

**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.: 595

Date Issued: 22 07 13

Customer	EPSON	Attention To	Gerald De Guzman
Item Code	5157542-00	Department	Production
Item Description	INDIVIDUAL BOX	Date of Detection	22 07 12
Job Order Number	JO-DRS22-L-0129-7-11	Section Detected	QA-SCREENING

ILLUSTRATION OF THE PROBLEM

☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

2000

73

3.65%

Nature of Defect:

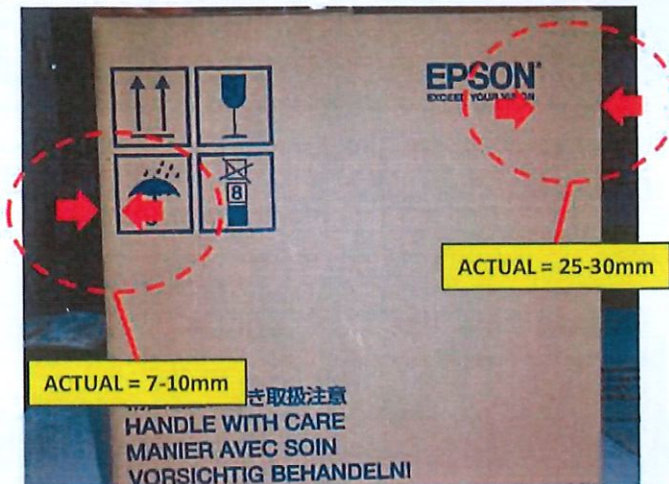
MISALIGN PRINT

Requirement:

20mm +/- 3mm

Actual:

Print dimension range from minimum of 7mm to a maximum of 30mm



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 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 checked="" type="checkbox"/> Dimension <input 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: 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****OUTFLOW ROOTCAUSE**

- BLUNT ORANGE RUBBER ROLLER
OF EQOS

- RANDOMLY OCCURRED

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	N/A	N/A	N/A	N/A
WIP				
FG				

System	N/A	
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B. Orientation

Date	N/A	Time	N/A
Title			
Attendees			

Design / Tools	N/A	
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C. Reworking

Rework Quantity	
Total Good	N/A
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: 07/14/22 PIC: QA IE

Identified Rootcause**Recommendation**

Blunt orange rubber roller

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	220717	[X] Yes [] No	replace roller.
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)	
<input checked="" type="checkbox"/> Closed				
<input type="checkbox"/> Still Open			Line Leader	Department Head
DATE AND SIGNATURE		QA Supervisor	QA Asst. Manager	
		Date:	Date:	Date:

INVESTIGATION REPORT FOR EPSON 515754200 INDIVIDUAL BOX MISALIGN PRINT

DIRECT CAUSE PROCESS/MATERIAL	W1	The factor consider that caused of misalign print is the blunt orange rubber roller in Eqos feeder. The orange rubber roller in the middle portion get blunt since it always being used due to most of the raw materials run in Eqos range to 600mm-1000mm width.
	W2	Since this item used big sheets with 1010 x 1300mm CF materials, during feeding the board get slipped in orange rubber roller that caused misalign print .



INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	Operator didn't notice the misalign print during sampling since the occurrence are randomly with the machine speed is 110bpm skin on mode.
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PRODUCTION CORRECTIVE ACTION

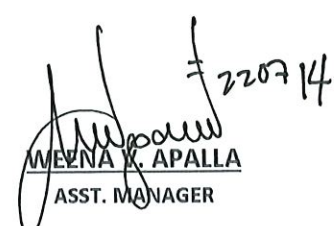
1. Replacement of Orange Rubber Roller (TD: 220717 upon Eqos Maintenance)
2. Set lifespan for Orange Rubber Roller (TD: To be monitor of Production IE's after the replacement)

PIC:	PRODUCTION
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PREPARED BY:


GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

 220714
WEENA K. APALLA
ASST. MANAGER