

**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.: 429

Date Issued: 21 06 07

Customer: SANYO DENKI

Attention To: Mr. Gerald De Guzman

Item Code: 00918237-01

Department: PRODUCTION

Item Description: CORRUGATED CARTON

Date of Detection: 21 06 03

Job Order Number: 1021-M-00866-39

Section Detected: QA - IN LINE

ILLUSTRATION OF THE PROBLEM

☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

419

149

35.56%

Nature of Defect:

POOR PRINT

Requirement:

NO POOR PRINT ON THE SOLID IMAGE

Actual:

W/ POOR PRINT ON THE SOLID IMAGE

NO. OF OCCURRENCE

DISPOSITION

AREA OF OCCURRENCE / ORIGIN

CONTENT



First



Hold



Slotter



Gluing



Material



Recurrence



Special Acceptance



EQOS



Vertical



Dimension

No.: _____



For Rework



Diecut



Others: _____



Appearance

Date: _____



Reject / Disposal



Detaching



Process / Method

Issued by

Checked by

Approved by

Received by
(Receiving Section)

Adrian Vergara
Adrian Vergara
QA-IE Staff

Mr. Roderick Ramos
Mr. Roderick Ramos
QA Supervisor

Mr. Rexel Almario
Mr. Rexel Almario
QA Asst. Manager

Mr. Gerald De Guzman
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:
Why 4:
Why 5:

N/A

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

N/A

Design / Toolings

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

N/A

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

N/A

Process / Material

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

PLS. SEE ATTACHED

Why 1:
Why 2:
Why 3:
Why 4:
Why 5:

PLS. SEE ATTACHED

**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)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

- ROUGH TEXTURE OF MATERIALS AND
HARD CYREL

OUTFLOW ROOTCAUSE

- 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

	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	N/A	Time	N/A
Title	N/A		
Attendees	N/A		

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 06 09

PIC: A. Vergara

Identified Rootcause

The materials' surface is rough.

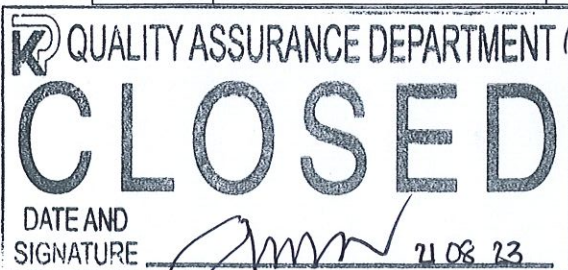
Recommendation**III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)**

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 07 27	[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 08 23	[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:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed			
<input type="checkbox"/> Still Open		QA Supervisor	QA Asst. Manager
<input type="checkbox"/> Re-Issue IRF		Date: 21 08 23	Date: 21 08 23
			
			IRISH MAY L. ESTAREJA Line Leader
			
			Department Head
			Date: 21 08 23



INVESTIGATION REPORT FOR POOR PRINT OF SANYO DENKI 00918237-01 CORRUGATED CARTON

DIRECT CAUSE PROCESS/MATERIAL	W1- The texture of the surface of material is rough and the cyrel composed of hard cyrel.
	W2- Due to rough texture of material the hard cyrel did not penetrate well in the solid image print that caused poor print.



The flexoplate of the item is composed of Hard flexoplates



Based on the actual condition of boards the surface of materials' kraftliner is rough

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Poor print didn't occurs during trial run, since the trial run approved by QA Patrol why the Egos proceed to mass production.
	W2- Possible the occurrence is randomly and did not trap during sampling since every sampling must conducted checking by main operator & QA Patrol

PRODUCTION CORRECTIVE ACTION


Since the rough texture of materials is inherent to UPPC according to QA our counter measure is the replacement of cyrel from Hard cyrel to combination of Hard & Soft cyrel, since on ME study the Soft cyrel is much better in solid image print.

PIC:	PRODUCTION	TARGET DATE:	210609
-------------	-------------------	---------------------	---------------

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
 SR. SUPERVISOR

UPDATES:

BEFORE



Old flexoplate was composed of hard plates



Solid layouts are soft flexoplates

REMARKS: New cyrel is for monitoring of effectiveness