

**KANEPACKAGE PHILIPPINE INC.**

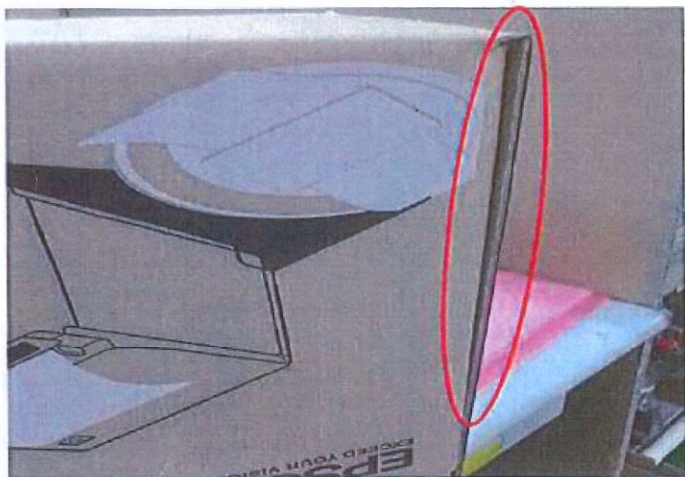
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 614

Date Issued: 22 08 06

Customer	EPSON IJP	Attention To	Gerald De Guzman
Item Code	516233900	Department	PRODUCTION
Item Description	INDIVIDUAL BOX	Date of Detection	22 08 04
Job Order Number	JO-DRS22-L-0148-10-1.1	Section Detected	PRD-SEMI AUTO

ILLUSTRATION OF THE PROBLEM☒ Major ☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
410	89	21.71%

Nature of Defect:

SHALLOW CREASING

Requirement:

Creasing should not be shallow

Actual:

shallow creasing causing misalign glue

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: Date:	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input checked="" type="checkbox"/> For Rework <input type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input checked="" type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others:	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
Rochelle Evangelista QA 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: NA Why 4: Why 5:
Design / Toolings	Why 1: Why 2: N/A Why 3: Why 4: Why 5:	Why 1: Why 2: NA Why 3: Why 4: Why 5:
Process / Material	Why 1: Why 2: Why 3: See attached Why 4: Why 5:	Why 1: Why 2: Why 3: See attached Why 4: Why 5:

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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

System

B. Orientation

Date

Time

Title

Attendees

Design /
Tools**C. Reworking**

Rework Quantity

Total Good

Rework Percentage (Good)

Process

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

Date Conducted: _____ PIC: _____

Identified Rootcause

Recommendation

WRONG CREATING IMPRESSION
ADJUSTMENT.

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

220808

☒ 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**IV. CLOSURE**

Status:

Remarks:

Approved by:

Process Owner Acknowledgment: (Receiving Section)

☐ Closed☐ Still Open

Re-issued IRF

DATE AND
SIGNATURE

QA Supervisor

QA Asst. Manager

Line Leader

Department Head

Date:

22/12/11

Date:

Date:

Date:



Kanepackage Philippine Inc.

PR-001-F12-REV.00

MEMO:

Jhaymelyn Oca
SO #: DRS22-L-0148-B

JOB ORDER

Customer: EPSON PRECISION PHILIPPINES INCORPORATED - IJP

JOB ORDER:



ITEM CODE: 516233900

JO-DRS22-L-0148-10-1.1

Netsuite Itemcode: 516233900

Item Description: INDIVIDUAL BOX, PA, CJ27

QTY: 410

DELIVERY DATE:
2022-08-04CREATED BY:
Tuiza, Jecille MaduroDATE RELEASED:
2022-08-02

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
422X908 CF TX175-C	410	20		430	190230	TS

Tooling Reference # F00

Control/Batch #:

RM Issued By: Jhay 8/4

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN	REJECTED QTY		REMARKS
		Operator	ME/QA			INHOUSE	SUPPLIER	
1. EQOS	8/4	ccarr	220804 JUNMAN	429	2. 1 G R	1		
2. GLUING SA 2600	8/4	n/s		420	G R			
3. LOT NUMBERING	8/4		sen	410	G R			
4. SCREENING	8/4		Maravilla J. caseta	170	G R	230		
5.					G R			
6.					G R			
7.					G R			
8.								
9.								
10.								

REJECTION HISTORY

Customer Claim:

Notes:

REMARKS

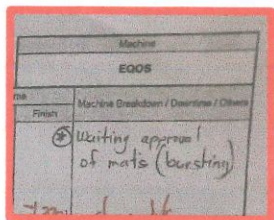
PROD PLAN: ADD #8 PLAN 2022-216

PROJ	DATE
BY: Jhay	
DATE: 8/4	
REVISION	

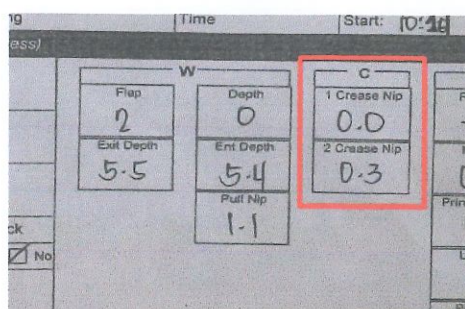
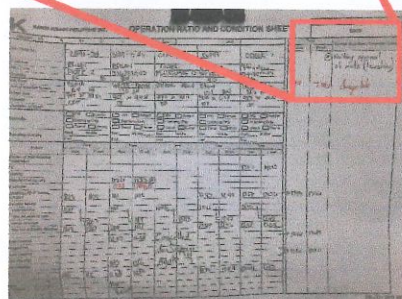
HOUSE	DATE: 8/4
Alora	

INVESTIGATION REPORT FOR SHALLOW CREASING OF EPSON IJP 5162339-00 INDIVIDUAL BOX

DIRECT CAUSE PROCESS/MATERIAL	W1	This item/materials have history of bursting specifically the batch that was processed on the last week of July.
	W2	Due to bursting issue, the operator make adjustments in the creasing impression to 0.6 and 0.3.



Eqos operators indicated that they encountered bursting.



Actual inspection report indicating 0.0 and 0.3 creasing impression.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	Operators focused more in avoiding the bursting issue since shallow creasing is reworkable and not all materials encountered the same defect. Also this model/material(CF UPPC) is prone to poor print.
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PRODUCTION CORRECTIVE ACTION

Set standard creasing impression for all CF materials to 0.1 and 0.1. If bursting was detected during trial and mass pro, the materials must be reconditioned using the misting facility.

PIC:	PRODUCTION	TARGET DATE:	NEXT RUNNING
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PREPARED BY:

MEL ABE 220809
MEL ABE
PROD. IE STAFF

APPROVED BY:

WEENA V. APALLA 220809
WEENA V. APALLA
ASST. MANAGER