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

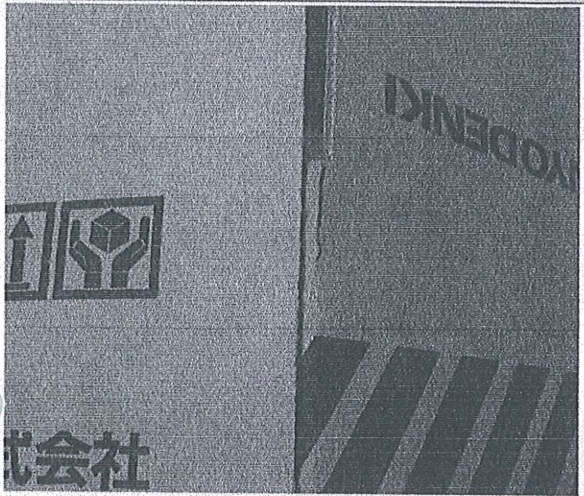
INVESTIGATION REPORT FORM (IRF)

■ Inhouse Detection ☐ Customer Claim

Control No.: 143 Date Issued: 200107

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	00665061-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	200106
Job Order Number	WO-19-M-02306-127	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM



■ Major ☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
2,240	50	2.23%

Nature of Defect:

BURSTING

Requirement:

No bursting on the smooth surface on the box

Actual:

Bursting on the smooth surface located at the glue tab

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
☐ First	☐ Hold	☐ Slotter	☐ Gluing	☐ Material
■ Recurrence	☐ Special Acceptance	☐ EQOS	☐ Vertical	☐ Dimension
No.: 2nd	☐ For Rework	☐ Diecut	■ Others:	■ Appearance
Date: 200106	■ Reject / Disposal	☐ Detaching	SEMI-AUTO GLUING	☐ Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
Adrian Vergara QA-IE Staff	Mr. Roderick Ramos QA Supervisor	Mr. Rexel Almario QA Asst. Manager	Mr. Gerald De Guzman / Ms. Weena Apalla 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: NOT A FACTOR Why 4: Why 5:	Why 1: Why 2: Why 3: NOT A FACTOR Why 4: Why 5:
Design / Toolings	Why 1: Why 2: Why 3: NOT A FACTOR Why 4: Why 5:	Why 1: Why 2: Why 3: NOT A FACTOR Why 4: Why 5:
Process / Material	Why 1: - OPERATOR REPORT THIS PROBLEM TO LEADER AND TRY DIFFERENT ADJUSTMENT Why 2: IN SETUP OF SEMI AUTO GLUING. Why 3: - WE FOUND THAT THE PROBLEM CAUSED IS THE BRITTLENESS OF MATERIALS BECAUSE Why 4: THE OCCURENCE OF BURSTING IS Why 5: RANDOMLY	Why 1: - LEADER APPROVED TO CONTINUE THE PROCESS Why 2: IN SEMI AUTO GLUING Why 3: - BECAUSE MATERIALS ALREADY HAVE PRINT AND WE DONT KNOW HOW MANY ARE AFFECTED Why 4: BECAUSE BURSTING OCCURS DURING BOX Why 5: FORM CHECKING IN QA SCREENING.

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 CONCLUSION

OCCURRENCE ROOTCAUSE	OUTFLOW ROOTCAUSE
- BRITTLENESS OF MATERIALS	- RANDOMLY OCCURENCE AND BURSTING OCCURS DURING BOX FORM CHECKING IN QA SCREENING.

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

A. Sorting Result

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	QA-Inline (Semi-Auto)	2,240	50	2,190

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Attendees	N/A		

C. Reworking

Rework Quantity	N/A
Total Good	N/A
Rework Percentage (Good)	N/A

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

	Actions to be done to eliminate recurrence	Who / When
System	N/A	
Design / Tools	N/A	
Process	Attach clearance reference on the gluing applicator to avoid over compression of the WIP during process and also to standardize the setting each material	Prod. (Next Running)

II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 20 01 08 PIC: A. Vergara

Identified Rootcause	Recommendation
~ Bursting occurs due to tight compression glue applicator on the materials and brittle surface of corrugated boards	~ Put clearance reference on the gluing applicator of the machine to standardize the clearance for each flute

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 01 08	[ ] Yes [✓] No	For follow-up
2nd Verification of Action	A. Vergara	20 01 16	[✓] Yes [ ] No	Corrective Action is already imp remented for both Semi-Auto Gluing Machine
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action	A. Vergara	20 03 11	[✓] Yes [ ] No	CA is implemented & effective

QUALITY ASSURANCE DEPARTMENT
CLOSED
DATE AND SIGNATURE: 200310

Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective and 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)	
[✓] Closed [ ] Still Open [ ] Re-Issue IRF	5 lot's running no occurence of same defect.	QA Supervisor Date: 20 07 08	QA Asst. Manager Date: 20 07 08	Line Leader Date: 200713	Department Head Date: 20 07 13