

**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.: 384

Date Issued: 21 02 18

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00415456-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	21 02 17
Job Order Number	JODRS21-M-00063-19	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

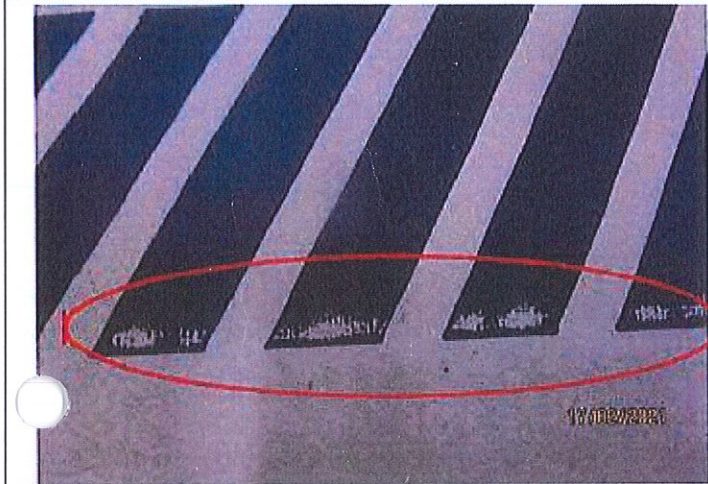
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
410	68	16.59%

Nature of Defect:

Misalign Print

Requirement:Printing tolerance is $\pm 5\text{mm}$ **Actual:**

The solid image coincided on the creasing that causes poor print. Solid image distance from creasing is 10mm



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 checked="" type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by Ms. Noelmi Cepeda QA Supervisor	Approved by Mr. Rexel Amario 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 1:		
	Why 2:				
	Why 3:	N/A			N/A
	Why 4:				
	Why 5:				
Design / Toolings	Why 1:		Why 1:		
	Why 2:				
	Why 3:	N/A			N/A
	Why 4:				
	Why 5:				
Process / Material	Why 1:		Why 1:		
	Why 2:				
	Why 3:	PLS. SEE ATTACHED			PLS. SEE ATTACHED
	Why 4:				
	Why 5:				

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

- CORRUGATED FIBER OR CRACK WHITE / KRAFT
STICK IN THE CYREL.

OUTFLOW ROOTCAUSE

- SPOT / SCUM move from different
LOCATION OR MAYBE 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		
Idees	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 02 20

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The mylar has no suteban on both ends.

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 20	<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 05 18	<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

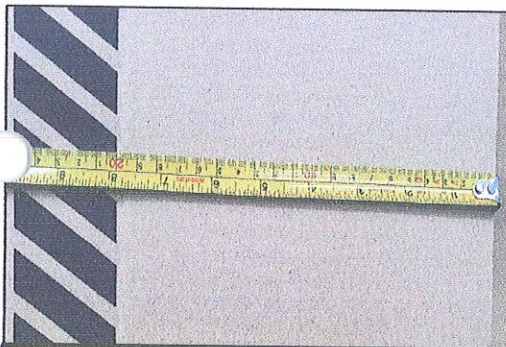
QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	CLOSED	QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Still Open		Date: 21 05 18	Date: 21 05 18	Date: 21 05 18	Date: 21 05 18
<input type="checkbox"/> Re-Issue IRF					

DATE AND
SIGNATURE

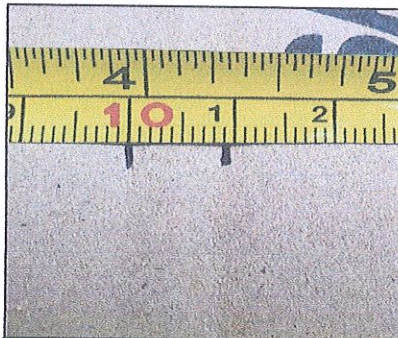
21 05 18

INVESTIGATION REPORT FOR MISALIGN PRINT OF SANYO DENKI 00415456-01 PACKAGE

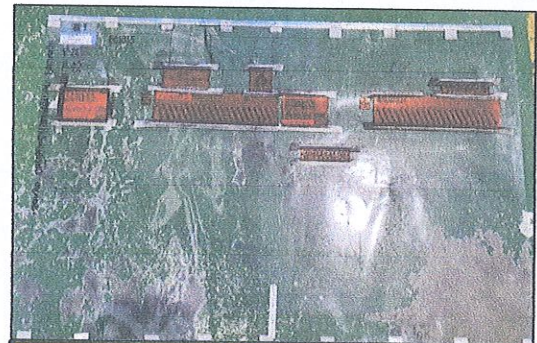
DIRECT CAUSE PROCESS/MATERIAL	W1- Based on the rejected sample print ^{MOV} downward of 4mm.
	W2- The 4mm movement is within the print tolerance, but because the print distance from the creasing line is only 10mm plus the 9mm mark of supplier creasing line its become more visible or sometimes cause of poor print.
	W3- Item is prone to movement vertically because the sheet size height is below 500mm.
	W4- Operator did not used Suteban.



REQUIREMENT: 204mm



**MARK OF SUPPLIER
CREASING LINE: 9mm**



No Suteban in Mylar/Cyrel

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Operator did not notice the print movement because possible its occurs randomly.
	W2- There is confusion because even the operator notice the print movement, it is within the ± 5 mm Print tolerance.

PRODUCTION CORRECTIVE ACTION

- Put Suteban in this item next running.
- Standardize the usage of Suteban in all items to Eqos Work Instruction.

PIC:	PRODUCTION	TARGET DATE:	ON-GOING
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PREPARED BY:

[Signature] 210219
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature] 210219
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 DELARDO	Prod'n		BANDY MANORCA	PROD'n	
E. DEVELLES	"		Mel Abe	Prod	
ANTHONY BETCO	Prod'n				
ROBERT DEUITO	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:

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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 MADE TO MAKE DUE TO PRINT DIMENSION OF SPOT 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 & time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:

GERALD DE GUZMAN