

**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.: 150

Date Issued: 20 01 22

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	00930135-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	20 01 21
Job Order Number	WO-19-M-02306-238	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

210

24

11.43%

Nature of Defect:

SCRATCHES

Requirement:

For Class A: scratch should be until 40mm x 50mm only

Actual:

Scratch reaches up to 50mm x 180mm

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
☒ First ☐ Recurrence No.: _____ Date: _____	☐ Hold ☐ Special Acceptance ☐ For Rework ☒ Reject / Disposal	☐ Slotter ☐ EQOS ☐ Diecut ☐ Detaching	☒ Gluing ☐ Vertical ☐ Others: _____	☐ Material ☐ Dimension ☒ Appearance ☐ Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by Mr. Roderick Ramos QA Supervisor	Approved by Mr. Rexel Almarino QA Asst. Manager	Received by (Receiving Section) 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:	NOT A FACTOR	Why 1:	NOT A FACTOR
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:	NOT A FACTOR	Why 1:	NOT A FACTOR
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:	PLS. SEE ATTACHED.	Why 1:	- OPERATOR CAN'T TRAP THE SCRATCHES
	Why 2:		Why 2:	BECAUSE THERE IS ONLINE QA IN SEMI AUTO GLUING.
	Why 3:		Why 3:	- AUTOMATIC AFTER FEEDING OF MATERIALS
	Why 4:		Why 4:	IN SEMI AUTO GLUING ONLINE QA
	Why 5:		Why 5:	CHECK THE ITEMS.
	Why 6:			

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INVESTIGATION REPORT FORM (IRF)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

JOGGER GATE MOVE DOWNWARD AND TOUCH THE ITEM THAT CAUSED SCRATCHES WHEN CONVEYOR AUTOMATICALLY RUN

OUTFLOW ROOTCAUSE

THERE IS ONLINE QA IN SEMI AUTO GLUING.

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	N/A			
WIP	N/A			
FG	QA-SEMI-AUTO	210	24	186

Actions to be done to eliminate recurrence**Who / When****B. Orientation**

Date	20 01 23	Time	08:20 - 08:28 A.M
Title	ORIENTATION REGARDING USAGE OF SECONDARY LOCK OF JOGGER GATE		
Dees	SEMI-AUTO GLUING OPERATORS		

Design / Tools**C. Reworking**

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

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

Date Conducted: 20 01 22

PIC: A. Vergara

Identified Rootcause

~The jogger guide leave scratches on the joint portion of the item because the jogger guide touches the material, the jogger's height clearance became narrow due to lose primary lock (Lever lock) because the string support was removed

Recommendation

~*Use the secondary lock of the machine to support the jogger guide from reducing the height clearance (the secondary lock moved 10mm upwards)
~ Apply on both semi-auto gluing machine

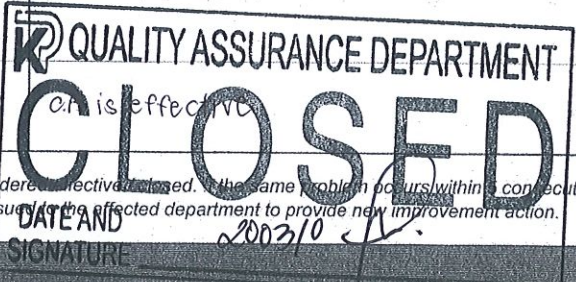
III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 01 23	☒ Yes ☐ No	Corrective Action is implemented
2nd Verification of Action			☐ Yes ☐ No	
3rd Verification of Action			☐ Yes ☐ No	
Effectiveness of Action	A. Vergara	20 03 05	☒ Yes ☐ No	CA is effective

Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective. 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	Bot's running no occurrence of same defects.	QA Supervisor Date: 20 07 08 QA Asst. Manager Date: 20 07 08	Line Leader Date: 2007/3 Department Head Date: 20 07 13

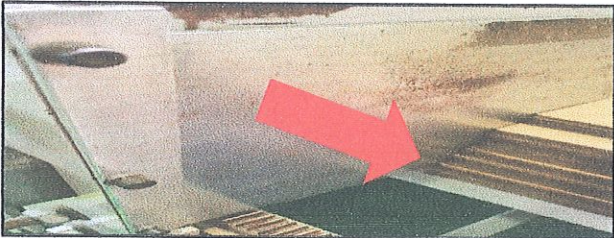


INVESTIGATION REPORT FOR SCRATCHES DEFECT OF SANYO DENKI 00930135-01 PACKAGE

DIRECT CAUSE PROCESS / MATERIALS

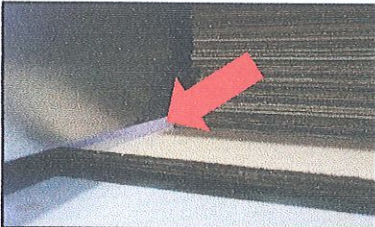
W1

The item was scratch by jogger gate when the conveyor automatically run during semi auto gluing process.

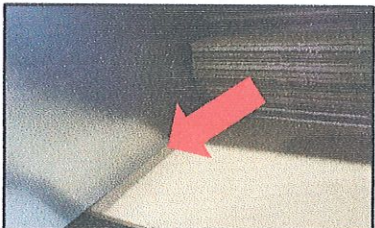


W2

Suddenly the jogger gate move downward and touch the item during mass production.



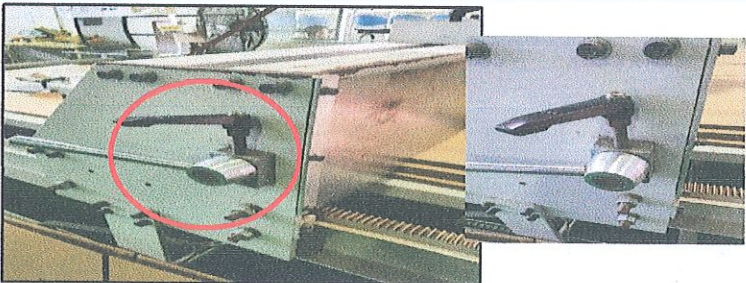
"GOOD"
JOGGER GATE HAVE



"NO GOOD"
JOGGER GATE TOUCH THE

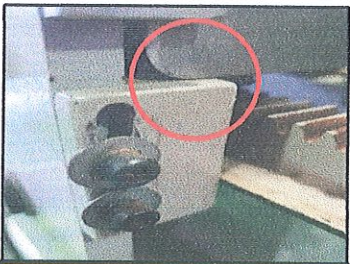
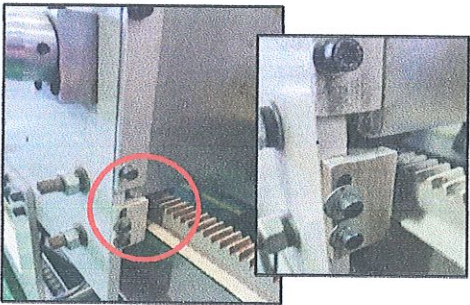
W3

The lock of jogger gate is getting loose due to machine vibration during process, that's why before the operator puts rope in the knob.



CORRECTIVE ACTION PROCESS

Upon investigation I notice that there is secondary lock of jogger gate. Orientation to use the secondary lock of jogger gate to eliminate this problem. Production / 200122



SECONDARY LOCK SUPPORT
TO JOGGER GATE NOT TO
MOVE DOWNWARD



ORIENTATION



KANEPACKAGE PHILIPPINE, INC.

MINUTES OF THE MEETING

DATE: 200123

TIME START: 08 20H

FINISHED: 08 28H

VENUE: SGM1 AUTO CLING AREA

ATTENDEES:

NAME	DEPT.	SIGN
MARLY JANE	Prod.	<i>[Signature]</i>
MARLY JANE	Man.	<i>[Signature]</i>
Rosemarie B.	Prod.	<i>[Signature]</i>

NAME	DEPT.	SIGN

AGENDA:

ORIENTATION, REGARDING USAGE OF SECONDARY LOCK
OF JOGGER GATE.

MINUTES:

page of

- MAKE SURE THE JOGGER GATE HAVE DISTANCE TO ITEM'S TO ELIMINATE SCRATCHES.
- MAKE SURE THE MAIN LOCK OF JOGGER GATE IS FULLY LOCK.
- AFTER THE MAIN LOCK, USE THE SECONDARY LOCK AND MAKE SURE THE SECONDARY LOCK IS FULLY SUPPORT TO JOGGER GATE NOT TO MOVE DOWNWARD.

Follow up meeting: (date & time)

For KPPI fill up only

Prepared by:

[Signature]
GEMARIE DE GUZMAN

Reviewed by:

File copy received by: