


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

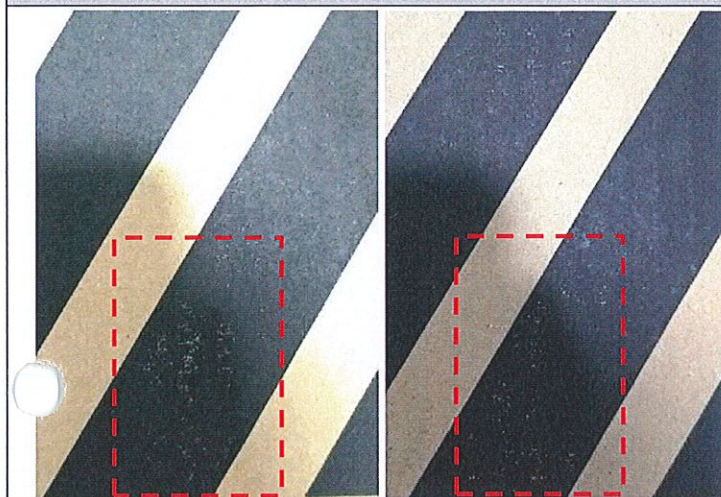
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 288

Date Issued: 20 09 16

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00897168-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	20 09 14
Job Order Number	WO-TO-IPD-424-1	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
232		46	19.83%
Nature of Defect:			
POOR PRINT			
Requirement:			
No spots or poor application of ink on the solid image			
Actual:			
Solid image is not complete			

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. 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: 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**

- COMPRESSION MARK FROM
MAGNETIC SUTEBAN

OUTFLOW ROOTCAUSE

- RANDOMLY WHY THE OPERATOR IN
QA PATROL DID NOT TRAP THE
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**

	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	
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B. Orientation

Date	20 09 19	Time	12:30NN ~ 12:35NN
Title	ORIENTATION REGARDING POOR PRINT OF SANYO DENKI 00891168-01 PACKAGE		
ides	EQOS OPERATORS		

Design / Tools	N/A	
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C. Reworking

Rework Quantity	N/A
Total Good	N/A
Rework Percentage (Good)	N/A

Process	PLS. SEE ATTACHED	
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II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 10 09 18

PIC: A. Vergara

Identified Rootcause

> Poor ink transfer from the rubber die because there was
a light dent on the boards because of suteban compres-
sion.

Recommendation

> Reduce the compression in printing unit-1
> Increase the viscosity of ink to fill-in the pinholes on
the surface of the boards

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	20 A. Vergara	20 09 18	<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 01 15	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is effective

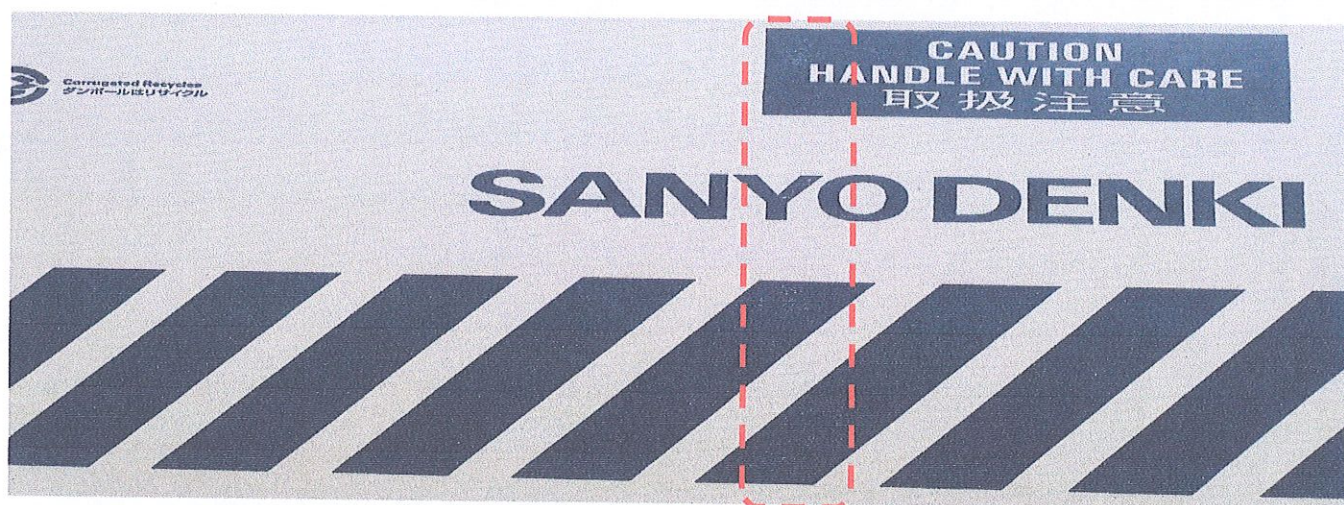
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improvement action.

IV. CLOSURE

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	CLOSED				
<input type="checkbox"/> Still Open		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Re-Issue IRF		Date: 210414	Date: 20414	Date: 210414	Date: 210414
DATE AND SIGNATURE 210414					

INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 00897168-01 PACKAGE

DIRECT CAUSE PROCESS/MATERIAL	W1- Upon investigation we found out that the poor print occurs in one straight line portion only.
	W2- Possible this is because of the compression mark from magnetic sutureban in the Printing Unit-1.
	W3 - Due to compression mark of magnetic sutureban that portion become submerged why it become poor print.



INDIRECT CAUSE PROCESS/MATERIAL	W1- Possible only the little bit soft materials only have compression mark because occurrence is random why the operator & QA patrol did not trap the affected of poor print.
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PRODUCTION CORRECTIVE ACTION

Orient the Eqos operator to reduce the compression of magnetic sutureban in Printing Unit-1 and place the magnetic sutureban in the portion without print if possible.			
PIC:	PRODUCTION	TARGET DATE:	200919

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
 SR. SUPERVISOR