

**KANEPACKAGE PHILIPPINE INC.**

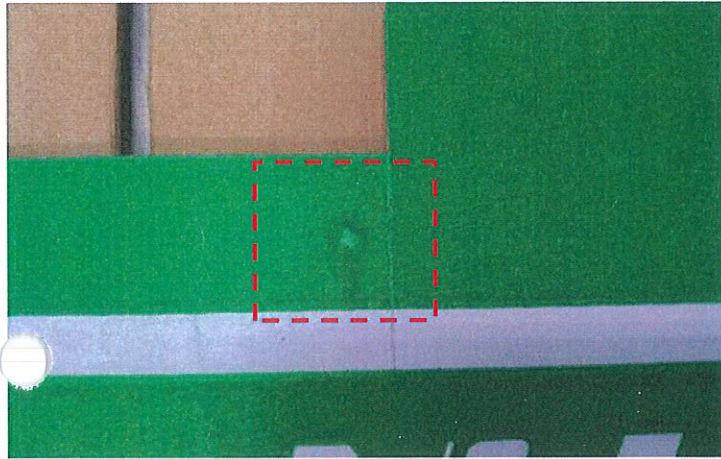
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
Telephone No. (049) 545-7166 to 69  
Fax No. (049) 545-6302

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

Control No.: 383

Date Issued: 21 02 18

Customer	NIDEC SUBIC	Attention To	Mr. Gerald De Guzman
Item Code	VR-E	Department	PRODUCTION
Item Description	BOX	Date of Detection	21 02 17
Job Order Number	JO-21-IPD-00071-3	Section Detected	QA - SCREENING

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

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1,020	52	5.09 %

Nature of Defect:

POOR PRINT (SCUM/SPOT)

Requirement:

Scum is not acceptable

Actual:

W/ scum on the solid image

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 2 Date: 21 02 17	<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 Almaric 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:



**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)****FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

- PRINT MOVE DOWNWARD OF 4mm  
BECAUSE SHEET SIZE IS PHONE TO MOVEMENT  
OR BELOW 500mm.

**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	21 02 19	Time	11:05 ~ 11:15 A.M.
Title	SEE ATTACHED MINUTES OF MEETING		
Idees	EQOS OPERATOR		

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: 21 02 19.

PIC: A. Vergara

**Identified Rootcause****Recommendation**

> there was a fiber stuck on the rubber die  
because there was a cracking on the sheets

**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 19	[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 30	[X] Yes [ ] 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**

<b>QUALITY ASSURANCE DEPARTMENT</b>		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	<b>CLOSED</b>	<input type="checkbox"/> Still Open	QA Supervisor	<input checked="" type="checkbox"/> M. MEER	Department Head
<input type="checkbox"/> Re-issue IRF		Date: 21 10 30	Date: 21 10 30	Date: 21 10 30	Date: 21 10 30
DATE AND SIGNATURE					



# INVESTIGATION REPORT FOR POOR PRINT (SPOT/SCUM) OF NIDEC SUBIC VR-E BOX

<b>DIRECT CAUSE PROCESS/MATERIAL</b>	<b>W1-</b> Due to the movement of Spot/Scum from different location we conclude that the problem is from corrugated fiber or crack white kraft.
	<b>W2-</b> Even we change the material to actual sheet we did not 100% sure that there is no corrugated fiber or crack white kraft in the raw materials.
	<b>W3-</b> The corrugated fiber or crack white kraft stick in the cyrel that caused spot/scum.

<b>INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL</b>	<b>W1-</b> Operator or even the QA patrol and ME who monitor this item are not notice the Spot/Scum because it is move from different location or maybe the occurrence is randomly.
--	---

## PRODUCTION CORRECTIVE ACTION

<input type="checkbox"/> Network of affected items if applicable? <input checked="" type="checkbox"/> - Orient the Eqos operator regarding this issue and get their idea on how to avoid this problem.			
<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>210222</b>

PREPARED BY:

*[Signature]*  
GERALD DE GUZMAN  
 PROD ASST. SUPERVISOR

APPROVED BY:

*[Signature]*  
WEENA V. APALLA  
 SR. SUPERVISOR





KANEPACKAGE PHILIPPINE INC.

## MINUTES OF THE MEETING

Date: 2/02/23 Time Start: 1105H Time Finished: 1113H Venue: EQOS AREA

## ATTENDEES:

Name	Section	Sign	Name	Section	Sign
CLEMAN BELARDO	Prod'n		SANDY MAWOREA	PROD'n	
E-DEVELLES	"		Mel Abe	Prod	
ANTHONY BETCO	Prod'n				
ROBERT DEUTTO	Prod'n				
Jessie James Calva	Prod.				

## AGENDA:

**ORIENTATION REGARDING MISALIGN PRINT OF EMORI HP33D1012 CARTON BOX, SANYO DENKI 00415456-01 PACKAGE & POOR PRINT (SPOT/SCUM) OF NIDEC SUBIC VR-E BOX**

## MINUTES:

page 1 of 1

## ROOTCAUSE:

- > Emori HP33D1012 Carton Box - random of warp materials.
- > Sanyo Denki 00415456-01 Package - not using of Suteban.
- > Nidec Subic VR-E Box - corrugated fiber or crack kraft liner stick in the cyrel

## CORRECTIVE ACTION:

- > Emori HP33D1012 Carton Box.
  - Temporarily hold the raw materials if there is visible warpage.
  - Immediately inform the leader in-charge for the coordination to the concern department.
- > Sanyo Denki 00415456-01 Package.
  - Put Suteban in the mylar on next running.
  - Use suteban in all items process in Eqos.
  - OPERATOR SUGGEST IF ABLE THE CREASING OF SUPPLIER IS MAKE TO MAKE DUE TO PRINT DIMENSION OF SPIN DISTANCE ONLY FROM CREASING LINE.
- > Nidec Subic VR-E Box.
  - Try to rework if applicable.
  - Any idea on how to avoid this problem?
  - ACCORDING TO OPERATOR POSSIBLE THE SCUM IS DUE TO INK RESIDUE.

## FOLLOW UP MEETING:

(date &amp; time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:

  
GERALD DE GUZMAN