


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.: 365

Date Issued: 21 01 19

Customer	SANYO DENKI	Attention To	Ms. Weena Apalla
Item Code	00939007-01	Department	PRODUCTION
Item Description	CORRUGATED CARTON	Date of Detection	21 01 19
Job Order Number	WO-DRS-20-M-01860-14	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM

☐ Major

☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

4699

68

1.45%

Nature of Defect:

POOR PRINT

Requirement:

No poor printing on the solid image

Actual:

W/ mottling on the solid image

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 4 Date: 21 01 19	<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 Almario 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: 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**

- TEXTURE OF MATERIALS.

OUTFLOW ROOTCAUSE

- REMARKABLE 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

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 01 21

PIC: A. Vergara

Identified Rootcause

> The surface of the boards are rough (Innate from UPPE boards)

Recommendation

> Increase the ink viscosity from 9secs. to 10~11secs.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 02 11	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation is implemented
2nd Verification of Action	A. Vergara	21 01 21	<input type="checkbox"/> Yes <input checked="" 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 04 08	<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)
<input checked="" type="checkbox"/> Closed	QUALITY ASSURANCE DEPARTMENT		
<input type="checkbox"/> Still Open		QA Supervisor	QA Asst. Manager
<input type="checkbox"/> Re-Issue IRF		Date: 21 04 14	Date: 21 04 14
			Line Leader
			Department Head
			Date: 21 04 14

DATE AND
SIGNATURE

21 04 14

KANEPACKAGE PHILIPPINE, INC.

SO No. :	Sales Order #DRS-20-M-01860
JO No. :	WO-DRS-20-M-01860-14
ISSUED BY :	Jhoana de Guzman
DATE ISSUED :	17-DECEMBER-2020
CUSTOMER	SANYO DENKI PHILS INC

NETSUITE	
QA TRANSFER TO FG	
BY:	CLM 21/1/21
DATE:	1/1/21
TIME:	7:50



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

1571

Item Description:	00939007-01 Corrugated Carton	Memo :	
Quantity:	2500 Piece	BK Code :	00939007-01
Delivery Date:	11 JANUARY-2021	Blades :	

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
475 X 1000 CF TX200/CM150/TX200 0	2520 2500	0	0	0pcs 2500	710009	010		ang 1/15

PROCESS	Finished Date Time		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
					In-house	Supplier		
1.EQOS 2ando 10/1/15	1/15		2500				JEREB	
2.DIECUT S1700	1/15		2500	25			Q	BLUDD OK
3.DETACH	1/15						AUTO STMP	
SD 1800 4.SEMI AUTO GLUING	1-15		2200 300				neke Jane Joo Cely	
5.LOT NUMBERING	01/15		2500				ICM/ERRAND	
6.SCREENING	01/15		2150		50		ERRAND/KHJ/THOM	
7.QA BUNDLE	01/15		300				KHJ/THOM	

REJECTION HISTORY

1. (A). Kailan: 04/11/19, (B). Problema: Misalign Print, (C) Ilan: 439 PCS., (D) Bakit: Dahil sa hindi pantay na materyales na ni run sa machine
2. (A). Kailan: 04/12/19, (B). Problema: Poor Print, (C). Ilan: 158 PCS., (D) Bakit: Hindi standard ink mixture ng supplier
3. (A). Kailan: 1/27/2020, (B). Problema: POOR PRINT, (C). Ilan: 44 PCS., (D) Bakit : Manipis na application ng ink sa boards dahil ang skip button ay hindi naka activate
4. Kailan: 3/05/2020, (B). Problema: MISALIGN DIECUT/ PRINT , (C). Ilan: 114 PCS., (D) Bakit : Ang gap ay nangyari dahil sa maluwa ng set up side guide ng feeding unit (printing location movement for lateral)
5. (A). Occurrence Date: 8/6/2020, (B). Problem: SCRATCHES, (C). NG Quantity: 62 PCS., (D) Rootcause: The printed image on the item contaminates the other item because the position of the glued items in the conveyor is not slanting since the roller was removed

NOTES

1. Isagawa ang pagtatapping ng boards bago ito ilagay sa mach
2. Laging isagawa ang pagchecheck ng viscosity bago ito ilaga printing
3. Laging iactive ang skip on ng machine sa mga items na may
4. Sundin ang standardize minimum and maximum side guide
5. No removing of roller on the machine

PR-001-F07 REV.00

BY: *Angela*

JO Received By(WHSE):

DATE: 1/15

Signature over printed name/Date/Time

SANYO DENKI PHILS. INC.

Item Code	QUANTITY
00939007-01	10 pcs.
Item Description	Supplier's QC
CORRUGATED CARTON	PASSED
Lot No. / Ref. No.	INSPECTION
210115 - 01860-14	RoHS OK
	QA-CG645

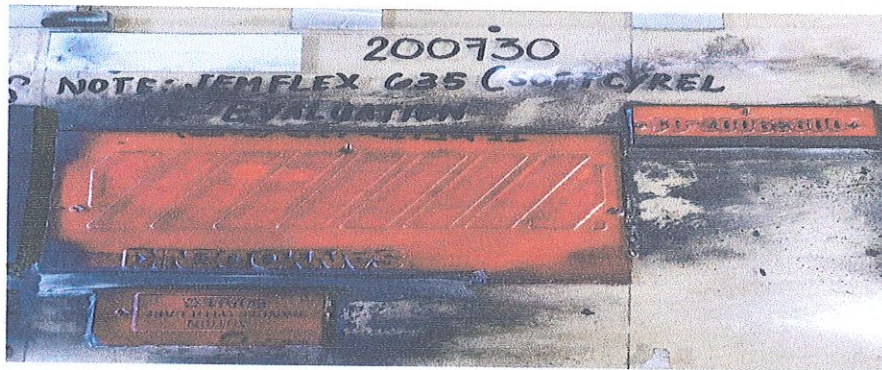
KANEPACKAGE PHILIPPINES INC.

Date/Time

2200 Transferred to WHS 01/15

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

DIRECT CAUSE PROCESS/MATERIAL	W1- Solid print character is already Jemflex 635 soft cyrel and separate to small character.
	W2- The possible factor we consider for this poor print is the texture of materials (Supplier is 818 > TX200/CM150/TX200)
	W3- We found that the surface of materials is rough and there's a lot of fibers.



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 CORRECTIVE ACTION

Propose the change materials to NPK

PIC:	PRODUCTION	TARGET DATE:	DISCUSS 4PM MEETING
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PREPARED BY:

[Signature]
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature] 210121
WEENA V. APALLA
SR. SUPERVISOR