

**KANEPACKAGE PHILIPPINE INC.**

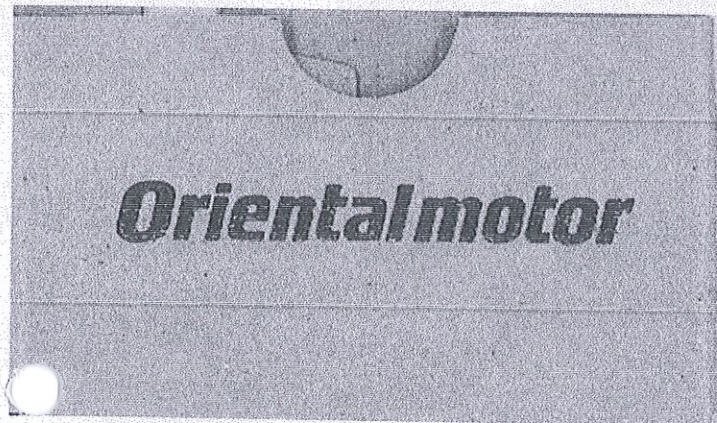
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 234

Date Issued: 20 07 01

Customer	KOYAMA	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	PKC0G801	Department	PRODUCTION
Item Description	INNER BOX	Date of Detection	20 06 30
Job Order Number	WO-20-M-00803-2	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

843

103

12.22%

Nature of Defect:

POOR PRINT

Requirement:

No spots on the logo

Actual:

multiple spot appeared on the logo

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Gluing	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension
No.: 2	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Others:	<input checked="" type="checkbox"/> Appearance
Date: 20 06 30	<input type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching		<input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)	
 Adrian Vergara QA-IE Staff		 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:

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

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

ACCUMULATED DUST STICK IN THE CYREL

OUTFLOW ROOTCAUSE

RANDOMLY OCCURRENCE AND DIDNT TRAP DURING TRIAL RUN/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	QA - SCREENING	843	103	740
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. Working

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 07 02

PIC: A. Vergara

Identified Rootcause

Recommendation

~ The rubber die has dirt that causes omission on some parts of rubber die w/ ink applied in the materials

~ Cleaning of rubber die

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 07 10	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. 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	20 10 27	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is implemented & 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

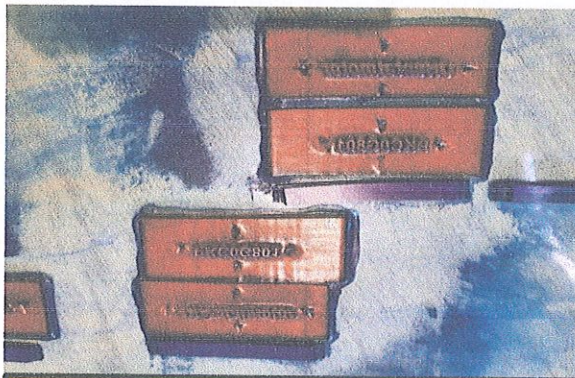
Status	Remarks	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed	QUALITY ASSURANCE DEPARTMENT	QA Supervisor	Line Leader
<input type="checkbox"/> Still open		QA Asst. Manager	Department Head
<input type="checkbox"/> Re-issue IRF			
Date: 21 04 14		Date: 21 04 14	Date: 21 04 14

DATE AND SIGNATURE

21 04 14

INVESTIGATION REPORT FOR POOR PRINT OF KOYAMA PKCOG801 INNER BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- According to investigation the possible caused of the Poor Print is the accumulated corrugated dust stick on the cyrel.
	W2- The corrugated dust from the top/print surface of sheets stick in the cyrel during mass production.
	W3- The vacuum in the feeder unit of Eqos located only in the lower/bottom portion why only the bottom/rough surface of sheets are clean by vacuum



Customer: KOYAMA			
Item Description: PKCOG801 INNER BOX			
Date	Running Qty.	Total Running	REMARKS
191001	255	255	OK
191005	345	595	OK
191008	200	795	OK
191116	255	1110	OK
191122	30	1140	OK
191210	253	1393	OK
200118	725	2118	GOOD
200218	505	2623	OK
200225	1040	3663	OK
200402	312	4185	OK
200411	215	4400	OK
200627	200	4600	OK

**CYREL IS IN GOOD CONDITION AND WITH 4,760 sheets PRINTED
(NOT A FACTOR)**

INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator proceed to mass production.
	W2 - Trial run approved by QA Patrol.
	W3 - No occurrence of poor print upon checking of Trial Run and possible the occurrence is randomly why it was not trap during sampling.

CORRECTIVE ACTION

Orientation to operator regarding quick tapping of sheets before feeding to remove the accumulated corrugated dust and once they found poor print immediately clean the cyrel using rags.

PIC:

Production

TARGET DATE:

200706

PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR