


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

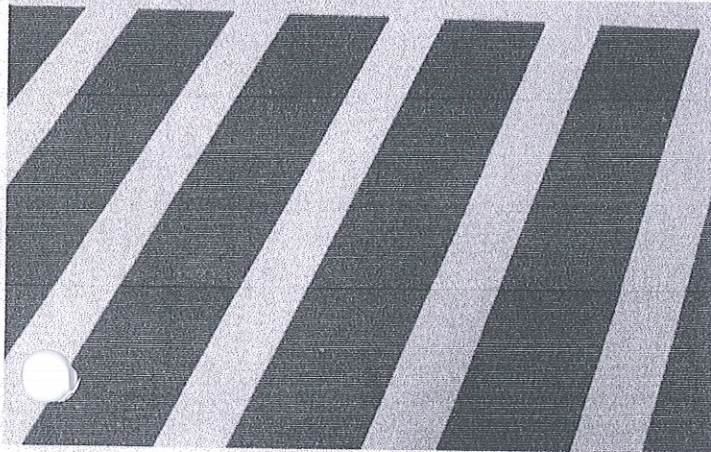
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 239

Date Issued: 20 07 06

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	00907149-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	20 07 02
Job Order Number	WO-DRS-20-M-00877-185	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM


<input type="checkbox"/> Major <input checked="" type="checkbox"/> Minor		
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
186	21	11.29%
Nature of Defect:		
POOR PRINT		
Requirement:		
Spotting on the solid print of the item should not be visible		
Actual:		
The spots on the inclined solid print is visible		

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	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	Design / Toolings	Process / Material
Why 1: Why 2: Why 3: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:
Why 1: Why 2: Why 3: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:

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

- WASHED BOARD MATERIALS

- RANDOM OCCURRENCE AND
SMALL QTY WHY DIDN'T 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**Actions to be done to eliminate recurrence****Who / When**

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	N/A			

System

N/A

B. Orientation

Date	Time	
N/A	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: 20 07 08

PIC: A. Vergara

Identified Rootcause**Recommendation**

~ The ink was not applied well from the rubber die
because the material used is washboards

~ Everytime encountered board that has visible CM
on the smooth surface use fresh ink w/ 10 secs.
& above the viscosity

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 09	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation & CA are 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 08 06	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	

QUALITY ASSURANCE DEPARTMENT**CLOSED**DATE AND
SIGNATURE

200807

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 <input type="checkbox"/> Still Open <input type="checkbox"/> Re-Issue IRF	No occurrence of POOR PRINT	 QA Supervisor Date: 200807	 IRISH MAY L. ESTARCEJA Line Leader Date: 200807 Department Head Date: 200807

INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 00907149-01 PACKAGE

DIRECT CAUSE PROCESS/MATERIAL	W1- Solid Black print did not penetrate well in corrugated board.
	W2- Some materials are washed board.
	W3- Instead of using 96pcs of design sheets 1475 X 2000 CBF UPPC, Slotter operator used the Good Scrap as compliance to production cost savings.



ACTUAL ITEMS WITH WASHED BOARD

JOB ORDER SHOW SLOTTED OPERATOR

INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator proceed to mass production.
	W2 - Trial run approved by QA Patrol.
	W3 - Operator didn't notice the poor print because possible occurrence is randomly and didn't detect during sampling due to small qty.

CORRECTIVE ACTION

Orient the Egos & Slotter operator not to use washed board materials in Sanyo Denki due to criticality of Big/Solid black print.

PIC:	PRODUCTION	TARGET DATE:	200709
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PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA W. APALLA
SR. SUPERVISOR