

**KANEPACKAGE PHILIPPINE INC.**

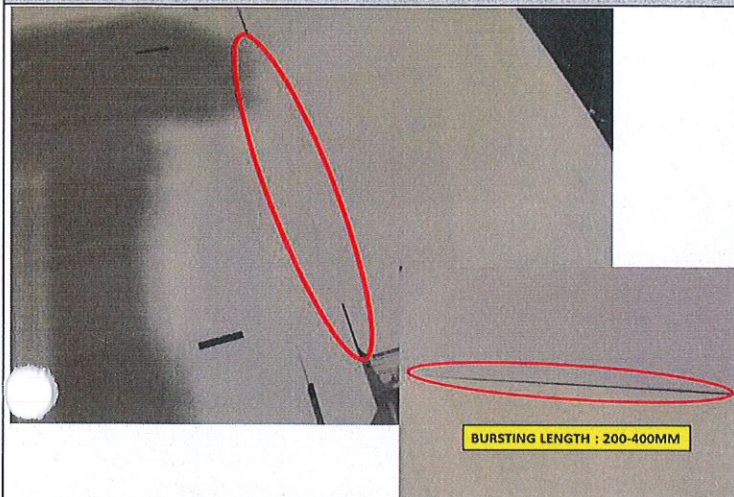
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 354

Date Issued: 20 12 17

Customer	TERADYNE	Attention To	Ms. Weena Apalla
Item Code	N / A	Department	PRODUCTION
Item Description	ASSEMBLY BOX	Date of Detection	20 12 16
Job Order Number	WO-20-C-0278-1	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major ☒ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
107	107	100.00%

Nature of Defect:

BURSTING

Requirement:

Bursting is good as long as it is visible and 50mm length only

Actual:

Bursting length range is 200mm ~ 400mm

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 checked="" type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input type="checkbox"/> Gluing <input type="checkbox"/> EQOS <input type="checkbox"/> Vertical <input checked="" type="checkbox"/> Diecut <input type="checkbox"/> Others: _____ <input type="checkbox"/> Detaching	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by Ms. Noemi Cepeda QA Supervisor	Approved by Mr. Rexel Almario QA Asst. Manager	Received by (Receiving Section) Ms. Weena Apalla 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: N/A Why 2: N/A Why 3: N/A Why 4: N/A Why 5: N/A	Why 1: N/A Why 2: N/A Why 3: N/A Why 4: N/A Why 5: N/A
Design / Toolings	Why 1: SEE ATTACHED Why 2: SEE ATTACHED Why 3: SEE ATTACHED Why 4: SEE ATTACHED Why 5: SEE ATTACHED	Why 1: N/A Why 2: N/A Why 3: N/A Why 4: N/A Why 5: N/A
Process / Material	Why 1: N/A Why 2: N/A Why 3: N/A Why 4: N/A Why 5: N/A	Why 1: N/A Why 2: N/A Why 3: SEE ATTACHED Why 4: SEE ATTACHED Why 5: SEE ATTACHED

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

new dieblade + new sponge is
used in unloading

OUTFLOW ROOTCAUSE

checking was not conducted since
there is no bursting before on this
item

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	
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B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Ideas	N/A		

Design / Tools

Design / Tools	N/A	
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C. Reworking

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

Process

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

Date Conducted: 20 12 18

PIC: A. Vergara

Identified Rootcause

Tight impression of creasing rule because the
sponge attached on the wood is not enough to
oppose the force

Recommendation

Grind the creasing rule of the die cut blade

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 21	[] Yes [x] No	C.A. will not pursue
2nd Verification of Action	A. Vergara	20 12 22	[x] Yes [] No	Recommendation is implemented
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	21 11 25	[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	Department Head
<input type="checkbox"/> Re-issue IRF		Date: 21 11 25	Date: 21 11 25	Date: 21 11 25	Date: 21 11 25
DATE AND SIGNATURE					

INVESTIGATION REPORT FOR BURSTING OF TERADYNE ASSEMBLY BOX - RFMG

DIRECT CAUSE PROCESS/MATERIAL	W1- New dieblade was used because the old blade was already worn-out.
	W2 - New sponge was used in layouting of the new blade which is less softer compared to the old sponge.
	W3- 12 mm hard sponge was used in blade layouting for 8 mm cutting blade.



New hard sponge was used in blade layout.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Brittleness of the materials can be considered as a factor for bursting since this is the first time that we encounter bursting for this item.
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PRODUCTION CORRECTIVE ACTION

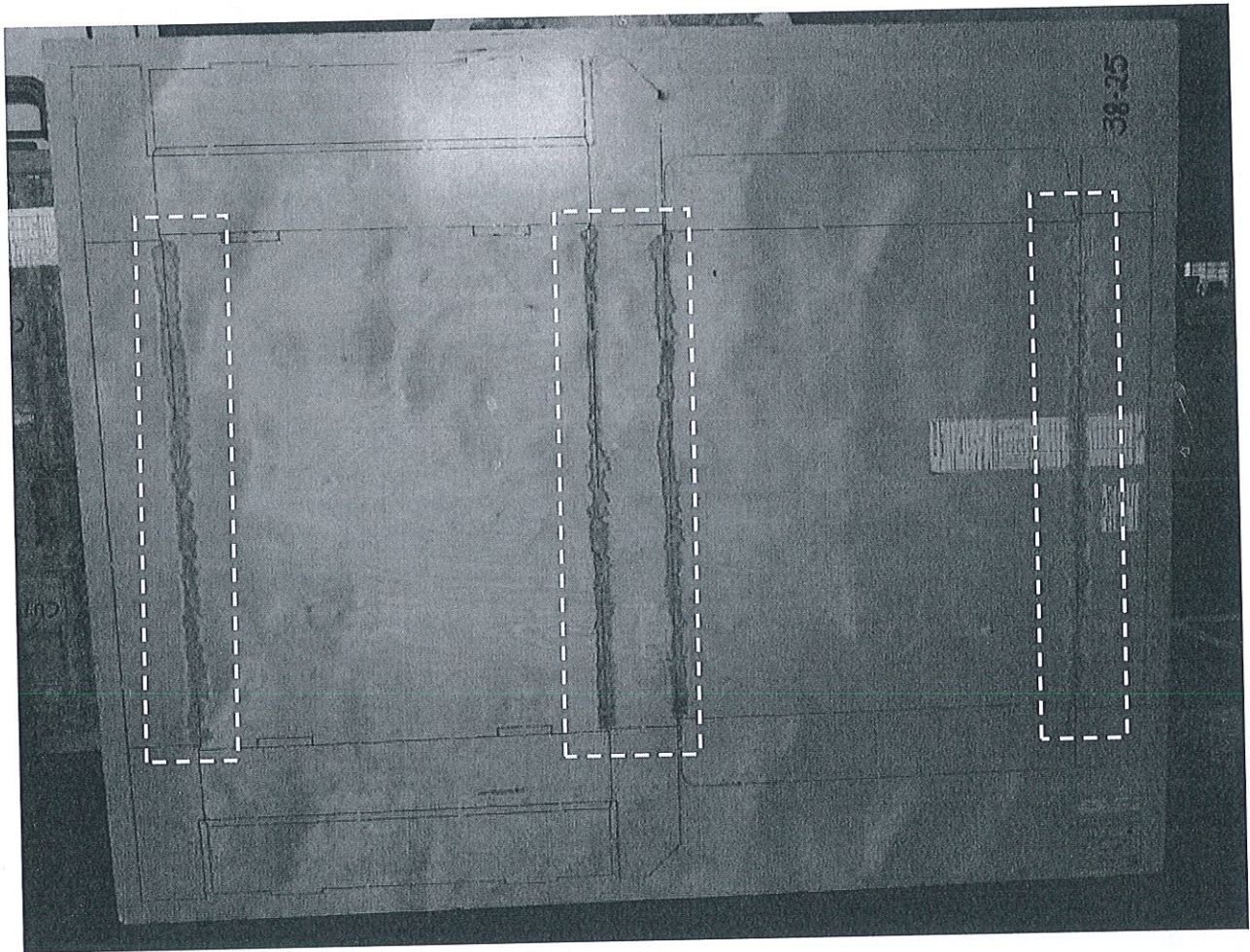
Replace the 12 mm hard sponge cushion with 12 mm Eperan cushion and monitor its effectiveness in the next processing.			
PIC:	TOOLING	TARGET DATE:	DEC. 21, 2020

PREPARED BY:


MELENCIO ABE
PROD. IE

APPROVED BY:


WEENA A. APALLA
SR. SUPERVISOR



The 4 creasing rules of the die cut blade were grinded to prevent occurrence of bursting on the same location.