


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.: 272

Date Issued: 20 08 14

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00740330-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	20 08 13
Job Order Number	WO-DRS-20-M-01050-121	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
410	28	6.82%

Nature of Defect:

POOR PRINT

Requirement:

Poor printing should not be visible in one arm length

Actual:

Solid print images has poor print

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

- POOR PRINT DUE TO WASHBOARD MATERIALS.

- RANDOMLY 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		
Att'ns	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 18

PIC: A. Vergara

Identified Rootcause**Recommendation**

> Ink transfer is not complete on the substrate because the material used is washboards.

> Increase ink viscosity from 9secs. to 10 secs.

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 20	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	Recommendation is implemented
2nd Verification of Action	A. Vergara	21 04 14	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	Suppliers have improvement for washboards
3rd Verification of Action			<input type="checkbox"/> Yes	<input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 01 22	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	Recommendation & Supplier improvement 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		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
		Date: 21 04 14	Date: 21 04 14	Date: 21 04 14	Date: 21 04 14

DATE AND
SIGNATURE

21 04 14

INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 00740330-01 PACKAGE

DIRECT CAUSE PROCESS/MATERIAL	W1- Solid Black print did not penetrate well in corrugated board.
	W2- The affected of Poor Print are obviously washed board.



INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator oriented and conducted fast browsing to segregate Wash Board materials.
	W2- Not 100% all materials are brows, because they need to consider not to stop or downtime the feeding of materials in Eqos.
	W3- Possible the Wash Board occurrence are randomly because only 28pcs are affected.

CORRECTIVE ACTION

Any Possible idea to trap the wash board before issued to production and not used in the item with Big / Solid Print.			
PIC:	QA & WAREHOUSE	TARGET DATE:	

Continues the fast browsing before feeding of materials in Eqos and put reminders in Eqos that " No Wash board allowed to use for the items with Solid Print" for the common reference for all specially Support person in eqos once they have absent Eqos operator.			
PIC:	PRODUCTION	TARGET DATE:	200820

PREPARED BY:

GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:

WEENA APALLA
 SR. SUPERVISOR