KAN	SEDACKAGE DUTI TOOT	TNC	INIVESTICA	ATION DEDOOT	CODM (ID)	
No. 5 Rir	NEPACKAGE PHILIPPI ng Road LISP II, Brgy. La Mesa, Calamba City, Lagu	INVESTIGATION REPORT FORM (IRI				
	ne No. (049) 545-7166 to 69 (049) 545-6302					
	464 .		Control No.: 327	Date Issued:	20 11 17	
Customer	NIDEC SUBIC		Attention To Mr. Gerald De Guzman			
em Code	VR-B RYZX000001		Department PRODUCTION			
em Description	PAD B		Date of Detection 20 11 16			
ob Order Number	WO-SO-IPD-1486-17		Section Detected QA - SCREENING			
	ILLUSTRATION OF THE PROBLEM		Major	Minor	***	
			Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentag	
Processor of the last of the l			2030	64	3.15%	
			Nature of Defect:			
Franks				BURSTING		
			Requirement:			
			No bursting on the surface of the item			
			Actual:			
				W/ bursting on the rough surface	9	
NO. OF OCCUI	RRENCE DISPOSIT	ΠΟΝ	AREA OF OCC	URRENCE / ORIGIN	CONTENT	
First	Hold		Slotter	[]		
Recurrence				Gluing	Material	
	Special Acceptai	nce	EQOS	Gluing Vertical	Material Dimension	
No.:	Special Acceptal For Rework	nce	_			
No.:			EQOS	Vertical	Dimension Appearance	
	For Rework Reject / Disposa	l	EQOS Diecut	Vertical Others:	Dimension Appearance	
Date:	For Rework Reject / Disposa Checked Ms. Noemi C	l by epeda	EQOS Diecut Detaching	Vertical Others: y final discontinuous ario Others: Mr Others	Dimension Appearance Process / Meti Received by (Receiving Section)	
Date:lssued b	For Rework Reject / Disposa Checked Ms. Noemi C QA Superv	I by sepeda visor)	Detaching Approved b Approved b Mr. Revel Alma QA Asst. Mana	Vertical Others: Mr General Mr G	Dimension Appearance Process / Meti Received by (Receiving Section) Profit of the Common Section of the C	
Date:	For Rework Reject / Disposa Checked Ms. Noemi C	l by Sepeda visor) I. INVESTIGATION (Appened?)	Detaching Approved b Approved b Mr. Rexet Alma QA Asst. Mana	Vertical Others: y final discontinuous ario Others: Mr Others	Dimension Appearance Process / Meti Received by (Receiving Section) Profit of the Common Section of the C	
Date:	For Rework Reject / Disposa Checked Ms. Noemi C QA Superv	I by epeda visor I. INVESTIGATIO	Detaching Approved b Approved b Mr. Revel Alma QA Asst. Mana NI ANALYSIS INDIRECT CAUSE:	Vertical Others: Mr General Mr G	Dimension Appearance Process / Met Received by (Receiving Section) Profit De Guzman ad/ Supervisor	
Date:	For Rework Reject / Disposa Which is the reason of occurrence, why it has	I by epeda visor I. INVESTIGATIO	Detaching Approved b Approved b Mr. Rexet Alma QA Asst. Mana	Vertical Others: Mr Collager Het (Analyze the reason of occurren	Dimension Appearance Process / Met Received by (Receiving Section) Profit De Guzman ad/ Supervisor	
Date:	For Rework Reject / Disposa Checked Ms. Noemi C QA Superv	l by Sepeda visor) I. INVESTIGATION Appened?)	Detaching Approved b Approved b Mr. Rexet Alma QA Asst. Mana N/ANALYSIS INDIRECT CAUSE: Why 1: Why 2: Why 3:	Vertical Others: Mr General Mr G	Dimension Appearance Process / Met Received by (Receiving Section) Profit De Guzman ad/ Supervisor	
Date:Issued b Adrian Verg QA-IE Sta DIRECT CAUSE: Why 1: Why 2: Why 3: Why 4:	For Rework Reject / Disposa Which is the reason of occurrence, why it has	I by Sepeda visor I. INVESTIGATIO	Detaching Approved b Approved b Mr. Revel Alma QA Asst. Mana N / ANALYSIS INDIRECT CAUSE Why 1: Why 2: Why 3: Why 4:	Vertical Others: Mr Collager Het (Analyze the reason of occurren	Dimension Appearance Process / Met Received by (Receiving Section) Profit De Guzman ad/ Supervisor	
Date:	For Rework Reject / Disposa Which is the reason of occurrence, why it has	I by Sepeda visor I. INVESTIGATIO	Detaching Approved b Approved b Mr. Rexet Alma QA Asst. Mana N/ANALYSIS INDIRECT CAUSE: Why 1: Why 2: Why 3:	Vertical Others: Mr Collager Het (Analyze the reason of occurren	Dimension Appearance Process / Met Received by (Receiving Section) Praid De Guzman ad/ Supervisor	
Date: Issued b Adrian Verg QA-IE Sta DIRECT CAUSE: Why 1: Why 2: Why 3: Why 4: Why 5: Why 1:	For Rework Reject / Disposa Which is the reason of occurrence, why it has	Tepeda visor I. INVESTIGATIO appened?)	Detaching Approved b Approved b Mr. Revel Alma QA Asst. Mana N / ANALYSIS INDIRECT CAUSE Why 1: Why 2: Why 3: Why 4:	Vertical Others: Mr Collager Het (Analyze the reason of occurren	Dimension Appearance Process / Met Received by (Receiving Section) Profit De Guzman ad/ Supervisor	
Date: Issued b Adrian Verg QA-IE Sta DIRECT CAUSE: Why 1: Why 2: Why 3: Why 4: Why 5: Why 1:	For Rework Reject / Disposa When the Company of th	l by cepeda visor) ! INVESTIGATIOnappened?)	Detaching Approved b Approved b Mr. Revel Alma QA Asst. Mana NI / ANALYSIS INDIRECT CAUSE: Why 1: Why 2: Why 3: Why 4: Why 5:	Vertical Others: Wr General Mr G	Dimension Appearance Process / Met Received by (Receiving Section) Profit De Guzman ad/ Supervisor	
Date: Issued b Adrian Verg QA-IE Sta DIRECT CAUSE: Why 1: Why 2: Why 3: Why 4: Why 5: Why 1:	For Rework Reject / Disposa Which is the reason of occurrence, why it has	I by Sepeda visor II INVESTIGATION II IN	Detaching Approved b Approved b Mr. Rexet Alma QA Asst. Mana NI / ANALYSIS INDIRECT CAUSE: Why 1: Why 2: Why 3: Why 4: Why 5: Why 1:	Vertical Others: Mr Collager Het (Analyze the reason of occurren	Dimension Appearance Process / Met Received by (Receiving Section) Profit De Guzman ad/ Supervisor	
Date: Issued b Adrian Verg QA-IE Sta DIRECT CAUSE: Why 1: Why 2: Why 3: Why 4: Why 5: Why 1:	For Rework Reject / Disposa When the Company of th	Tepeda visor I. INVESTIGATIO appened?)	Detaching Approved b Approved b Mr. Revel Alma QA Asst. Mana N/ ANALYSIS INDIRECT CAUSE Why 1: Why 2: Why 4: Why 5: Why 1: Why 2:	Vertical Others: Wr General Mr G	Dimension Appearance Process / Met Received by (Receiving Section) Profit De Guzman ad/ Supervisor	
Date:	For Rework Reject / Disposa When the Company of th	I by Sepeda visor I. INVESTIGATIO Appened?)	Detaching Approved b Approved b Mr. Revel Alma QA Asst. Mana IN / ANALYSIS INDIRECT CAUSE: Why 1: Why 2: Why 4: Why 5: Why 1: Vhy 2: Vhy 3:	Vertical Others: Wr General Mr G	Dimension Appearance Process / Meti Received by (Receiving Section) Profit of the Common Section of the C	
Date:	For Rework Reject / Disposa When the Company of th	I by Sepeda visor II INVESTIGATION II IN	Detaching Approved b Approved b Mr. Rexet Alma QA Asst. Mana NI / ANALYSIS INDIRECT CAUSE: Why 1: Why 2: Why 3: Why 4: Why 5: Vhy 1: Vhy 2: Vhy 3:	Vertical Others: Wr General Mr G	Dimension Appearance Process / Methodology (Received by (Receiving Section) Profile of the control of the c	
Date:	For Rework Reject / Disposa Whise Note in Country (Analyze the reason of occurrence, why it has PA	l by Sepeda visor) I. INVESTIGATION (V)	Diecut Detaching Approved b Mr. Revel Alma QA Asst. Mana N/ ANALYSIS INDIRECT CAUSE: Why 1: Why 2: Why 4: Why 5: Vhy 4: Vhy 4: Vhy 5: Why 4: Vhy 5:	Vertical Others: Wr Conger Mr Conger Here (Analyze the reason of occurrent	Dimension Appearance Process / Methodology (Received by (Receiving Section) Profile of the control of the c	
Date:	For Rework Reject / Disposa Whise Note in Country (Analyze the reason of occurrence, why it has PA	I by Sepeda visor I. INVESTIGATION VI	Diecut Detaching Approved b Mr. Revel Alma QA Asst. Mana N/ ANALYSIS INDIRECT CAUSE: Why 1: Why 2: Why 4: Why 5: Vhy 4: Vhy 4: Vhy 5: Why 4: Vhy 5:	Vertical Others: Wr Conger Mr Conger Here (Analyze the reason of occurrent	Dimension Appearance Process / Metr Received by (Receiving Section) 201/17 Erafd De Gurman ad/ Supervisor	
Date:	For Rework Reject / Disposa When the Company of th	I by Sepeda visor II INVESTIGATION VI	Diecut Detaching Approved b Mr. Revel Alma QA Asst. Mana N/ ANALYSIS INDIRECT CAUSE: Why 1: Why 2: Why 4: Why 5: Vhy 4: Vhy 4: Vhy 5: Why 4: Vhy 5:	Vertical Others: Wr General Mr G	Dimension Appearance Process / Metr Received by (Receiving Section) 201/17 Erafd De Gurman ad/ Supervisor	

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)

				FINAL COM	ICLUSION			
	OCCURRE	NCE ROOTCAUSE			OUTFLOW ROOTCAUSE			
-Bnn	TLE on we	TAK KRA;	T U	NER	-nava	omly occurrence	Marie Constant And Taylor	
IMMEDIA	TE ACTION: (Action to be do	one to contain/ temporary	correct the p	roblem found)	CORRECTIVE	ACTION: (Actions to be done to ensure that the problem will no	t hannon again)	
A. Sorting Resu	lt en					tions to be done to eliminate recurrence	Who / When	
	Location	Total Stock	NG	Total Good			vviio / vviien	
RM	N/A				System			
WIP	N/A					N/A		
FG	N/A							
B. Orientation			3.17					
Date	N/A	Time	NIG	}	Design /	1./		
Title		N/A			Tools	MA		
es		N/A						
C. Reworking		- 1						
Rework Quantity N/A								
Total Good N/A					Process	PLS. SEE ATTACKED		
Rework Percer	The state of the s							
II. QA RO	OTCAUSE VERIFICATION		by QA In-	charge)	Date Conducted:_	20 11 18 PIC: A. Vergara	L	
		d Rootcause			Recommendation			
Brittle Tight im boards s	materials Pression of di ince the ejecti	iecut blade or used is gr	to curi ay spi	rogated onge				
		III. CORRECT	IVE ACTIO	ON VERIFICATION	N (To be filled ou	it by QA In-charge)		

	Checked by	Date	Implemented?	Remarks		
1st Verification of Action	A vergora	201120	[∕]Yes []No	C.A. is implemented		
2nd Verification of Action			[]Yes []No			
3rd Verification of Action			[]Yes []No			
Effectiveness of Action	A. Vergara	21 09 14	[/]Yes []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.

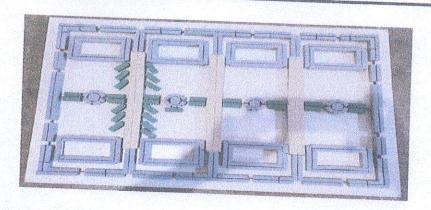
					IV. CL	OSURE		
QUALITY ASSURANCE DEPARTA			Approved by:		Process Owner Acknowledgment: (Receiving Section)			
Still (ben		S		QA U	pervisor	QA Assi Managar	III. MEER Line Leader	Department Heat
				Date	09 15	Date: 11 09 15	Date: 21 09 15	Date: 27 09 15
DATE AND SIGNATUR	/ /	mn	11	0915		9		

INVESTIGATION REPORT FOR BURSTING OF NIDEC SUBIC VR-B RYZX000001 PAD B

DIRECT CAUSE PROCESS/MATERIAL W1- Blade layout is within standard using gray sponge.

W2- Possible the brittle or weak Kraft Liner is the cause of bursting.

W3 - Brittle or weak Kraft liner specially if CB-flute materials is prone in bursting.



INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL

W1- Diecut operator proceed to mass production because trial run approved by ME.

W2- Operator do some remedy if they encounter bursting.

W3- Operator did not trap the bursting during sampling because possible its occurs randomly.

PRODUCTION CORRECTIVE ACTION

Re-layout the die-blade using 13-15mm Eperan cushion, as one of the countermeasure in bursting.

PIC:

PRODUCTION

TARGET DATE:

201120

PREPARED BY:

GRALO DE GUZMAN PROD ASST. SUPERVISOR

APPROVED BY:

WEENALY APALLA SR. SUPERVISOR

PINOS