

**KANEPACKAGE PHILIPPINE INC.**

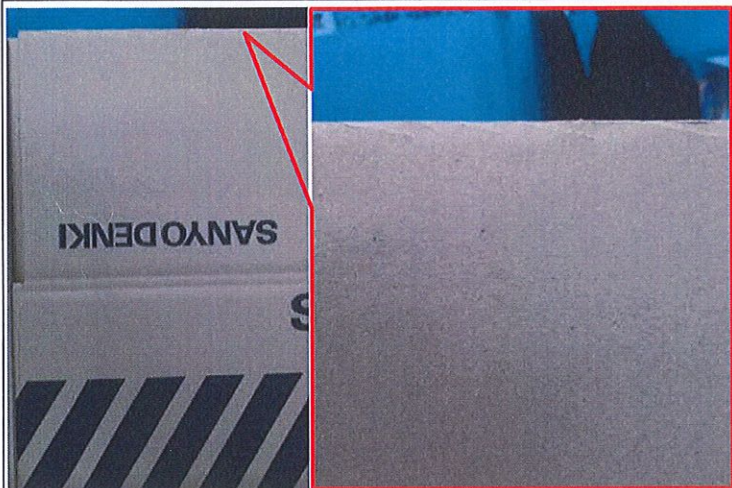
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 428

Date Issued: 21 06 01

Customer	SANYO DENKI	Attention To	Mr. Gerald De Guzman
Item Code	00918237-01	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	21 06 01
Job Order Number	JO21-M-00866-34	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
900		91	10.11%
Nature of Defect:			
BURSTING ON EDGE			
Requirement:			
Bursting on edge should be located in the bottom flaps			
Actual:			
Bursting on edge is located in upper flaps			

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: 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**

- *BURSTING ON EDGE TO RAW MATS
FROM SUPPLIER*

- *NO INFORMATION & TAG
FOR THE OCCURRENCE OF BURSTING*

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

II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)Date Conducted: 21 06 02PIC: A. Vergara**Identified Rootcause****Recommendation**

Wrong positioning of cracking, because there are 91 pieces of boards that the facing of cracking is in the opposite side

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 05	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is implemented
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 06 26	<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	QUALITY ASSURANCE DEPARTMENT		
<input type="checkbox"/> Still Open			
<input type="checkbox"/> Re-Issue IRF			
CLOSED		QA Supervisor	QA Ass. Manager
		Date: 21 06 26	Date: 21 06 26
			IRISH MAY L. ESTAREJA Line Leader
			Department Head
			Date: 21 06 26

**DATE AND
SIGNATURE**

[Signature]
21 06 26

INVESTIGATION REPORT FOR BURSTING ON EDGE OF SANYO DENKI 00918237-01 PACKAGE

DIRECT CAUSE PROCESS/MATERIAL	W1- Bursting on the edge happened in Supplier side, since the Raw materials is actual and only Egos & Gluing are in-house process.
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INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- There is random filing of raw materials with bursting on edge issued in Egos.
	W2- Egos feeder operator did not notice the bursting on edge since only fast browsing are required during feeding in Egos and no information or tag that the raw materials have occurrence of bursting on edge.

PRODUCTION CORRECTIVE ACTION

Horizontal Implementation to IQA and Supplier our practice in Slotter to face the bursting on edge in one side only with tag and information to Egos operator.			
PIC:	QA	TARGET DATE:	TO BE DISCUSS IN 4PM MEETING

PREPARED BY:

 210603
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

 210603
WEENA V. APALLA
SR. SUPERVISOR