

**KANEPACKAGE PHILIPPINE INC.**

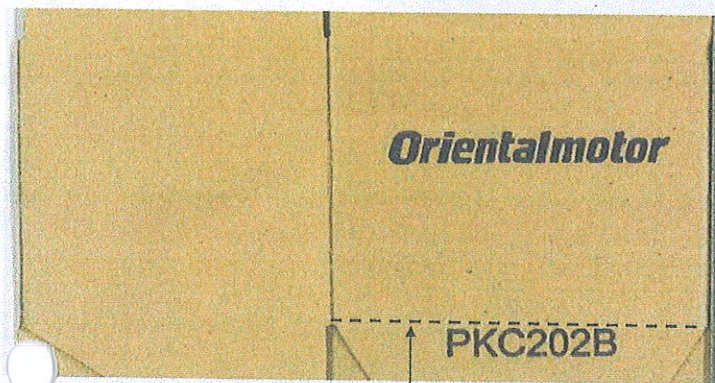
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 344

Date Issued: 20 12 09

Customer	KOYAMA	Attention To	Mr. Gerald De Guzman
Item Code	PKC202B-A	Department	PRODUCTION
Item Description	MOTOR INNER BOX	Date of Detection	20 12 07
Job Order Number	WO-20-M-01731-1	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
4061	165	4.06%

Nature of Defect:

MISALIGN PRINT

Requirement:Printing movement tolerance is $\pm 3\text{mm}$ **Actual:**

Printing movement is 9mm

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 3 Date: 20 12 07	<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 checked="" type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others:	<input type="checkbox"/> Material <input checked="" type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by Ms. Noemi Cepeda QA Supervisor	Approved by Mr. Revel Almarlo QA Asst. Manager	Received by (Receiving Section) 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**

- WARP MATERIALS

OUTFLOW ROOTCAUSE

- RANDOMLY 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		
Indees	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: 21 12 10 PIC: A. Vergara

Identified Rootcause**Recommendation**

> Delay timing of boards because the condition of the materials are warp.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 12 04	<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 03 26	<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**QUALITY ASSURANCE DEPARTMENT**

☒ Closed
☐ Still Open
☐ Re-Issue

CLOSED

Approved by:**Process Owner Acknowledgment (Receiving Section)**

QA Supervisor

QA Asst. Manager

Line Leader

Department Head

Date:

Date:

Date:

Date:

21 04 14

21 04 14

21 04 14

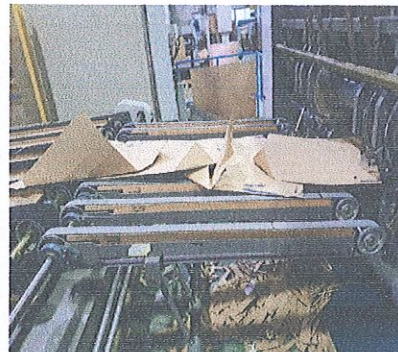
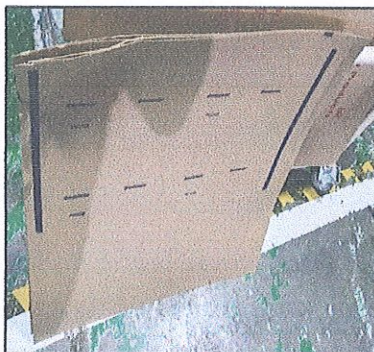
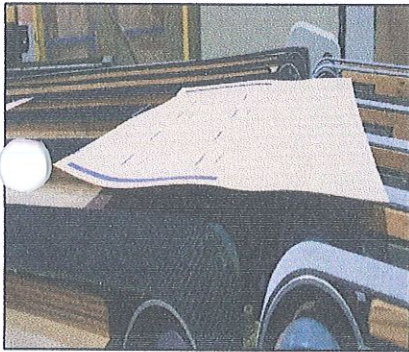
21 04 14

DATE AND
SIGNATURE

21 04 14

INVESTIGATION REPORT FOR MISALIGN PRINT OF KOYAMA PKC202B-A MOTOR INNER BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- There is random of warp materials issued in Eqos.
	W2- Warp materials bump in the machine feed gate and roller that caused of misalign print.



**ACTUAL
CONDITION
OF ITEMS**

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- When operator encountered error due to warp board they immediately inform the Production Leader.
	W2- The outflow did not trap during sampling due to randomly occurrence.

PRODUCTION CORRECTIVE ACTION

- Immediately stop the process and look for another "not warp" materials in Warehouse.
- Inform the concern person and recondition the warp materials.

PIC:	PRODUCTION	TARGET DATE:	201204 (DONE)
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PREPARED BY:

[Signature] 201209
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature]
WEENA V. APALLA
SR. SUPERVISOR