

**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.: 330

Date Issued: 20 11 23

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00459572-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	20 11 19
Job Order Number	WO-DRS-20-M-01556-23	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1,000	136	13.60%

Nature of Defect:

POOR PRINT (NG REWORK)

Requirement:

No poor print and rework should not be visible

Actual:

Retouched ink was visible

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	 Ms. Naomi 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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INVESTIGATION REPORT FORM (IRF)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE****OUTFLOW ROOTCAUSE**

ROUGH TEXTURE OF MATERIALS
SURFACE

REWORKABLE & RANDOMLY OCCURRENCE

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

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

System		Who / When
	N/A	

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Issues	N/A		

Design / Tools		Who / When
	N/A	

C. Reworking

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

Process		Who / When
	PLS. SEE ATTACHED	

II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)Date Conducted: 20 11 24PIC: A. Vergara**Identified Rootcause****Recommendation**

The surface of the material is rough


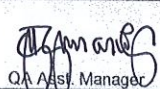
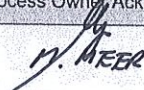

Replace the flexoplate to combination of soft & hard plate

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 08 03	[X] Yes [] No	Recommendation is implemented
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	21 09 04	[X] Yes [] No	Recommendation is effective

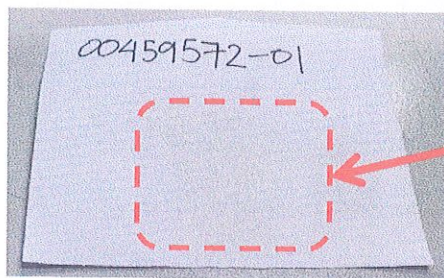
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department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

IV. CLOSURE

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	CLOSED	<input type="checkbox"/> Still open	 QA Supervisor	 QA Asst. Manager	 Line Leader
<input type="checkbox"/> Re-Isue IR		Date: <u>21 09 06</u>	Date: <u>21 09 06</u>	Date: <u>21 09 06</u>	Date: <u>21 09 06</u>
DATE AND SIGNATURE 					

INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 00459572-01 PACKAGE

DIRECT CAUSE PROCESS/MATERIAL	W1- Factor we consider for this poor print is the texture of materials, but we cant 100% sure.
	W2- We found that the surface of materials is rough and there's a lot of fibers.
	W3- Also we found scuffing when you rub the solid print portion.




**PRODUCTION
MANUAL RUB TEST
USING WHITE BOND
PAPER**

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- They proceed to mass production because the trial run was approved by QA Patrol.
	W2- If Eqos operator notice Poor print they make adjustment in setup, but if is reworkable and occurrence is random so they stick on the existing setup.


PRODUCTION CORRECTIVE ACTION

Will closely monitor this item next running with asking help to ME and QA, to find concrete possible root cause and to give definite countermeasure.			
PIC:	PRODUCTION	TARGET DATE:	1ST WEEK OF DECEMBER

PREPARED BY:


GERARDO DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

 7 201123
WEENA V. APALLA
SR. SUPERVISOR