

1951


**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.: 297

Date Issued: 20 09 19

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00415456-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	20 09 17
Job Order Number	WO-DRS-20-M-01194-167	Section Detected	QA - IN LINE

**ILLUSTRATION OF THE PROBLEM**
☐ Major

☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

1,498

30

2.00 %

Nature of Defect:

GLUE STAIN

Requirement:

No glue stain on the surface of the item

Actual:

W/ glue stain



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 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	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**

LEAK OF GLUE APPLICATOR

**OUTFLOW ROOTCAUSE**EVEN OPERATOR WIPE OUT THE GLUE STAIN  
THE MARK OF GLUE DIDNT REMOVE**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

**B. Orientation**

Date	N/A	Time	N/A
Title	N/A		
Attendees	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 09 21

PIC: A. Vergara

**Identified Rootcause**

&gt; The glue drip on the surface of the boards, because it was leak from the glue applicator. The glue applicator copper head overheats.

**Recommendation**> Clean the copper head  
> Standardize the frequency of cleaning copperhead**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 25	<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 11 14	<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**

<b>QUALITY ASSURANCE DEPARTMENT</b>		<b>Approved by:</b>		<b>Process Owner Acknowledgment: (Receiving Section)</b>	
<input checked="" type="checkbox"/> Closed	<input type="checkbox"/> Still Open	<input type="checkbox"/> Re-Issue IRF	<b>DATE AND SIGNATURE</b>	<b>QA Supervisor</b>	<b>QA Asst. Manager</b>
<b>CLOSED</b>		Date: 21 01 11	Date: 21 01 11	Date: 21 01 11	Date: 21 01 11



## INVESTIGATION REPORT FOR GLUE STAIN OF SANYO DENKI 00415456-01 PACKAGE

<b>DIRECT CAUSE</b> PROCESS/MATERIAL	W1- Possible glue stain happened due to leak glue from the glue applicator.
	W2- Due to mechanism of glue applicator the glue applicator copper head got overheat that cause of dried glue.
	W3 - Dried glue accumulated in the roller of glue applicator that caused leak glue.

<b>INDIRECT CAUSE</b> PROCESS/MATERIAL	W1- Operator try to wipe out the glue stain in the box but the mark of glue didn't remove.
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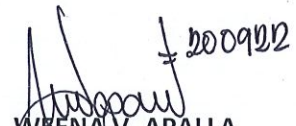
## PRODUCTION CORRECTIVE ACTION

<p>The overheating of glue applicator copper head is inherent due to its mechanism, why the corrective action of production is to standard the cleaning of glue applicator after 6hrs of operation and before the end of the shift. Totally glue applicator clean twice per shift and once they encounter leak glue before the standard time set, operator need to immediately report the abnormality happen to Leader in-charge.</p>			
<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>200925</b>

PREPARED BY:

  
**GERALD DE GUZMAN**  
 PROD ASST. SUPERVISOR

APPROVED BY:

  
**WEENA V. APALLA**  
 SR. SUPERVISOR