

**KANEPACKAGE PHILIPPINE INC.**

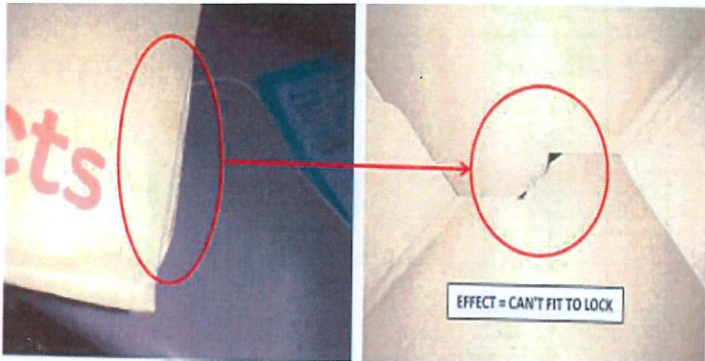
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 599

Date Issued: 22 07 19

Customer	KOWA EMORI	Attention To	Gerald De Guzman
Item Code	HP01D2000-3	Department	Production
Item Description	CARTON BOX	Date of Detection	22 07 19
Job Order Number	JO22-M-01435-1	Section Detected	CUSTOMER

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

7,500

Reject Quantity (pcs.)

266

Reject Percentage

3.54%

Nature of Defect:

CANNOT FIT LOCK

Requirement:

Lower flap must be lock

Actual:

Lower flap cannot be lock

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 type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input checked="" 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: 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**

- MOVEMENT / MISALIGN CHASE OF
STEEL PLATE

OUTFLOW ROOTCAUSE

- DONT HAVE REFERENCE TO
DETERMINE THIS ISSUE.

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

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

MISALIGN CHASE OF
STEEL PLATE

N/A

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	R. EVAN LOUISA	22/02	[<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: <input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-issue IRF	Remarks: QUALITY ASSURANCE DEPARTMENT CLOSED	Approved by: QA Supervisor Date: 22/201	Process Owner Acknowledgment: (Receiving Section) Line Leader Date:	Department Head Date:
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DATE AND
SIGNATURE 22/11/30

INVESTIGATION REPORT FOR KOWA EMORI HP01D2000-3 CARTON BOX CANNOT FIT LOCK

DIRECT CAUSE PROCESS/MATERIAL	1	Upon verification of actual reject it is similar to what happened in Nidec Subic Flexwave D which is due to movement/misalign chase of steel plate.
	2	July 14, 2022 we coordinate to Engineering the problem and they found out that the height of one of the screw installed in the chase is different of about 8mm that caused inclination of the chase of steel plate and caused misaligned reverse creasing during cutting. As corrective action Engineering pulled-out the chase of steel plate, they remove the screw and grind to reduced the height of screw.
	3	After the repair and finished the Emori D2000, no other item with creasing matrix to be process that day.
	4	July 15, 2022 night shift they process another batch of Emori D2000 and out of 7500pcs lot quantity there is random of cannot fit lock of 266pcs, there is a factor since the actual reject is similar to Nidec possible that still there is movement happened in chase of steel plate.



REJECT: THE REVERSE CREASING MATRIX IS



GOOD: THE REVERSE CRASING MATIX

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	Operator didn't notice the cannot fit lower flap lock since they don't have reference to determine this issue. Guideline not yet available that time since target date in on 220722
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PRODUCTION CORRECTIVE ACTION

- > Coordinate to Caledonian the issue regarding chase of steel plate since they have part replacement and preventive maintenance of Eterna on July 27-30, 2022.
- > Finish the Orientation of Guidelines to determine cannot fit lower flap lock for items with 2nd process gluing of lower flap. (TD: 220726)

PIC:	PRODUCTION
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PREPARED BY:

[Signature] 220721
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature]
WEENA Y. APALLA
ASST. MANAGER



KANEPACKAGE PHILIPPINE, INC.

ATTENDANCE SHEET

Submitted by: GERARDO DE GUAYAN Date: 21.07.21

ACTIVITY ORIENTATION REGARDING GUIDELINES TO DETERMINE CANNOT FIT LOWER FLAP LOCK OF ALL TYPES WITH 2ND PROCESS GLUING OF LOWER FLAP

Attendees				
	FIRST NAME	LAST NAME	DIV. / DEPT.	SIGNATURE
1	JOHN	REYNOLDO	PROD	<i>[Signature]</i>
2	LESSIE	REYES	PROD	<i>[Signature]</i>
3	JENNIN	DE CLARO	PROD	<i>[Signature]</i>
4	JOE	MARQUEZ	PROD	<i>[Signature]</i>
5	RON FAN	LOPEZ	PROD	<i>[Signature]</i>
6	ALONSO	LOPEZ	PROD	<i>[Signature]</i>
7	ERNESTO	BRITISER JR	PROD	<i>[Signature]</i>
8	DANIEL	MANGARIN	PROD	<i>[Signature]</i>
9	DAVID	REYES	PROD	<i>[Signature]</i>
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