

**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.: 336

Date Issued: 20 11 27

Customer: TERADYNE

Item Code: PRO2302G

Item Description: BOX

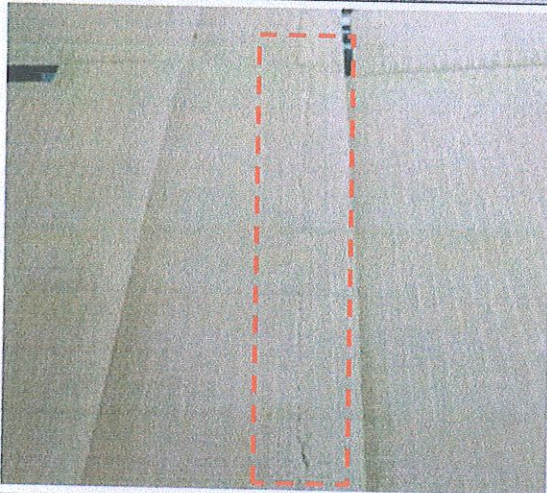
Job Order Number: WO-20-C-0258-3

Attention To: Mr. Gerald De Guzman

Department: PRODUCTION

Date of Detection: 20 11 25

Section Detected: QA - SCREENING

**ILLUSTRATION OF THE PROBLEM**☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

1000

139

13.90%

Nature of Defect:

BURSTING

Requirement:

No bursting on the item

Actual:

Bursting length is 520mm and located inside the item

**NO. OF OCCURRENCE****DISPOSITION****AREA OF OCCURRENCE / ORIGIN****CONTENT**☒ First  
☐ Recurrence

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

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

☐ Hold  
☐ Special Acceptance  
☐ For Rework  
☒ Reject / Disposal☐ Slotter  
☐ EQOS  
☒ Diecut  
☐ Detaching☐ Gluing  
☐ Vertical  
☐ Others: \_\_\_\_\_☐ Material  
☐ Dimension  
☒ Appearance  
☐ Process / Method

Issued by

Checked by

Approved by

Received by  
(Receiving Section)Adrian Vergara  
QA-IE StaffMs. Noemi Cepeda  
QA SupervisorMr. Rexel Almario  
QA Asst. ManagerMr. 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

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

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:

PLS. SEE ATTACHED



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**INVESTIGATION REPORT FORM (IRF)****FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

- COMPRESSED EPERAN CUSHION.
- BRITTLE 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	N/A	Time	N/A
Title	N/A		
Issues	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 12 01

PIC: A. Vergara

Identified Rootcause

Recommendation

Tight impression on the corrugated boards because the cushion that was attached gets thin

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 12 04	[X] Yes [ ] No	C.A. is implemented
2nd Verification of Action			[ ] Yes [ ] No	
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action	A. Vergara	21 10 12	[X] Yes [ ] No	C.A. is implemented

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.

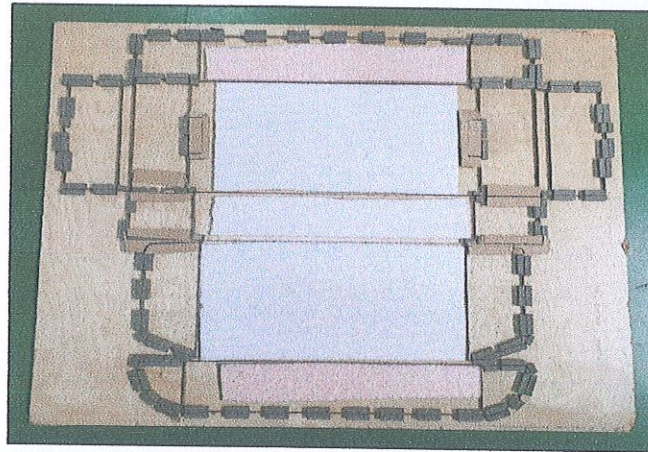
**IV. CLOSURE**

<b>QUALITY ASSURANCE DEPARTMENT</b>		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	<b>CLOSED</b>	QA Supervisor	QA Ass. Manager	Line Leader	Department Head
<input type="checkbox"/> Still Open		Date: 21 10 13	Date: 21 10 13	Date: 21 10 13	Date: 21 10 13
<input type="checkbox"/> Re-Issue IRF					
DATE AND SIGNATURE					



# INVESTIGATION REPORT FOR BURSTING OF TERADYNE PRO2302G BOX

<b>DIRECT CAUSE</b> PROCESS/MATERIAL	W1- Die-blade already have Eperan cushion for the counter measure to bursting problem.
	W2- One of the factor to be consider is the compressed Eperan cushion due to machine compression, because upon verification the thickness of Eperan cushion in die-blade is 10mm and only 2mm higher than the 8mm cutting blade.
	W1 - Another factor to be consider is the brittle materials, because the items is existing and this is the first time we encountered outflow of bursting for this item.




<b>INDIRECT CAUSE</b> (OUTFLOW) PROCESS/MATERIAL	W1- Obviously in die-blade layout that the operator did some remedy to avoid bursting.
	W2- Operator did not trap the bursting during sampling because possible its occurs randomly.

## PRODUCTION CORRECTIVE ACTION

- Replacement of Eperan cushion from 12mm to 14-15mm thickness.
- Monitor next running the effectiveness of 14-15mm thickness Eperan.

<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>201127</b>
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PREPARED BY:

  
**GERALD DE GUZMAN**  
 PROD ASST. SUPERVISOR

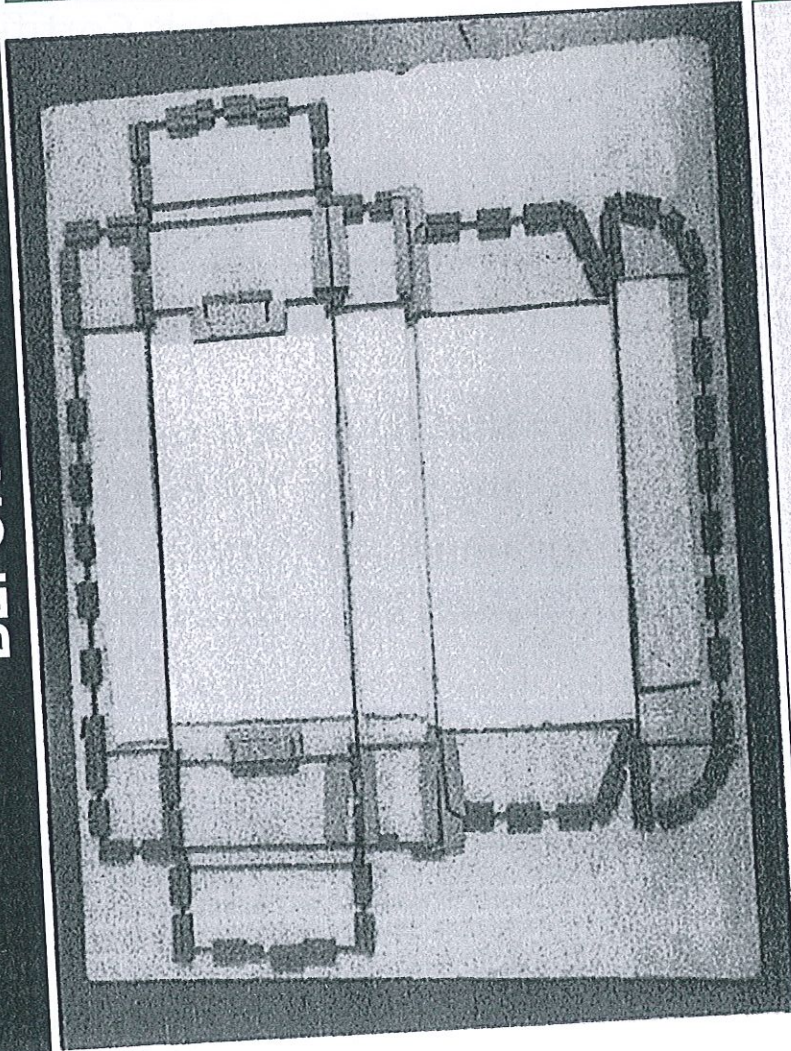
APPROVED BY:

  
**WEENA V. APALLA**  
 SR. SUPERVISOR



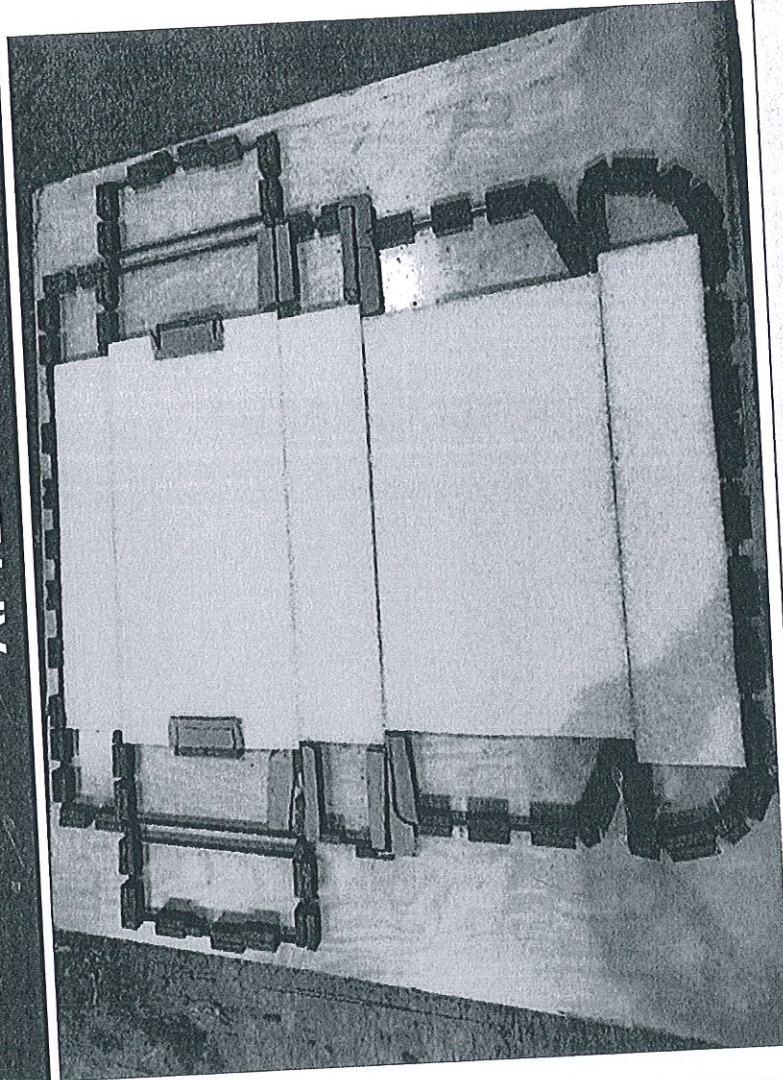
# UPDATES:

**BEFORE**



Thickness is  $\leq 10\text{mm}$

**AFTER**



Thickness is 13 to 15mm