

**KANEPACKAGE PHILIPPINE INC.**

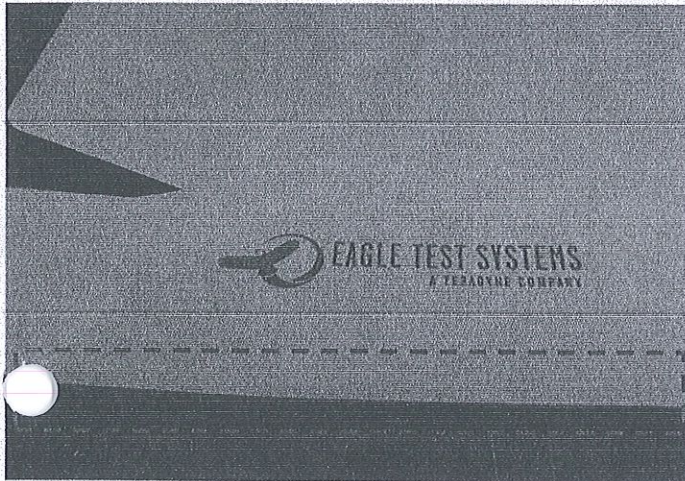
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
Telephone No. (049) 545-7166 to 69  
Fax No. (049) 545-6302

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

Control No.: 218

Date Issued: 20 06 08

Customer	TERADYNE	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	PRO2302G	Department	PRODUCTION
Item Description	BOX	Date of Detection	06 20 20
Job Order Number	WO-20-C-0124-5	Section Detected	QA - SCREENING

**ILLUSTRATION OF THE PROBLEM**☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1,015	17	1.67%

**Nature of Defect:**

MISALIGN PRINT (EXCESS PRINT)

**Requirement:**

Suteban marking should not appear on the item

**Actual:**

Small portion of the suteban appear on the flap of the item

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ Date: _____	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input checked="" type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others: _____	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by  Adrian Vergara QA-IE Staff	Checked by  QA Supervisor	Approved by  Mr. Rexel Almario QA Asst. Manager	Received by (Receiving Section)  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: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: 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)****FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

- POSSIBLE THE PRINT GOT MOVE  
BECAUSE OF RANDOM WARP MATERIALS.

**OUTFLOW ROOTCAUSE**

- DID NOT IDENTIFY THE PRINT MOVEMENT  
IN EADS BECAUSE THE ITEM IS NOT YET DIE-CUTTED

**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	QA - SCREENING	1,015	17	998
FG	N/A			

**Actions to be done to eliminate recurrence****Who / When**

System

N/A

Design /  
Tools

N/A

Process

PLS. SEE ATTACHED

**B. Orientation**

Date	N/A	Time	N/A
Title	N/A		
Att. /ees	N/A		

**C. Reworking**

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

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

Date Conducted: 20 06 09

PIC: A. Vergara

**Identified Rootcause****Recommendation**

The cutuban of the rubber die is near on the  
flap part of the item, the movement of the  
printing is 3mm only

~same w/ the propose CA.:  
Move the cutuban gripper by 6mm

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 06 09	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Corrective Action is Implemented
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 04 09	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. 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)
<input checked="" type="checkbox"/> Closed	QA - QUALITY ASSURANCE DEPARTMENT	QA Supervisor	QA Manager
<input type="checkbox"/> Still Open			
<input type="checkbox"/> Re-issue IRF			
DATE		Date:	Date:
21 04 14		21 04 14	21 04 14

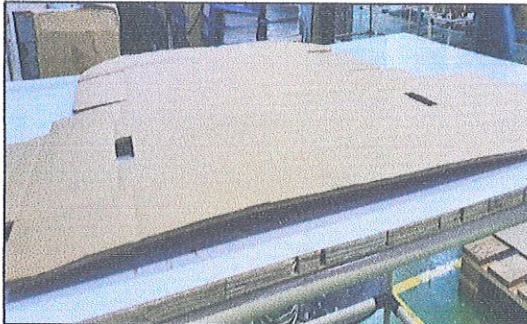
**DATE AND  
SIGNATURE**

21 04 14



# INVESTIGATION REPORT FOR EXCESS PRINT OF TERADYNE PR02302G BOX

<b>DIRECT CAUSE PROCESS/MATERIAL</b>	<b>W1-</b> The possible factor of problem is the print movement in Eqos.
	<b>W2-</b> We notice that the reject items is warp that possible caused of print movement.

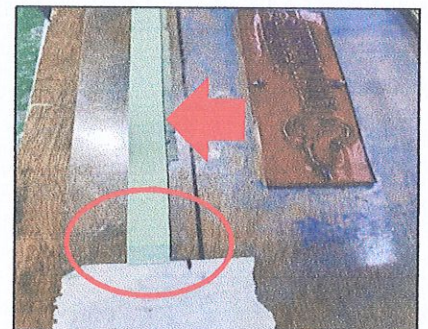
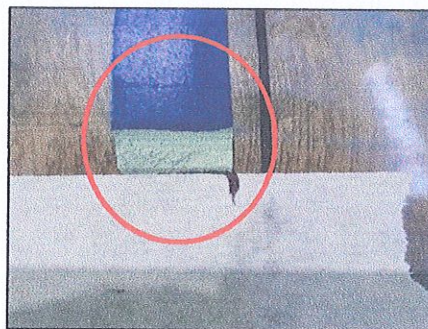


<b>DIRECT CAUSE PROCESS/MATERIAL</b>	<b>W1-</b> Operator proceed to mass production.
	<b>W2 -</b> Trial run approved by QA Patrol.
	<b>W3 -</b> Did not identify the print movement because the occurrence are randomly and not visible because item are not yet die-cutted.

## CORRECTIVE ACTION

Adjust backward the suteban because even the print is within tolerance the suteban mark will appear.

<b>PIC:</b>	<b>Production</b>	<b>TARGET DATE:</b>	<b>DONE</b>
-------------	-------------------	---------------------	-------------



Separate and recondition if encountered warp materials.

<b>PIC:</b>	<b>Production &amp; QA</b>	<b>TARGET DATE:</b>	<b>Upon Detection</b>
-------------	----------------------------	---------------------	-----------------------