	<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.

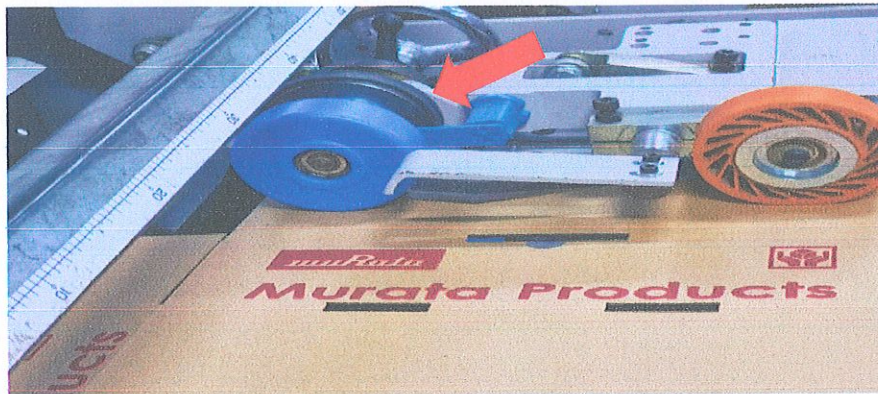
IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed <input type="checkbox"/> Re-Issue IR	QUALITY ASSURANCE DEPARTMENT	QA Supervisor Date: 21 12 07	QA Asst. Manager Date: 21 12 07	Line Leader IRISH MAY L. ESTAREJA Date: 21 12 07
			Department Head Date: 21 12 07	

CLOSED
DATE AND SIGNATURE  21 12 07

INVESTIGATION REPORT FOR TEAR OFF OF KOWA-EMORI HP33D1014 CARTON BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- Based on investigation Diecut S1700 encounter uneven length size of printed board.
	W2- Because the item undergo auto stripping, the small size of uneven printed board loosed in auto stripping guide and the right side scrap get small why when the stripping belt collected the scrap it also hit the item that caused Tear Off.



INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Diecut S1700 operator cant adjust the machine setup because they need to consider the dimension of print.
--	--

PRODUCTION CORRECTIVE ACTION

Orient the Diecut S1700 operator to void the stripping process and immediate inform the Leader in-charge once they encounter uneven length size of printed board with auto stripping process.

PIC:	PRODUCTION	TARGET DATE:	211025
-------------	-------------------	---------------------	---------------

PREPARED BY:


GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR


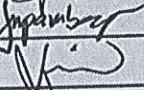
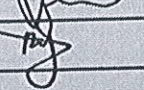
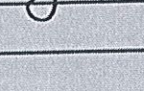


KANEPACKAGE PHILIPPINE INC.

MINUTES OF THE MEETING

Date: 211025 Time Start: 1535H Time Finished: 1542H Venue: S1700 AREA

ATTENDEES:

Name	Section	Sign	Name	Section	Sign
Gil Copino	Die Cut				
MICHAEL PAMBAWO	DIE CUT				
DARWIN MANGARBO	"				
RAMN PAMBAW	DIE CUT				

AGENDA:

**ORIENTATION REGARDING TEAR OFF OF
KOWA-EMORI HP33D1014 CARTON BOX**

page 1 of 1

MINUTES:

ROOTCAUSE:

During Diecut S1700 mass production the short size of uneven board have small scrap in the right side and since the item underwent auto stripping, when the stripping belt collected the scrap the item with small scrap was randomly hit by stripping belt that caused Tear Off. Diecut S1700 operator cant adjust the machine setup because they need to consider the dimension of print.

CORRECTIVE ACTION:

- > Void the auto stripping process once they encountered uneven board.
- > Immediately Inform to the Leader in-charge the problem.
- > If the Auto Stripping Process effect to the quality of the item its better to process it to Detaching.

FOLLOW UP MEETING:

(date & time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:


GERALD DE GUZMAN