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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

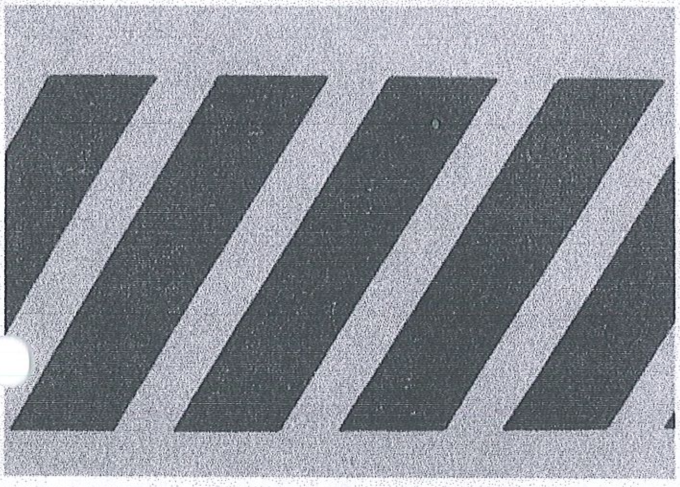
INVESTIGATION REPORT FORM (IRF)

■ Inhouse Detection ☐ Customer Claim

Control No.: 153 Date Issued: 20 01 23

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	00939007-01	Department	PRODUCTION
Item Description	CORRUGATED CARTON	Date of Detection	200122
Job Order Number	WO-19-M-02109-32	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM



■ Major ☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
2,020	44	2.17%

Nature of Defect:

POOR PRINT

Requirement:

No pinholes on the solid print (At least it is not visible in 1 arm length)

Actual:

Pinholes on the solid print is visible in 1 arm length

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
☐ First	☐ Hold	☐ Slotter	☐ Gluing	☐ Material
■ Recurrence	☐ Special Acceptance	■ EQOS	☐ Vertical	☐ Dimension
No.: 2	☐ For Rework	☐ Diecut	☐ Others:	■ Appearance
Date: 20 01 22	■ 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	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: - STUDY OF SKIP-OFF PRINTING FOR SANYO DENKI ITEM'S. Why 2: - PRODUCTION TARGET IS TO STANDARD Why 3: WHICH ITEM NEED TO UNDERGO SKIP OFF OR SKIP-ON PRINTING. Why 4: - FOR CAPACITY MONITORING OF Why 5: EQOS MACHINE.	Why 1: - NO ALLOTTED MATERIALS FOR THE STUDY Why 2: OF SKIP-OFF OR SKIP-ON PRINTING. Why 3: - POOR PRINT IS REWORKABLE. Why 4: Why 5:

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FINAL CONCLUSION

OCCURRENCE ROOTCAUSE	OUTFLOW ROOTCAUSE
- STUDY OF SKIP-OFF PRINTING FOR SANYO DENKI ITEMS. TO STANDARD THE SKIP-OFF OR SKIP-ON PRINTING PROCESS.	- NO ALLOTTED MATERIAL FOR THE STUDY AND POOR PRINT IS REWORKABLE.

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	2,020	44	1,976

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	N/A
Design / Tools	N/A	N/A
Process	- STANDARD THIS ITEM TO SKIP-ON PRINTING	PRODUCTION NEXT RUNNING

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

Date Conducted: 20 01 27 PIC: A. Vergara

Identified Rootcause	Recommendation
~Small pinholes on the surface of the item has no ink. The transferred ink from the photopolymer to the substrate is thin. the photopolymer rotate once on the anilox roller prior ink transfer. Because "skip-off" was setup for the running of the item	~ Always activate skipping on the item w/ solid print ~ If possible identify the items that need to undergo skipping setup

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 27	[✓] Yes	[ ] No	Corrective Action is implemented
2nd Verification of Action			[ ] Yes	[ ] No	
3rd Verification of Action			[ ] Yes	[ ] No	
Effectiveness of Action	A. Vergara	20 02 18	[✓] Yes	[ ] No	C.A is effective

QUALITY ASSURANCE DEPARTMENT
CLOSED
DATE AND SIGNATURE 200210

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	6 lots running no occurrence of same defects.	QA Supervisor Date: 20 07 08	QA Asst. Manager Date: 20 07 08	Line Leader Date: 200713	Department Head Date: 20 07 13