

**KANEPACKAGE PHILIPPINE INC.**

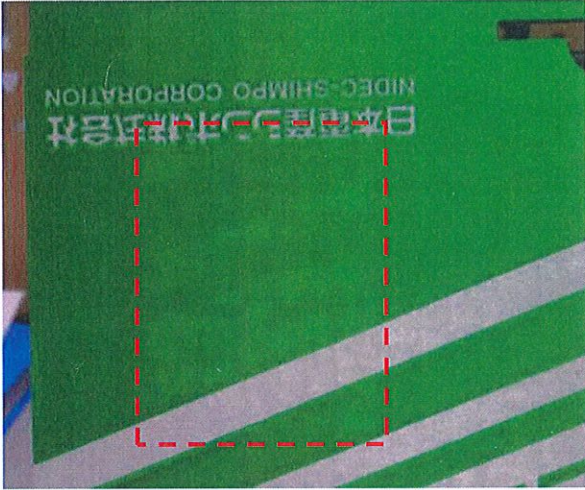
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 407

Date Issued: 21 04 05

Customer	NIDEC SUBIC	Attention To	Mr. Gerald De Guzman
Item Code	VR-D	Department	PRODUCTION
Item Description	BOX	Date of Detection	21 03 31
Job Order Number	JO-TO-21-IPD-00063-5	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
2000	71	3.55%

Nature of Defect:

SCUM

Requirement:

No scum on the solid image

Actual:

W/ scum on the 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	 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:	N/A	Why 1:	N/A
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:	N/A	Why 1:	N/A
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:	PLS. SEE ATTACHED	Why 1:	PLS. SEE ATTACHED
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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

ADHESIVE
STICK IN THE CANAL

- OCCURS AT THE END PORTION OF MASS PRODUCTION

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	21 04 13	Time	16:33 - 16:39
Title	ORIENTATION REGARDING SCUM OF MICRO-SUBIC VR-D BOX		
Issues	EQOS OPERATORS		

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 04 06

PIC: A. Vergara

Identified Rootcause**Recommendation**

The ink was contaminated by dirt. Since flexo plate was contaminated by adhesive. There was an adhesive on the material surface

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 13	[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 10 18	[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

Status: <input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-Issue IRF	Remarks: QUALITY ASSURANCE DEPARTMENT CLOSED DATE AND SIGNATURE: <u>21 10 18</u>	Approved by: QA Supervisor: <u>21 10 18</u> QA Asst. Manager: <u>21 10 18</u>	Process Owner Acknowledgment: (Receiving Section) IRISH MAY L. ESTAREJA Line Leader Date: <u>21 10 18</u> Department Head: <u>21 10 18</u>
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INVESTIGATION REPORT FOR SCUM OF NIDEC SUBIC VR-D BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- <u>There</u> is adhesive (Double sided tape) stick in the material surface.
	W2- The adhesive stick in the cyrel during mass production.
	W3- Ink did not penetrate in the portion of cyrel have adhesive that caused of scum.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Operator and QA Patrol did not notice the scum during sampling.
	W2- Possible the scum occurs at the end portion of mass production.

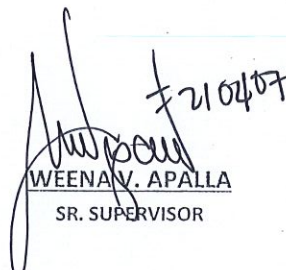
PRODUCTION CORRECTIVE ACTION

Alert the Eqos operator that upon detection of scum immediately clean the cyrel before proceed to mass production.			
PIC:	PRODUCTION	TARGET DATE:	210408

PREPARED BY:


GÉRALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:


WEENAY V. APALLA
SR. SUPERVISOR



KANEPACKAGE PHILIPPINE INC.

MINUTES OF THE MEETING

Date: 210413 Time Start: 1633H Time Finished: 1639H Venue: EQOS AREA

ATTENDEES:

Name	Section	Sign	Name	Section	Sign
DAVID BONAYON	EQOS				
Marvin Pamulakakin	"				
Henry	CLAVE				
JOHNS	ACEP				
PEDRO	CHARL	EQOS			

AGENDA:

ORIENTATION REGARDING SCUM OF NIDEC SUBIC VR-D BOX

MINUTES:

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ROOTCAUSE:

There is adhesive (Double sided tape) stick in the material surface, the adhesive stick in the cyrel during mass production the ink did not penetrate in the portion of cyrel have adhesive that caused of scum.

CORRECTIVE ACTION:

- > Upon detection of scum immediately clean the cyrel before proceed to mass production.
- > Make sure the cyrel totally dried before resume to mass production.

FOLLOW UP MEETING:

(date & time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:

GERARDO DE GUZMAN