



☐ Inhouse Detection ☒ Customer Claim Date Issued: JUNE 14, 2022

Customer	EPSON VP	Attention To	GERALD DE GUZMAN
Item Code	5150486-00	Department	KPLAGUNA-PRODUCTION
Item Description	CARTON BOX (STD;B)	Date of Detection	JUNE 14, 2020
Job Order Number	JO-22-L-00122-35 (A) JO-22-L-00122-36 (B)	Section Detected	EPSON VP
ILLUSTRATION OF THE PROBLEM		Major Minor	
		Lot Quantity (pcs.)	Reject Percentage
		380	0.26%

Nature of Defect:	POOR PRINT
	

Requirement:

ITEM SHOULD BE IN GOOD CONDITION NO POOR PRINT

Actual:	POOR PRINT OCCURRED ON THE ITEM PANEL
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NO. OF OCCURRENCE		DISPOSITION		AREA OF OCCURRENCE / ORIGIN			CONTENT
☒ First	☐	☐ Hold	☐	☐ Slotter	☐	Gluing	☐ Material
☐ Recurrence	☐	☐ Special Acceptance	☒	☒ EQOS	☐	Vertical	☐ Dimension
No.:	☐	☐ For Rework	☐	☐ Diecut	☐	Others:	☒ Appearance
Date: _____	☒	☒ Reject / Disposal	☐	☐ Detaching			☐ Process / Method
Issued by		Checked by		Approved by			Received by (Receiving Section)

 M. Prakash QA-IE Staff	 QA Supervisor	QA Asst. Manager	Head/ Supervisor
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INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)

System / Training	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:

Design / Toolings	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:
	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:

Process / Material	
Why 1:	Why 1:
Why 2:	Why 2:
Why 3:	Why 3:
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**

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					
WIP					
FG					
B. Orientation					
Date	Time				
Title					
Attendees					
C. Reworking					
Rework Quantity					
Total Good					
Rework Percentage (Good)					
II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)					
Date Conducted: _____ PIC: _____					
Recommendation					
III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)					
	Checked by	Date	Implemented?	Remarks	
1st Verification of Action			[] Yes [] No		
2nd Verification of Action			[] Yes [] No		
3rd Verification of Action			[] Yes [] No		
Effectiveness of Action			[] Yes [] No		
<i>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.</i>					
IV. CLOSURE					
Status:	Remarks:	Approved by:		Process Owner Acknowledgment: (Receiving Section)	
☐ Closed		QA Supervisor		QA Asst. Manager	Department Head
☐ Still Open					
☐ Re-Issue IRF				Date:	Date:

FG-378

1320H, Philip 5/18



Kanepackage Philippines Inc.

JOB ORDER

PR-001-F12-REV.00

MEMO: - Norte -

de Jesus, Melissa
SO #: TO22-L-00122REV3

Customer : EPSON PRECISION PHILIPPINES INCORPORATED - VP		JOB ORDER:
ITEM CODE: 515048600 PANEL A		JO-22-L-00122-35
Netsuite Itemcode : 515048600 PANEL A		

Item Description : H794 (CZEC) CARTON BOX (EAI)_PH PART A

QTY: 380	DELIVERY DATE: 2022-05-17	CREATED BY: Dario, Engleberth Nunez	DATE RELEASED: 2022-05-11
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Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
530X845 CBF NPK180	380		N/A	380	0167761	PW

Tooling Reference # **E - 84 - 20**

Control/Batch #:

RM Issued By: **ELMER**

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN	REJECTED QTY		REMARKS
		Operator	ME/QA			INHOUSE	SUPPLIER	
1. EQOS	5/18	HKHMC	Robing	378	2 Z G R			TAL
2. PRODUCTION PACKING					G R			378
3. FOR TRANSFER TO KP LIMA					G R			
4.					G R			
5.					G R			
6.					G R			
7.					G R			
8.					G R			
9.								
10.								

QUALITY ASSURANCE DEPARTMENT

REJECTION HISTORY

Customer Claim:
Notes:

REMARKS
PROD PLAN: ADD #3 PLAN 2022-137

WROUST OUT

NAME: **Daw** DATE: **5/18**

FG-378



Kanepackage Philippine Inc.

PR-001-F12-REV.00

MEMO: - Norte -

de Jesus, Melissa

SO #: TO22-L-00122REV3

JOB ORDER

Customer : EPSON PRECISION PHILIPPINES INCORPORATED - VP		JOB ORDER:	
ITEM CODE: 515048600 PANEL B Netsuite Itemcode: 515048600 PANEL B		JO-22-L-00122-36	
Item Description : H794 (CZECH) CARTON BOX (EAI)_PH PART B			
QTY: 380	DELIVERY DATE: 2022-05-17	CREATED BY: Dario, Engleberth Nunez	DATE RELEASED: 2022-05-11

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
530X845 CBF NPK180	380		N/A	380	016224	PW

Tooling Reference # E - 86 - 200

Control/Batch #:

RM Issued By: EMMANUEL

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN	REJECTED QTY		REMARKS
		Operator	ME/QA			INHOUSE	SUPPLIER	
1. EQOS	5/18	HKHMC		378	2 2 G R			18L / 380
2. PRODUCTION PACKING					G R			
3. FOR TRANSFER TO KP LIMA					G R			
4.					G R			
5.					G R			
6.					G R			
7.					G R			
8.								
9.								
10.								

Customer Claim:	REJECTION HISTORY
Notes:	WHOLEST OUT 5/19 chelle

REMARKS

PROD PLAN: ADD #3 PLAN 2022-137

5/18
 AIG:

NAME: Dan DATE: 5/18

**INVESTIGATION REPORT FOR POOR PRINT OF
EPPI VP 515048600 CZECH CARTON BOX**

DIRECT CAUSE PROCESS/MATERIAL	W1	The corrugated board issued to Eqos have submerged portion.
	W2	The Eqos cyrel cant penetrate in the submerged portion of corrugated board that caused poor print or broken image.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	Broken image cannot detected during sampling since the machine speed during mass production is 120bpm (Board Per Minute) and only 1pc is affected.
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PRODUCTION CORRECTIVE ACTION

If ok to QA to conduct 100% sorting of raw materials during in coming	
PIC:	QA

PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
ASST. MANAGER