

**KANEPACKAGE PHILIPPINE INC.**

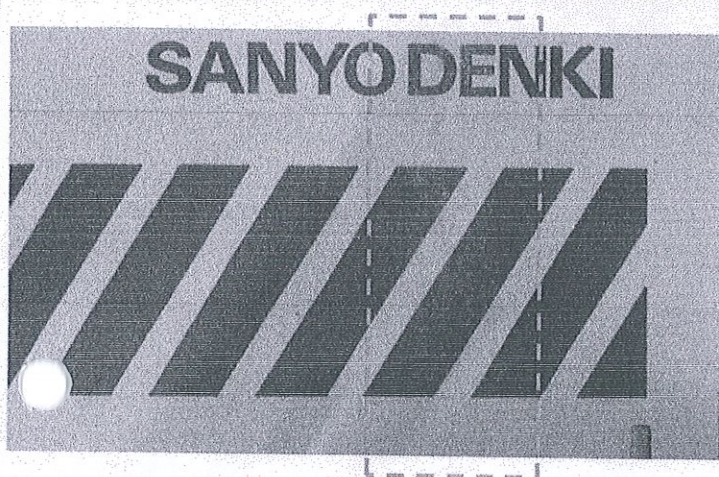
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 264

Date Issued: 20 08 06

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00939007-01	Department	PRODUCTION
Item Description	CORRUGATED CARTON	Date of Detection	20 08 05
Job Order Number	WO-20-M-01049-12	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major ☒ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1367	62	4.54%

Nature of Defect:

SCRATCHES (Scuffing)

Requirement:

No contamination of ink from other boxes

Actual:

W/ contamination of ink

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 type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching	<input checked="" 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	 Ms. Noemi Cepeda QA Supervisor	 Mr. Rexel Almario QA Asst. Manager	 Mr. Gerald De Guzman 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:	N/A	Why 1:	N/A
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:	N/A	Why 1:	N/A
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:	PLS. SEE ATTACHED	Why 1:	PLS. SEE ATTACHED
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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

- OPERATOR REMOVE THE ROLLER WHY THE ITEM GOT FLAT IN BELT AND BECAUSE OF JUGGER THE BELT SCRATCH THE ITEM.

OUTFLOW ROOTCAUSE

- OPERATOR NOT IMMEDIATE NOTICE THE SCRATCHES BECAUSE THE OCCURRENCE IS RANDOMLY.

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	20 08 11	Time	9:55 ~ 10:00
Title	ORIENTATION REGARDING SCRATCHES OF SANYO DENKI DC939007-01 CORRUGATED CARTON		
Issues	SEMI-AUTO GLUING OPERATORS		

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 08 10

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The printed image on the item contaminates the other item because the position of glued items in the conveyor is not slanting since the roller was removed

~ NO removing of roller on the machine

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

	Checked by	Date	Implemented?		Remarks
1st Verification of Action	A. Vergara	20 08 14	<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 07	<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

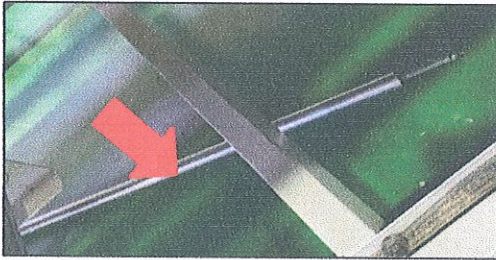
Status:	Remarks:	Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	QUALITY ASSURANCE DEPARTMENT CLOSED	QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Still Open		Date: 21 01 11	Date: 21 01 04	Date: 21 01 04	Date: 21 01 04
<input type="checkbox"/> Re-issue IRF					

DATE AND
SIGNATURE

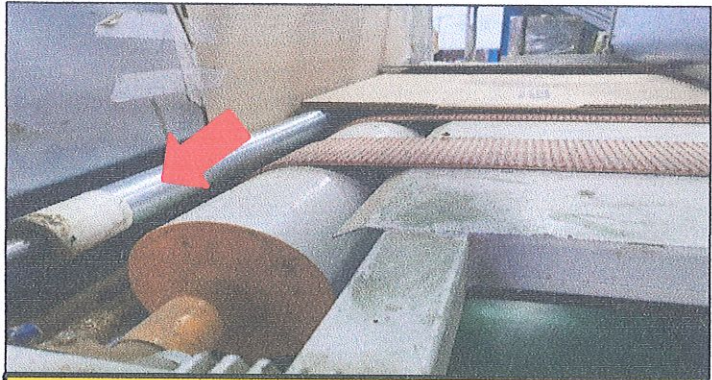
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INVESTIGATION REPORT FOR SCRATCHES OF SANYO DENKI 00939007-01 CORRUGATED CARTON

DIRECT CAUSE PROCESS/MATERIAL	W1- Item did not inclined after feeding in Semi-Auto gluing.
	W2- Operator removed the roller why the item get flat in the belt.
	W3- Item flat in belt and because of the jogger why the back side of box got scratches by belt.



Operator remove this roller because according to them when they process small box like EPSON 0864 the items did not push continuously by belt because it was inclined.



Roller make the items little bit inclined to the belt.

INDIRECT CAUSE PROCESS/MATERIAL	W1- Semi auto gluing operator not immediate notice the scratches because the occurrence is randomly, and when they notice it they immediate inform the Production Leader in-charge and transfer the process in manual gluing for the meantime.
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CORRECTIVE ACTION


Back the roller of Semi-Auto Gluing

PIC:	PRODUCTION	TARGET DATE:	200806
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Re-orient the semi-auto gluing operator regarding Abnormality Rule and do not remove anything fixed part of machine without approval of Leaders.

PIC:	PRODUCTION	TARGET DATE:	200810
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PREPARED BY:


GERARDO DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
 SR. SUPERVISOR