

**KANEPACKAGE PHILIPPINE INC.**

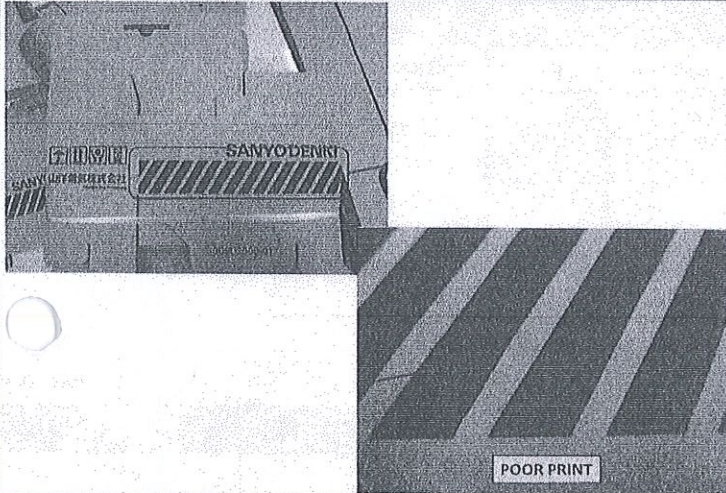
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 160

Date Issued: 20 02 04

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	00902009-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	20 02 01
Job Order Number	WO-DRS-20-M-0087-123	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

1065

Reject Quantity (pcs.)

81

Reject Percentage

7.60%

Nature of Defect:

POOR PRINT

Requirement:

No spots on the solid print of the item

Actual:

Occurrence of spots on the solid print

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 02 01	☒ Reject / Disposal	☐ Detaching		☐ Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)	
 Adrian Vergara QA-IE Staff	 Mr. Rodolfo 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:	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:	PLS. SEE ATTACHED
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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

- DIFFERENT VISCOSITY OF INK FROM LEFT TO RIGHT OF ANILOX DUE TO UNEVEN SUPPLY OF WATER FROM SHOWER (ROLLING) NOZZLE.

- POOR PRINT DETECTED AT THE END PORTION OF MASS PRODUCTION, OPERATOR PERKED TO INCLUDE THE AFFECTED BECAUSE 20% OF 60% ARE AFFECTED AND IT WAS REMEDYABLE

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			
WIP	N/A			
FG	QA - In Line	1065	51	1,014

System	N/A	
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B. Orientation

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

Design / Tools	N/A	
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C. Reworking

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

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

Date Conducted: 20 02 07

PIC: A. Vergara

Identified Rootcause**Recommendation**

As per checking on the actual condition of machine
@ Printing Unit 1:
L = 5.34 mL ; R = 3.87 mL
@ Printing Unit 2:
L = 2.39 mL ; R = 3.83 mL

~ The machine needs to undergo proper maintenance to fix the discrepancy on the left shower for both printing unit

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 02 07	[] Yes [X] No	Prod. coordinate the issue to engineering target date of maintenance is 20 02 15
2nd Verification of Action	A. Vergara	20 02 15	[X] Yes [] No	Eng'g clean the clogged shower
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	20 05 16	[X] 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	Got running no occurrence of poor print	 QA Supervisor Date: 20 07 08	 QA Asst. Manager Date: 20 07 08 Line Leader Date: 2007/3 Department Head Date: 20 07 13

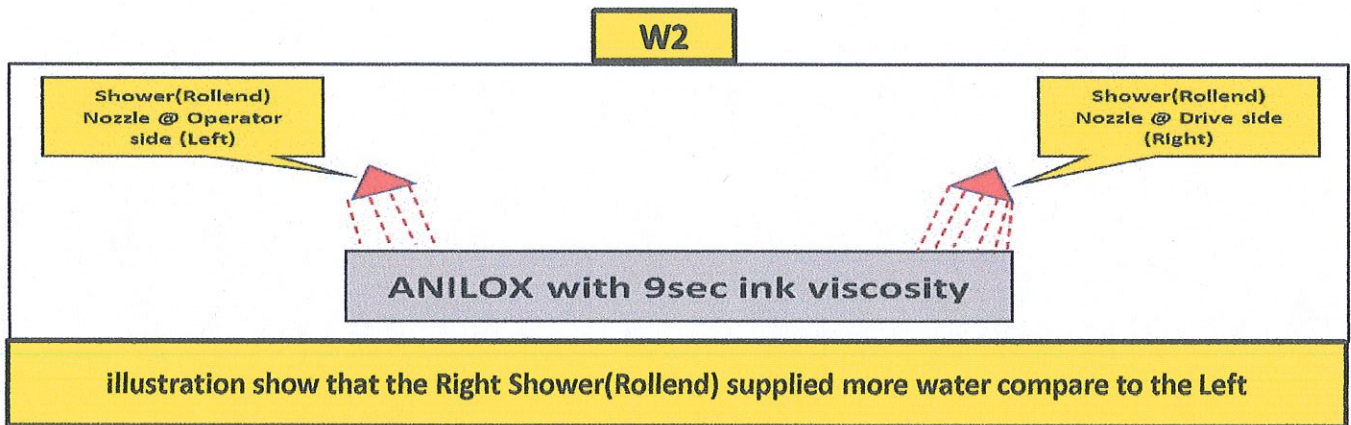
INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 00902009-01 PACKAGE

W1 - The ink viscosity change upon mass production, due to uneven distribution of water supplied from Shower (Rollend) Nozzle in Eqos.

DIRECT CAUSE PROCESS / MATERIAL

W2 - The water supplied in ink by Shower (Rollend) Nozzle in Drive side (right) is much more compare on the Operator side (left)

W3 - The different viscosity of ink from left to right is the bigger factor of poor print, because the item used is Big sheets 1025 x 1584 BF / 6 outs, the 2 cavities at the right side are affected of poor print.



KANEPACKAGE PHILIPPINE INC.											
EQOS DEVELOPMENT REMARKS SHEET											
DATE	CUSTOMER	ITEM CODE	MATERIAL/SHEET		INK COLOR/VISCOCITY		CVREL+R-BACK	ANILOX,PRINTING IMPRESSION		RE DIFFICULTY	
12/13/1	Toradyne	TP100720 1A001	CBF	UPPC	T. blue	9	0-25	0-3	4-0	SKIP	
	Sanyo denki	0090200901	BF	UPPC	black	9	0-25	0-5	1-3	SKIP	
	Emori	EM0000401A0	BF	UPPC	Red	9	0-25	0-3	1-3		
	Emori	EM0000601A001	BF	UPPC	Red	9	0-25	0-3	1-3		

No abnormality found in machine settings

INDIRECT CAUSED PROCESS / MATERIAL

W1 - Trial Run approved by QA Patrol before proceed to mass production.

W1 - Poor print detected at the end portion of mass production, operator decided to include the affected item because 2 out of 6outs are affected and it was reworkable.

CORRECTIVE ACTION PROCESS

: Report the abnormality to sir. Suzuki for more technical action regarding this problem.

PIC: Production Leader

Target Date: 200207

EQOS DEVELOPMENT REMARKS SHEET

DATE	CUSTOMER	ITEM CODE	MATERIAL/SHEET	INK COLOR/VISCOSITY	CYREL+R-BACK	ANILOX, PRINTING IMPRESSION	REMARKS DIFFICULTY, ACTION
10/1/01	Tenadyne	T9007201A001	CBF UPVC	T. blue 9	G-35	G-3 4-0	SKIP
	Sanyo daniel	00902200101	BF UPVC	black 9	G-35	G-6 1-3	SKIP
	Emori	EM0000401A0	BF UPVC	Red 9	G-35	G-3 1-3	
	Emori	EM0000601A001	BF UPVC	Red 9	G-35	G-3 1-3	
	Emori	EM0000901A0	CBF UPVC	Red 9	G-35	G-3 1-4	SKIP
	EPSON VP	S151475001	CBF FUJI	Black 9	G-35	G-3 5-0	No Data
	Emori	EM0000301A002	BF UPVC	Red 9	G-35	G-3 5-0	
	Repley	Cap000701A001	CBF UPVC	black 9	G-35	G-3 1-4	
	Line Seiki	LS000301A003	CBF UPVC	Brown 9	G-35	G-3 4-9	SKIP
	Sanyo daniel	00902001801	CBF UPVC	black 9	G-35	G-3 1-8	SKIP
			CBF UPVC	black 9	G-35	G-3 4-7	SKIP 1c
	SMK	SMK000201B	CF UPVC	black 9	G-35	G-5 4-6	SKIP 2c
					G-35	G-3 1-6	SKIP
	MERASENCO	MRC0004301A008	CF FUJI	MERA BLUE 9	G-35	G-3 1-7	
10/02/01	EMORI	EM0000201A001	B UPVC	RED 9	G-35	G-3 1-1	SKIP on IPD
10/04	NICEPA	NPT000101A002	CF UPVC	BLACK 9	G-35	G-3 1-6	SKIP
	MOYAMA	MY0003001A001	CF UPVC	RED 9	G-35	G-3 1-3	SKIP
	EPSON	511595400	CF UPVC	BLACK 9	G-35	G-3 1-1	
	EPSON	512671100	CF UPVC	D. BLUE 9	G-35	G-4 1-5	SKIP
	EPSON	513638500	CF UPVC	D. BLUE 9	G-35	G-4 1-5	SKIP
		511593800	CF UPVC	D. BLUE 9	G-35	G-4 1-5	SKIP
		511652200	CF UPVC	D. BLUE 9	G-35	G-4 1-3	SKIP
		511510800	CF FUJI	D. BLUE 9	G-35	G-4 1-3	SKIP
		511583500	CF UPVC	D. BLUE 9	G-35	G-5 1-5	SKIP
	EPSON	515724400	CB UPVC	D. BLUE 9	G-35	G-4 1-3	SKIP
	EPSON	515754200	CF UPVC	D. BLUE 9	G-35	G-4 4-4	SKIP IPD
					G-35	G-4 1-4	