

**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	NIDEC SUBIC	Attention To	Mr. Gerald De Guzman
Item Code	VR-C	Department	PRODUCTION
Item Description	BOX	Date of Detection	21 02 26
Job Order Number	JO-21-IPD-00071-6	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM

☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

1034

25

2.42%

Nature of Defect:

POOR PRINT

Requirement:

Color should not be fading

Actual:

Color is fading



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 Almario 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 1:
	Why 2:		
	Why 3:		
	Why 4:		
	Why 5:		
Design / Toolings	Why 1:	Why 1:	Why 1:
	Why 2:		
	Why 3:		
	Why 4:		
	Why 5:		
Process / Material	Why 1:	Why 1:	Why 1:
	Why 2:		
	Why 3:		
	Why 4:		
	Why 5:		

N/A

N/A

N/A

N/A

PLS. SEE ATTACHED

PLS. SEE ATTACHED

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

- LOW VISCOSITY OF INK

OUTFLOW ROOTCAUSE

- MISSED SOME OCCURRENCE DUE TO MACHINE SPEED 130BPM.

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

Design / Tools

N/A

Process

PLS. SEE ATTACHED

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
dees	N/A		

C. Reworking

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

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

Date Conducted: 21 03 03

PIC: A. Vergara

Identified Rootcause

Low viscosity on the other side of the sheet because there is too much water on the affected part. There is two active showers on the affected part

Recommendation

> After machine stoppage or before starting of production, ink & water should be mix in the anilox for a minute
> After mixing, the first 3 sheets should separate

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 04 09	[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 11 07	[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

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-issue IRF	CLOSED	QA Supervisor	QA Asst./Manager	Line Leader	Department Head
		Date: 21 11 07	Date: 21 11 07	Date: 21 11 07	Date: 21 11 07

DATE AND
SIGNATURE

21 11 07

INVESTIGATION REPORT FOR POOR PRINT OF NIDEC SUBIC VR-C BOX

DIRECT CAUSE PROCESS/MATERIAL

- W1-** Upon investigation Operator and even QA Patrol concern the problem they encountered in print color.
- W2-** Even they set the ink to the standard viscosity of 9sec sometimes the print is too dark but if they add water from water shower of machine its become too lighter.
- W3-** There is possibility that the poor print occurs when the QA patrol ask to operator to add some water because the print is too dark, but when the operator add water using water shower of machine the print got too lighter why they need to changed the ink in the bucket.

O AND CONDITION SHEET

EQOS			
Start	Time	Finish	Machine Breakdown / Downtime / Others
1940	1942		cleaning eyelet due to solid print.
1945	1948		printed print cleaning eyelet
1957	2000		waiting water kulanog
2025	2030		cleaning eyelet
2107	2111		cleaning eyelet due to solid print.
2244	2253		retyping eyelet due to sabet and cleaning eyelet.
2257	2307		spot cleaning waste eyelet.
2310	2322		sabet retyping and cleaning eyelet and cleaning sensor stroke.
2324	2330		change viscosity and cleaning eyelet due to spot.
2357	0000		crush roller

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL

- W1-** Operator separate the reject poor print they trap during sampling.
- W2-** Possible that they missed some occurrence of poor print during sampling because the machine speed is 130bpm in Skip On mode.

PRODUCTION CORRECTIVE ACTION

- Ask for help of ME and QA for the standardization of ink viscosity for Nidec Subic item, since this item is white kraft and the print is green why there is difficulty to get the required print color.
- Provide approved LSD sample for Nidec Subic item in Eqos area for the color reference of operator.

PIC: **PRODUCTION** **TARGET DATE:** **TO BE DISCUSS IN 4PM MEETING**

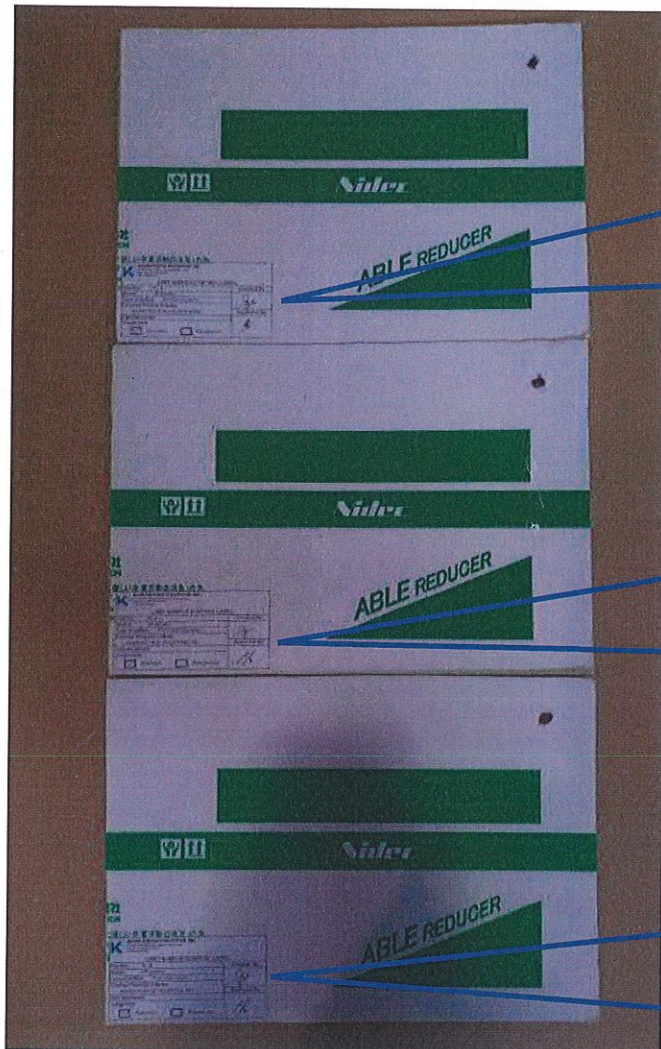
PREPARED BY:

[Signature] 210303
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature] 210303
WEENA V. APALLA
SR. SUPERVISOR

COLOR LIMIT SAMPLE WITH CUSTOMER'S APPROVAL:



KANEPACKAGE PHILIPPINE INC. <small>No. 9 Ring Road, 2/F, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100</small>	
LIMIT SAMPLE CONTROL LABEL	
Part No.: N / A	Checked By:
Model: VR Models	
Type of Defect: Print Color (Dark)	
External Provider's Name	
KANEPACKAGE PHILIPPINE INC.	
Date Approved:	Approved By:
Judgement:	
<input checked="" type="checkbox"/> Approved <input type="checkbox"/> Disapproved	

KANEPACKAGE PHILIPPINE INC. <small>No. 9 Ring Road, 2/F, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100</small>	
LIMIT SAMPLE CONTROL LABEL	
Part No.: N / A	Checked By:
Model: VR Models	
Type of Defect: Print Color (Standard)	
External Provider's Name	
KANEPACKAGE PHILIPPINE INC.	
Date Approved:	Approved By:
Judgement:	
<input checked="" type="checkbox"/> Approved <input type="checkbox"/> Disapproved	

KANEPACKAGE PHILIPPINE INC. <small>No. 9 Ring Road, 2/F, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100</small>	
LIMIT SAMPLE CONTROL LABEL	
Part No.: N / A	Checked By:
Model: VR Models	
Type of Defect: Print Color (Light)	
External Provider's Name	
KANEPACKAGE PHILIPPINE INC.	
Date Approved:	Approved By:
Judgement:	
<input checked="" type="checkbox"/> Approved <input type="checkbox"/> Disapproved	