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

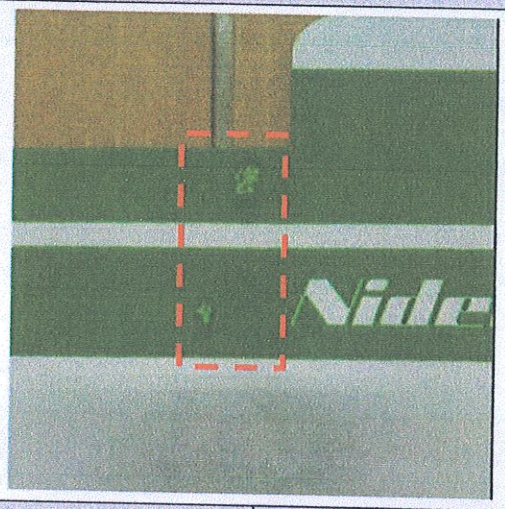
INVESTIGATION REPORT FORM (IRF)

■ Inhouse Detection ☐ Customer Claim

Control No.: 328 Date Issued: 20 11 17

Customer	SUBIC NIDEC
Item Code	VR-B RYZX000001
Item Description	BOX
Job Order Number	WO-SO-IPD-1436-1
Attention To	Mr Gerald De Guzman
Department	PRODUCTION
Date of Detection	20 11 16
Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM



☐ Major ■ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
4000	250	6.25%

Nature of Defect:

SPOT

Requirement:

No spot on the solid image

Actual:

W/ spot on the solid image

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
■ First	☐ Hold	☐ Slotter ☐ Gluing	☐ Material
☐ Recurrence	☐ Special Acceptance	■ EQOS ☐ Vertical	☐ Dimension
No.:_____	☐ For Rework	☐ Diecut ☐ Others:	■ Appearance
Date:_____	■ Reject / Disposal	☐ Detaching _____	☐ 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: 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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FINAL CONCLUSION

OCCURRENCE ROOTCAUSE	OUTFLOW ROOTCAUSE
- CRACK IN WHITE KRAFT STUCK IN THE CYPEL DURING MASS PRODUCTION	- RANDOMLY OCCURRENCE

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

A. Sorting Result

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	N/A			

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Attendees	N/A		

C. Reworking

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

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

	Actions to be done to eliminate recurrence	Who / When
System	N/A	
Design / Tools	N/A	
Process	PLS. SEE ATTACHED	

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

Date Conducted: 20 11 18 PIC: A. Vergara

Identified Rootcause	Recommendation
There was a material fiber stuck on the rubber plate because there was a cracking on the edge of the materials.	From common sheets to exact sheet

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 01	[✓] Yes [ ] No	Material used is exact sheets
2nd Verification of Action			[ ] Yes [ ] No	
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action	A. Vergara	21 05 11	[✓] Yes [ ] No	Recommendation is effective

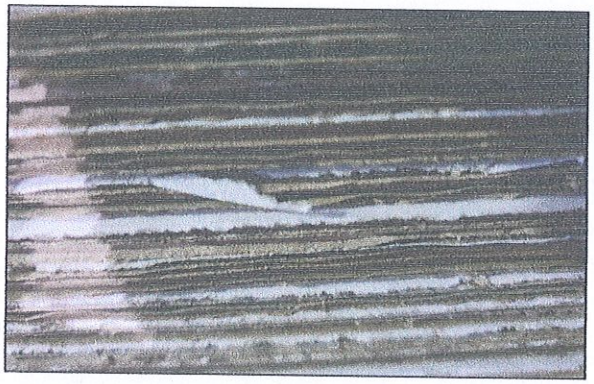
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improvement action.

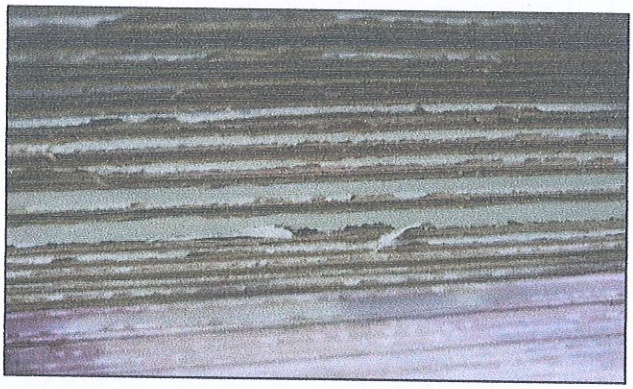
IV. CLOSURE

Status	Remarks	Approved by:		Process Owner Acknowledgment: (Receiving Section)	
[✓] Closed	QUALITY ASSURANCE DEPARTMENT CLOSED				
[ ] Still Open		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
[ ] Re-Issue IRF	DATE AND SIGNATURE 22 01 18	Date: 22 01 18	Date: 22 01 18	Date: 22 01 18	Date: 22/01/18

INVESTIGATION REPORT FOR SPOT OF NIDEC SUBIC VR-B RYZX000001 BOX

DIRECT CAUSE PROCESS/MATERIAL	**W1**- This item underwent Slotter process before the printing process in Eqos.
	W2- We notice that the white kraft is brittle and due to cutting mechanism of Slotter there are cracking happen in the white kraft
	W3- The crack in white kraft stuck in the cyrel during mass production because the occurrence is in one portion only.





INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	**W1**- Eqos immediate stop and clean the cyrel once they encountered spot.
	W2- Possible the operator did not notice the outflow because it was happen randomly.

PRODUCTION SUGGESTION CORRECTIVE ACTION

Transfer of slotter process in Slotter Mexico in Superflex, because the cutting mechanism of Slotter Mexico is smooth like in vertical machine even the board is brittle.

Also will push exact sheet - will generate comma sheets for all White Kraft. for Next PO.

PIC:	SALES / MPD	TARGET DATE:	Within November

PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR
20/11/18

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR
20/11/19