

**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.: 603

Date Issued: 22 07 26

Customer	EPSON	Attention To	Gerald De Guzman
Item Code	5115938-00	Department	Production
Item Description	OUTER CARTON BOX	Date of Detection	22 07 25
Job Order Number	JO22-M-01575-1	Section Detected	QA-SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
800	200	25.00%

Nature of Defect:

BURSTING

Requirement:

no bursting

Actual:

occurrence of bursting

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 Rochelle Evangelista QA-IE Staff	Checked by Roderick Ramos QA Sr. Supervisor	Approved by Rexel Almario QA Asst. Manager	Received by (Receiving Section) 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: W/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**

THE POINTED EDGE OF GLUE APPLICATOR
HEAD HOLDER IN SA2600-1 HIT THE ITEMS

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

Actions to be done to eliminate recurrence

Who / When

	Location	Total Stock	NG	Total Good
RM				
WIP				
FG				

System	N/A	
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B. Orientation

Date		Time	
Title			
Attendees			

Design / Tools	N/A	
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C. Reworking

Rework Quantity	
Total Good	
Rework Percentage (Good)	

Process	PLS. SEE ATTACHED	
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II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 7/29/20

PIC: QA IE

Identified Rootcause
Pointed edge of glue tab hit the material

Recommendation
N/A

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	QA IE	7/29/20	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	grinded the pointed edge by prd.
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.

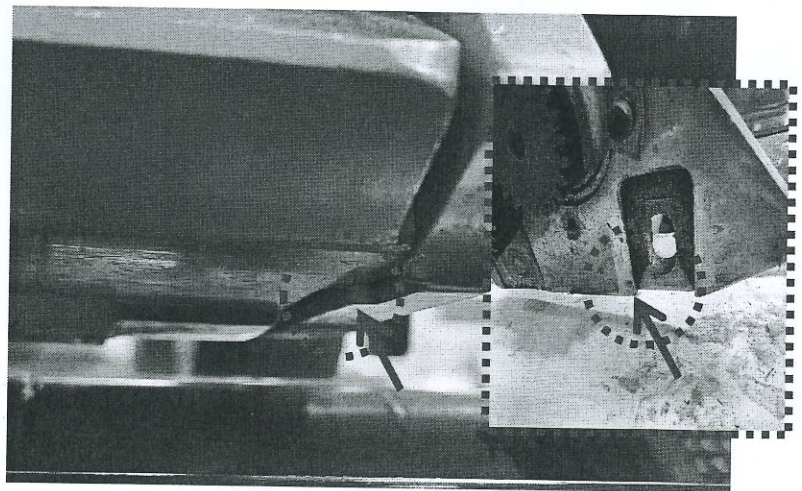
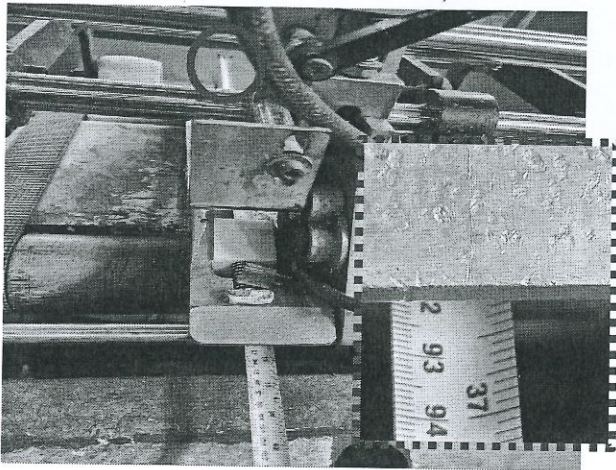
IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	Supplier related		Line Leader	Department Head
<input type="checkbox"/> Still open		QA Supervisor	QA Asst. Manager	
Re-Issue IRF	Date: 2/20/21	Date:	Date:	Date:

NOTE: CANCEL - SUPPLIER RECT.

INVESTIGATION REPORT FOR EPSON 5115938-00 OUTER CARTON BOX BURSTING

DIRECT CAUSE PROCESS/MATERIAL	W1	There is a pointed edge in glue applicator head holder in SA2600-1.
	W2	Since this item is big box with 939 x 2502 CF when it got incline during feeding in SA2600-1 the pointed edge hit the items result cut/bursting of the items.



INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	Catcher operator didn't notice the bursting since the sampling checking is on the first, middle and last of mass production only since they have online QA in SA2600.
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PRODUCTION CORRECTIVE ACTION

Request to engineering to grind the pointed age of glue applicator head holder of SA2600-1 and SA2600-2

PIC:	PRODUCTION	TARGET DATE:	220729
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PREPARED BY:

[Signature]
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature]
WEENA V. APALLA
ASST. MANAGER