

**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.: 233

Date Issued: 20 06 30

Customer: SANYO DENKI

Item Code: 00949344-01

Item Description: PRINT SPECIFICATION

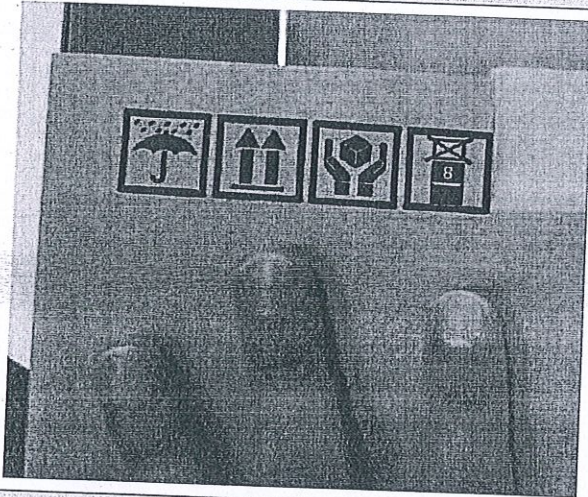
Job Order Number: WO-DRS-20-M-00856-143

Attention To: Mr. Gerald De Guzman / Ms. Weena Apalla

Department: PRODUCTION

Date of Detection: 20 06 29

Section Detected: QA - SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

573

Reject Quantity (pcs.)

115

Reject Percentage

20.07%

Nature of Defect:

MISALIGN PRINT

Requirement:

Print tolerance is $\pm 3\text{mm}$

Actual:

18mm distance from creasing line

NO. OF OCCURRENCE☐ First
☒ Recurrence

No.: 2nd

Date: 20 06 30

DISPOSITION☐ Hold
☐ Special Acceptance
☐ For Rework
☒ Reject / Disposal**AREA OF OCCURRENCE / ORIGIN**☐ Slotter
☒ EQOS
☒ Diecut
☐ Detaching
☐ Gluing
☐ Vertical
☐ Others:**CONTENT**☐ Material
☒ Dimension
☐ Appearance
☐ Process / Method

Issued by

Adrian Vergara
QA-IE Staff

Checked by

QA Supervisor

Approved by

Mr. Rexel Almarino
QA Asst. ManagerReceived 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:
Why 4:
Why 5:

N/A

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

N/A

Design / Toolings

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

N/A

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

N/A

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

**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****OUTFLOW ROOTCAUSE**

- MISALIGN OCCURS DUE TO WARP MATERIALS.

- OCCURRENCE IS RANDOMLY AND DIDNT TRAP 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	N/A			

Actions to be done to eliminate recurrence

Who / When

System

N/A

B. Orientation

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

Design / Tools

N/A

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: 200701

PIC: A. Vergara

Identified Rootcause

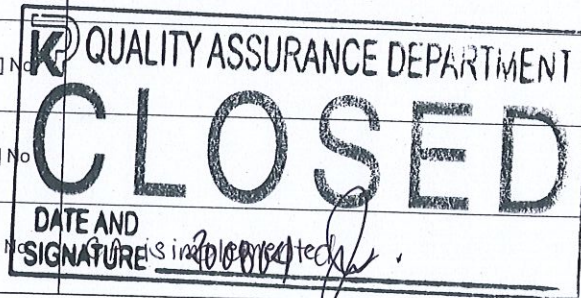
~ the materials delayed on the registration timing on the printing unit of the machine, the materials slipped/ jammed awhile on the rollers because the materials used is warp because the sheets used is prone to warping

Recommendation

1. Change diecut and rubber die layout from 600 to 100 and also the sheet size of material from 1025 x 1584 mm to 484 x 933 mm

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	200702	[X] Yes [] No	CA is implemented
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	200723	[X] Yes [] No	



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		NOEMI V. OCEPEDA	
☐ Still Open		QA Supervisor	QA Asst. Manager
☐ Re-Issue IRF		Date: 200805	Date: 200805
			IRISH MAY L. ESTAREJA Line Leader
			Department Head
			Date: 200825

KANEPACKAGE PHILIPPINE, INC.

SO No.: Sales Order #DRS-20-M-00856
 JO No.: WO-DRS-20-M-00856-143
 ISSUED BY: Jhoana de Guzman
 DATE ISSUED: 22-JUNE-2020
 CUSTOMER: SANYO DENKI PHILS INC

NETSUITE
 QA TRANSFER
 BY: JPSA/17
 DATE: 22/06/20
 TIME: 1:40pm

SANYO DENKI PHILS. INC.

Item Code: 00949344-01
 Item Description: BOX PRINT SPECIFICATION
 Lot No. / Ref. No.: 200629 - 00856/143
 QUANTITY: 10 pcs.
 Supplier's QC: PASSED
 INSPECTION: RoHS OK
 QA-CG508

Item Description: 00949344-01 PRINT SPECIFICATION
 Quantity: 485 Piece
 Delivery Date: 26-JUNE-2020

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.
1025 X 1584 BF TX200/CM125/TX200 0	84	101	0	0pcs	101

PROCESS	Finished Date	Time	GOOD QTY	REJECT QTY	OPERATOR	Remarks
1.ECOS	6/22		100	1	JALD	
2.ETERNA	06/20		100	17	F.S.m	
3.DETACH	06/20		622	-	MARK BENIO YANYAN UWAY	
4.CONVEYOR 1	06/20		575	47 pcs Due to warp Materials		
5.LOT NUMBERING	6/20		4th		um/wen	
6.SCREENING						
7.QA BUNDLE	06/20		456 (bal: 129)	117	Kenn	

REJECTION HISTORY

- (A). Kailan: 03/20/19, (B). Problema: Misalign Print, (C). Ilan: 196 PCS., (D) Bakit: Ang materyales ay warp (>15mm)
- (A). Kailan: 09/4/2019, (B). Problema: Blotted Print, (C). Ilan: 83 PCS., (D) Bakit: Ang ink ay nagbara sa cyrel ng item dahil sa machine stoppage
- (A). Kailan: 1/16/2020, (B). Problema: MISALIGN PRINT, (C). Ilan: 10 PCS., (D) Bakit: Ang stacking ng materyales sa feeding unit ay masyadong mataas kung kaya't habang pinoproseso ang item nag kakaron ng delay
-
-

NOTES

- Ang QA at WHSE ay kailangan irecondition ang warp na materyales
- Ugaling magsampling checking ng prinosesong item at kapag may nakatang blotted during sampling linisin agad ang cyrel bago ulit mag proseso
- Bawasan ang stacking height sa feeding unit
-
-

PR-007-F07

JO Received By(WHSE):

Signature over printed name/Date/Time

PRODUCTION OUT

BY: Returned to(QA):

Signature over printed name/Date/Time

DATE:

NETSUITE

INVESTIGATION REPORT FOR MISALIGN PRINT OF SANYO DANKI 00949344-01 PRINT SPECIFICATION

DIRECT CAUSE PROCESS/MATERIAL	W1- Gluing operator trap 42pcs of misalign print listed in Job Order and reported to leader in-charge.
	W2- According to investigation in Eqos & Eterna that time, they encounter random of warp materials during process of this item.
	W3- This item is 6outs used 1025 X 1584 BF (Big Sheets), why prone to warp and also to misalign print.

INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator proceed to mass production.
	W2 - Trial run approved by QA Patrol, both Eqos & Eterna.
	W3 - Occurrence is randomly and didn't trap during sampling (3pcs = start, middle & last) because only 101pcs sheets needed.

CORRECTIVE ACTION

Immediate implementation of existing corrective action. Transfer from 6outs to 1out using 484 X 933 BF (Horizontal implementation to 00902009-01, Die-blade & Cyrel are Available for both item)			
PIC:	Sales, MPD & Production	TARGET DATE:	Next running