

**KANEPACKAGE PHILIPPINE INC.**

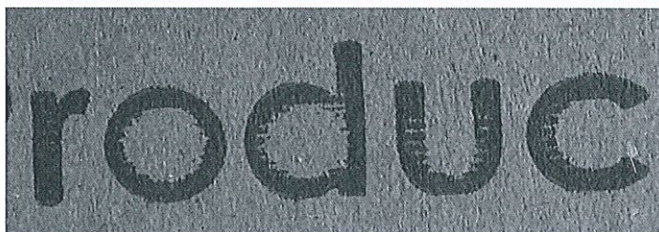
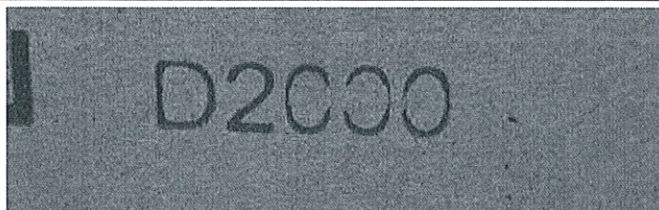
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
Telephone No. (049) 545-7166 to 69  
Fax No. (049) 545-6302

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

Control No.: 483

Date Issued: 21 11 03

Customer	KOWA-EMORI	Attention To	Mr. Gerald De Guzman
Item Code	HP01D2000	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	21 11 03
Job Order Number	JO21-M-01629-89	Section Detected	PRD - EQOS

**ILLUSTRATION OF THE PROBLEM**☐ Major☒ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
6,000	300	5.00%

**Nature of Defect:**

Poor Print

**Requirement:**

Characters should be completely printed

**Actual:**

Text is not completely printed

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.: <u>2</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Appearance
Date: <u>21 11 03</u>	<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 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 2: Why 3: <u>N/A</u> Why 4: Why 5:	Why 1: Why 2: Why 3: <u>N/A</u> Why 4: Why 5:
Design / Toolings	Why 1: Why 2: Why 3: <u>N/A</u> Why 4: Why 5:	Why 1: Why 2: Why 3: <u>N/A</u> Why 4: Why 5:
Process / Material	Why 1: Why 2: Why 3: <u>PLS. SEE ATTACHED</u> Why 4: Why 5:	Why 1: Why 2: Why 3: <u>PLS. SEE ATTACHED</u> Why 4: Why 5:



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**INVESTIGATION REPORT FORM (IRF)****FINAL CONCLUSION****OCCURRENCE ROOTCAUSE****OUTFLOW ROOTCAUSE**

- ANILOX IMPRESSION ADJUSTED UPWARD  
AUTOMATICALLY.

- OPERATOR LEFT THE MONITOR FOR A  
WHILE TO GET WATER TO DRINK.

**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			
WIP	N/A			
FG	N/A			

System

N/A

**B. Orientation**

Date	N/A	Time	N/A
Title	N/A		
Attendees	N/A		

Design /  
Tools

N/A

**C. Reworking**

Rework Quantity	N/A
Total Good	N/A
Rework Percentage (Good)	N/A

Process

PLS. SEE ATTACHED

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

Date Conducted: 21 11 04

PIC: A. Vergara

**Identified Rootcause****Recommendation**

The impression applied by the anilox roller to the substrate is light only. Because the anilox roller impression is loose. The Anilox roller impression automatically adjusted upwards.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 11 12	<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 11 22	<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"/> Still Open <input type="checkbox"/> Re-Issue IRF	QUALITY ASSURANCE DEPARTMENT	QA Supervisor Date: 21 11 22	QA Asst. Manager Date: 21 11 22
		IRISH MAY L. ESTAREJA Line Leader Date: 21 11 22	Department Head Date: 21 11 22

**CLOSED**DATE AND  
SIGNATURE

21 11 22

QA-027-F01 REV.01

## INVESTIGATION REPORT FOR POOR PRINT OF KOWA-EMORI HP01D2000 CARTON BOX

<b>DIRECT CAUSE</b> PROCESS/MATERIAL	W1- There is machine error happened during mass production.
	W2- The Anilox impression automatically adjusted upward that caused poor print.

<b>INDIRECT CAUSE (OUTFLOW)</b> PROCESS/MATERIAL	W1- When the main operator get thirst he got some water in the water dispenser near in Eqos since the item is long running with 6000pcs lot quantity, but when the operator back on the monitor and get sampling he notice the poor print and the anilox impression adjusted upward.
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### PRODUCTION ACTION PLAN

1. Immediately separate the affected item (Done) 2. Coordinate the problem to sir Suzuki (TD: 211105) 3. Orient the Eqos operator that always need substitute incase that the main operator need to drink water. (TD: 211105)	
<b>PIC:</b>	<b>PRODUCTION</b>

PREPARED BY:

  
**GERALD DE GUZMAN**  
 PROD ASST. SUPERVISOR

APPROVED BY:

  
**WEENA K. APALLA**  
 SR. SUPERVISOR



# JOB ASSIGNMENT FOR EQOS

Group	NAME	NOVEMBER 15 TO 20, 2021	NOVEMBER 22 TO 27, 2021	NOVEMBER 29 TO DECEMBER 4, 2021	DECEMBER 6 TO 11, 2021	DECEMBER 13 TO 18, 2021	DECEMBER 20 TO 24, 2021	DECEMBER 27 TO 29, 2021
A	PEDRO CHAVEZ	A	E	D	C	B	A	E
	MARVIN PAMULAKLIN	B	A	E	D	C	B	A
	ANTHONY BETCO	C	B	A	E	D	C	B
	ROBERT DELITO	D	C	B	A	E	D	C
	REYMIL LORENZO	E	D	C	B	A	E	D
B	HENRY CLAVE	A	E	D	C	B	A	E
	CEMAR BELARDO	B	A	E	D	C	B	A
	JESSE JAMES CALVA	C	B	A	E	D	C	B
	JOLITO ACEJO	D	C	B	A	E	D	C
	DAVID RUPERT BONAYON	E	D	C	B	A	E	D

Assignment :	A - MAIN OPERATOR	machine setup and data encoding	D - FEEDER	setup cyrel
		trial run checking		feeding the sheet
		updating document		cleaning of cyrel
		sampling checking		removing cyrel from the machine
		arranging the pallet		setting aside the scrap
B - STACKER		getting the pallet	E - SUB OPERATOR	arranging the pallets
		updating cyrel monitoring bin card		preparing the pattern needed
		setup cyrel		preparing the ink needed
		feeding the sheet		cut and remove the stretch film in new sheets.
		cleaning of cyrel		sub to main operator incase the main operator is not available
C - FEEDER		setting aside the scrap		

NOTE: LEADERS WILL ASSIGN OTHER PIC IN THE ABSENCE OF THE RESPONSIBLE PERSON.

PREPARED BY:

*[Signature]* 2/11/22  
GERALD DE GUZMAN  
SR. SUPERVISOR

APPROVED BY:

*[Signature]* 2/11/22  
WEENA VAPALLA  
SR. SUPERVISOR