

**KANEPACKAGE PHILIPPINE INC.**

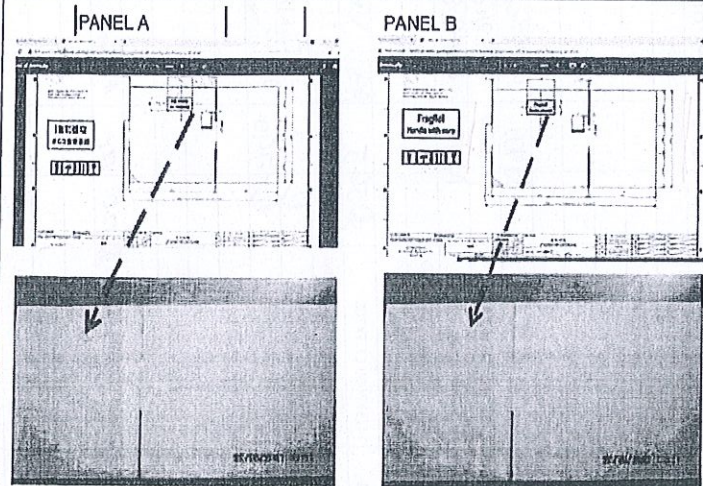
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 426

Date Issued: 21 05 31

Customer	SHIMADZU	Attention To	Mr. G. De Guzman / Mr. R. Almario / Ms. B. Marasigan
Item Code	321-63334-01	Department	PRD / QA / IMS
Item Description	OUTSIDE BOX KETT	Date of Detection	21 05 29
Job Order Number	JO21-R-00125-2	Section Detected	QA - OQA

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
173	173	100.00%

Nature of Defect:

WRONG ATTACHMENT OF DRAWING

Requirement:

Correct attachment of drawing

Actual:

Attached drawing is 321-63334

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ Date: _____	<input checked="" type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input 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 checked="" type="checkbox"/> Others: <u>SCREENING / IMS</u>	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by Mr. Roderick Ramos QA Supervisor	Approved by Mr. Rexel Ramos QA Asst. Manager	Received by (Receiving Section) Mr. G. De Guzman / Mr. R. Almario / Ms. B. Marasigan 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**- **WRONG DRAWING ISSUANCE**- **MISLOOK THE DIFFERENCE OF LAST 2-DIGIT CODE.****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	21 06 04	Time	12:45 NN - 12:35 NN
Title	ORIENTATION REGARDING WRONG ITEM PRODUCED OF SHIMADZU 321-63334 -01 OUTSIDE BOX KETT		
Attendees	EQOS / SLITTER / GLUING OPERATORS		

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 06 01

PIC: A. Vergara

Identified Rootcause**Recommendation**

> Wrong attachment of drawing in the I.O.

> Omission of 321-63334 in the drawing system

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 04	[X] Yes [] No	C.A. & Recommendation are implemented
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	21 11 23	[X] Yes [] No	C.A. & Recommendation are 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

Stamps	Remarks	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed	QUALITY ASSURANCE DEPARTMENT		
<input type="checkbox"/> Still Open	CLOSED	QA Supervisor	IRISH MAY L. ESTAREJA Line Leader
<input type="checkbox"/> Re-Issue IRF	Date: 21 11 23	QA Asst. Manager	Department Head
DATE AND SIGNATURE	21 11 23	Date: 21 11 23	Date: 21 11 23

INVESTIGATION REPORT FOR THE WRONG ITEM PRODUCED OF SHIMADZU 321-63334-01 OUTSIDE BOX KETT

DIRECT CAUSE PROCESS/MATERIAL	W1- Wrong drawing issued by IMS.
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INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	JC	W1- JC checked the JO vs Drawing but they probably they mislooked the last 2-digit of the item and they consider only the main code.
	SLOTTER	W1- Operator read the item code but they did not notice the differenced between JO vs. Drawing since they focus more to check the cutting size needed between JO vs. Drawing and it is the same.
	EQOS	W1- Operator read the item code in the JO and Drawing and its almost the same, he did not notice the last 2-digit. W2- During input of the item code in Eqos monitor (321-63334-01) the dimension show in the monitor is same in the drawing and trial run approved by QA patrol why the operator confident that there is no problem.
	GLUING	W1- Even operator read the item code, they did not notice the differenced between JO vs. Drawing because its almost same and they focus more to check the actual item vs. drawing.


PRODUCTION CORRECTIVE ACTION

<p>1. JC start the scanning of QR code in JO and Drawing to assure that there is no discrepancy between JO vs. Drawing.</p> <p>2. Re-orient the Machine operator to double check the detail in the JO vs. Drawing to assure that there's no discrepancy.</p>			
PIC:	PRODUCTION	TARGET DATE:	<p>1 - ON GOING TRIAL</p> <p>2 - 200603</p>

PREPARED BY:


GERALD DE GUZMAN
PROD-ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
SR. SUPERVISOR

Problem:

Wrong issuance/ attachment of drawing

Rootcause:

- ~ Wrong pick-up of drawing on system drawing by DDC issuer. DDC issuer copy only the item code "321-63334" not including the last 2 digit -01 from KIS system to drawing system.
- ~ Double checking of printed drawing prior issuance was not being done

Corrective Action:

- ~ Request to system development group for immediate activation of QR code for those drawing with available QR code.

PIC: B. Marasigan/ V. Simondac

Date: June 01, 2021

- ~ Strict implementation of copying all item code including last 2 digits from KIS system to drawing system.

PIC: A. Olivar/ V. Simondac

Date: June 01, 2021

- ~ Strict implementation of double checking of drawing item key and item code prior issuance. DDC issuer to put check mark on the item key and item code as evidence that double checking was done prior release of drawing. To be applied for those drawing without QR code.

PIC: A. Olivar/ V. Simondac

Date: June 01, 2021

Prepared by:

V. Simondac/ B. Marasigan

Approved by:

J. Gallos



KANEPACKAGE PHILIPPINE INC.

MINUTES OF THE MEETING

Date: 210604 Time Start: 1225H Time Finished: 1235H Venue: Production Area

ATTENDEES:

Name	Section	Sign	Name	Section	Sign
ANTHONY DELA CRUZ	EQOS		DETER BALLE	GLUING	
Shamir Mera	Cloter		MARVIN PATO	GLUING	
ARNOLD AGUIA	SURFER		Samuel Bello	GLUING	
Jessie James Calva	EQOS				
CLEMA DELARDO	EQOS				
Reyniel LORENZO	EQOS				
Robert Desito	EQOS				

AGENDA:

ORIENTATION REGARDING WRONG ITEM PRODUCED OF SHIMADZU
321-63334-01 OUTSIDE BOX KETT

MINUTES:

page 1 of 1

ROOTCAUSE:

ROOT CAUSE: Wrong attachment of drawing, due to wrong drawing issued by IMS.

OUTFLOW: Mislooked or did not notice the difference between last 2-digit of item code

CORRECTIVE ACTION:

> JC start the scanning of QR code in JO and Drawing to assure that there is no discrepancy between JO vs. Drawing.

> Operator must conduct checking of JO vs. Drawing before machine setup.

> Always double check the critical part specially the item code.

> Check the item code from 1st digit up to the last digit "DON'T SKIP" to check the last 2-digit because this is the critical part where the revision of the item indicated.

FOLLOW UP MEETING:

(date & time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:

210604
GERALD DE GUZMAN

UPDATES:

Detail

Reload

Customer SMZ - SHIMADZU PHILIPPINES MFG. INC (ROS)

Number 0057

Pages 7

Pages

Page	Item Key	Revision	Code	Description	Addl Info	Drawing
1	SMZ-0057-03AA-01	01	321-63335	PS FORM UPPER / BOTTOM (KETT)		View
2	SMZ-0057-03AA-01	01	321-63336-01	PS FORM FRAME (KETT)		View
3	SMZ-0057-03AA-01	01	321-63336-02	PS FORM FRAME (KETT)		View
4	SMZ-0057-01AD-03	03	321-63337	BOTTOM PAD (KETT)		View
5	SMZ-0057-01AD-04	04	321-63338	FRAME PAD BOTTOM (KETT)		View
6	SMZ-0057-01AD-04	04	321-63338	FRAME PAD BOTTOM (KETT) BLADE		View
7	SMZ-0057-01AD-04	04	321-63339	FRAME PAD UPPER (KETT)		View
-	SMZ-0057-01AB-03	03	321-63334	OUTSIDE BOX (KETT)	IN-ACTIVE DON NOT USE	View

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All Drawings: View