

**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.: 620

Date Issued: 22 09 03

Customer	KOWA EMORI	Attention To	Gerald De Guzman
Item Code	HP01D2000-3	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	22 09 02
Job Order Number	JO22-M-01859-3	Section Detected	PRD

## ILLUSTRATION OF THE PROBLEM

☒ Major ☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
10,050	102	1.01%

## Nature of Defect:

INVERTED PRINT

## Requirement:

Print should be on the smooth surface

## Actual:

Print is on the rough surface

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:	



**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**

- RANDOM OF INVERTED PILE OF MATERIALS ISSUED IN EQOS WITH UNUSUAL ROUGH SURFACE TEXTURE.

**OUTFLOW ROOTCAUSE**

- RANDOMLY OCCURRENCE

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

**B. Orientation**

Date		Time	
Title			
Attendees			

**Design / Tools**

N/A

**C. Reworking**

Rework Quantity	
Total Good	
Rework Percentage (Good)	

**Process**

PLS. SEE ATTACHED

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

Date Conducted: \_\_\_\_\_ PIC: \_\_\_\_\_

**Identified Rootcause****Recommendation**

N/A

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	22/09/20	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	N/A
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			<input type="checkbox"/> Yes <input type="checkbox"/> 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.

**IV. CLOSURE**

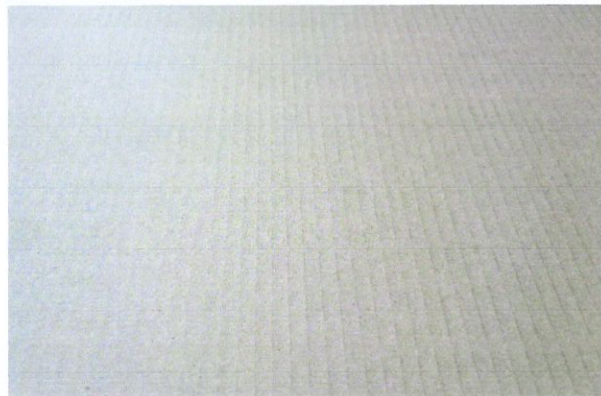
Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input type="checkbox"/> Close			
<input type="checkbox"/> Still			
<input type="checkbox"/> Re-Issue IRF			
DATE AND SIGNATURE	11/10/20	QA Supervisor	QA Asst. Manager
		Line Leader	Department Head
		Date: 2/201	Date:

# INVESTIGATION REPORT FOR INVERTED PRINT OF KOWA EMORI HP01D2000-3 CARTON BOX

<b>DIRECT CAUSE PROCESS/MATERIAL</b>	<b>W1</b>	There is random inverted pile of materials issued in Eqos.
	<b>W2</b>	Eqos operator didn't notice the random inverted pile of materials and inverted print since the rough surface is unusual because its almost same to smooth surface and also contribute the machine speed of 120bpm skip Off mode.



**ACTUAL INVERTED PRINT REJECT**



**USUAL ROUGH SURFACE OF MATERIALS**

## PRODUCTION CORRECTIVE ACTION

**Orient and alert the Eqos operator regarding this unusual rough surface of materials that almost same to smooth surface.**

<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>220906</b>
-------------	-------------------	---------------------	---------------

**PREPARED BY:**

*[Signature]*  
**GERALD DE GUZMAN**  
PROD ASST. SUPERVISOR

**APPROVED BY:**

*[Signature]* 220905  
**WEENA X. APALLA**  
ASST. MANAGER