

**KANEPACKAGE PHILIPPINE INC.**

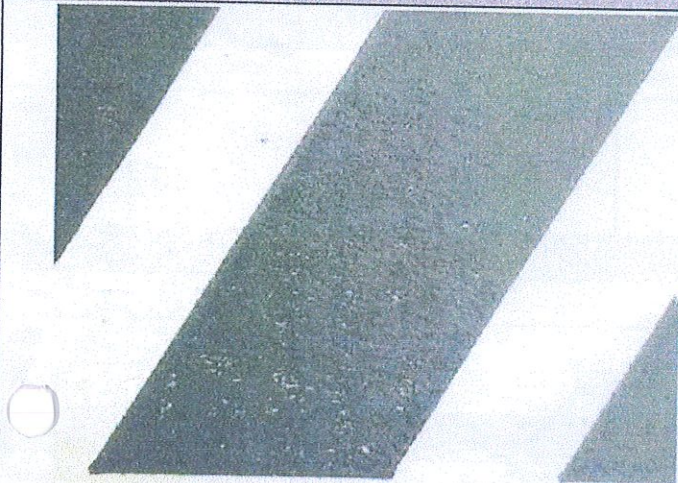
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 367

Date Issued: 21 01 20

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	01033584-01	Department	PRODUCTION
Item Description	BOX PRINT	Date of Detection	21 01 19
Job Order Number	WO-DRS-20-M-01892-136	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

419

38

9.07%

Nature of Defect:

POOR PRINT

Requirement:

No poor print on the solid image

Actual:

W/ poor print on the solid image

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 Adrian Vergara QA-IE Staff	Checked by Ms. Noemi Cepeda QA Supervisor	Approved by Mr. Rexel Almario QA Asst. Manager	Received by (Receiving Section) 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**

- TEXTURE OF MATERIALS.
- NOT SOFT CYREL THE SOLID PRINT CHARACTER

- REMARKABLE AND RANDOM 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

N/A

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Attendees	N/A		

Design / Tools

N/A

C. Working

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: 21 01 22

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The surface of the boards are rough (Innate from UPPE boards)

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

	Checked by	Date	Implemented?		Remarks
1st Verification of Action	A. Vergara	21 02 01	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	change of cyrel is implemented change of material will not pursue
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 08	<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:	Remarks:	Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Still Open		Date: 21 05 10	Date: 21 05 10	Date: 21 05 10	Date: 21 05 10
<input type="checkbox"/> Re-Issue IRF		DATE AND SIGNATURE			

CLOSED

21 05 10

INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 01033584-01 BOX PRINT

DIRECT CAUSE PROCESS/MATERIAL	W1- The possible factor we consider for this poor print is the texture of materials (Supplier is SUNPACK > TX200/CM150*3/TX200)
	W2- We found that the surface of materials is rough and there's a lot of fibers.
	W3- Another possibility is the cyrel (the solid print is not soft cyrel).

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

- Request for soft cyrel for solid print character and existing cyrel for the small character.
- Propose the change materials to NPK

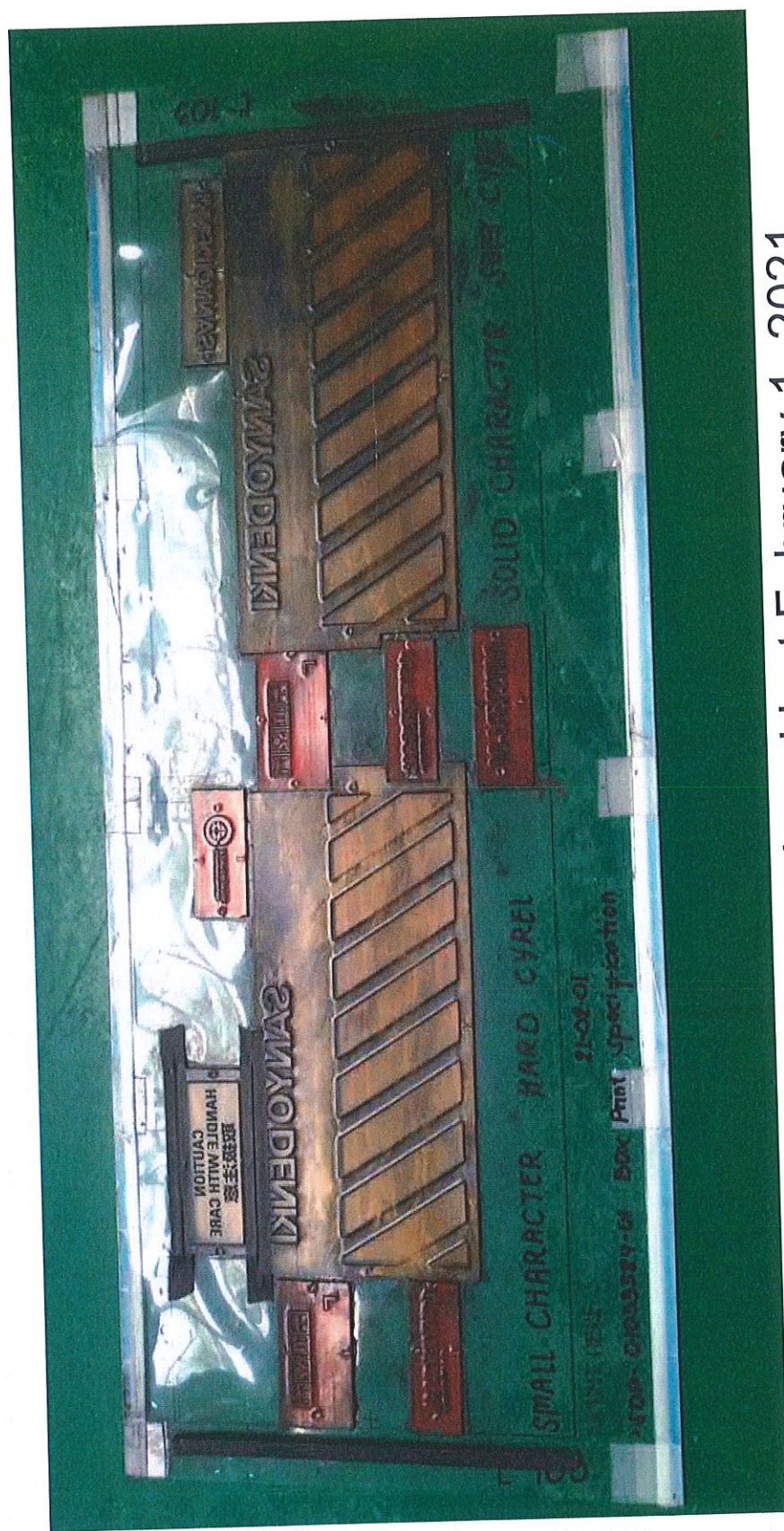
PIC:	PRODUCTION	TARGET DATE:	210123
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PREPARED BY:


GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR



The flexoplate were replaced last February 1, 2021.