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# 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.: 333

Date Issued: 20 11 24

Customer: NIDEC SUBIC  
Item Code: VR-D RYZXD000003  
Item Description: BOX  
Job Order Number: WO-SO-IPD-1486-7

Attention To: Mr. Gerald De Guzman  
Department: PRODUCTION  
Date of Detection: 20 11 23  
Section Detected: QA - SCREENING

### ILLUSTRATION OF THE PROBLEM


☐ Major

☒ Minor

Lot Quantity (pcs.): 1500

Reject Quantity (pcs.): 153

Reject Percentage: 10.20%

Nature of Defect:

MISALIGN PRINT

Requirement:

Print tolerance is +/-5mm

Actual:

Printing movement is 6 ~ 7mm

### NO. OF OCCURRENCE

☒ First  
☐ Recurrence

No.: \_\_\_\_\_

Date: \_\_\_\_\_

### DISPOSITION

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

### AREA OF OCCURRENCE / ORIGIN

☐ Slotter ☐ Gluing  
☒ EQOS ☐ Vertical  
☒ Diecut ☐ Others: \_\_\_\_\_  
☐ Detaching

### CONTENT

☐ Material  
☒ Dimension  
☒ Appearance  
☐ Process / Method

Issued by

Checked by

Approved by

Received by  
(Receiving Section)

Adrian Vergara  
QA-IE Staff

Ms. Noemi Cepeda  
QA Supervisor

Mr. Rexel Almaric  
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:  
Why 4:  
Why 5:

N/A

Design / Toolings

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:

N/A

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

N/A

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**

- WARP MATERIALS

**OUTFLOW ROOTCAUSE**

- 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**

	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 11 26	Time	1:30 - 1:35 P.M.
Title	ORIENTATION REGARDING MISALIGN PRINT / DIE CUT OF NIDEC SUBIC VR-D RYZXPODD03 BOX		
Attendees	S1700 OPERATORS		

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 11 25

PIC: A. Vergara

**Identified Rootcause****Recommendation**

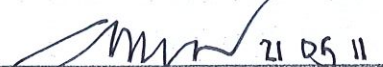
The diecut is offset by 6-7mm because the material is warp.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 11 26	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. 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 05 11	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> 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. CLOSURE**

Status: <input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-issue IRF	Remarks: <b>CLOSED</b>	Approved by:  QA Supervisor Date: 21 05 11	Process Owner Acknowledgment: (Receiving Section)  Line Leader Date: 21 05 11	Department Head Date: 21 05 11
DATE AND SIGNATURE:  21 05 11				



# INVESTIGATION REPORT FOR MISALIGN PRINT/DIECUT OF NIDEC SUBIC VR-D RYZXD000003 BOX

<b>DIRECT CAUSE</b> PROCESS/MATERIAL	W1- Based on investigation during Diecut S1700 process, operator encountered random of warp materials.
	W2- The standard setup of Diecut side guide is actual sheet size +3mm, but if the materials is warp the +3mm tolerance was loosed.
	W3- Possible the warp materials move lateral upon Diecut process that caused misalign.


<b>INDIRECT CAUSE</b> <b>(OUTFLOW)</b> PROCESS/MATERIAL	W1- They proceed to mass production because the trial run was approved by QA Patrol.
	W2- The warp materials is randomly mix in the materials they process.
	W3- Operator did not trap the misalign during sampling due to randomly occurrence.

## PRODUCTION CORRECTIVE ACTION

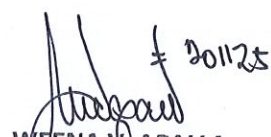
Orient the Diecut operator to separate the affected item once they encounter random of warp materials, because the warp materials need different side guide setup or materials recondition.

<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>201126</b>
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PREPARED BY:

  
**GERALD DE GUZMAN**  
PROD ASST. SUPERVISOR

APPROVED BY:

  
**WEENA V. APALLA**  
SR. SUPERVISOR





KANE PACKAGE PHILIPPINE INC.

## MINUTES OF THE MEETING

Date: 20/1/26 Time Start: 1330H Time Finished: 1335H Venue: DIECUT AREA

## ATTENDEES:

Name	Section	Sign	Name	Section	Sign
DARWIN WANGABAT	S1700				
ENI TOURNINO	S1700				
FRANCO CAND	S-1700				
CARLO CALVARIO	S-1700				

## AGENDA:

ORIENTATION REGARDING MISALIGN PRINT/DIECUT OF  
NIDEC SUBIC VR-D RYZXD000003 BOX

## MINUTES:

page 1 of 1

## ROOTCAUSE:

- Based on Investigation during Diecut S1700 process, operator encountered random of warp materials.
- The standard setup of Diecut side guide is actual sheet size +3mm; but if the materials is warp the +3mm tolerance was loosed.
- Possible the warp materials move lateral upon Diecut process that caused misalign.

## CORRECTIVE ACTION:

- > Once encounter random of warp materials, separate the affected materials.
- > Adjust the side guide with +3mm tolerance base on materials warpage.
- > If the adjustment of side guide is not affected because still there is occurrence of misalign, the next countermeasure is to recondition the affected materials.

\* For the Sanyo Denki 01039400-01 Storage Pad, any occurrence of bursting even it not visible if the item is already assemble the judgement is reject because we deliver the collapse.

## FOLLOW UP MEETING:

(date &amp; time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:

GERALD DE GUZMAN