

**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.: 270

Date Issued: 20 08 12

Customer	SANYO DENKI		Mr. Gerald De Guzman
Item Code	00665061-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	20 08 08
Job Order Number	WO-DRS-20-M-01050-83	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

2,205

Reject Quantity (pcs.)

126

Reject Percentage

5.56%

Nature of Defect:

BURSTING

Requirement:

No bursting on the outer portion of the box

Actual:

W/ bursting on the glue tab



NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 3 Date: 20 08 12	<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 Adrian Vergara QA-IE Staff	Checked by Ms. Noemi Cepeda QA Supervisor	Approved by Mr. Rexel Almario QA Asst. Manager	Received by (Receiving Section) 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: 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**

— BRITTLE MATERIALS.

— RANDOM OCCURRENCE

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	N/A	Time	N/A
Title	N/A		
Issues	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 08 10

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The corrugated material touched on the roller of the glue applicator
> The materials used are brittle.

> Transfer the item from semi-auto gluing to manual gluing

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 17	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	OPTION 1 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 09 06	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. (Option 1) 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		
<input type="checkbox"/> Still Open	CLOSED	QA Supervisor	Line Leader
<input type="checkbox"/> Re-Issue IRF	Date: 20 09 11	QA Asst. Manager	Department Head
		Date: 21 01 11	Date: 21 01 11

DATE AND SIGNATURE

20 09 09

INVESTIGATION REPORT FOR BURSTING OF SANYO DENKI 00665061-01 PACKAGE

DIRECT CAUSE PROCESS/MATERIAL	W1- Bursting occurs due to brittleness of materials combine with the compression of Gluing Applicator.
---	---



Machine already have clearance reference
as our corrective action on last occurrence
of this problem (200106)

INDIRECT CAUSE PROCESS/MATERIAL	W1- During sampling when operator found bursting they immediate report to Leader in-charge.
	W2- Leader in-charge instruct to conduct reverse pre folding as immediate action.
	W3 - Operator conduct reverse pre-folding but not 100% effective because still there is random occurrence of bursting.

CORRECTIVE ACTION

(OPTION-1) Transfer of item from Semi-Auto Gluing to Conveyor-1, because only this item have occurrence of this issue in Semi-Auto Gluing.			
PIC:	Production	TARGET DATE:	(If approve) Next Running

(OPTION-2) Change materials supplier of this from Sunpack to Package World.			
PIC:	Sales & Purchasing	TARGET DATE:	

PREPARED BY:

200813
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

200813
WEENA V. APALLA
SR. SUPERVISOR