| 002210 | | | - | | | | | |
|--|---|---|---|-----------------------------------|---|--|--|--|
| KAI No. 5 N Telepho | | E PHILIPPINE INC. a Mesa, Calamba City, Laguna b 69 | INVESTIGATION REPORT FORM (IRF) Inhouse Detection Customer Claim Control No.: 188 Date Issued: 20 02 25 | | | | | |
| Customer | KOYAMA | | Attention To | Mr. Gerald De Guzman / Ms | | | | |
| Item Code | PKC0G801 | | Department PRODUCTION | | | | | |
| Item Description | INNER BOX | | Department PRODUCTION Date of Detection 20 02 20 | | | | | |
| Job Order Number | WO-20-M-002 | 41_10 | Section Detected | QA - SCREENING | | | | |
| Job Order Number | ILLUSTRATION O | | Major | Minor | | | | |
| | ILLUSTRATION OF | THE PROBLEM | Lot Quantity (pcs.) | Reject Quantity (pcs.) | Reject Percentage | | | |
| | | | Nature of Defect: | | | | | |
| | | | Nature of Bered. | Poor Print | | | | |
| | unen | tal motor 💮 | Requirement: | | | | | |
| | | | | No spotting on the text of the it | em | | | |
| | | (| Actual: | | | | | |
| | | | | The logo has spotting | | | | |
| NO. OF OCC | URRENCE | DISPOSITION | AREA OF OC | CURRENCE / 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 | | | |
| Issue | d by | Checked by | Approved | l by | Received by (Receiving Section) | | | |
| | | 10 | 10 | | , 11 | | | |
| 111 | m | / Mlau | for/Mills | lmaria | John Ma War Are | | | |
| Adrian QA-IE | | Mr. Roderick Ramos QA Supervisor | Mr. Rexel A | | oe Guernan / Ms. Weena Apalla Head/ Supervisor | | | |
| WA-IE | 1 | | TION / ANALYSIS | | | | | |
| DIRECT CAUS | SE: (Analyze the reaso | on of occurrence, why it happened?) | | SE: (Analyze the reason of occur | rence, why it leaked?) | | | |
| Why 1: | · · · · · · · · · · · · · · · · · · · | | Why 1: | | | | | |
| | | | Why 2: | | | | | |
| System / Training Myh 3: Why 3: Why 4: | MOT | A PACTOR | Why 3: | NOT A F | HOTOR | | | |
| E Why 4: | | | Why 4: | | | | | |
| ₩hy 5: | | | Why 5: | | | | | |
| Why 1: | | | Why 1: | 77 - 3 - 1 - 2 | | | | |
| 100000000000 | | | Why 2: | | | | | |
| Why 3: | WOT | A PACTOR | Why 3: | NOT A PA | crop | | | |
| Sb Why 2: Why 3: Why 4: | 100 | , , , , , , , | Why 4: | | | | | |
| Why 5: | | | Why 5: | | | | | |
| Why 1: | | | Why 1: | | | | | |
| | | | Why 2: | | | | | |
| My 3: | PLS. 5 | ET ATTACHED | | LS. SEE ATTA | HED | | | |
| es es | | | Why 4: | | | | | |
| 200 E CONTROL DE CONTR | | | | | | | | |
| Why 5: | | | Why 5: | | | | | |

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)

| | Fax No. (049) 54 | 3"0302 | | | | | | | 26 () | | |
|---|--|--|-----------------------------------|--|---|-------------------------------------|-----------------------|---|---|---------------|--|
| | | | | | FINAL CON | CLUSION | | CUTE ON DOCTON | | | |
| | | | ROOTCAUSE | | | | | OUTFLOW ROOTCAUSE | | | |
| - THE | INK DO | ZIED F | rst in 7 | THE CYN | VEL E | HOT | DETECT | D 100% AL | LTHEA | PRECIED | |
| BEO | OP DUE | to u | MRP V | WATER | IKS. | | 1716m | of SAMPLING | Arve ja | acrice) | |
| VIOLENIA SECULIA | TE ACTION: (AC | | | | | | | ctions to be done to ensure that the | e problem will not h | appen again) | |
| A. Sorting Resu | | | | | 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - | | Actions to be d | one to eliminate recurrence | | Who / When | |
| | Loca | ition | Total Stock | NG | Total Good | | | | 100000000000000000000000000000000000000 | | |
| RM | N/A | | | | | Cuatana | | N) /. | | - | |
| WIP | | | | | | System | N/A | | | | |
| FG | QA - SCR | | 2,000 | 31 | 1,969 | | | | | | |
| B. Orientation | | | | | | | | | | | |
| Date | N/A | | Time | N/A | | Design / | | NA | | | |
| | | | N/A | | | Tools | | | | | |
| Attendees | | ************************************** | N/A N/A | | | | | | | | |
| C. Reworking | | | | | | | | | | | |
| Rework Quan | itity | | N/A | | | Process | P | LS. SEE ATTI | MICED | | |
| Total Good | N/ | | | 9 | | | | | | | |
| HARRIST THE POST THE REAL PROPERTY OF THE | entage (Good) | | 1/1 | | | | | 7 DIO 8 110 | (201A) | | |
| II. QA F | ROOTCAUSE V | Alfada Asia San | | out by QA In-c | harge) | Date Conduct | ted: 10 02 2 | | r.galia | | |
| | | | Rootcause | | | | 00 | Recommendation | | r.ı | |
| | the rubb | e of ink erdic is | applied contami | hated by | erdie 1 dirt/ | dirt/fi | | ed rubber die to | remove | The | |
| fibers | | | | | | | | | | | |
| | | | III. CORRE | ECTIVE ACTIO | N VERIFICATI | ION (To be fill | led out by QA Ir | n-charge) | | 1.0 | |
| | | Chec | ked by | Date | | nented? | | Remarks | | | |
| 1st Verificat | ion of Action | A.Verga | V73 | 20 02 28 | Yes | [] No | CA is full | y implemented | | | |
| | | n volga | Y () | LV OL LS | | | | | | | |
| 2nd Verificat | tion of Action | | | | []Yes | [] No | IP QU | ALITY ASSURANC | E DEPAR | MENT | |
| 3rd Verificat | tion of Action | | | | []Yes | [] No | C | | | | |
| Effectivene | ess of Action | A. Vergo | ira | 20 06 12 | [/] Yes | [] No | C.A. IS eP DATE AN | | 4 | | |
| Note: If no s | same defects / ¡ r 3rd verification | oroblems occu n of action still | rs for 5 consec not yet implem | cutive deliveries nented, Investig | s, corrective ac ation Report sl | tion is conside hall be re-issue | red effective / cl | osed. If the same problem of d department to provide new | deurs within 5 comprovement a | onsecutive | |
| | | | | 10 May 10 | IV. CL | OSURE | | | | | |
| Status: | | Remarks: | | | | ved by: | 75 TEN | Process Owner Acknowle | dgment: (Recei | ving Section) | |
| Closed | | | | Ara | mas 70 | T ALS A | × 1200 | 11. | 1 | | |
| Still Open | | | | 1 1 | pervisor | 79 | Manager | Line Leader | Departm | neat Head | |
| Re-Issue IRF | : | | | | 07 08 | Date: 20 | | Date: 2007/3 | Date: 20 6 | 113 | |
| | | | | | | | | | 1 | | |

| | W1 - The ink dried fast in the cyrel. | | | | | | |
|------------------|---|--|--|--|--|--|--|
| DIRECT CAUSE | W2- Because of several machine stop due to misalign print defect. | | | | | | |
| PROCESS/MATERIAL | W2 - Because there is ramdom of warp materials mixed. | | | | | | |
| | W4 - Based on the monitoring the machine stop 4 times due to misalign print and 1 time to clean the cyrel due to poor print. | | | | | | |

INDIRECT CAUSE

An 30to

W1 - Operator found 61sheets reject in trial run out of 505sheets.

W2- The operator conducts only sampling checking why not 100% detected all the affected and make adjustment on the settings once problem detected.

| OPERATORS: | | | 0 | | | | DATE: | | | | | | |
|--|--|--|--|------------------------|---|--------------------------|--|--|--|--|--|--|--|
| | | | 0 | | | | SHOFT: | | | | | | |
| OB CREEK & | M 30 39 0 195 | diab | Delb- | 30 | 30 1015 | | 0338 3 | 417 | 0000 | - 13 | 1 PENAMES | | |
| CUSTOMER TEM COBE | PRECENT BOL | | Pince table | | | EDUCE | | SOF | | | Compared to the compared to th | | |
| GLANTITY | | | Signigated | | SINGROTE | | 00 0 69/98% | | name anse | | A JOHN ISM SOME NOT TO WHERE | | |
| NO COLOR | 100.5 | | 1110 | | | | 100 | | 1,2 | 100000000000000000000000000000000000000 | ATTING THE PART OF THE COURSE THE THE THE TOTAL THE | | |
| Actual Machine Several | 20 3 4 12 | | Sode F | | 13- 600 C | | U.A.CE DOUGNIE | | 6000 Sachne | | property and garage percent | | |
| Sheet Size | | | | | | | | | | | | | |
| Matarical | Fig. | 124 | Lega x s | 7.5 | CALV | 212 | 800C S | 1314 | STATE OF THE | LU | | | |
| | | F-1 (5) | -17 | 5416 | 1.72 | | C.65 F | | EPIT | | with an caper, title fire tree. | | |
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| Updarking | SE ESTATION | | | | | - | | and the second | | | pour reason issonies a | | |
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| Carrel communication and communicati | | | Participation of the last of t | ECONOMICS STATE | | (Alleganical Property | RESERVED TO STREET | Personal Services | POST SOLUTION | | e out of on partitions when more | | |
| of protected diversion trap for college | | Total Services | | | Direction of | | | Reference | NAME OF TAXABLE PARTY. | | 1483-1484 / | | |
| Machine Ermetalowers | | | ALC: NO. | | | | - | TO SECURE | Management | THE CONTRACTOR | The second secon | | |
| Paral med sharing related being | | | 1200 | - | | | | Linear | Extraordization | SCHOOL STREET | Auta made Demon Screp Stop | | |
| Charge sinor Cleaning of neare | - | - | ***** | - | - | I | 1533 | 1535 | | SCHOOL SECTION | machine and his the | | |
| CHARLES OF LIGHTS | | | ETC. CO. | | | 9 | | A CONTRACTOR OF THE PARTY OF TH | 200000000000000000000000000000000000000 | THE STREET STREET | | | |
| repair isom key | 12.59 N | | Salt Contract | | 1524 | - | 7.50 | | | | # 1539-1540 DEFECT LODGE CHAPTIES | | |
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| Market Comment | | ASSESSED FOR | - | | 022183128 | | | 100000 | 1500 | THE RESERVE | | | |
| | | 1812/2010/12/2 | | | | | | | | | | | |
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| | | | | | | | | | | | | | |
| | | | | MALESTAN PRODUCTION | | M THE STREET, SHOULD SEE | | THE PERSON NAMED IN | | | The state of the s | | |
| | | | | alk per al discount in | | | | | | | | | |

CORRECTIVE ACTION

> Clean immediately the cyrel upon detection.

PIC: Production

Target Date: 200227 (Done)

> For arrangement of corrective action regarding warp materials.

PIC: Sales, Purchasing, MPD, Warehouse, QA and Production.