

**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.: 404

Date Issued: 21 03 23

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00902009-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	21 03 22
Job Order Number	JO21-M-00309-106	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM



<input type="checkbox"/>	Major	<input checked="" type="checkbox"/>	Minor
Lot Quantity (pcs.)		Reject Quantity (pcs.)	Reject Percentage
3,300		451	13.66 %
Nature of Defect:			
POOR PRINT			
Requirement:			
No poor print on the solid image of the carton box			
Actual:			
W/ mottling on the solid image			

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 4 Date: 21 03 22	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input checked="" type="checkbox"/> For Rework <input 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. Noemi Cepeda QA Supervisor	 Mr. Rexe Amario 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****OUTFLOW ROOTCAUSE**

ROUGH TEXTURE / UNEVEN DISTRIBUTION
OF MATERIALS OF WATER IN INK.

RANDOM 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**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 24

PIC: A. Vergara

Identified Rootcause**Recommendation**

> Rough surface corrugated boards
> There is uneven distribution of water from nozzle

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 24	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Water shower in printing unit 2 was replaced
2nd Verification of Action	A. Vergara	21 04 06	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	The flexoplate was replaced
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 07 07	<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"/> Status: Closed	CLOSED				
<input type="checkbox"/> Still Open		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Re-Issue IRF		Date: 21 07 07	Date: 21 07 07	Date: 21 07 07	Date: 21 07 07
DATE AND SIGNATURE		21 07 07			

INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 00902009-01 PACKAGE


<i>Material</i> DIRECT CAUSE PROCESS/MATERIAL	"Based on investigation there is two possible caused of poor print"
	W1- Texture of the surface of materials is rough.
	W2- Rough texture of materials effect to the print impression that possible caused of poor print.
<i>Machine</i> PROCESS/MATERIAL	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 Poor Print & Blotted.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Even the operator conducted different adjustment in print impression during running, still there is a random occurrence of poor print occurs.
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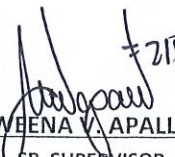
PRODUCTION CORRECTIVE ACTION

> Since Production did not control the rough texture of materials, our action plan is to try the Soft cyrel for the solid image print and Hard cyrel for the small character print. (PR done)			
> Engineering schedule to conduct assessment today for the Shower Nozzle.			
PIC:	PRODUCTION	TARGET DATE:	ON-GOING

PREPARED BY:


 GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


 WEENA V. APALLA
 SR. SUPERVISOR

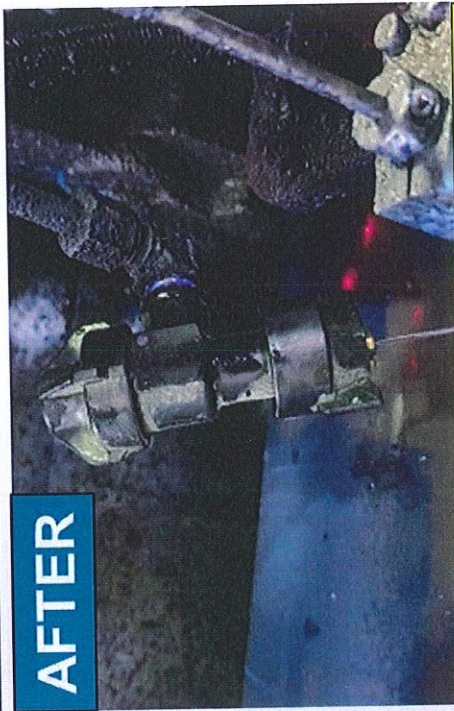
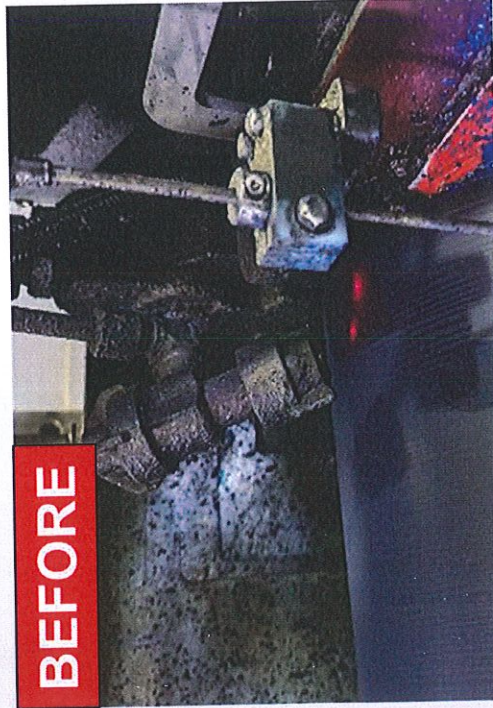
UPDATES:

NEW FLEXO PLATE SETUP:

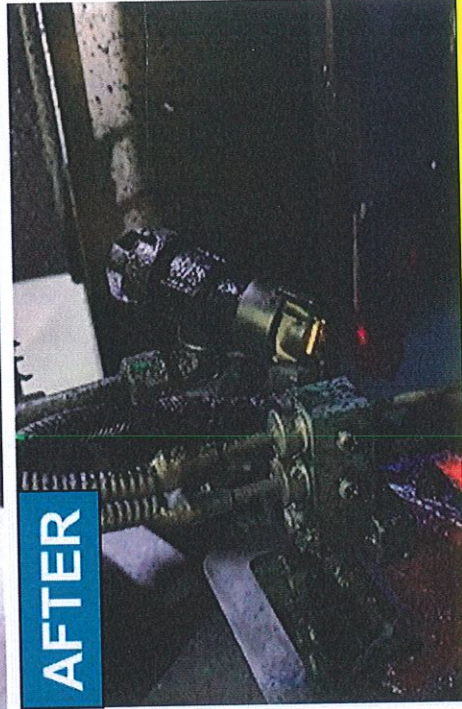
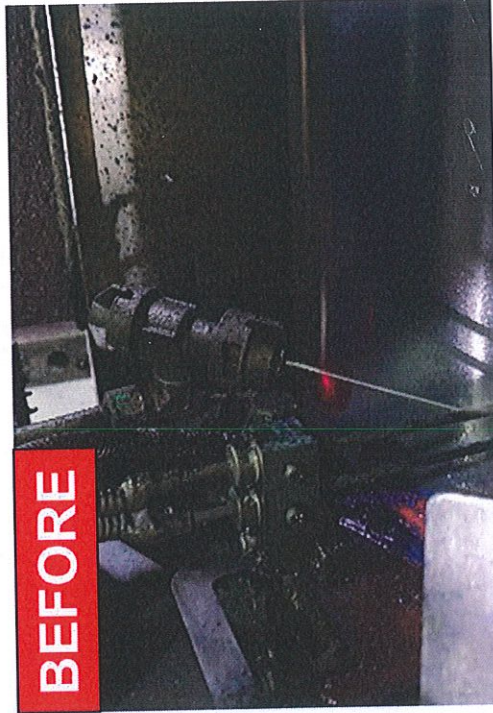


NOTE: Light color rubber dies are soft flexoplate and the dark color rubber dies are hard flexoplate.

UPDATES:



LEFT NOZZLE



RIGHT NOZZLE

REMARKS:

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

>For checking of effectiveness