


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

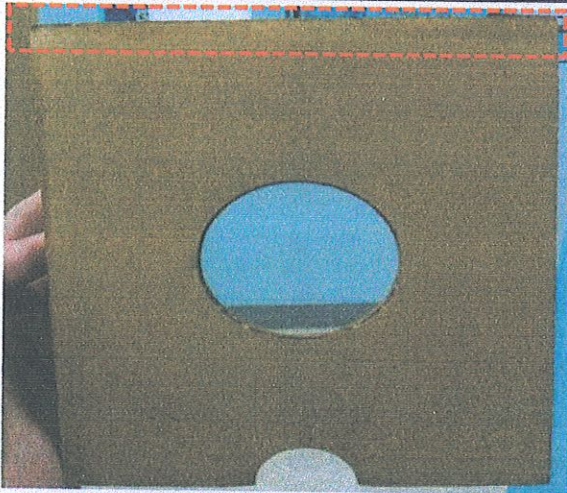
☐ Customer Claim

Control No.: 360

Date Issued: 21 01 04

Customer	NIDEC SUBIC	Attention To	Mr. Gerald De Guzman
Item Code	DUNNAGE SET	Department	PRODUCTION
Item Description	TOP AND BOTTOM SET	Date of Detection	QA - SCREENING
Job Order Number	WO-SO-IPD-1609-6	Section Detected	20 12 21

ILLUSTRATION OF THE PROBLEM
☐ Major

☒ Minor


Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

1000

24

 2.40%
~~24.00%~~

Nature of Defect:

GLUE STAIN / EXCESS GLUE

Requirement:

No excess glue on the surface of the item

Actual:

W/ Excess glue

NO. OF OCCURRENCE		DISPOSITION		AREA OF OCCURRENCE / ORIGIN		CONTENT	
<input checked="" type="checkbox"/> First		<input type="checkbox"/> Hold		<input type="checkbox"/> Slotter	<input checked="" type="checkbox"/> Gluing	<input type="checkbox"/> Material	
<input type="checkbox"/> Recurrence		<input type="checkbox"/> Special Acceptance		<input type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension	
No.: _____		<input type="checkbox"/> For Rework		<input type="checkbox"/> Diecut	<input type="checkbox"/> Others: _____	<input checked="" type="checkbox"/> Appearance	
Date: _____		<input checked="" type="checkbox"/> Reject / Disposal		<input type="checkbox"/> Detaching		<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 Almarie 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 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	PLS. SEE ATTACHED	Why 3:	PLS. SEE ATTACHED
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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

- THE ROLLER WITH GLUE TOUCHED THE BASE OF JIG DUE TO HOLE OF THE ITEM AND IT CAUSED GLUE STAIN.

OUTFLOW ROOTCAUSE

- NO REJECTION CRITERIA YET BECAUSE THE ITEM IS IPD.

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		
Attendees	N/A		

Design / Tools

N/A

C. Working

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: 20 01 05 PIC: A. Vergara

Identified Rootcause**Recommendation**

> Glue contamination from jig because the design of the item has a hole on the center

> Fabricate jig for dunnage set to prevent glue contamination

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

	Checked by	Date	Implemented?		Remarks
1st Verification of Action	A. Vergara	21 01 05	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	Recommendation is implemented
2nd Verification of Action	A. Vergara	21 01 08	<input type="checkbox"/> Yes	<input type="checkbox"/> No	C.A. will not be pursue
3rd Verification of Action			<input type="checkbox"/> Yes	<input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 03 10	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	Recommendation 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)	
Still open	QUALITY ASSURANCE DEPARTMENT	QA Supervisor	QA Assn. Manager	Line Leader	Department Head
Re-Issue IRF		Date: 210414	Date: 210414	Date: 210414	Date: 210414

DATE AND SIGNATURE

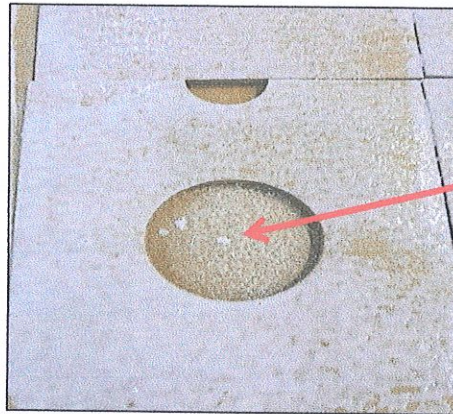
210414

INVESTIGATION REPORT FOR GLUE STAIN OF NIDEC SUBIC DUNNAGE SET TOP AND BOTTOM

DIRECT CAUSE PROCESS/MATERIAL	W1- Possible that the glue stain came from the jig that they used during assembly.
	W2- During application of glue using paint roller, the roller with glue touched the base of jig due to hole of the item and it caused glue stain.



GLUE APPLICATION USING PAINT ROLLER



**GLUE LEAK IN
THE BASE OF JIG
THAT CAUSED
GLUE STAIN**

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Because the glue stain is unavoidable due to the design and process of the item, and no rejection criteria yet because the item is IPD the operator think that the small amount of glue stain is acceptable.
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PRODUCTION CORRECTIVE ACTION

Create rejection criteria that applicable base on the items design and process.

PIC:	SALES, QA & PRODUCTION	TARGET DATE:	DISCUSS TO 4PM MEETING
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PREPARED BY:

Bd/ 210105
GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:

210105
WEENA V. APALLA
 SR. SUPERVISOR