

**KANEPACKAGE PHILIPPINE INC.**

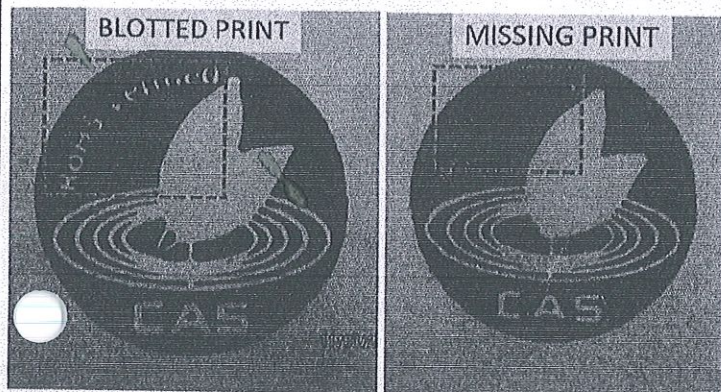
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 207

Date Issued: 20 03 13

Customer	SHIMADZU	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	321-72138	Department	PRODUCTION
Item Description	PACKING BOX	Date of Detection	20 03 12
Job Order Number	WO-20-R-071-13	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

29

29

100.00%

Nature of Defect:

BLOTTED PRINT

Requirement:

RoHS Verified Text should be readable

Actual:

The affected text is not readable

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	 QA Supervisor	 Mr. Rexel Almario QA Asst. Manager	 Mr. Gerald De Guzman / 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:

NOT A FACTOR

NOT A FACTOR

PLS. SEE ATTACHED

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

- PRIN CHARACTER IS TOO SMALL AND
THE TEXT IS ENGRAVE

OUTFLOW ROOTCAUSE

- DONT HAVE ENOUGH TIME TO
CONDUCT MORE SAMPLING BECAUSE
QTY ARE ONLY 32pgs VS. 125 BPM.

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	QA- IN LINE	29	29	0

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

System	N/A	
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B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Att...Jees	N/A		

Design / Tools

Design / Tools	N/A	
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C. Reworking

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

Process

Process	PLS. SEE ATTACHED	
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II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 20 03 16

PIC: A. Vergara

Identified Rootcause**Recommendation**

-The affected text is very narrow & shallow,
tendency to accumulate ink very easily on the
text because the ink applied on the ink roll to
rubber die because the setup is in "skip on"
(To prevent poor print to solid images)

-change the design of the affected text:
Proposals:
1. From Engrave to Emboss
2. Deeper the engrave of the rubber die
-change material from TX200 to NPK180

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 03 16	[] Yes [X] No	coordinated to sales for discussion to customer (Discussed during 3 PM Meeting)
2nd Verification of Action	A. Vergara	20 12 28	[X] Yes [] No	-Recommendation is implemented - change paper only -change design will not pursue
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	21 10 25	[X] Yes [] 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	QUALITY ASSURANCE DEPARTMENT	Approved by:	Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	CLOSED	QA Supervisor	Line Leader	
<input type="checkbox"/> Still Open		QA Ass. Manager	Department Head	
<input type="checkbox"/> Re-Issue IRF		Date: 21 10 26	Date: 21 10 26	Date: 21 10 26
DATE AND SIGNATURE				

INVESTIGATION REPORT FOR BLOTTED PRINT OF SHIMADZU 321-72138 PACKING BOX

DIRECT CAUSE DESIGN/TOOLING	W1- Print character is too small and the text is Engrave.
	W2 - Engrave text specially if small character is prone to blotted print.

INDIRECT CAUSE PROCESS/MATERIAL	W1- Even they consider to cleaned the cyrel due to blotted print they encountered (With record in the machine ratio), it was occurs again due to small and Engrave text.
	W2- This item is very difficult to print because you need to consider the two factor in same time 1st not to become blotted print the engrave text and 2nd not to become poor print the solid character.
	W3 - Unlike before in Long Way Printing we process this item " STOP & GO" routine, after print of 5pcs we stop to clean the cyrel then print another 5pcs.

INDIRECT CAUSE PROCESS/MATERIAL	W1 - Trial run approved by QA Patrol.
	W2- Don't have enough time to conduct more sampling.

CORRECTIVE ACTION

Any possible improvement in character specially to Engrave text because this item is long time problem of Printing operator regarding rejection.

PIC:	Design & Sales	TARGET DATE:	
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