

**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.: 390

Date Issued: 21 03 01

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00681655-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	21 02 26
Job Order Number	JO21-M-00284-42	Section Detected	QA - IN LINE

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

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

200

150

75.00%

Nature of Defect:

BLOTTER PRINT

Requirement:

Text should be readable

Actual:

affected text are not readable

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.: _____	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Appearance
Date: _____	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
 Adrian Vergara QA-IE Staff	 Mr. Roderick Ramos QA Supervisor	 Mr. Rexel Almaro QA Asst. Manager	 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 2:	
	Why 3:	N/A	Why 3:	N/A
	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:	PLS. SEE ATTACHED	Why 3:	PLS. SEE ATTACHED
	Why 4:		Why 4:	
	Why 5:		Why 5:	



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

- BLUNT CYREL  
- WASH BOARD MATERIALS

- ACCEPTABLE JUDGEMENT FOR  
THE PRODUCTION SIDE.

**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	
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**B. Orientation**

Date	N/A	Time	N/A
Title	N/A		
Issues	N/A		

Design / Tools	N/A	
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**C. Reworking**

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

Process	PLS. SEE ATTACHED	
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**II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)**

Date Conducted: 21 03 02

PIC: A. Vergara

**Identified Rootcause****Recommendation**

The condition of the rubber die is blunt

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 03 09	[ <input checked="" type="checkbox"/> ] Yes [ ] No	C.A. is effective implementive
2nd Verification of Action			[ ] Yes [ ] No	
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action	A. Vergara	21 06 03	[ <input checked="" type="checkbox"/> ] 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			
<input type="checkbox"/> Re-issue IRF		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
		Date: 21 06 03	Date: 21 06 03	Date: 21 06 03	Date: 21 06 03
DATE AND SIGNATURE					



# INVESTIGATION REPORT FOR BLOTTED PRINT OF SANYO DENKI 00681655-01 PACKAGE

## DIRECT CAUSE PROCESS/MATERIAL

W1- Upon trial run operator encountered problem in poor print.

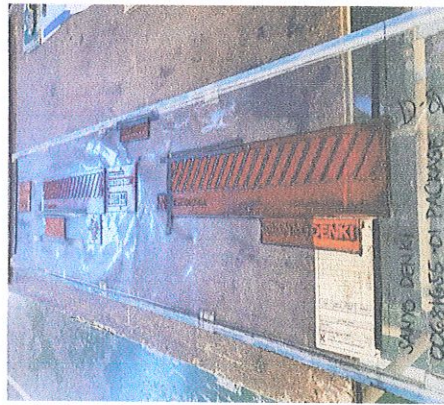
W2- The Leader in-charge notice that the solid character of the cyrel is already blunt and the texture of materials is wash board.

W3- Due to criticality of this item that time, Leader in-charge decide to put backing tape at the back of the mylar to eliminate poor print.

W4- The poor print is eliminated, but because the mylar is layout in combination of solid character and small text character the backing tape affect to small text character that cause blotted print.

Time	Start	Finish	Remarks
2047	2055		rag boggy rag topology type, poorprint, and cleaning appt.
2045	2109		cleaning cyrel due to blotted.
2101	2114		cleaning cyrel due to blotted poorprint.

Time	Start	Finish	Remarks
2047	2055		rag boggy rag topology type, poorprint, and cleaning appt.
2045	2109		cleaning cyrel due to blotted.
2101	2114		cleaning cyrel due to blotted poorprint.



KANE PACKAGE PHILIPPINE INC.			
CYREL MONITORING CARD			
Customer: S. DENKI			
Item Description: 00681655-01			
Date	Running Qty.	Total Running	REMARKS
200604	210	210	✓
200607	212	422	✓
200829	213	635	✓
201115	220	855	✓
201204	220	1075	OK
210116	210	1285	OK
210126	210	1495	WORN OUT 200301

## INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL

W1- Operator immediate cleaned the cyrel 2 times due to trap blotted print.

W2- But due to backing tape <sup>the</sup> blotted print occurs continuously.

W3- Leader in-charge decided to reject the 5pcs worst blotted print and include some of the affected, because on his judgement it was acceptable since the lot qty is 200pcs only and the item is critical that time.

## PRODUCTION CORRECTIVE ACTION

- Request for the cyrel replacement (Done 210301)
- Separate mylar for the Solid character and Small text character.

PURCHASE REQUEST	
Requester: [Signature]	Request Date: [Date]
Request Description: [Text]	Request Status: [Text]
Request Amount: [Text]	Request Priority: [Text]
Request Reason: [Text]	Request Approval: [Text]

PIC: PRODUCTION TARGET DATE: UPON ARRIVAL OF NEW CYREL

PREPARED BY:

GERALD DE GUZMAN  
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA  
SR. SUPERVISOR