INVESTIGATION REPORT FORM (IRF)   Investigation   Investigat	102					
Fig. 10, 100 September 20 Control No. 2019 Dela based: 2 20 01 1  Customer UsperFLEX Control No. 2019 Dela based: 2 20 01 1  Interface Control No.	No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna		INVESTIGATION REPORT FORM (IRF)			
Customer SUPERFIEX Altorition To Superfield	Telepho	ne No. (049) 545-7166 t	o 69	Inhouse Detection	Custo	omer Claim
Tem Code    Sas N				Control No.: 268	Date Issued:	20 08 11
Then Decretion Outer ROX Outer Nonzol  BEQUIDS  BEQUIDS  BEQUIDS  BEQUID THE PROBLEM  LEG Carrier My (pc.s.)  Control (pc.s.)  Control (pc.s.)  BEQUID THE PROBLEM  LEG Carrier My (pc.s.)  Control (pc.s.)  Regard Quarter (pr.s.)  Regard Quarter (pr.s.)  Sequel Percentage  ADD 1 Print Photod not be exceeded on the crossing line  NO. OF COCUMERICE  DISPOSITION  NO. OF COCUMERICE  NO. OF COCUMERICE  NO. OF COCUMERICE  DISPOSITION  NO. OF COCUMERICE				Attention To	Mr. Gerald De Guzmam / M	lr. Rexel Almario
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Lot Quantity (pcs.)   Reject Quantity (pcs.)   Reject Parcentage 408   1   0.25%	Job Order Number			Section Detected	CUSTOMER - XYLEM	
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MISALIGN PRINT / DIECUT  Recurrement    Recurrement   Recurrement	-				Reject Quantity (pcs.)	
Requirement:    Requirement   Requirement   Requirement		•		Nature of Defect.		
Print should not be exceeding on the creasing line					MISALIGN PRINT / DIECUT	
The print exceeded on the creasing line    NO. OF OCCURRENCE   DISPOSITION   AREA OF OCCURRENCE / ORIGIN   CONTENT		@GOULDS		Requirement:		
The print exceeded on the creasing line    No. OF OCCURRENCE		a wydawn Escala	839N	Print sh	ould not be exceeding on the cr	easing line
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Adrian Vergara  OA-IE Staff  OA Supervisor  I. INVESTIGATION / ANALYSIS  DIRECT CAUSE: (Inalyze the reason of occurrence, why it happened?)  Why 1:  Why 2:  Why 3:  Why 4:  Why 5:  Why 5:  Why 5:  Why 5:  Why 6:  Why 6:  Why 6:  Why 7:  Why 7:  Why 6:  Why 7:  Why 8:  Why 9:  Why 4:  Why 9:  Why 4:  Why 5:  Why 5:  Why 6:  Why 6:  Why 6:  Why 6:  Why 6:  Why 7:  Why 8:  Why 8:  Why 8:  Why 9:  W			Reject / Disposal	Detaching		Process / Method
Adrian Vergara OA-IE Staff  Ms. Noemi Cepeda GA Supervisor  CINVESTIGATION / ANALYSIS  DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)  Why 1: Why 2: Why 3: Why 4: Why 5: Why 5: Why 5: Why 7: Why 9: Why 1: Why 9: Why 1: Why 9: Why 1: Why 2: Why 5: Why 5: Why 5: Why 5: Why 6: Why 7: Why 7: Why 6: Why 7: Why 7: Why 7: Why 8: Why 9: Why 9: Why 9: Why 1: Why 9: Why 9: Why 1: Why 9: Why 9: Why 1: Why 9: Why 1: Why 9: Why 1: Why 2: Why 3: Why 4: Why 5: Why 6: Why 6: Why 7: Why 7: Why 7: Why 7: Why 8: Why 6: Why 7: Why 7: Why 7: Why 8: Why 6: Why 7: Why 7: Why 7: Why 7: Why 8: Why 6: Why 7: Why 7: Why 7: Why 7: Why 8: Why 7: Why 9: Why 9: Why 9: Why 4: Why 9: Why 4: Why 4: Why 4: Why 5: Why 4: Why 5: Why 5: Why 4: Why 5: Why 4: Why 5: Why 4: Why 4: Why 4: Why 4: Why 5: Why 4: Why 5: Why 4: Why 5: Why 5: Why 5: Why 6: Why 6: Why 6: Why 6: Why 6: Why 6: Why 7: Why 7: Why 7: Why 8: Why 9: Why 8: Why 8: Why 8: Why 8: Why 9: Why 8: Why 9: Why 8: Why 9: W	Issued I	by	Checked by	Approved b	у	Received by
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DATE AND

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## 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)**

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	OCCURRENC	E ROOTCA	USE	FINAL CO	DICLUSION	OUTFLOW ROOTCAUSE	
						OUTFLOW ROUTGAUSE	
- v	varp n	1 KTER	lars		-	PANDOM OCCURRENCE WHY TRAP DURING SAMPLING	
IMMEDIATE ACTION	N: (Action to be done	to contain/ tem	porary correct the p	roblem found)	CORRE	CTIVE ACTION: (Actions to be done to ensure that the problem	
A. Sorting Result						Actions to be done to eliminate recurrence	1
	ocation	Total Sto	ck NG	Total Good		22.20 to de doite to climinate recurrence	Who / Whe
RM N	18						
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Total Good	N				Process	PLS. SEE ATTACHET	
Rework Percentage (Good	d)	N/A					
II. QA ROOTCAUSI	E VERIFICATION			charge)	Date Condu	cted: 20 08 12 PIC: A Nevagra	
>Wrong printing	Identified R	ootcause				Recommendation	
ernor timing of affected materia due to warp mat	I dammed e	on the p	viviting mo	chine	> separ	of weight uigs for warp compate the flat boards to warp h	Poavds
		III. CORR	RECTIVE ACTIO	N VERIFICATION	ON (To be fil	led out by QA In-charge)	
	Checke		Date	Impleme	ON THE STREET	Remarks	
1st Verification of Action	A. Vergar	a	20 0E 12	✓Yes	[ ] No	C.A. is implemented	
2nd Verification of Action	A. Vergan	<b>a</b>	20 09 01	[/] Yes	[ ] No	Process transfer to SFLI	
3rd Verification of Action				[ ]Yes	[ ] No		A
Effectiveness of Action	A. Vergar	а	20 0901	[ \( \sum \) Yes	[ ] No	C.A. is effective	1.7
Note: If no same defects / deliveries or 3rd verification  Status:  Close QUALITY	Pennarks  Remarks  ASSURANC	yet impleme	utive deliveries, ented, Investiga RTMENT	ion Report shall	URE	ed effective / closed. If the same problem occurs within it to the affected department to provide new improvement to provide new improvement.	nt action.

210

Date: 21 01

# INVESTIGATION REPORT FOR MISALIGN PRINT OF SUPERFLEX 839N OUTER BOX

	$oldsymbol{W1} ext{-}$ Warp materials is the one possible caused why the print got misalign in Eqos.
DIRECT CAUSE PROCESS/MATERIAL	<b>W2</b> - If materials is warp specially big board the tendency of board is bump to machine roller.
AM	<b>W3</b> - Board got delay or un-timing why the print got misalign.

INDIRECT
CAUSE
PROCESS/MATERIAL

 $oldsymbol{W1} ext{-}$  Operator didn't notice the misalign print because possible the occurrence is random and didn't trap during sampling.

## **CORRECTIVE ACTION**

	Continues the rec	condition and usage of Paper we	ight Jig.	
OIC:	WAREHOUSE & QA	TARGET DATE:	ON-GOING	

	Separate and recondition	on once the operator encounter v	warp materials.	
PIC:	PRODUCTION	TARGET DATE:	ON-GOING	

PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

**APPROVED BY:** 

WEENA V APALLA

R. SUPERVISOR