

**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.: 291

Date Issued: 20 09 16

Customer	KOYAMA	Attention To	Mr. Gerald De Guzman
Item Code	PKC202B-A	Department	PRODUCTION
Item Description	MOTOR INNER BOX	Date of Detection	20 09 16
Job Order Number	WO-20-M-01175-7	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

3,544

100

2.82%

Nature of Defect:

BLOTTED PRINT

Requirement:

Text should be clean and free from blotting

Actual:

"e" is affected of blotting

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 2 Date: 20 09 15	<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 Adrian Vergara QA-IE Staff	Checked by Ms. Noemi Cepeda QA Supervisor	Approved by Mr. Rexel Almarino 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: 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: PLS. SEE ATTACHED Why 4: Why 5:	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:
Process / Material	Why 1: Why 2: Why 3: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A Why 4: Why 5:

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

- SHALLOW DISTANCE AND HOLE OF CYREL (LOGO)

OUTFLOW ROOTCAUSE

- NOT ALL FOUR OUTS ARE AFFECTED OF BLOTTED PRINT

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	N/A	Time	N/A
Title	N/A		
Endees	N/A		

Design / Tools	PLS. SEE ATTACHED	
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C. Reworking

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

Process	N/A	
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II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 20 09 18 PIC: A. Vergara

Identified Rootcause**Recommendation**

- The spaces on the letters are narrow. The ink creates links because it is accumulate easily

- Cleaning of cyrel using brush
- Provide a new set of rubber die where the space on letter i & c is wider.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 09 18	[X] Yes [] No	Re-orientation for cleaning the cyrel is done
2nd Verification of Action	A. Vergara	20 10 13	[X] Yes [] No	New cyrel is in used
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	21 01 04	[X] Yes [] 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	QA Supervisor	Line Leader	Department Head
<input type="checkbox"/> Still Open		Date: 21 01 11	Date: 21 01 11	Date: 21 01 11
<input type="checkbox"/> Re-issue IRF				

DATE AND
SIGNATURE

21 01 09

INVESTIGATION REPORT FOR BLOTTED PRINT OF KOYAMA PKC202B-A INNER BOX.

DIRECT CAUSE PROCESS/MATERIAL	W1- The affected of blotted print in Koyama Orientalmotor Inner Box 202B, 505B and G801 is always in the same portion from the previous blotted issues.
	W2- During checking of the cyrel we notice that Orientalmotor logo distance between letter r & i is very shallow and the hole of Letter e is too small and shallow why this portion is prone to blotted print even the other area is good.
	W2- Due to Shallow distance and hole of cyrel the ink was easy to clogged on that portion.

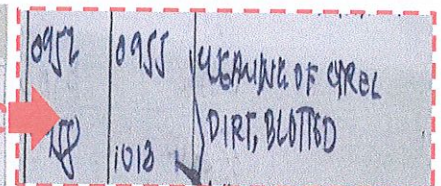
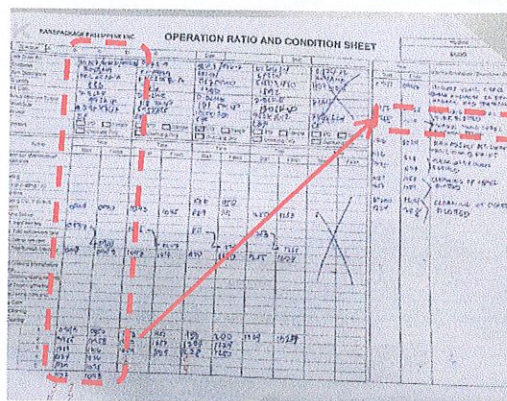
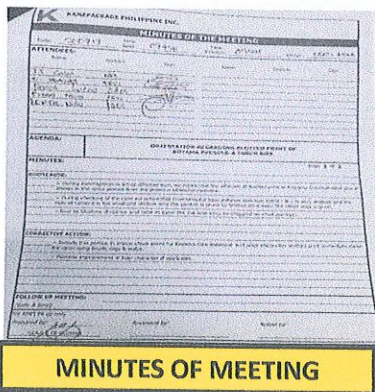


INDIRECT CAUSE PROCESS/MATERIAL	W1 - Possible the occurrence is randomly.
	W1 - Eqs operator can't segregate the affected off blotted because not all the 4outs are affected.

CORRECTIVE ACTION

Re-orient the operator to include this portion in their critical check point for Koyama Orientalmotor and once they encounter blotted print immediate clean the cyrel using brush, rags & water.

PIC:	PRODUCTION	TARGET DATE:	DONE
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**Proof that Operator check
this portion as critical point
and they immediately
conducted cleaning of cyrel
once they encounter**

Improvement in logo character if applicable, because if not possible this problem is continues to all Koyama Inner Box.

PIC:	DESIGN	TARGET DATE:	in today
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PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR