

**KANEPACKAGE PHILIPPINE INC.**

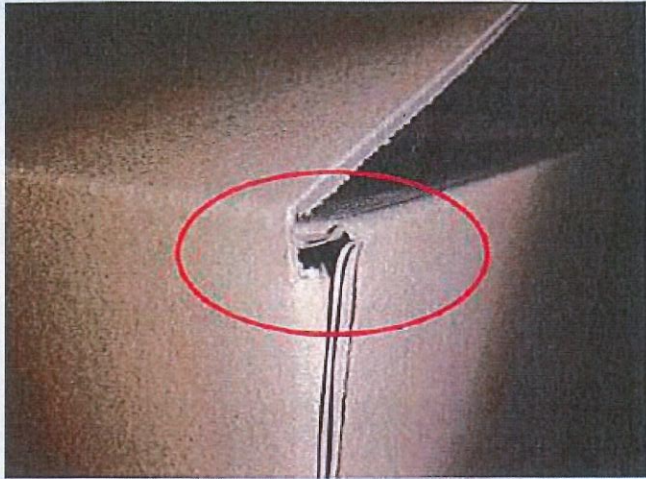
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
Telephone No. (049) 545-7166 to 69  
Fax No. (049) 545-6302

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

Control No.: 597

Date Issued: 22 07 16

Customer	EPSON ASP/EPLB	Attention To	Gerald De Guzman
Item Code	511600900	Department	Production
Item Description	OUTER CARTON BOX	Date of Detection	22 07 15
Job Order Number	JO22-M-01391-2	Section Detected	QA-SCREENING

**ILLUSTRATION OF THE PROBLEM**☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
250	240	96.00%

Nature of Defect:

POOR SLOT

Requirement:

No poor slot

Actual:

poor slot

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 type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching	<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-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

- ACTUAL BOARD EXCESS BY 6mm  
IN HEIGHT DIMENSION.

#### OUTFLOW ROOTCAUSE

DONT HAVE ENOUGH TIME TO CONDUCT  
BOX FORMING SINCE MASS PRO TIME  
IS ONLY 3 MINUTES DUE TO SMALL QTY.

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

WRONG SPEC MATERIAL.

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	220722	<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	

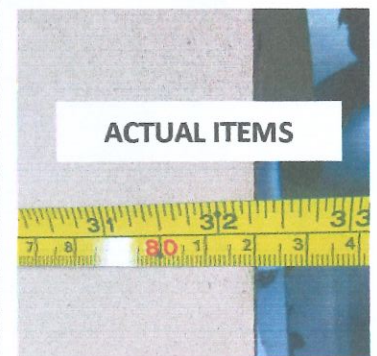
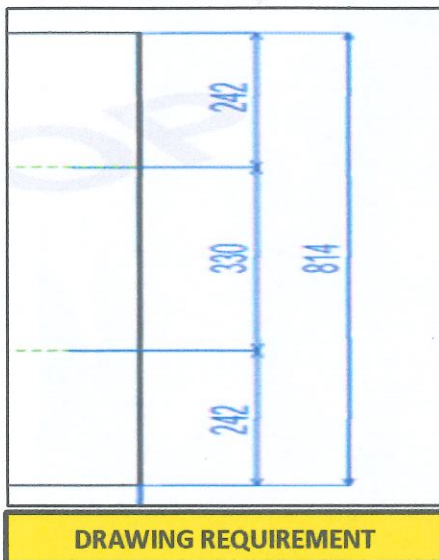
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improvement action.

### IV. CLOSURE

QUALITY ASSURANCE DEPARTMENT	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-Issue IRF DATE AND SIGNATURE	QA Supervisor Date: 22/20/	Line Leader Date:
	QA Asst. Manager	Department Head
	Date:	Date:

## INVESTIGATION REPORT FOR EPSON 511600900 OUTER CARTON BOX POOR SLOT

<b>DIRECT CAUSE PROCESS/MATERIAL</b>	<b>W1</b>	Upon checking of actual reject there is 6mm excess in Height dimension of actual items.
	<b>W2</b>	Requirement: 814mm vs. Actual: 820.
	<b>W2</b>	Since the dimension registered in Eqos is based in Drawing dimension the 6mm excess in actual dimension of items result to poor slot.



**6mm POOR  
SLOT OCCURS**

<b>INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL</b>	<b>W1</b>	Eqos Feeder didn't notice the uneven sheets since the raw materials pile by 20pcs, possible the first 20pcs pile is correct dimension since out of 260pcs produced by Eqos 240pcs are affected of poor slot.
	<b>W2</b>	Eqos Main Operator didn't notice the poor slot since they don't have enough time to conduct box form checking during sampling since the mass production time is only 3minutes due to machine speed of 105bpm Skip Off mode.

## PRODUCTION CORRECTIVE ACTION

1. Orient the Eqos operator regarding this Issue. (TD: 220719)
2. Feed Back to supplier since the raw materials is actual board with creasing and also alert the other concern regarding this issue. (TD: Discuss in 4pm meeting)

<b>PIC:</b>		<b>TARGET DATE:</b>	
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PREPARED BY:

**GERALD DE GUZMAN**  
PROD ASST. SUPERVISOR

APPROVED BY:

**WEENA V. APALLA**  
ASST. MANAGER



## MINUTES OF THE MEETING

Date: 220222 Time Start: 10:30 # Time End: 15:30 Venue: PMD - AMES

## ATTENDEES:

Name	Dept.	Sign	Name	Dept.	Sign
CLEVER BELARDO	Prod				
JOSE JAMES CALA	Prod				
RAFAEL LACOMBO	Prod				
JUAN BELARDO	Prod				

## AGENDA:

**ORIENTATION REGARDING EPSON  
511600900 OUTER CARTON BOX POOR SLOT**

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## MINUTES:

Upon checking of actual reject there is 6mm excess in Height dimension of actual items.

**INDIRECT CAUSED:** Requirement: 814mm vs. Actual: 820.

Since the dimension registered in Epos is based in Drawing dimension the 6mm excess in actual dimension of items result to poor slot.

**CORRECTIVE ACTION:**

> Orient the Epos operator regarding this issue

> Ford Back to supplier since the raw materials is actual board with cracking and also alert the other concern regarding this issue

## FOLLOW UP MEETING:

(date &amp; time)

for KPPI file up only

Prepared by:

Reviewed by:

Noted by:

*[Signature]*  
Raymond E. Guzman