

**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

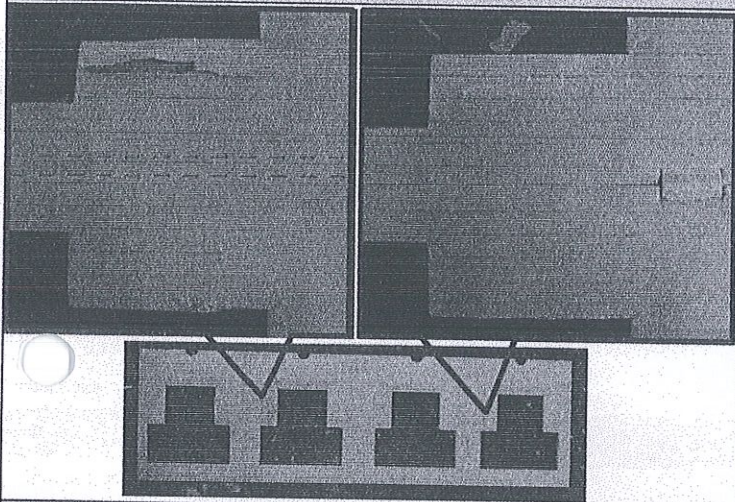
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 204

Date Issued: 20 03 09

Customer	NIDEC SUBIC
Item Code	VR-C RYZXD000002
Item Description	PAD A
Job Order Number	WO-IPD-850-3

Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Department	PRODUCTION
Date of Detection	20 03 07
Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

818

140

17.11%

Nature of Defect:

BURSTING

Requirement:

No bursting on the surface of the item

Actual:

Bursting occurred on any part of the item

NO. OF OCCURRENCE**DISPOSITION****AREA OF OCCURRENCE / ORIGIN****CONTENT**☐ First
☒ Recurrence

No.: 2nd

Date: 20 03 07

☐ Hold
☐ Special Acceptance
☐ For Rework
☒ Reject / Disposal☐ Slotter
☐ EQOS
☒ Diecut: S1700
☐ Detaching☐ Gluing
☐ Vertical
☐ Others:☐ Material
☐ Dimension
☒ Appearance
☐ Process / Method

Issued by

Checked by

Approved by

Received by
(Receiving Section)
Adrian Vergara
QA-IE Staff

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:
Why 4:
Why 5:

NOT A FACTOR

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

NOT A FACTOR

Design / Toolings

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

NOT A FACTOR

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

NOT A FACTOR

Process / Material

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

PLS. SEE ATTACHED

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

PLS. SEE ATTACHED

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

- NO SPACING LAYOUT OF RUBBER SPONGE
IN THE DIE CUT BLADE THAT POSSIBLE CAUSED
OF BURSTING.

OUTFLOW ROOTCAUSE

- NOT ALL GOOTS ARE AFFECTED AND
NOT DETECTED DURING SAMPLING.

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 - Screening	818	140	678

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

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

Design / Tools**C. Reworking**

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

Process

PLS. SEE ATTACHED

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

Date Conducted: 20 03 16

PIC: A. Vergara

Identified Rootcause

-Tight impression of die cut blade on the corrugated material

Recommendation

1. Additional cushion on the diecut blade to reduce the impact to the material
2. Relayout the diecut blade from gray ejector to eperan cushion

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 03 16	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	- Recommendation is fully implemented but still for monitoring (Item no.1 only)
2nd Verification of Action	A. Vergara	20 05 08	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	- Recommendation # 2 is fully implemented
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	20 10 13	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	- Recommendation # 2 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.

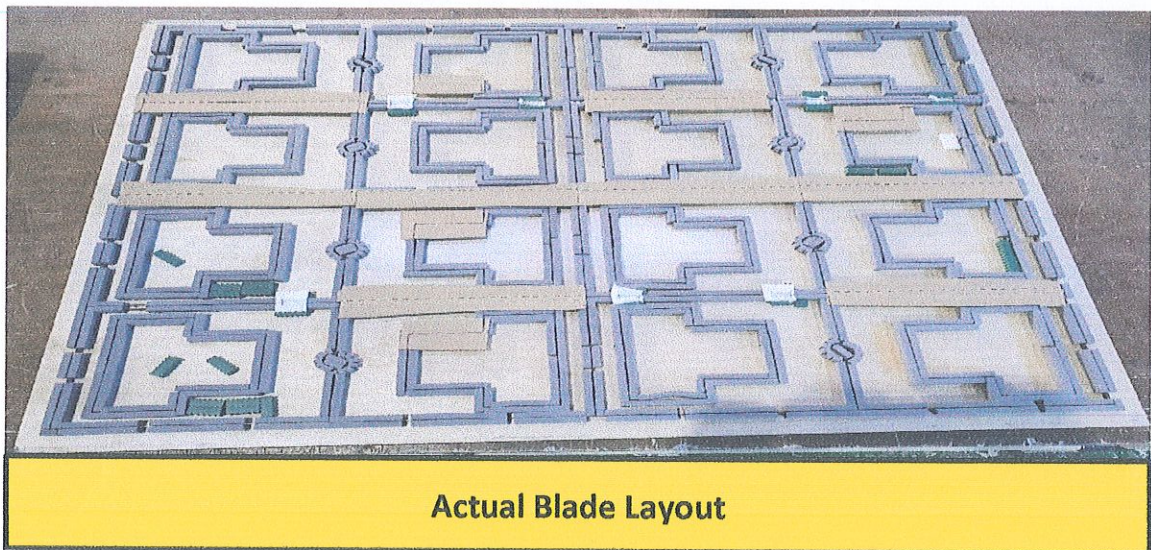
IV. CLOSURE

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	CLOSED				
<input type="checkbox"/> Still Open		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Re-Issue IRF		Date: 21 01 11	Date: 21 01 11	Date: 21 01 11	Date: 21 01 11
DATE AND SIGNATURE					

INVESTIGATION REPORT FOR BURSTING OF NIDEC SUBIC VR- C RYZXD000002 PAD A (IPD)

DIRECT CAUSE PROCESS/MATERIAL	W1 - Possible caused of the occurrence is because the air pressure during impression in penetrate in the item.
	W2 - No spacing layout of rubber sponge in the diecut blade.

INDIRECT CAUSE PROCESS/MATERIAL	W1 - Trial run approved by ME why they proceed in mass production.
	W2- Operator did not notice the affected of bursting during sampling.
	W3- Possible not all 6 outs are affected and the released of the items in receiver is per batch of 25pcs.



CORRECTIVE ACTION

> Re-layout of diecut blade and put spacing in the rubber sponge.

PIC: Production tooling

Target Date: 200313