2817

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

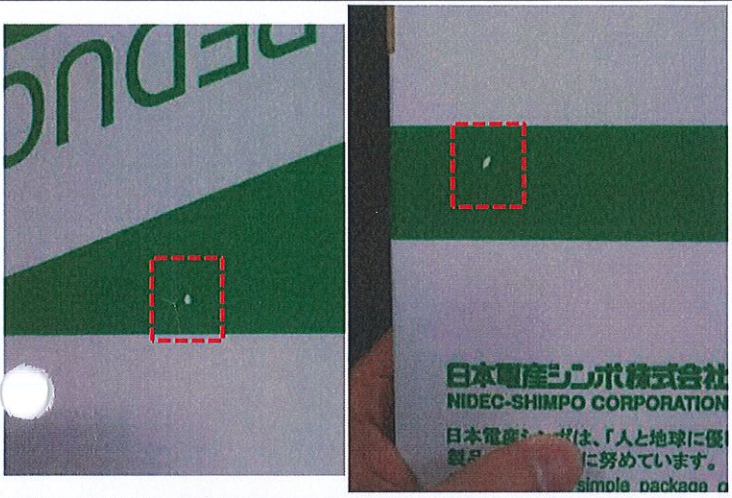
INVESTIGATION REPORT FORM (IRF)

■ Inhouse Detection ☐ Customer Claim

Control No.: 317 Date Issued: 20 10 30

Customer	NIDEC SUBIC	Attention To	Mr. Gerald De Guzman
Item Code	VR-D RYZXD000003	Department	PRODUCTION
Item Description	BOX	Date of Detection	20 10 28
Job Order Number	WO-SO-IPD-1438-7	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM



☐ Major ■ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1899	57	3.00%

Nature of Defect:

SPOT

Requirement:

Spot should be 1mm with minimum of 3 occurrence only (Based General DLC)

Actual:

Spot is >1mm

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 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: Why 4: Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:
Design / Toolings	Why 1: Why 2: Why 3: Why 4: Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:
Process / Material	Why 1: Why 2: Why 3: Why 4: Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:

CANCEL

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FINAL CONCLUSION

OCCURRENCE ROOTCAUSE	OUTFLOW ROOTCAUSE

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				
WIP				
FG				

B. Orientation

Date		Time	
Title			
dees			

C. Reworking

Rework Quantity	
Total Good	
Rework Percentage (Good)	

	Actions to be done to eliminate recurrence	Who / When
System		
Design / Tools		
Process		

II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted:_____ PIC:_____

Identified Rootcause	Recommendation

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action			[ ] Yes [ ] No	
2nd Verification of Action			[ ] Yes [ ] No	
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action			[ ] Yes [ ] No	

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)	
[ ] Closed	QUALITY ASSURANCE DEPARTMENT CLOSED CANCELLED IRF	QA Supervisor	QA Asst. Manager	Line Leader	Department Head
[ ] Still Open					
[ ] Re-Issue IRF		Date: 210414	Date: 210414	Date: 210414	Date: 210414

DATE AND SIGNATURE 21 04 14

KANEPACKAGE PHILIPPINE, INC.

O-4-3379

2015-2340

SO No. :	Sales Order #SO-IPD-1438
JO No. :	WO-SO-IPD-1438-7
ISSUED BY :	Jhoana de Guzman
DATE ISSUED :	15-OCTOBER-2020
CUSTOMER	NIDEC SUBIC PHILIPPINES CORPORATION

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

QA TRANSFER TO FG
BY:
DATE: 201028
TIME:

Item Description:	VR-D RYZXD000003 BOX	Memo:	
Quantity:	2000 Piece	BK Code :	VR-D BOX
Delivery Date:	20-OCTOBER-2020 (Oct. 26)	Blades :	

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
1475 X 2000mm B-Flute (WK135/CM125/TX200) 0	505	890X929 BF	1010	0pcs 505	201013	SP		10/19

PROCESS	Finished Date	Finished Time	GOOD QTY	Trial Run	REJECT QTY In-house	REJECT QTY Supplier	OPERATOR	Remarks
1.SLOTTER BIG	10/10		1010	1			Rey/Guiller	
2.SLOTTER SMALL	10/20		1010	1			BETCO GUILLER	
3.EQOS	10/20		1010	2			CTM HD	
4.DIECUT S1700	10/27		1009	7	1		G/D	
5.DETACH	10/27		2018				Win Toto Larry	
6.CONVEYOR 1	10/27		2001	—	17		VJ / BEN / TON ROD	
7.LOT NUMBERING	10/27		2000				Kuni / Rinn	
8.SCREENING	10/28		1897		30	1	JESIE / SIR NICO / SIR KREXEL	
9.QA BUNDLE	10/27		800		67		CEPE / R	

REJECTION HISTORY

1.
2.
3.
4.
5.

Janine FG 1097
201028
3:20 pm

NOTES

1. Approved over lapping of print at class C (upper flap of the box) ±2 mm for this lot only. - E. Gonzales/201027
2.
3.
4.
5.

WHOUSE

KANEPACKAGE PHILIPPINE, INC.		
CUSTOMER	NIDEC SUBIC PHILS. CORP.	
ITEM CODE	VR-D RYZXD000003	RoHS OK
ITEM DESCRIPTION	BOX	
LOT NO.	201027 - WO-SO-IPD-1438-7	QA-KP022
QUANTITY	10 pcs.	IPD / QA PASSED

PR-001-F07 REV.00

JO Received By(WHSE): Signature over printed name/Date/Time

Antony 10/27
Signature over printed name/Date/Time