

**KANEPACKAGE PHILIPPINE INC.**

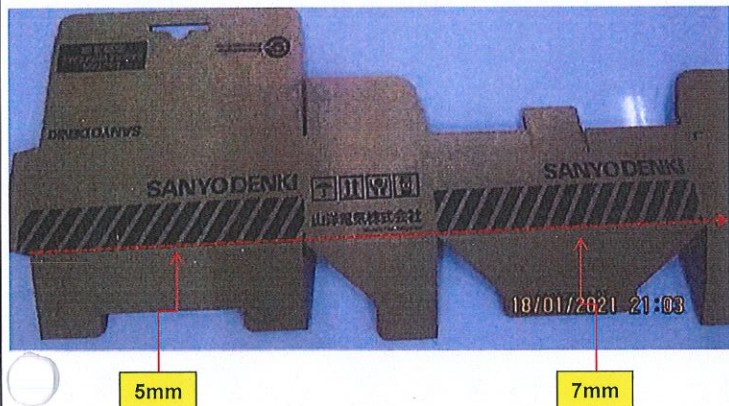
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 368

Date Issued: 21 01 20

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00902009-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	21 01 20
Job Order Number	WO-DRS-20-M-01892-155.1	Section Detected	QA-INPROCESS PRD- GLUING

ILLUSTRATION OF THE PROBLEM☐ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1126	126	11.19%

Nature of Defect:

MISALIGN PRINT

Requirement:

The print is slanting position

Actual:

Print positioning should be straight

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input checked="" type="checkbox"/> Dimension
No.: 2nd	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Appearance
Date: 21 01 20	<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 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: P/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

2mm MISALIGN PRINT IS WITHIN
THE TOLERANCE

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

Design /
Tools

N/A

Process

PLS. SEE ATTACHED

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Issues	N/A		

C. Reworking

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

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

Date Conducted: 4 01 22

PIC: A. Vergara

Identified Rootcause

The materials that were used is warp

Recommendation**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 26	<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	21 03 23	<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

<input checked="" type="checkbox"/> Status: QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed					
<input type="checkbox"/> Still Open		QA Supervisor		Line Leader	
<input type="checkbox"/> Re-Issue IRF		QA Asst. Manager		Department Head	
DATE AND SIGNATURE		Date: 21 04 14	Date: 21 04 14	Date: 21 04 14	Date: 21 04 14

KANEPACKAGE PHILIPPINE, INC.

- last run 1/18
- w/sched 1/13
AK-01-00022



SO No. :
JO No. :
ISSUED BY :
DATE ISSUED :
CUSTOMER

WO-DRS-20-M-01892-155.1
Jhoana de Guzman
11-JANUARY-2021
SANYO DENKI PHILS INC

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

Item Description: 00902009-01 PACKAGE
Quantity: 116 Piece
Delivery Date: 12 JANUARY-2021

Memo :
BK Code : 00902009-01
Blades :

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
484 X 933 BF TX200/CM125/TX200 0	126	0	0	0pcs		QW		Amelia 01/18

PROCESS	Finished		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
	Date	Time			In-house	Supplier		
1.EQOS boards	1/18		126	2			M.H.RAB	
2.DIECUT S1700 01/18 JRM			126	3			DOR/NIN	OK/BLADE
3.DETACH	1/18		126				Night Shift	
4.CONVEYOR 1								
5.LOT NUMBERING								
6.SCREENING								
7.QA BUNDLE								

REJECTION HISTORY

1. (A). Kailan: 04/11/19, (B). Problema: Misalign Print, (C). Ilan: 439 PCS., (D) Bakit: Dahil sa hindi pantay na materyales habang tinatakbo ito sa machine

2. (A). Kailan 09/14/2019, (B). Problema: Poor Print, (C). Ilan: 245 PCS., (D) Bakit: Ang ginamit na cyrel ay hindi akma sa machine

3. (A). Kailan: 2/1/2020, (B). Problema: POOR PRINT, (C). Ilan: 81 PCS., (D) Bakit : Kulang ang ink sa boards dahil ang viscosity ng ink ay hindi akma sa kadahilanan hindi balanse ang distribution ng tubig sa pagitan ng end shower

4.

5.

NOTES

1. Kailangan magsagawa ng tapping ng boards bago ito iproseso

2. Magsagawa ng pagchecheck ng printing appearance ng item

3. Kailangan linisin lagi ang water shower para hindi ito magbara

4.

5.

PR-001-F07 REV.00

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

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

NAME: for DATE: 1/18

INVESTIGATION REPORT FOR MISALIGN PRINT OF SANYO DENKI 00902009-01 PACKAGE

DIRECT CAUSE PROCESS/MATERIAL	W1- Eqos operator encountered random of warp materials during process of this item
	W2- They immediately inform the leader in-charge and QA Patrol, then separate the affected materials.
	W3- But suddenly some of acceptable wave warp materials less than 10mm got caused of 2mm inclined print.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Since the 2mm misalign print is within tolerance and no instruction from QA patrol to stop the process during sampling, Eqos operator proceed to mass production.
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PRODUCTION CORRECTIVE ACTION

Orient the Eqos operator that they need to conduct another trial run approved by QA patrol for the acceptable warp materials before proceed to mass production.			
<i><12mm - Acceptable</i>			
PIC:	PRODUCTION	TARGET DATE:	210115

PREPARED BY:

[Signature] 2/10/21
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature] 2/10/21
MEENA V. APALLA
SR. SUPERVISOR