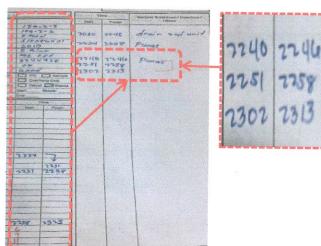# KANEPACKAGE PHILIPPINE INC.

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.:	621	Date Issued:	22 09 08

Customer	EPSON IJP	Attention To	Gerald De Guzman
Item Code	5150864-01	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	22 09 07
Job Order Number	JO-DRS22-L-0179-2-7 /2-6	Section Detected	QA-SCREENING

ILLUSTRATION OF THE PROBLEM

☒ Major		☐ Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage	
6,020	96	1.59%	

Nature of Defect:

BLOTTED PRINT

Requirement:

Acceptable up to 3 pcs. Per line

Actual:

almost all the characters and logo is blotted.

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)
Rochelle Evangelista	Roderick Ramos	Rexel Almario	Gerald De Guzman
QA-IE Staff	QA Sr. Supervisor	QA Asst. Manager	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:

QA-027-F01 REV.01

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FINAL CONCLUSION

OCCURRENCE ROOTCAUSE	OUTFLOW ROOTCAUSE
- CYREL STARTING TO BLUNT	- DUE TO MACHINE SPEED OF 90 BPM SKIP OFF MODE

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

	Location	Total Stock	NG	Total Good
RM				
WIP				
FG				

Actions to be done to eliminate recurrence

		Who / When
System	N/A	
Design / Tools	N/A	
Process	PLS. SEE ATTACHED	

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: _____

Identified Rootcause	Recommendation
BLUNT CYREL.	N/A

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	R. EVANGELISTA	220908	[X] Yes [ ] No	N/A
2nd Verification of Action			[ ] Yes [ ] No	
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action			[ ] Yes [ ] No	

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.

QUALITY ASSURANCE DEPARTMENT

CLOSED

IV. CLOSURE

Status	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
Closed			
Still Open		QA Supervisor QA Asst. Manager	Line Leader Department Head
DATE AND SIGNATURE	220908	Date: Date: 22120	Date: Date:
Re-issue IRF			

QA-027-F01 REV 01

INVESTIGATION REPORT FOR BLOTTED PRINT OF EPSON IJP 515086401 INDIVIDUAL BOX

DIRECT CAUSE PROCESS/MATERIAL	W1	Operator encountered blotted print during running of this item and cleanup the cyrel to removed the blotted.
	W2	There is a factor that the caused of blotted print is the cyrel starting to blunt since its already 306,922sheets printed that time.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	Eqos operator didn't separate all the affected of blotted since the machine speed is 90bpm skip off mode.

PRODUCTION CORRECTIVE ACTION

Used the spare/backup cyrel since tooling custodian already have spare/backup cyrel of this item due to fast running.

PIC:	PRODUCTION	TAGET DATE	STARTING TODAY

PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
ASST. MANAGER