

**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

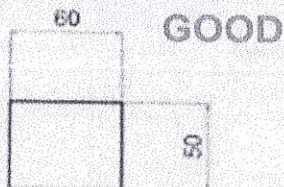
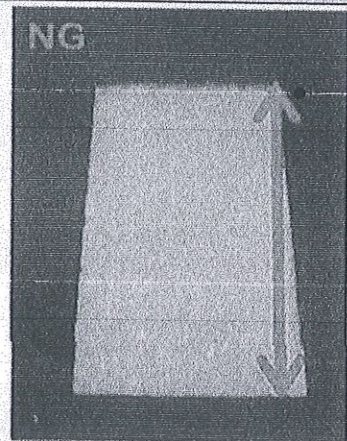
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 236

Date Issued: 20 07 02

Customer	SUPERFLEX
Item Code	LOKD92001-2172-8
Item Description	CUSHION LOWER PART 8
Job Order Number	WO-20-M-00851-21

Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Department	PRODUCTION
Date of Detection	20 07 01
Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM

PART 8
MATERIAL: PP30 (t=20)
2 PCS/SET
REQUIREMENT: 60mm $\pm$ 2

ACTUAL :80mm☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
80	80	100.00%

Nature of Defect:

OFF SPECS

Requirement:

Item dimension should be within ± 2 mm tolerance

Actual:

Actual length size is 80mm

NO. OF OCCURRENCE**DISPOSITION****AREA OF OCCURRENCE / ORIGIN****CONTENT**☒ First
☐ Recurrence

No.: _____

Date: _____

☐ Hold
☐ Special Acceptance
☒ For Rework
☐ Reject / Disposal

☐ Slotter	☐ Gluing
☐ EQOS	☒ Vertical
☐ Diecut	☐ Others: _____
☐ Detaching	

☐ Material
☒ Dimension
☐ Appearance
☐ Process / Method

Issued by

Checked by

Approved by

Received by
(Receiving Section)

Adrian Vergara
Adrian Vergara
QA-IE Staff

QA Supervisor

Mr. Rexel Almario
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:

N/A

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

N/A

Design / Toolings

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

N/A

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

N/A

Process / Material

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

PLS. SEE ATTACHED

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

PLS. SEE ATTACHED

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

- OPERATOR MISLOOK THE 60mm TO 80mm.

OUTFLOW ROOTCAUSE

- THE 1 TRIAL CONDUCTED HAS WRONG DIMENSION DUE TO MISLOOK OF 60mm TO 80mm.

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	20 07 08 20 07 10	Time	08:28 - 08:30 N/A
Title	ORIENTATION REGARDING OFF SPECS OF SUPER FLEX 10K092001-2172-8 N/A CUSHION LOWER PARTS		
Attendees	VERTICAL OPERATOR N/A		

Design / Tools

N/A

C. Reworking

Rework Quantity	80 PCS.
Total Good	80 PCS.
Rework Percentage (Good)	100%

Process

PLS. SEE ATTACHED

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

Date Conducted: 20 07 03

PIC: A. Vergara

Identified Rootcause

The operator confuse on the dimension of the item because the operator failed to check the actual sample based on the drawing

Recommendation

check the drawing in the trial run prior mass production

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 07 10	☒ Yes ☐ No	CA is implemented
2nd Verification of Action			☐ Yes ☐ No	
3rd Verification of Action			☐ Yes ☐ No	
Effectiveness of Action	A. Vergara	21 06 30	☒ Yes ☐ No	CA 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: ☒ Closed ☐ Still Open ☐ Re-issue IRF	Remarks: QUALITY ASSURANCE DEPARTMENT CLOSED DATE AND SIGNATURE: 21 07 01	Approved by: QA Supervisor Date: 21 07 01	 QA Asst. Manager Date: 21 07 01	Process Owner Acknowledgment: (Receiving Section) Line Leader Date: 21 07 01	 Department Head Date: 21 07 01
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INVESTIGATION REPORT FOR OFF SPECS OF SUPERFLEX LOKD92001-2172-8 CUSHION LOWER PART 8

DIRECT CAUSE PROCESS/MATERIAL	W1- Operator cut the cushion in wrong dimension 80mm instead of 60mm requirement.
	W2- Operator got mislook the 60mm to 80mm.

INDIRECT CAUSE PROCESS/MATERIAL	W1- The 1 trial run conducted by operator has wrong dimension due to mislook of 60mm to 80mm.
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CORRECTIVE ACTION

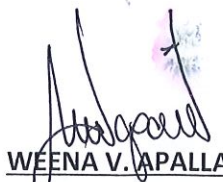
Rework the affected item from 80mm actual to 60mm requirement.			
PIC:	Production	TARGET DATE:	10 07 02

Orientation to always double check the dimension digit in the drawing during Trial Run.			
PIC:	Production	TARGET DATE:	10 07 08

PREPARED BY:


GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
SR. SUPERVISOR