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

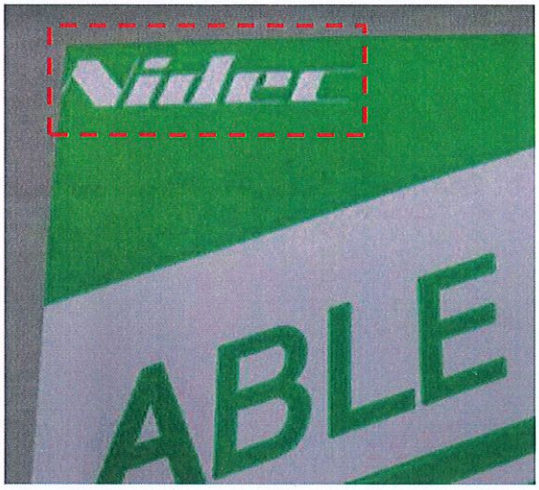
INVESTIGATION REPORT FORM (IRF)

■ Inhouse Detection ☐ Customer Claim

Control No.: 396 Date Issued: 21 03 08

Customer	NIDEC SUBIC	Attention To	Mr. Gerald De Guzman
Item Code	VR-B	Department	PRODUCTION
Item Description	BOX	Date of Detection	21 03 06
Job Order Number	JO-21-IPD-00071-2	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM



☐ Major ■ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
932	113	12.12%

Nature of Defect:

MISALIGNED DIE-CUT

Requirement:

Customer's logo should not be cut

Actual:

Cut Nidec Logo

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
■ First	☐ Hold	☐ Slotter ☐ Gluing	☐ Material
☐ Recurrence	☐ Special Acceptance	☐ EQOS ☐ Vertical	■ Dimension
No.:_____	☐ For Rework	■ Diecut ☐ Others:	☐ Appearance
Date:_____	■ Reject / Disposal	☐ Detaching _____	☐ Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
Adrian Vergara QA-IE Staff	Ms. Noemi Cepeda QA Supervisor	Mr. Rexel Almario QA Asst. Manager	210308 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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FINAL CONCLUSION

OCCURRENCE ROOTCAUSE	OUTFLOW ROOTCAUSE
- SLIPPY SURFACE OF WHITE KRAFT MATS.	- RANDOMLY OCCURRENCE

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

A. Sorting Result

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	N/A			

B. Orientation

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

C. Reworking

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

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

	Actions to be done to eliminate recurrence	Who / When
System	N/A	
Design / Tools	N/A	
Process	PLS. SEE ATTACHED	

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

Date Conducted: 21 03 10 PIC: A. Vergara

Identified Rootcause	Recommendation
> The materials slips on the printing machine's roller because the boards are smooth	

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 29	[/] Yes [ ] No	C.A. is implemented
2nd Verification of Action			[ ] Yes [ ] No	
3rd Verification of Action			[ ] Yes [ ] No	
Effectiveness of Action	A. Vergara	21 07 14	[/] Yes [ ] No	C.A. is effective

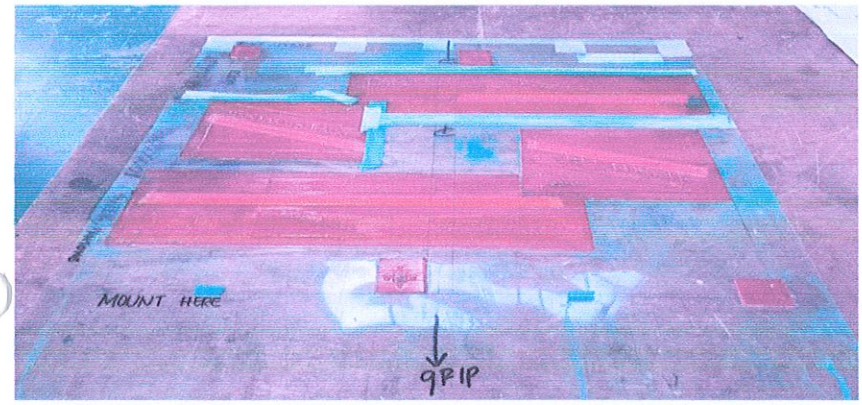
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improvement action.

IV. CLOSURE

Status:	Remarks:	Approved by:		Process Owner Acknowledgment: (Receiving Section)	
[/] Closed	QUALITY ASSURANCE DEPARTMENT CLOSED	QA Supervisor	QA Asst. Manager	Line Leader	Department Head
[ ] Still Open		Date: 21 07 14	Date: 21 07 14	Date: 21 07 14	Date: 21 07 14
[ ] Re-Issue IRF	DATE AND SIGNATURE 21 07 14				

INVESTIGATION REPORT FOR MISALIGN PRINT OF NIDEC SUBIC VR-B BOX

DIRECT CAUSE PROCESS/MATERIAL	**W1**- Operator in Eqos concern that the white kraft is prone to misalign due to slippy surface.
	W2- Possible that the sheet slide during printing since during checking of actual reject the print was slanted.



No Suteban in Cyrel Mylar because the sheet size is more than 500mm in height.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	**W1**- Misalign print did not visible since the machine speed is 130bpm and the items is not yet die-cutted.
	W2- Eqos operator did not notice the misalign print during sampling since the occurrence is randomly.

PRODUCTION CORRECTIVE ACTION

Put Suteban in both side of Cyrel Mylar for better grip of sheets even the sheet size is more than 500mm in height, since the white kraft according to Eqos operator is slippy why it is prone to misalign.

PIC:	PRODUCTION	TARGET DATE:	NEXT RUNNING

PREPARED BY:

210309

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

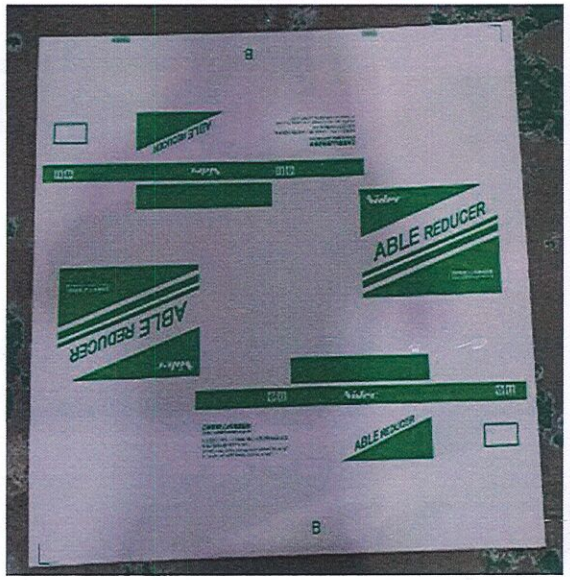
APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR

UPDATES:

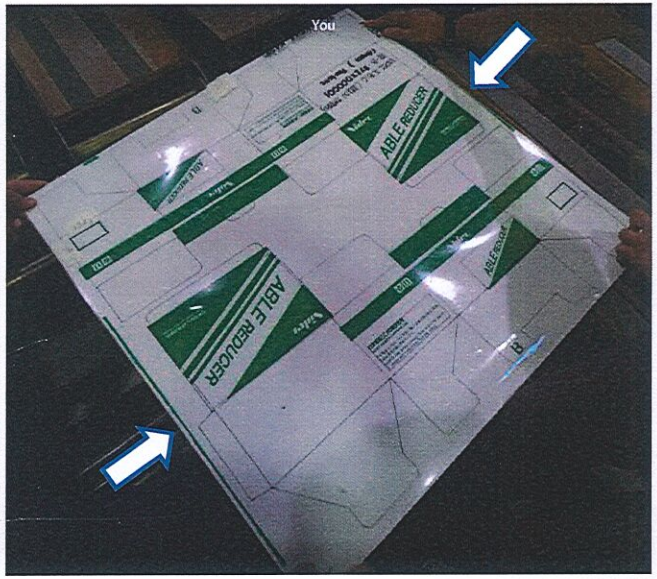
REMARKS: Suteban was not mount end to end.

BEFORE



No suteban on both ends

AFTER



With suteban on both ends