

**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

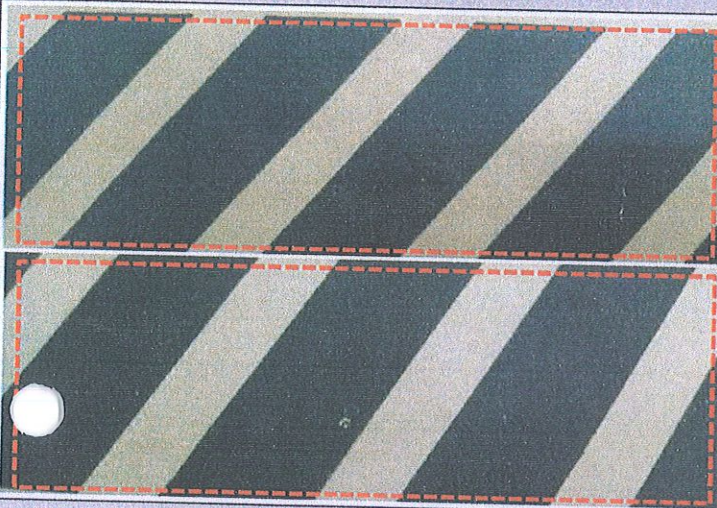
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 320

Date Issued: 20 11 05

Customer: SANYO DENKI
Item Code: 00939007-01
Item Description: CORRUGATED CARTON
Job Order Number: WO-DRS-20-M-01555-16

Attention To: Mr. Gerald De Guzman
Department: PRODUCTION
Date of Detection: 20 11 04
Section Detected: QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.):

5000

Reject Quantity (pcs.):

43

Reject Percentage

0.86%

Nature of Defect:

POOR PRINT

Requirement:

No mottling on the solid image

Actual:

W/ mottling on the solid image

NO. OF OCCURRENCE**DISPOSITION****AREA OF OCCURRENCE / ORIGIN****CONTENT**

☐ First
☒ Recurrence

No.: 3

Date: 20 11 04

☐ Hold
☐ Special Acceptance
☐ For Rework
☒ Reject / Disposal

☐ Slotter
☒ EQOS
☐ Diecut
☐ Detaching

☐ Gluing
☐ Vertical
☐ Others:

☐ Material
☐ Dimension
☒ Appearance
☐ 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:

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:

PLS. SEE ATTACHED

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

PLS. SEE ATTACHED

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**

- CONSIDERATION OF SMALL TEXT PRINT VS. SOLID IMAGE PRINT.
- CORRUGATED FIBER IN MATERIALS.

OUTFLOW ROOTCAUSE

- Reworkable and random 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

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Issues	N/A		

Design / Tools

PLS. SEE ATTACHED

C. Reworking

Rework Quantity	687 pcs.
Total Good	584 pcs.
Rework Percentage (Good)	93.00% 93.14%

Process

PLS. SEE ATTACHED

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

Date Conducted: 201104

PIC: A. Vergara

Identified Rootcause**Recommendation**

The impression applied on the corrugated boards is not enough to fill-in the solid image of the item
> If the impression is too tight small character will gain blotting.

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

	Checked by	Date	Implemented?		Remarks
1st Verification of Action	A. Vergara	201109	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	C.A. is implemented (except for change materials)
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	201222	<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

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



DATE AND
SIGNATURE

[Signature] 210414

INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 00939007-01 CORRUGATED CARTON

DIRECT CAUSE PROCESS/MATERIAL	W1- 1st factor is the consideration of small text print vs. solid image print.
	W2- There are difficulty in operator to setup this item because of the combination of small text and solid image.
	W3- There's a time that the print of Solid Image is compromise, because operator needs to consider that the print of small text will not be blotted.

SIMULATION:

PRINTING SETUP	TEXT	SOLID IMAGE
INK NIP: 6.2 PRINT PULL NIP: 2.6 SPEED: 126 BPM	Recyclable 再生資源として使用でき 資源を大切にしましょう	
REMARKS:	GOOD	NO GOOD
PRINTING SETUP	TEXT	SOLID IMAGE
INK NIP: 6.5 PRINT PULL NIP: 2.2 SPEED: 126 BPM	Recyclable 再生資源として使用でき 資源を大切にしましょう	
REMARKS:	NO GOOD	GOOD

DIRECT CAUSE PROCESS/MATERIAL	W1- 2nd factor is the corrugated fiber in materials.
	W2- We notice that there are lot of corrugated fiber in material that cause of spot in the solid image (584pcs for rework due to spot), including downtime in the process (5.43hrs total process time).

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- They proceed to mass production because the trial run was approved by QA Patrol.
	W2- If Eqos operator notice Poor print they make adjustment in setup, but if is reworkable and occurrence is random so they stick on the existing setup.

PRODUCTION SUGGESTION CORRECTIVE ACTION

Separate the mylar of small text print to solid image print.

PIC:	DESIGN & PRODUCTION	TARGET DATE:	NOV 6, 2020
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Change materials

PIC:	SALES / MPD	TARGET DATE:	November Week 2
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PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR

* Will coordinate to purchasing.