

1440


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.: 400

Date Issued: 21 03 15

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00902010-01	Department	PRODUCTION
Item Description	PRINT SPECIFICATION	Date of Detection	21 03 13
Job Order Number	JO21-M-00309-109	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM


<input type="checkbox"/> Major <input type="checkbox"/> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)
3,260	81
Reject Percentage	
2.48%	
Nature of Defect:	
POOR PRINT	
Requirement:	
Solid print should no mottling print	
Actual:	
W/ mottling print on solid image	

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ Date: _____	<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	Checked by	Approved by	Received by (Receiving Section)	
 Adrian Vergara QA-IE Staff	 Ms. Npemi Cepeda 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 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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INVESTIGATION REPORT FORM (IRF)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

- ALMOST WASH BOARD MATERIALS
- UNEVEN DISTRIBUTION OF THE SHOWER
NOZZLE

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	N/A	Time	N/A
Title	N/A		
Issues	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: 21 03 16

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The smooth surface of the material has uneven flatness because the material is almost washboard
> Uneven supply of water from water shower

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 16	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Orientation is conducted
2nd Verification of Action	A. Vergara	21 03 23	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Shower nozzles were replaced
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 06 04	<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

Status	Remarks	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed			
<input type="checkbox"/> Still Open			
<input type="checkbox"/> Re-Issue IRF			

DATE AND
SIGNATURE

21 06 04

INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 00902010-01 PRINT SPECIFICATION

DIRECT CAUSE PROCESS/MATERIAL	"Based on investigation there is two possible caused of poor print"
	W1- Texture of the surface of materials is almost wash board.
	W2- Wash board effect to the print impression that possible caused poor print.
	W1- Uneven water distribution of the shower nozzle of Eqos machine.
	W2- The supply of water from left shower nozzle is minimal than the right shower nozzle.
	W3- The uneven distribution of water in ink may affect to the ink viscosity that may possible cause of Blotted & Poor Print.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Eqos operator did not notice the misalign print during sampling since the occurrence is randomly with 2.48%.
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PRODUCTION ACTION PLAN

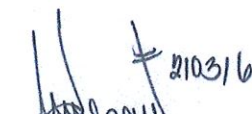
- > Alert the Eqos operator regarding this issue.
 - Discuss the possible root cause of the problem.
 - Try to adjust the settings once they encountered wash board like adjustment in print impression.
 - Once they trap wash board materials upon issuance that possible cause of poor print, immediate inform the Leader in-charge for the coordination of affected items.
- > Request to Engineering to check the condition of anilox and the calibration of shower nozzle of Eqos Machine.

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


 GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


 WEENA A. APALLA
 SR. SUPERVISOR



KANEPACKAGE PHILIPPINE INC.

MINUTES OF THE MEETING

Date: 210316 Time Start: 11:13 AM Time Finished: 11:17 AM Venue: EDOS AREA

ATTENDEES:

Name	Section	Sign	Name	Section	Sign
DAVID BONAYON	EQOS				
Martin Panalalakh	"				
RAMIL PAMBAGO	"				
Henry CLAVE	EQOS				
Jolito Acejo	"				

AGENDA:

**ORIENTATION REGARDING POOR PRINT OF
SANYO DENKI 00902009-01 PACKAGE**
ADD: 00902010-01

MINUTES:

page 1 of 1

ROOTCAUSE:

One possible caused we consider is the texture of raw materials since the occurrence of poor print is only 11.74%, because we notice that the surface of actual reject is washboard.

CORRECTIVE ACTION:

> Try to adjust the settings once they encountered wash board like adjustment in print impression.

> Once the raw materials have visible wash board upon issuance, immediate inform the Leader in-charge for the coordination of affected items.

FOLLOW UP MEETING:

(date & time)

for KPPI fill up only

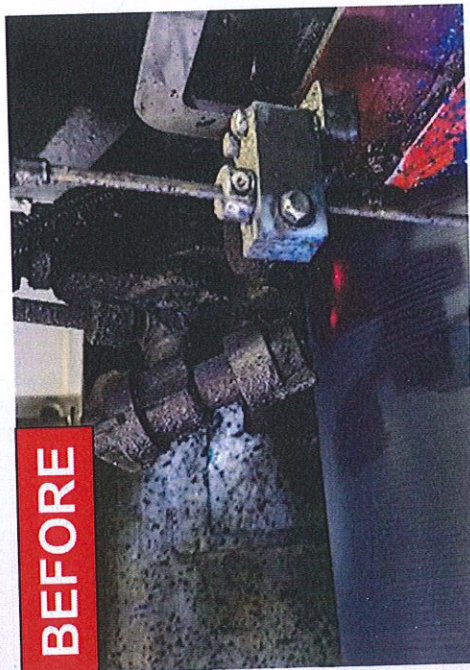
Prepared by:

Reviewed by:

Noted by:


GERARDO DE GUZMAN

UPDATES:

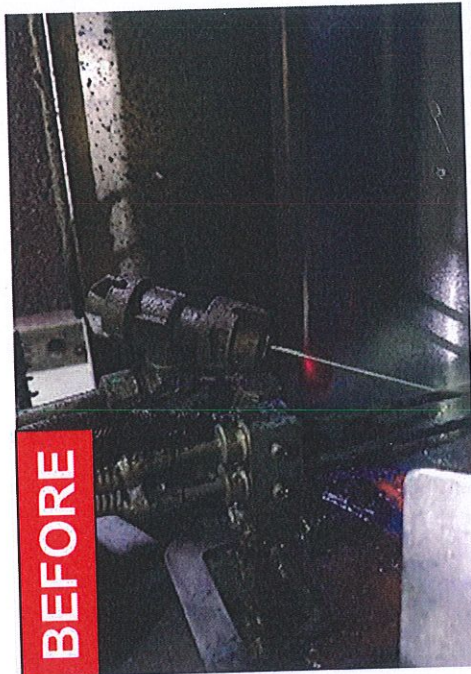


BEFORE

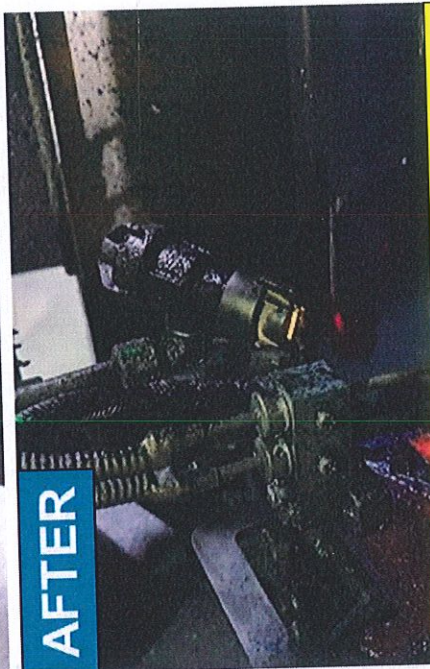


AFTER

LEFT NOZZLE



BEFORE



AFTER

RIGHT NOZZLE

REMARKS:

>The nozzles were replaced because they produced water with uneven volumes

>For checking of effectiveness