


**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

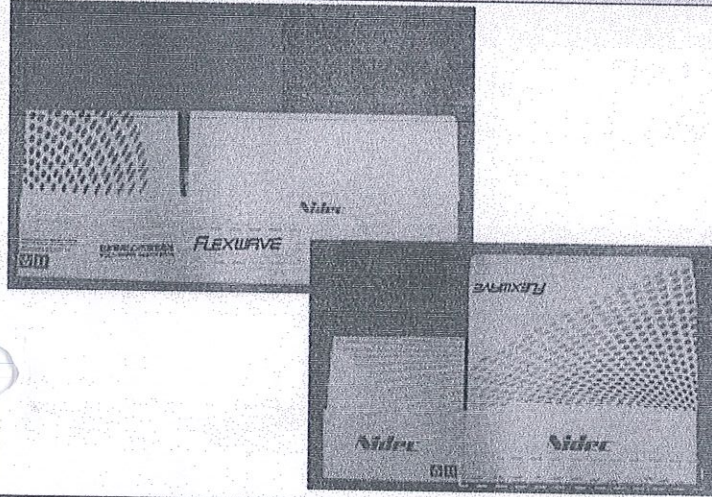
**INVESTIGATION REPORT FORM (IRF)**
☒ Inhouse Detection

☐ Customer Claim

Control No.: 263

Date Issued: 20 08 06

Customer	NIDEC SUBIC	Attention To	Mr. Gerald De Guzman
Item Code	L00086478	Department	PRODUCTION
Item Description	FLEXWAVE C BOX	Date of Detection	20 08 04
Job Order Number	WO-SO-IPD-1220-1	Section Detected	QA - IN LINE

**ILLUSTRATION OF THE PROBLEM**

☒ Major

☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

1960

44

2.24%

Nature of Defect:

MISALIGN PRINT

Requirement:

The character should not be slanting

Actual:

The printed characters are slanted

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 checked="" 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	 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: N/A Why 3: 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**

- TRANSFER OF PROCESS FROM S170D TO ETERNA.
- DISCREPANCY IN DRAWING VS. CYREL.

**OUTFLOW ROOTCAUSE**

- EDDS OPERATOR DIDN'T NOTICE THE MISALIGN PRINT BECAUSE THE ITEMS ARE NOT YET DIE-CUTTED.

**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. 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: 20 OK 10

PIC: A. Vergara

**Identified Rootcause****Recommendation**

> The printing is in oblique position because the item has high stacking height in the feeding unit of the printing machine

- > Reduce stacking height (same w/ 1012)
- > Mounting of pokayoke marks on the mylar to monitor the printing movement for vertical position & oblique printing

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 10 17	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation 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 09 16	<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: <input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-issu IRF	Remarks: <b>QUALITY ASSURANCE DEPARTMENT</b> <b>CLOSED</b> Date: 21 09 16	Approved by: QA Supervisor: [Signature] Date: 21 09 16	QA Asst. Manager: [Signature] Date: 21 09 16	Process Owner Acknowledgment: (Receiving Section) Line Leader: [Signature] Date: 21 09 16	Department Head: [Signature] Date: 21 09 16
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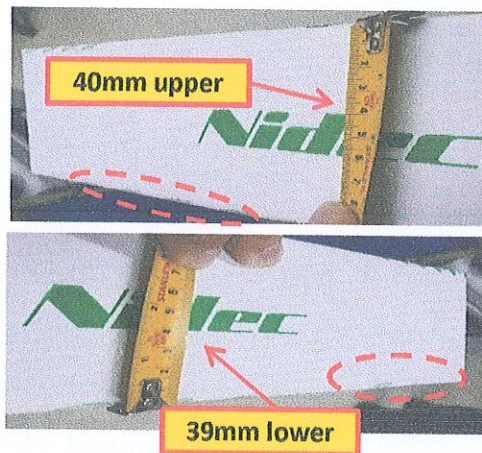
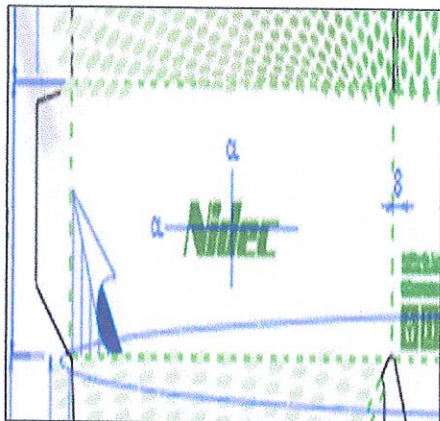
DATE AND SIGNATURE

[Signature] 21 09 16



## INVESTIGATION REPORT FOR MISALIGN PRINT OF NIDEC SUBIC L00086478 FLEXWAVE C BOX

<b>DIRECT CAUSE</b> PROCESS/MATERIAL	<b>W1-</b> Item under adjustment stage because this is IPD and from Diecut S1700 during sample making, this item transfer in Eterna why the Eqos operator take an hour to setup the layout of this item.
	<b>W2-</b> We found discrepancy in Drawing vs. Cyrel even the Nidec logo is within center line requirement, but there is excess 5mm print in lower flap.



**DISCREPANCY IN DRAWING vs. CYREL THE NIDEC LOGO IS ALMOST CENTER LINE BUT THERE IS EXCESS 5mm PRINT IN LOWER FLAP**

<b>INDIRECT CAUSE</b> PROCESS/MATERIAL	<b>W1-</b> Operator proceed to mass production.
	<b>W2-</b> Trial run approved by QA.
	<b>W3-</b> Eqos operator didn't notice the misalign print because the items are not yet die-cutted.

### CORRECTIVE ACTION

Coordinate this problem in Sales in-charge according the problem in discrepancy between Drawing vs. Cyrel.			
<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>200811</b>
Put pokayoke mark as alignment reference for print in both mylar of Black & Green cyrel.			
<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>Next running</b>

PREPARED BY:

**GERALD DE GUZMAN**  
PROD ASST. SUPERVISOR

APPROVED BY:

**WEENA V. APALLA**  
SR. SUPERVISOR