		AGE PHILIPPINE INC. By. La Mesa, Calamba City, Laguna	INVESTIGA	ATION REPORT	FORM (IRF)				
Telepho	one No. (049) 545-710 (049) 545-6302	66 to 69	Inhouse Detection	Custo	omer Claim				
			Control No.: 171	Date Issued:	20 02 17				
Customer	SANYO DE	NKI	Attention To Mr. Gerald De Guzman / Mr. Rexel Almario						
Item Code	00902009-0	01	Department PRD / QA						
Item Description	PRINT SPE	CIFICATION	Date of Detection 20 02 12						
Job Order Number	and a sale of the	0-M-00087-122	Section Detected CUSTOMER - SANYO DENKI						
	ILLUSTRATION	OF THE PROBLEM	Major	Minor	•				
			Lot Quantity (pcs.) 400	Reject Quantity (pcs.)	Reject Percentage				
	CYLLAI FERNI MAIS DIN DHE COM CH THE PACKACING	DEVICE OF THE PROPERTY OF THE	Nature of Defect	MISALIGN PRINT					
	NO GOOD	D MATERIAL 1	Requirement: The sticker guide should	d be 10mm away from the creas	sing line w/ ±5mm tolerance				
	TANDARD: 10.00mm	DINEGO	Actual:	icker guide touches the creasin	g line				
NO. OF OCCU	JRRENCE	DISPOSITION	AREA OF OCC	URDENOS (OCIONA					
First		Hold		JRRENCE / ORIGIN	CONTENT				
Recurrence		Special Acceptance	Slotter	Gluing	Material				
No.:		For Rework	Diecut	Vertical	Dimension				
Date:		Reject / Disposal	Detaching	Others:	Appearance				
Issued	by	Checked by	Approved by		Process / Method Received by				
Adrián Ver QA-IE S		Mr. Roderick Ramos QA Supervisor	Mr. Rexel Alma	Mr. Gerald	De Guzman / Mr. Rexel Almario lead/ Supervisor				
DIRECT CAUSE	(Analyze the reas	I. INVESTIGAT son of occurrence, why it happened?)	ION / ANALYSIS	: (Analyze the reason of occurre	ence, why it leaked?)				
Why 1: Why 2: Why 3: Why 4: Why 5:	NOT	A PACTOR	Why 1: Why 2:	OT A PA					
Why 1: Why 2: Why 3: Why 4: Why 5:	POT	A FACTOR	Why 1: Why 2: Why 3: Why 4: Why 5:						
Why 1: Why 2: Why 3: Why 4: Why 5:	PCS. 5	EE MTACHED	Why 1: Why 2:	SEE ATTACH	(ED				



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)

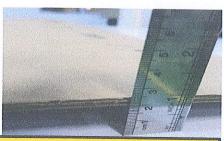
					FINAL CO	NCLUSION				
		OCCURRENC	E ROOTCAUS	E				OUTFLOW ROOTCAL	JSE	
	INT/D 15 MA	IECUT RP n			CAUSED	ラオ	mplin	DID NOT ,	THE OCCU	
IMMEDI	IATE ACTION: (Action to be done	to contain/ tempor	ary correct the pro	blem found)	CORREC	TIVE ACTION:	(Actions to be done to ensure	hat the problem will not	happen again)
A. Sorting Re	sult						Actions to be	done to eliminate recurre	ence	Who / When
	Loc	cation	Total Stock	NG	Total Good					
RM	<u> </u>	/A								
WIP	f	V/A				System				
FG	CUSTOMB	r-sop	400	10	390					
B. Orientation	1		_	_						
Title	MATERIAL	ON REGARD	Time (NG RANDOR	1:30 P.M		Design / Tools		N/A		
C. Reworking										
Rework Qua	Rework Quantity N/A						PI	5. SEE ATT	FICHED	
Total Good						Process				A
Rework Per	centage (Good)		N/A							
II. QA	ROOTCAUSE	VERIFICATIO	N (To be filled	out by QA In-o	charge)	Date Conduc	ted: 10 02	18 PIC: A.	Vergara	
		Identified	Rootcause					Recommendation		
condition	naterials (the mate n of mate gh feeding	erials an	ppeal ms warp ight causa	cs of mat	use the erial	to lout ~ Put pol monitor unit ~ Apply	kayoke m the timi	ie & diecut black ark on the ming of materia to 00902009-01	ylar of the	it em to
			TO STATE OF THE STATE OF	ECTIVE ACTIO	N VERIFICAT	ION (To be fill	led out by QA	In-charge)		
<u>()) " </u>		Chec	ked by	Date	Impler	nented?		Remar	ks	
1st Verifica	tion of Action	A. Vergo	ava	20 02 20	Yes	[] No	CA is f	fully implement	ed	
2nd Verifica	ation of Action	A. Verga	ra	20 02 20	[才Yes	[] No	Roomine It my	ALITY ASSURAL	ICE DEPART	MENT
3rd Verifical	tion of Action				[]Yes	[] No				
Effectivene	ess of Action	A. Vergar	ପ	20 06 09	[⊿]Yes	[] No	DATE AN	110000	imple meinted	49
Note: If no s deliveries o	same defects / p r 3rd verification	problems occur n of action still i	s for 5 consecution of yet implement	utive deliveries, ented, Investiga	corrective ac ation Report st	tion is consider nall be re-issue	red effective / c ed to the affecte	losed. If the same problem of department to provide i	m occurs within 5 conew improvement a	onsecutive ction.
	N New Degree Wil				IV. CLC	SURE				
Status:		Remarks:			Appro	ved by:		Process Owner Acknow	wledgment: (Receiv	ving Section)
Closed				nAm	M. M.	All	W. 200	011	1	
Still Open				1 1	row w) pervisor	JA Ass)	Manager)	Jine Leader	Departm	ant Head
Re-Issue IRF		1 4. 1. 1.	of an	Date: 20	07 08	Date: 20	ชา อี่	Date: 2007/3		17 13

INVESTIGATION REPORT FOR MISALIGN PRINT / DIECUT OF SANYO DENKI 00902009-01 PRINT SPECIFICATION

PROCESS / MATERIAL

- W1 Cannot identify between Eqos and Eterna the caused of Misalign Print/Diecut, but 1 of the Factor and have a proof that cause of misalign is the warp materials.
- **W2** Eqos operator conducted Study that the Random warp materials have big effect to Print movement.
- W3 Eterna record the machine ERROR downtime due to warp material. This machine error is one of the big factor of misalign diecut.





RANDOM WARP MATERIALS with 18mm WARPAGE



Print move 8mm upward for warp materials (Requirement 25mm vs. Actual 17mm)

4	SERVINO SERVINO		
	6 6 YO	8	e.

The lower flap slot move 12mm upward (Requirement 119mm vs. Actual

			DE CO	1/HEEM	MACKE	IK .				
MADRIE STREET			i.				mar.			
FOR CITIES 8	100				T		-			
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quita da	A HAR	Salar S	1000		1	05.00			*	1000
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Actual machine Spend Actual machine Prompts	-	hro.	1	12	15 pa		tal.			70.30
Sport for		113		15 hos	1000	The same	170			Section.
Maintel	ALC:				25 4 265		178 4 (179		333	
	100		1	•	7.6		1 3			
ACTIVITY		Tru:	1	Tr e	1	253	1 1	74		2/4
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Agnaptive			I EUR	1-200 page	12130		I DECEMBER	17/25	R. Lincold	5551F
Modify	1		1200		1000	10000	19.500	6300	11355	III-
Visit of saling			1		1000	1				1
Mashire Brashdawn	-	-	1	4	1		-		1000	
Sport Other Logina	+		10000	-	-	10000	-		26265	-
Byolive	1	1	17/7	1116	-	-	manue.	* 10000	-	1
Useton Set on			10000	20000000			1	-	1	1
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3. Sissus new brade	E	1 at 2	High	115.45	1.00	1156	2210	112	1000	-
4 Tital Rus	153,00	1845	CAL	1250	1500	100	239	Ti.	100000	
5 04 photographagonical	le la	115	12.19	152	13/1	13.5	150	BILL		
Mara Prodersion	2220	1000	507000	10000	1000	1	1	1000	100	Tes
1	125	1903 0	1757	1850	1110	113	11776	113.69		
	61/45	A COLUMN	7000	933669	100	111	10000	10000		0 00
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Eterna operator record the machine error last January 29, 2020 for Sanyo Denki 00902009-01 Package with JO# WO-DRS-20-M-00087-122 due to warp material

INDIRECT CAUSED

W1 - Possible that the warp materials occurrence is randomly.

PROCESS / MATERIAL

- W2 Trial run in both machine are approved by QA patrol why they proceed in mass production.
- W3 Misalign print did not detected in sampling checking because the occurrence is randomly.

CORRECTIVE ACTION PROCESS

> Orient in Eqos Operator and Production Leader that if there is random occurrence of warp materials, operator immediate report the problem to Production Leader in-charge. The Production Leader in-change will request sorting of the affected item to QA Leader in-change.

PIC: Production

Target Date: 200218

> From 6outs with materials of 1025 X 1584 BF that (Prone to warp because Big sheets). The 3pm team propose to back in 1out with materials of 484 X 933 BF (Not prone to warp).

PIC: 3pm team

Date: For Checking of tooling and Schedule

NOTE: DIECUT BLADE PR DONE 200218
- CYNEL FOR NE-LAYOUT UPON RECEIVING
OF NEW DIECUT BLADE



PR No.: 20-

PURCHASE REQUEST

Date:		18-Feb-20			Carrier:					
External F	xternal Provider: SUPERDIECUT			***************************************	Place of D	elivery:	KPPI Laguna			
Customer Name: SANYO DENKI		·····································	-	Terms:			3			
To:		Purchasing Departm	nent	The state of the s	Mode:					
Attention:	A A				Others:					
Delivery Date	Item (Code/ Description	Selling	Quantity	Unit Price	New U	Init Price	Amount	GPF	
			12							
11-Feb-20		00902009-01 URCHASE REQUEST	n/a	1 SET		n	n/a			

Delivery Date to Customer	Remarks	Prepared by	Approved by	Received by
	From 3PM TEAM PROPOSAL (From: 6 outs To: 1out)	R Malvar	W. Apalla, R. Ramos, M. Casillano	Purchasing Re

Customer's								
PO Qty	Item Code/ Description		Inventory		DD 0	Material	Ending Inventory/	
		RM	WIP	FG	PR Quantity	Controller	Remarks	
				- 25.				

