					*		
		SE PHILIPPINE INC.	INVESTIGA	TION REPOR	T FORM (IRF)		
	No. 5 Ring Road LISP II, Brgy. I Telephone No. (049) 545-7166 t		Inhouse Detection	Cus	Customer Claim		
	Fax No. (049) 545-6302		Control No.: 613	Date Issued	22 08 06		
Custor	mer	EPSON IJP	Attention To	Gerald	De Guzman		
			Department PRODUCTION				
Item D	Pescription	INDIVIDUAL BOX	Date of Detection 22 08 04				
	rder Number	JO-DRS22-L-0148-13-3	Section Detected PRD-SEMI AUTO				
000 0	ILLUSTRATION O		Major Major	Mine			
	IEEGSTRATION	I THE PROBLEM	Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage		
			FERENCE LABOR STREET, STREET	BEAT TO SELECT THE SECOND STATE OF THE	MI MATERIA DI LES LA CREATA CONTRA		
		The same of the sa	1,500	309	20.60%		
	1 -	7 /	Nature of Defect:				
-	1.			POOR SLOT			
			Requirement:				
			Not poor slot				
			Actual:				
				with poor slot			
	NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCU	JRRENCE / 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 b	y	Received by		
					(Receiving Section)		
				. ,1			
	Rochelle #vangelista QA-IE Staff	Roderick Ramos QA Sr. Supervisor	Rexel Almar QA Asst. Mana		Gerald De Guzman  Head/ Supervisor		
			TION / ANALYSIS				
	DIRECT CAUSE: (Analyze the reason		<b>社会研究的复数数据的</b>	: (Analyze the reason of occi	urrence, why it leaked?)		
	Why 1:	, , , , , , , , , , , , , , , , , , ,	Why 1:	(			
ing	Why 2:		Why 2:				
Trair		NA		117			
System / Training	1		Why 3:	P/A			
Sys	Why 4: Why 5:		Why 4:				
			Why 5:				
gs	Why 1:			Why 1:			
oolin	Why 2:	1 /.	Why 2:				
Design / Toolings	Why 3:	N/A		Why 3:			
Desi	Why 4:			,			
	Why 5:						
<u>a</u> .	Why 1:		Why 1:		•		
Process / Material	Why 2:	~ (m 115)	Why 2:	S. SEE A			
1/886	Why 3:	SEE ATTAMED	Why 3:	s. Stt A	1 ) ACHE!		
Proce	Why 4:		Why 4:				
	Why 5:		Why 5:	4F			

		E PHILIPPINE INC.	INVESTIGA	ATION REPORT	FORM (IRF)	
No. 5 Ring F Telephone N Fax No. (049	No. (049) 545-7166 t	La Mesa, Calamba City, Laguna to 69	Inhouse Detection Control No.: 615		mer Claim	
Customer		EPSON IJP	Attention To	Date Issued:	22 08 06	
Item Code		516233900	Department	Gerald De	1 - Marc 1990 (1990)(1990 (1990)(1990 (1990)(1990 (1990)(1990 (1990 (1990 (1990 (1990 (1990 (1990 (1990 (1990 (1990 (199	
Item Description		INDIVIDUAL BOX	Date of Detection	149		
Job Order Number		JO-DRS22-L-0148-10-1.1	Section Detected	22 0	te Mass	
	LUSTRATION OF	F THE PROBLEM		PRD-SEI	WI AUTO	
	LOSTIVATION OF	T THE PROBLEM	Major	Minor		
			Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage	
			410	145	35.37%	
			Nature of Defect: POOR SLOT			
X and a second		Tarabal IIII	Requirement:			
	X		No poor slot			
			Actual:			
				with poor slot		
NO. OF OCCURR	RENCE	DISPOSITION	AREA OF OCC	URRENCE / 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 b	y	Received by	
-1		2015 25, 126 (22 G.S., KNIDS) 5250(32 575 18) 515 18)			(Receiving Section)	
Rochelle Evange	alieta	Roderick Ramos	Devel Almon	. 1		
ØA-IE Staff	siista	QA Sr. Supervisor	Rexel Almar QA Asst. Mana		rald De Guzman ad/ Supervisor	
		I. INVESTIGATI	ON / ANALYSIS	E LEGIN CONTRACT		
DIRECT CAUSE: (A	nalyze the reasor	n of occurrence, why it happened?)	INDIRECT CAUSE	: (Analyze the reason of occurre	nce, why it leaked?)	
Why 1:			Why 1:			
B LI Why 2:			Why 2:			
System / Training Mys 4:  Why 3:  Why 4:	Why 3:					
Why 4:				Why 3: Why 4:		
ගි Why 5:				/ /		
Why 1:			Why 5:			
			Why 2:			
8	Why 3: Why 4:			Why 3: Why 4:		
ng Mhy 4:						
₩hy 5:						
1 (1 (1 (1 (1 (1 (1 (1 (1 (1 (1 (1 (1 (1			Why 5:			
	Why 2: Why 3: PLS. SEE ATTACKED		Why 1:	\$		
TE VVIII 2.			Why 2:	CT 1-73	11	
Why 2:  Why 3:  Why 4:			Access to the control of the control	SEE ATTAC	rup)	
			Why 4:			
Why 5:	Why 5:			v		

## R

#### 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 CON	CLUSION			
	OCCURREI	NCE ROOTCAUSE				OUTFLOW ROOTCAUSE		
F	nom supp	PUER	9	SINCE WITHIN TOLERANCE				
A. Sorting Result	E ACTION: (Action to be do	one to contain/ temporary	/ correct the pi	roblem found)		VE ACTION: (Actions to be done to ensure that the problem will not	nappen again)	
A. Sorting Result						Actions to be done to eliminate recurrence	Who / When	
DAA	Location	Total Stock	NG	Total Good				
RM WIP					System	NA		
FG					di di con			
			Me 'ajak sar					
B. Orientation  Date								
		Time			Design /	N /.		
Title				Tools	N/\(\Lambda\)			
Attendees								
C. Rework Quantity								
Rework Quantit	У		8		Process PLS. SEE ATTAC	PLS. SEE ATTACHED	<b>D</b>	
	1 (Od)							
Rework Percent			<b>医</b>	STRUCTURE VICTOR				
II. QA RO	OTCAUSE VERIFICATI		it by QA In-	-charge)	Date Conducted	d: PIC:		
	Identifie	ed Rootcause		Recommendation				
	off specs	MATERIAL.				NA		
		III. CORREC	TIVE ACTION	ON VERIFICATION	N (To be filled	out by QA In-charge)		
	Ch	ecked by	Date	Impleme	ented?	Remarks		

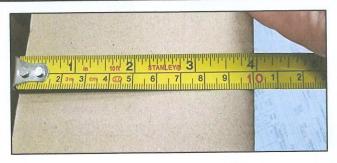
	Checked by	Date	Implemented?		Remarks	
1st Verification of Action	R. EVANGELISTA	230808	Yes	[ ] No	MA	
2nd Verification of Action			[]Yes	[ ]No		
3rd Verification of Action			[ ]Yes	[ ]No		
Effectiveness of Action			[]Yes	[ ] No		

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. CLO	SURE		
Status: Remarks:	/ Approv	red by:	Process Owner Acknowled	dgment: (Receiving Section)
Closed Silt Oper	Supervisor	QA Asst. Manager	Line Leader	Department Head
REPARE IND	וטמבי/	Date:	Date:	Date:
SIGNATURE 22 (130)				

# INVESTIGATION REPORT FOR POOR SLOT OF EPSON 516234200 & 516233900 INDIVIDUAL BOX

		Operator encounter of off specs in horizontal creasing line from supplier, requirement is 96.5mm but the actual is 99 to100mm
DIRECT CAUSE PROCESS/MATERIAL	1 10/2	Since the off specs is within tolerance dimension of $\pm 3$ mm operator adjust the setup with additional 3mm slot depth.
	W3	The additional 3mm slot depth caused poor slot in the board with exact dimension requirement



	W1	Since the off specs is within the tolerance dimension no sorting conducted.
CAUSE (OUTFLOW) PROCESS/MATERIAL		Operator didn't notice the poor slot since there is a factor its occurs randomly with machine speed of 100bpm skip on mode.

### PRODUCTION CORRECTIVE ACTION

Option 1: Orient the operator to setup the machine within the requirement even there is off specs of horizontal creasing line from supplier, since the possible effect of this is bulging but reworkable.

Option 2: Sorting of Off Specs even within the tolerance dimension since we found out the effect is poor slot to none off specs board if operator adjust the slot depth.

PIC: PRODUCTION TARGET DATE: To be discuss in 4pm meeting

PREPARED BY:

GERALD DE GUZMAN
PRODASST, SUPERVISOR

APPROVED BY:

MEENA V. APALLA

ASST. MANAGER