

**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.: 313

Date Issued: 20 10 12

Customer	NIDEC SUBIC
Item Code	VR-D-RYZXD000003
Item Description	BOX
Job Order Number	WO-SO-IPD-1397-1.1

Attention To	Mr. Gerald De Guzman
Department	PRODUCTION
Date of Detection	20 10 09
Section Detected	QA - SCREENING

**ILLUSTRATION OF THE PROBLEM**☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

1,776

129

7.26 %

Nature of Defect:

Damaged Print

Requirement:

No damaged print on the solid print

Actual:

W/ damaged on the solid print

**NO. OF OCCURRENCE****DISPOSITION****AREA OF OCCURRENCE / ORIGIN****CONTENT**☒ First☐ Hold☐ Slotter☐ Gluing☐ Material☐ Recurrence☐ Special Acceptance☒ EQOS☐ Vertical☐ Dimension

No.: \_\_\_\_\_

☐ For Rework☐ Diecut☐ Others: \_\_\_\_\_☒ Appearance

Date: \_\_\_\_\_

☒ Reject / Disposal☐ Detaching☐ Process / Method

Issued by

Checked by

Approved by

Received by  
(Receiving Section)

Adrian Vergara  
QA-IE Staff

Ms. Noemi Cepeda  
QA Supervisor

Mr. Rexel Almaro  
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:  
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



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

- CORRUGATED FIBER STICK IN THE CYREL

**OUTFLOW ROOTCAUSE**

- ALL ARE FOCUS IN MISALIGN PRINT PROBLEM THAT TIME.

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 10 15 PIC: A. Vergara

**Identified Rootcause****Recommendation**

The fibers leaved a mark on the materials since fiber was attached on the rubber die, the long fiber was inherent to corrugated boards since it was came from slitting process

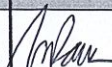
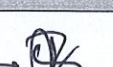
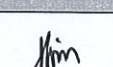

> From design sheets to exact sheets to prevent fibers.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 10 28	<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	21 02 17	<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>		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	<input type="checkbox"/> Still Open	<input type="checkbox"/> Re-issue IRF	 QA Supervisor	 QA Asst. Manager	 Line Leader
DATE AND SIGNATURE  210414		Date: 210414	Date: 210414	Date: 210414	Date: 210414



ALIPPINE, INC.

INC.	FORM 01-18
RP.	4/10/09
0003	RoHS OK
D-1397-1.1	QA-CG508
IPD	QA PASSED

WO-SO-IPD-1397-1.1

Jhoana de Guzman

8-OCTOBER-2020

NIDEC SUBIC PHILIPPINES CORPORATION

NETSUITE  
QA TRANSFER TO FG

BY: JUNMAR / 400

DATE: 201009

TIME: 0021

Memo:

BK Code:

VR-D BOX

Blades:

Light Industry Science Park II,  
National Highway, Calamba, 4027 Laguna  
Tel: (049) 545 7166/67  
Fax: (049) 544-0010

Item Description: VR-D RYZXD000003 BOX  
Quantity: 1014 Piece  
Delivery Date: 9-OCTOBER-2020

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
1475X2000 BF WK160/CM125/TX200 0	260	890X929	520	0pcs 260	260/97	GP		own 10/8

PROCESS	Finished		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
	Date	Time			In-house	Supplier		
1.SLOTTER BIG	10/8		520	1			SA	
2.SLOTTER SMALL	10/8		520	1			BK	
3.EQOS	10/8		520	3			DENJY	
4.DIECUT S1700	10/8		500	8	20 mic ALUM		G/m	
5.CONVEYOR 1			700 350 350	2			Control Product	
6.LOT NUMBERING	10/08 10/08		400 + 300 700				KUM/KENND	
7.SCREENING							KUM/KENND	
8.QA BUNDLE	10/08 10/09		400 + 300 700 340	112 91-8			Kenn	

## REJECTION HISTORY

1. NETSUITE  
2. QA TRANSFER TO FG  
3. BY: JUNMAR / 340  
4. DATE: 201010  
5. TIME: 0239

CLOSED

PRODUCTION OUT

BY: Ablon

DATE: 10/8

## NOTES

1. 400 Transferred to Q.A - Ablon 10/8
2. 300 Transferred to Q.A - Ablon 10/8
3. print damages FOR (S.A) AS PER SIR NIDY OF SALES (129 PCS)
- 4.
- 5.

PR-001-F07 REV.00

JO Received By(WHSE):

Signature over printed name/Date/Time

JO Returned to QA:

Signature over printed name/Date/Time

WHOUSE OUT

NAME: R/punny

DATE: 10/08

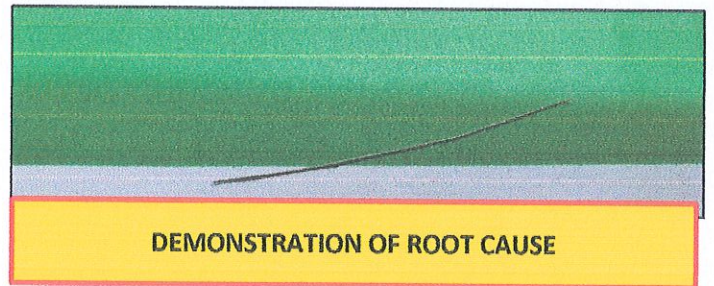
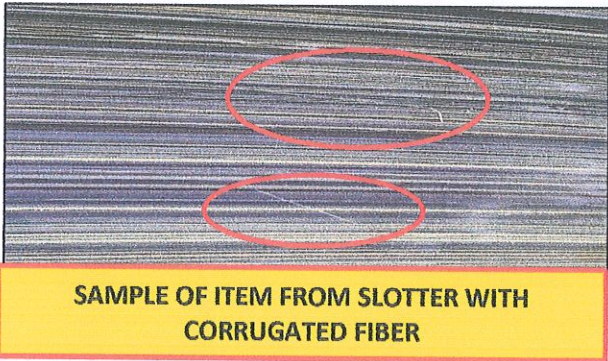
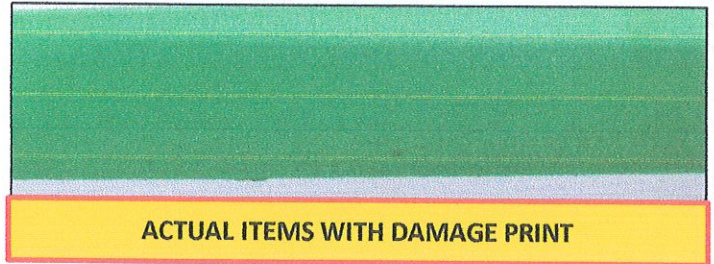
Instructed by sir Niboy  
to use WK160 white kraft  
gel

JO Received By(WHSE):



## INVESTIGATION REPORT FOR DAMAGE PRINT OF NIDEC SUBIC VR-D-RYZXD000003 BOX

<b>DIRECT CAUSE PROCESS/MATERIAL</b>	<b>W1-</b> This item underwent Slotter process before the printing process in Eqos.
	<b>W2-</b> Corrugated board is prone in corrugated fibers specially if undergone cutting in Slotter process.
	<b>W3-</b> Possible that there is a corrugated fibers that was stuck in the cyrel during mass production because the occurrence is in one portion only.



<b>INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL</b>	<b>W1-</b> Eqos operator, QA, ME and Production Leaders monitored the item during the process since this is IPD. The print is critical that time and this is an urgent process because Nidec will pick up the item that same night.
	<b>W2-</b> Several problem was encountered at that time, but all are in focused with the 4mm misalign print trapped in the middle of mass production and failed to noticed the foreign material in the cyrel causing damaged print.

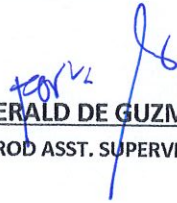
### PRODUCTION CORRECTIVE ACTION

> On the next running of any Nidec Subic White Kraft item, clean all sides of the palletize board to remove excess fiber. > Will include this reject on the checkpoints during mass production.			
<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>NEXT RUNNING OF ANY NIDEC SUBIC WHITE CRAFT</b>

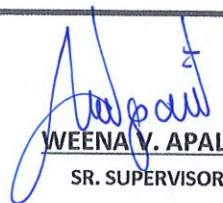
### PRODUCTION SUGGESTION FOR IMPROVEMENT

<b>PIC:</b>	<b>SALES</b>	<b>TARGET DATE:</b>	
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PREPARED BY:

  
**GERALD DE GUZMAN**  
 PROD ASST. SUPERVISOR

APPROVED BY:

  
**WEENA V. APALLA**  
 SR. SUPERVISOR