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

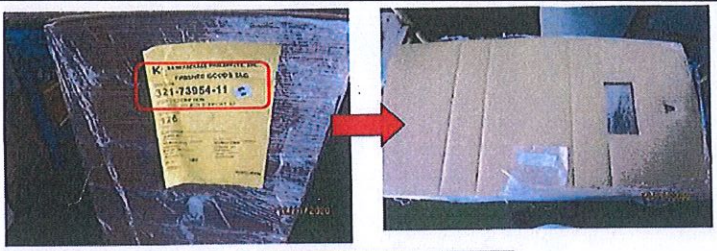
INVESTIGATION REPORT FORM (IRF)

■ Inhouse Detection ☐ Customer Claim

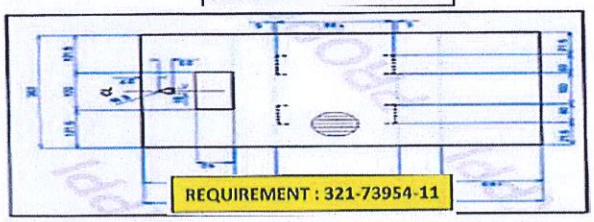
Control No.: 324 Date Issued: 20 11 13

Customer	SHIMADZU	Attention To	Mr Gerald De Guzman
Item Code	321-73954-11	Department	PRODUCTION
Item Description	ACCESSORY BOX SUPPORT, AP	Date of Detection	20 11 13
Job Order Number	WO-20-R-262-9	Section Detected	OQA

ILLUSTRATION OF THE PROBLEM



ACTUAL ITEM : 321-73954-01



■ Major ☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
126	126	100.00%

Nature of Defect:

WRONG ACTUAL VS. LABEL

Requirement:

Actual item and label should be tally

Actual:

Actual item and label is not tally

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 PACKING	☐ 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	OUTFLOW ROOTCAUSE
- WRONG BLADE ISSUED BY TOOLING CUSTODIAN	- OPERATOR NOT CHECK THE ACTUAL VS. DRAWING DURING TRIAL RUN

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

A. Sorting Result

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	N/A			

B. Orientation

Date	20 11 20	Time	13:27 - 13:39 H
Title	ORIENTATION REGARDING WRONG ITEM OF SHIMADZU 321-73954-11 ACCESSORY BOX SUPPORT, AP		
Attendees	TOOLING, DETACHING, & DIE-CUT OPERATORS		

C. Reworking

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

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

	Actions to be done to eliminate recurrence	Who / When
System	N/A	
Design / Tools	N/A	
Process	PLS. SEE ATTACHED	

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

Date Conducted: 20 11 16 PIC: A. Vergara

Identified Rootcause	Recommendation
Wrong attachment of labels, because the item produced were wrong, since the diecut blade issued is not correct.	

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 11 19	[✓] Yes [ ] No	C.A. is implemented
2nd Verification of Action			[ ] Yes [ ] No	
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action	A. Vergara	21 01 17	[✓] 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

Status	Remarks	Approved by:		Process Owner Acknowledgment (Receiving Section)	
[✓] Closed	QUALITY ASSURANCE DEPARTMENT				
[ ] Still Open	CLOSED				
[ ] Re-Issued		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
		Date: 210414	Date: 210414	Date: 210414	Date: 210414

DATE AND SIGNATURE 21 04 14

EPACKAGE PHILIPPINE, INC.

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

42-19

5 lot nos-

26x1

JO No. :	Sales Order #SO-20-R-262
JO No. :	WO-20-R-262-9
ISSUED BY :	Jhoana de Guzman
DATE ISSUED :	29-OCTOBER-2020
CUSTOMER	SHIMADZU PHILIPPINES MFG. INC

Item Description:	321-73954-11 ACCESSORY BOX SUPPORT, AP
Quantity:	126 Piece
Delivery Date:	9-NOVEMBER-2020
Memo :	
BK Code :	321-73954-11
Blades :	Rack 13-37

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
1475 X 2000 CBF UPPC TX200/CM125X3/TX200 0	17	670 X 755 CBF	68	0pcs 17	141567	TS		

PROCESS	Finished Date	Finished Time	GOOD QTY	Trial Run	REJECT QTY In-house	REJECT QTY Supplier	OPERATOR	Remarks
1.SLOTTER BIG	11/6		34	1				
2.SLOTTER SMALL	11/7		68	1			BK RG	
3.DIECUT S1400	11/9		68	1	—		FC	
4.DETACH	11/9		128				[illegible]	
5.LOT NUMBERING	11/10		126				Darrel/PRD	
6.PRODUCTION PACKING	11/10		126				[illegible]	2 [illegible]

REJECTION HISTORY

1.
2.
3.
4.
5.

QUALITY ASSURANCE DEPARTMEN

ENCODED

NOTES

1.
2.
3.
4.
5.

CUSTOMER: SHIMADZU PHILIPPINES MFG. INC
ITEM CODE: 321-73954-11
ITEM DESCRIPTION: ACCESSORY BOX SUPPORT
LOT NUMBER: 201110-WO-20-R-262-9
QUANTITY: 25 pcs.
ROHS OK
PRD
MP
QA PASSED

PR-001-F07 REV.00

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

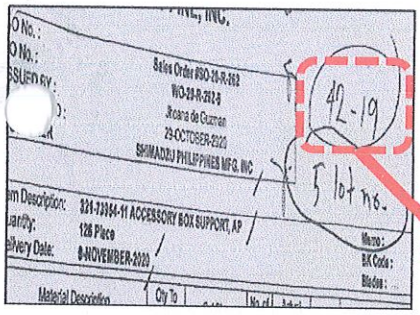
WHOUSE OUT
NAME: [illegible] DATE: 11/10

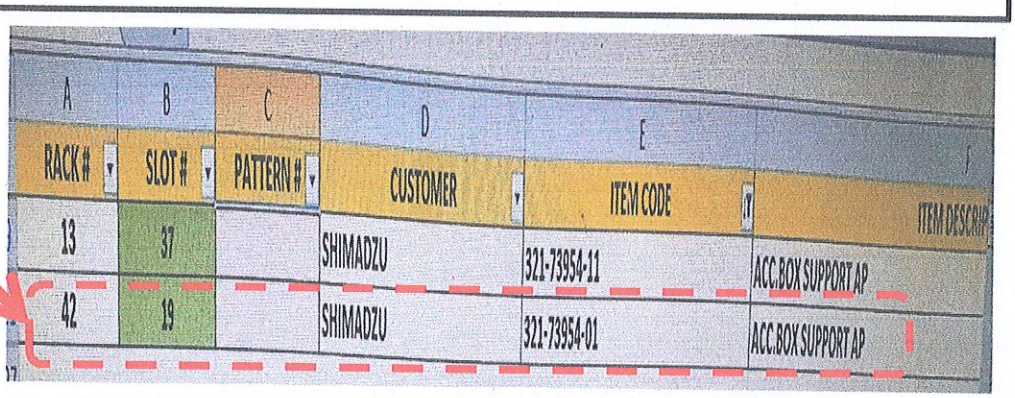
JO Returned to(QA): _____
Signature over printed name/Date/Time

PRODUCTION OUT
BY: Arlene
DATE: 11/10
NETSUITE

INVESTIGATION REPORT FOR WRONG ITEM OF SHIMADZU 321-73954-11 ACCESSORY BOX SUPPORT, AP

DIRECT CAUSE **PROCESS/MATERIAL**	**W1**- Tooling custodian picked a wrong die-blade.
	W2- During Searching/filtering of item needed in the Master list, he did not finish the typing of item code until the end number.
	W3- Two item code appears in monitor and he got misslook and pick the 321-73954-01.





A	B	C	D	E	J
RACK #	SLOT #	PATTERN #	CUSTOMER	ITEM CODE	ITEM DESCRIP
13	37		SHIMADZU	321-73954-11	ACC.BOX SUPPORT AP
42	19		SHIMADZU	321-73954-01	ACC.BOX SUPPORT AP

INDIRECT CAUSE (OUTFLOW) **PROCESS/MATERIAL**	**W1**- Because this item is existing during trial run Diecut operator check only the cutting condition of die-blade and the visual appearance.
	W2- Both Diecut and Detaching operator not check the actual vs. drawing during trial run.

PRODUCTION CORRECTIVE ACTION

- Issue NTE to concern person.
- Orient the tooling custodian that during searching/filtering of tooling needed strictly finish the typing of item code.
- Re-orient the Diecut and Detaching operator regarding actual vs. drawing checking during trial run and check the actual blade condition by checking actual output during trial run. Assessment will indicate in the "REMARKS" portion of the Job Order.

PIC:	PRODUCTION	TARGET DATE:	201119

PREPARED BY:

201116

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

201116

WEENA V. APALLA
SR. SUPERVISOR