

1736


**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

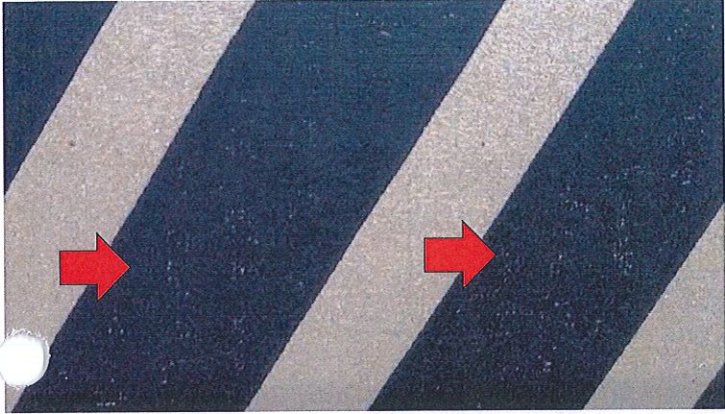
**INVESTIGATION REPORT FORM (IRF)**
☒ Inhouse Detection

☐ Customer Claim

Control No.: 351

Date Issued: 20 12 16

Customer	SANYO DENKI	Attention To	Ms. Weena Apalla
Item Code	00912906-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	20 12 14
Job Order Number	WO-DRS-20-M-01693-182	Section Detected	QA - IN LINE

**ILLUSTRATION OF THE PROBLEM**


<input type="checkbox"/> Major	<input checked="" type="checkbox"/> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
718	35	4.87%

Nature of Defect:

POOR PRINT

Requirement:

Mottling on the solid image should not be visible

Actual:

Mottling on the solid image is visible

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ Date: _____	<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 type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
 Adrian Vergara QA-IE Staff	 Ms. Noemi Cepeda QA Supervisor	 Mr. Rexel Almarid QA Asst. Manager	 Ms. Weena Apalla 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:



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

7 EXCESS WATER CAUSING LOW VISCOSITY  
7 NOT COMPLETELY DRIED CYREL

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****Actions to be done to eliminate recurrence****Who / When**

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

**B. Orientation**

Date	N/A	Time	N/A		Design / Tools	
Title	N/A				N/A	
Indees	N/A					

**C. Reworking**

Rework Quantity	N/A		Process	
Total Good	N/A		See Attached	
Rework Percentage (Good)	N/A			

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

Date Conducted: 20 12 17 PIC: A. Vergara

**Identified Rootcause****Recommendation**

> Incomplete application of ink due to excess water on the cyrel

**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 18	[X] Yes [ ] No	C.A. is implemented
2nd Verification of Action			[ ] Yes [ ] No	
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action	A. Vergara	21 04 15	[X] 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: <input checked="" type="checkbox"/> Closed	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<b>QUALITY ASSURANCE DEPARTMENT</b>			
<b>CLOSED</b>	QA Supervisor	QA Asst. Manager	Line Leader
Date: 21 05 14	Date: 21 05 14	Date: 21 05 14	Date: 21 05 14
DATE AND SIGNATURE			



# KANEPACKAGE PHILIPPINE, INC.

SO No. :	Sales Order #DRS-20-M-01693
JO No. :	WO-DRS-20-M-01693-182
ISSUED BY :	DARIO, ENGLEBERTH N.
DATE ISSUED :	7-DECEMBER-2020
CUSTOMER	SANYO DENKI PHILS INC

**NETSUITE**  
**QA TRANSFER TO FG**  
 BY: Janine FB  
 DATE: 2012/11  
 TIME: 2:52 AM  
 Light Industry Science Park  
 National Highway, Calamba, 4027, Laguna  
 Tel: (049) 545 7166/67  
 Fax: (049) 544-0010

Item Description: <b>00912906-01 PACKAGE</b>	Memo :
Quantity: <b>700 Piece</b>	BK Code : <b>00912906-01</b>
Delivery Date: <b>14-DECEMBER-2020</b>	Blades :

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
1475 X 2000 CF UPPC TX200/CM125 /TX200 0	360	567 X 1718 CF	720	0pcs	112900	TS		any

PROCESS	Finished Date	Time	GOOD QTY	Trial Run	REJECT QTY In-house	Supplier	OPERATOR	Remarks
1.SLOTTER BIG	12/11		360	1			UOG	
2.SLOTTER SMALL	12/11		720	1			KG	
3.EQOS	12/14		770 689	3	2		OHYN	sk
4.SEMI AUTO GLUING	12/14		400 +289 11	1			mani edward	
5.LOT NUMBERING	12/14		700				kim/anyin	
6.SCREENING	12/14		400 260		27		Arish/ Dawin	
7.QA BUNDLE	12/14		13		16		Keaneth JIMWEL	more Bal.

## REJECTION HISTORY

1. (A). Occurrence Date: 03/27/19, (B). Problem: Poor Print, (C). NG Quantity: 38 PCS., (D) Rootcause: low viscosity of ink due to excessive water from the shower and rough surface of material

2.  
3.  
4.  
5.

## NOTES

1. Reduce usage of water supply specially if the running is continuous

2. 400 transferred to QA Jan 12/14  
 3. 289 Transferred to QA Jan 12/14  
 4.  
 5.

PR-001-F07 REV.00

JO Received By(WHSE):

Signature over printed name/Date/Time

PRODUCTION OUT

BY: charlotte

DATE: 12/14

NETSUITE

<b>SANYO DENKI PHILS. INC.</b>	
Item Code <u>00912906-01</u>	QUANTITY <u>10 pcs.</u>
Item Description <u>PACKAGE</u>	Supplier's QC <u>PASSED</u>
Lot No. / Ref. No. <u>201214 - 01693-182</u>	INSPECTION <u>RoHS OK</u>
QA-CG538	
<b>KANEPACKAGE PHILIPPINES INC.</b>	



# INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 00912906-01 PACKAGE

<b>DIRECT CAUSE PROCESS/MATERIAL</b>	<b>W1-</b> Possible, that after cleaning of cyrel, operator did not completely dried the cyrel using dry rags, which leaving water residue on the cyrel.
	<b>W2-</b> Due to excessed water supply of automatic shower to Anilox, the 9 sec viscosity became lower that caused poor print.

OPERATION RATIO AND CONDIT

SHEET

Machine	EQOS
Time	Machine Breakdown / Downtime / Others
Start	Finish
0004	0009
	CLEANING CYREL (3X)

Machine Ratio of Eqos indicating downtime during running due to Cleaning of cyrel.

<b>INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL</b>	<b>W1-</b> Operator proceed to mass production because the trial run was approved by QA Patrol.
	<b>W2-</b> Eqos operator make adjustment in set-up if they notice poor print, but they stick on the existing set-up because the occurrence was random and based on investigation report 35 pcs (4.87%) only was rejected out of 718 Lot quantity.

## PRODUCTION CORRECTIVE ACTION

Orient the operator that before to continue the mass production after cleaning the cyrel, make sure that the cyrel is dried enough. Also remind them to always observe the anilox mirror to keep the normal viscosity level.

<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>201218</b>
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PREPARED BY:

LEI ANN MARIE AVILES  
IE STAFF

APPROVED BY:

WEENA V. APALLA  
SR. SUPERVISOR