

2292


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.: 358

Date Issued: 20 12 22

Customer	KOYAMA	Attention To	Ms. Weena Apalla
Item Code	PKC202B-A	Department	PRODUCTION
Item Description	INNER MOTOR BOX	Date of Detection	20 12 21
Job Order Number	WO-20-M-01804-13	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM


<input type="checkbox"/> Major	<input checked="" type="checkbox"/> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
6000	47	0.78%

Nature of Defect:

POOR PRINT

Requirement:

No poor print on the logo

Actual:

W/ poor print

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. Noemi Cepeda QA Supervisor	 Mr. Rexel Almarino QA Asst. Manager	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:		Why 1:	
	Why 2:		Why 2:	N/A
	Why 3:	N/A	Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	See Attached File	Why 3:	See Attached File
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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

- > Ink nip impression changes
- > uncleaned cyrel
- > Low ink viscosity

The occurrence of poor print is random

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		
Attendees	N/A		

Design /
Tools

N/A

C. Reworking

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

Process

See Attached

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

Date Conducted: 20 12 22

PIC: A. Vergara

Identified Rootcause

- > Light impression of cyrel to boards because the Ink Nip is changing during mass production
- > Possible that the affected part was not cleaned

Recommendation**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	<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 04 22	<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

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 04 23	Date: 21 04 23	Date: 21 04 23	Date: 21 04 23
DATE AND SIGNATURE					

INVESTIGATION REPORT FOR POOR PRINT OF KOYAMA PKC202B-A MOTOR INNER BOX

DIRECT CAUSE PROCESS/MATERIAL	W1 - As per operator the Ink nip and Print pull nip in EQOS changes during running which results to random occurrence of poor print.
	W2- As per operator, there is a possibility that they hadn't clean the affected portion.
	W3- Possible that too much water supply in anilox roller results to less than 9 seconds of ink viscosity which causes poor print.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1 - The operator proceeded to mass production since the sample was approved by the QA patrol.
	W2 - The item has 4 outs and theres a possibility that the operator did not notice the affected portion during sampling.
	W3 - The occurrence is random since only 47 or 0.78% out of 6000 lot quantity were affected.

PRODUCTION CORRECTIVE ACTION

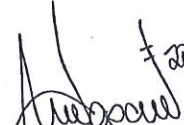
Orient the operators to closely monitor the ink viscosity during running and stop the mass production to clean the cyrel once they encountered printing rejections.

PIC:	PRODUCTION	TARGET DATE:	DEC. 28, 2020
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PREPARED BY:


MELENCIO ABE
PROD. IE

APPROVED BY:


WEENA A. APALLA
SR. SUPERVISOR