1890 & 1872

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

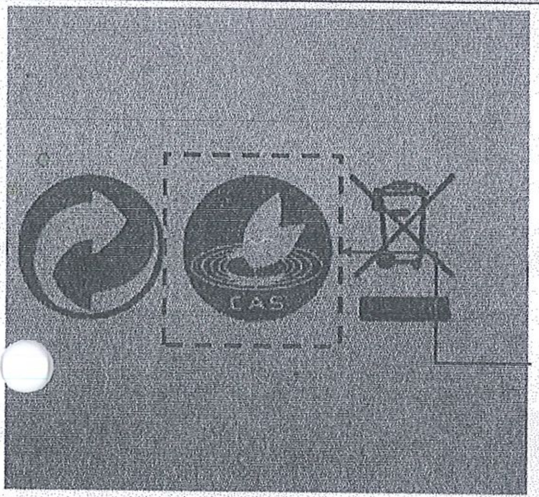
INVESTIGATION REPORT FORM (IRF)

■ Inhouse Detection □ Customer Claim

Control No.: 149 Date Issued: 20 01 21

Customer	SHIMADZU	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	321-71417-01	Department	PRODUCTION
Item Description	PACKING BOX	Date of Detection	20 01 20
Job Order Number	WO-20-R-010-6 & WO-20-R-010-7	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM



Text printed should is RoHS Verified

■ Major □ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
176	29	16.48%

Nature of Defect:

BLOTTED PRINT

Requirement:

Text should be readable

Actual:

The affected text is not readable

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
■ First	□ Hold	□ Slotter	□ Gluing	□ Material
□ Recurrence	□ Special Acceptance	■ EQOS	□ Vertical	□ Dimension
No.:______	□ For Rework	□ Diecut	□ Others:	■ Appearance
Date:______	■ Reject / Disposal	□ Detaching	______	□ Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
Adrian Vergara QA-IE Staff	Mr. Roderick Ramos QA Supervisor	for 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: - PRINT CHARACTER IS TOO SMALL AND Why 2: THE TEXT IS ENGRAVE Why 3: - ENGRAVE TEXT SPECIALLY IF Why 4: SMALL CHARACTER IS PRONE Why 5: TO BLOTTED PRINT.	Why 1: Why 2: - APPROVED BY CUSTOMER Why 3: Why 4: Why 5:
Process / Material	Why 1: - FOR 176pcs RUNNING TIME OF THIS ITEM Why 2: IS ALMOST 1-2 MINUTES ONLY. Why 3: - UNLIKE TO LONGWAY PRINTING BEFORE, WE PROCESS THIS ITEM STOP AND GO ROUTINE. Why 4: AFTER PRINTING OF 5pcs WE STOP AND Why 5: CLEAN THE CYREL THEN PRINT ANOTHER 5pcs.	Why 1: Why 2: - BLOTTED PRINT CAN'T DETECT Why 3: DURING SAMPLING. Why 4: - DONT HAVE ENOUGH TIME TO Why 5: CONDUCT MORE SAMPLING.

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FINAL CONCLUSION

OCCURRENCE ROOTCAUSE	OUTFLOW ROOTCAUSE
ENGRAVE AND SMALL TEXT CHARACTER.	- NOT ENOUGH TIME TO CONDUCT MORE SAMPLING DUE TO SMALL QTY.

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 - SEMI - AUTO	176	29	147

B. Orientation

Date	N/A	Time	N/A
Ti[illegible]	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	N/A
Design / Tools	CHANGE THE PRINT CHARACTER FROM ENGRAVE TO EMBOSS PRINT IF APPLICABLE	SALES & DESIGN
Process	IF POSSIBLE TRANSFER THIS ITEM TO LONGWAY PRINTING IN SUPERFLEX TO CONDUCT STOP & GO PROCESS.	

Date Conducted: 20 01 22 PIC: A. Vergara

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

Identified Rootcause	Recommendation
The engrave text on the photopolymer has accumulated ink because the accumulated easily since the text is very small and thin	-Immediately clean the cyrel upon detection of the defect during printing mass production ~ Change design the affected photopolymer (suggestion): * Emboss * still engrave but the textsize bigger ~ Change paper from uppc to NPK

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 22	[✓] Yes [ ] No	Corrective Action is implemented (Please see Recommendation - first recommendation only)
2nd Verification of Action	A. Vergara	20 12 28	[✓] Yes [ ] No	Recommendation is implemented - change paper only
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action	A. Vergara	20 10 12	[✓] Yes [ ] No	Recommendation is effective

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)	
[✓] Closed [ ] Still Open [ ] Re-Issue IRF		QA Supervisor Date: 21 01 11	QA Asst. Manager Date: 21 01 11	Line Leader Date: 21 01 11	Department Head Date: 21 01 11

QUALITY ASSURANCE DEPARTMENT
CLOSED
DATE AND SIGNATURE 21 01 09