


**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

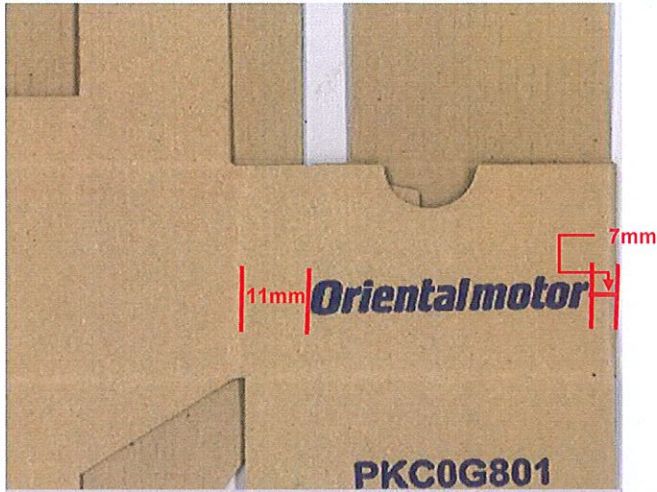
**INVESTIGATION REPORT FORM (IRF)**
☒ Inhouse Detection

☐ Customer Claim

Control No.: 421

Date Issued: 21 05 12

Customer	KOYAMA	Attention To	Mr. Gerald De Guzman
Item Code	PKC0G801	Department	PRODUCTION
Item Description	INNER BOX	Date of Detection	21 05 12
Job Order Number	JO21-M-00621-2	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
3038		67	2.21%
Nature of Defect:			
MISALIGN PRINT			
Requirement:			
Printing tolerance should be with +/-3mm			
Actual:			
Printing movement is >4mm			

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 5 Date: 21 05 12	<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 checked="" type="checkbox"/> Dimension <input 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: 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**

- WARP MATERIALS

- 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****Actions to be done to eliminate recurrence****Who / When**

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

**B. Orientation**

Date	N/A	Time	N/A		Design / Tools	N/A	
Title	N/A						
Attendees	N/A						

**C. Reworking**

Rework Quantity	N/A		Process	PLS. SEE ATTACHED	
Total Good	N/A				
Rework Percentage (Good)	N/A				

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

Date Conducted: 21 05 13

PIC: A. Vergara

**Identified Rootcause****Recommendation**

> Warp corrugated boards

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 06 16	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is implemented. Except for Action 2 since it is for discussion w/management
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 12 18	<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			
QA Supervisor		QA Asst. Manager	IRISH MAY L. ESTAREJA Line Leader
Date: 21 12 20		Date: 21 12 20	Date: 21 12 20

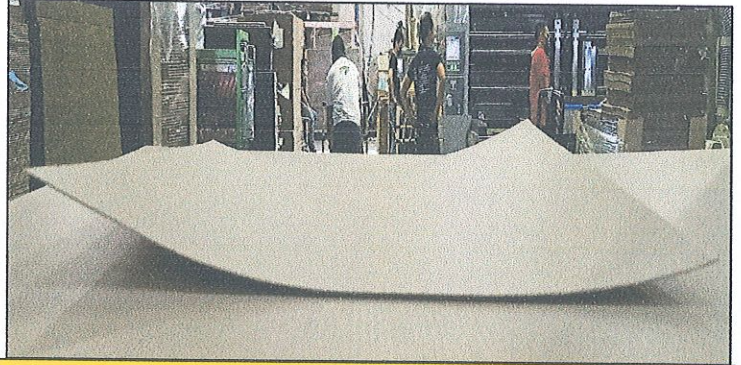
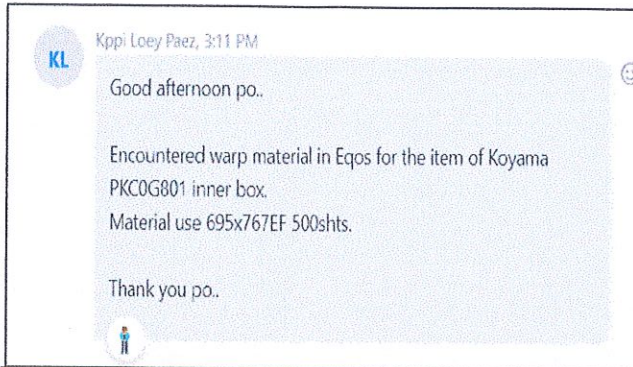
DATE AND  
SIGNATURE

*[Signature]* 21 12 20



# INVESTIGATION REPORT FOR MISALIGN PRINT OF KOYAMA PKC0G801 INNER BOX

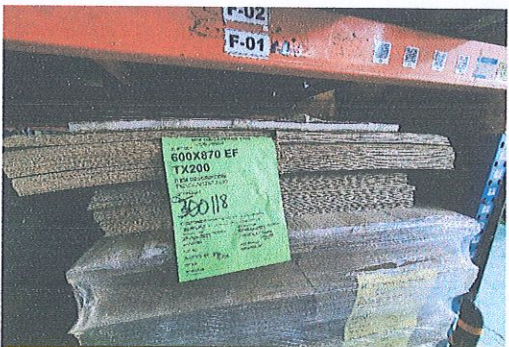
<b>DIRECT CAUSE PROCESS/MATERIAL</b>	<b>W1-</b> The caused of print misalignment for this item is the warp materials, since the materials is prone in warpage 695 x 676 EF and critical due to 4outs in die-blade.
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## PRODUCTION LEADERS CONCERN REGARDING WARP MATERIALS OF THIS ITEM

<b>INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL</b>	<b>W1-</b> Misalign print did not trap during sampling because possible the occurrence are randomly since 67pcs out of 3038pcs or 2.21% are affected.
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## PRODUCTION CORRECTIVE ACTION

<p>- Proper palletizing and application of weight jig for E-flute material since it was prone to warpage.</p> <p>- Pneumatic Pressing Machine for reconditioning warp materials.</p>			
			
<b>FINDINGS DURING GENBA</b>			
<b>PIC:</b>	<b>PRODUCTION</b>	<b>TARGET DATE:</b>	<b>To be discuss in 4pm meeting</b>

PREPARED BY:

  
**GERALD DE GUZMAN**  
PROD ASST. SUPERVISOR

APPROVED BY:

  
**WEENA V. APALLA**  
SR. SUPERVISOR