

**KANEPACKAGE PHILIPPINE INC.**

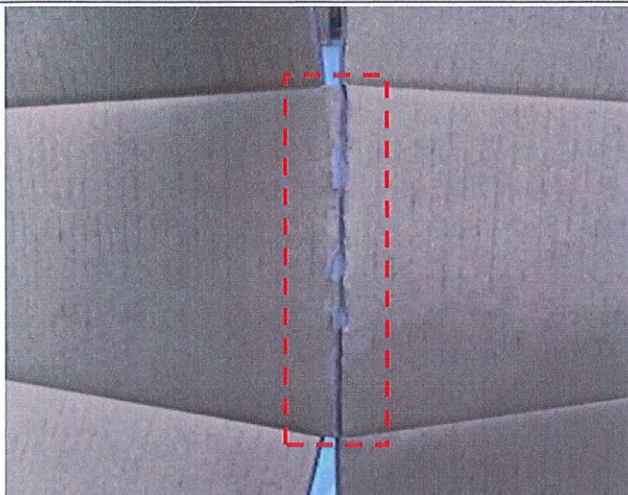
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 427

Date Issued: 21 06 02

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00958254-01	Department	PRODUCTION
Item Description	BOX PRINT SPECIFICATION	Date of Detection	21 06 01
Job Order Number	JO21-M-00441-95	Section Detected	PRD - GLUING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

800

74

9.25%

Nature of Defect:

BURSTING

Requirement:

No bursting on the creasing line of the Carton Box

Actual:

Bursting is end to end

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 type="checkbox"/> EQOS <input checked="" 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 Adrian Vergara QA-IE Staff	Checked by Mr. Roderick Ramos QA Supervisor	Approved by Mr. Rexel Almarico QA Asst. Manager	Received by (Receiving Section) 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 2:		
	Why 3:		
	Why 4:		
	Why 5:		
Design / Toolings	Why 1:	N/A	
	Why 2:		
	Why 3:		
	Why 4:		
	Why 5:		
Process / Material	Why 1:	PLS. SEE ATTACHED	
	Why 2:		
	Why 3:		
	Why 4:		
	Why 5:		

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

— USING OF HARD STRIPPING JIG
1.0 TON

— 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	System	
RM	N/A				M/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	
Total Good	N/A	PLS. SEE ATTACHED	
Rework Percentage (Good)	N/A		

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

Date Conducted: 21 Dec 23

PIC: A. Vergara

Identified Rootcause**Recommendation**

the stripping jig used is 1.0 ton - it is not flexible

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 Dec 04	[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 Dec 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

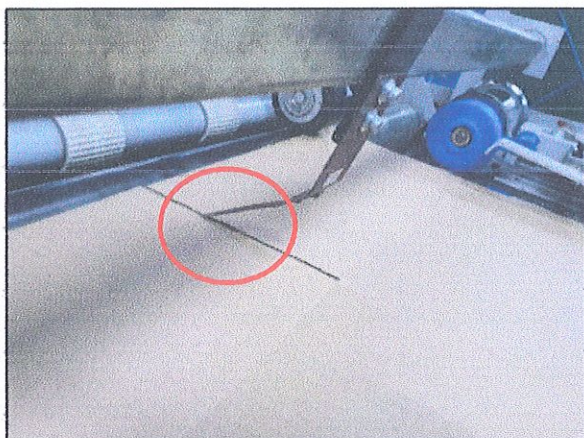
QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Status: Closed	Remarks:				
<input type="checkbox"/> Will Open		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Re-Issue IRF		Date: 21 Dec 20	Date: 21 Dec 20	Date: 21 Dec 20	Date: 21 Dec 20
DATE AND SIGNATURE					

INVESTIGATION REPORT FOR BURSTING OF SANYO DENKI

00958254-01 BOX PRINT SPECIFICATION

DIRECT CAUSE PROCESS/MATERIAL

W1- Item undergo auto stripping process in Diecut S1700. Since we don't have standard in using of stripping jig, the stripping jig they used is not so flexible and caused bursting of affected items.



1.0 ton Stripping Jig

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL

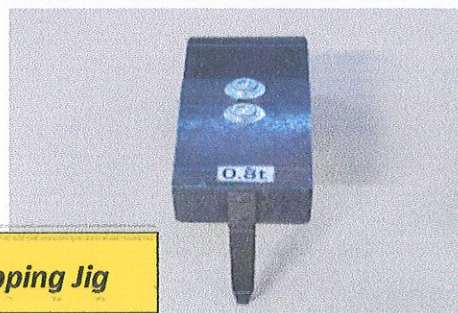
W1- Upon trial run there is no occurrence of bursting occurs

W2- During sampling operator notice the random occurrence of bursting they immediately check what is the problem and they found out that the stripping jig is the caused of bursting.

W3- Since the occurrence is randomly and not to stop the machine, they just inform the Leader in charge and Gluing Operator to sort the Panel-A of the items before process due to random occurrence of bursting..

IMMEDIATE / REMEDIAL ACTION

Operator immediately removed the 1.0 ton stripping jig and replaced it by more flexible 0.8 ton stripping jig



0.8 ton Stripping Jig

PRODUCTION CORRECTIVE ACTION

Pull out the 1.0 ton stripping jig in Diecut S1700 and store it in tooling since the 0.8ton can also used in auto stripping of hard materials.

PIC:

PRODUCTION

TARGET DATE:

200604

PREPARED BY:

[Signature]
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature]
WEENA V. APALLA
GR. SUPERVISOR