

**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.)

6,020

Reject Quantity (pcs.)

96

Reject Percentage

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
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.:	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Appearance
Date:	<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)
Rochelle Evangelista QA-IE Staff	Roderick Ramos QA Sr. Supervisor	Rexel Almario QA Asst. Manager	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: 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:

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

- CYREL STARTING TO BLUNT

OUTFLOW ROOTCAUSE

- DUE TO MACHINE SPEED OF 90BPM
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

Status: ☒ Closed ☐ Still Open

DATE AND SIGNATURE:  220908

IV. CLOSURE

Approved by:

Process Owner Acknowledgment: (Receiving Section)

QA Supervisor

QA Asst. Manager

Line Leader

Department Head

Date:

22/09/08

Date:

Date:

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.

Time	Start	End	Remarks
7:20	7:45		Drain out unit
7:45	7:50		Print
7:50	7:55		Print
7:55	8:00		Print
8:00	8:05		Print
8:05	8:10		Print
8:10	8:15		Print
8:15	8:20		Print
8:20	8:25		Print
8:25	8:30		Print
8:30	8:35		Print
8:35	8:40		Print
8:40	8:45		Print
8:45	8:50		Print
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8:55	9:00		Print
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