

**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

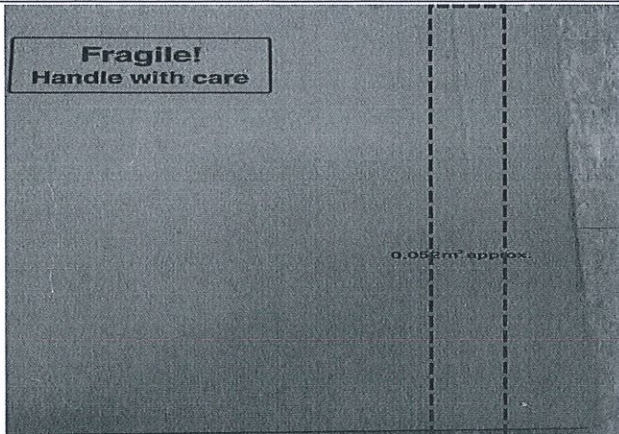
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 436

Date Issued: 21 06 24

Customer	SHIMADZU	Attention To	Mr. Gerald De Guzman
Item Code	321-62392-12	Department	PRODUCTION
Item Description	CORRUGATED BOX LARGE	Date of Detection	21 06 23
Job Order Number	JO21-R-00144-7	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM

☐ Major☒ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
305	106	34.75%

Nature of Defect:

SCORING

Requirement:

SCORING is not acceptable

Actual:

W/ Scoring - 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 type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input checked="" 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. Rex Almarin 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: 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**

- FG ITEM PALLETIZED IN ALMOST
2 DAYS

- LACK OF INFORMATION

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

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 Oct 25

PIC: A. Vergara

Identified Rootcause**Recommendation**

The carton boxes was stacked in the pallet
for 2 days because there was a confusion where
it will be inspected.

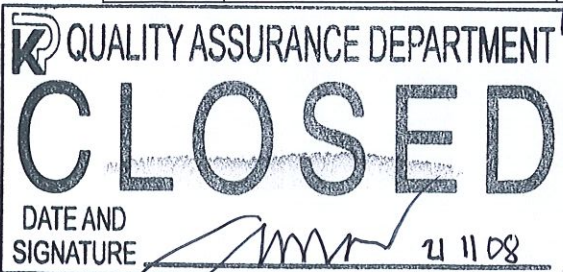
III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 Oct 25	<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 Nov 25	<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.

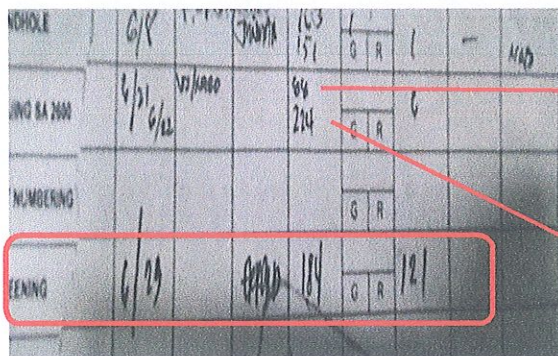
IV. CLOSURE

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 Date: 21 11 08	 QA Asst. Manager Date: 21 11 08
		 IRISH MAY L. ESTAREJA Line Leader Date: 21 11 08	 Department Head Date: 21 11 08



INVESTIGATION REPORT FOR SCORING OF SHIMADZU 321-62392-12 CORRUGATED BOX LARGE

DIRECT CAUSE PROCESS/MATERIAL	W1- Item newly transfer the process in Semi-Auto Gluing by MPD.
	W2- Since it was newly transfer Production Leader and IE conducted assessment before the approval of mass production.
	W3- Semi-Auto Gluing operator palletized the item and transfer in QA Screening-3 because according to Semi-auto online QA the item was assign in QA Screening-3.
	W4- Gluing process finished and transferred to QA Screening-3 last June 21 and 22, 2021 but it was checked June 23, 2021.
	W5- Scoring occurs because the item was palletized in almost 2 days.



210621	SHIMADZU	321-62392-12	88	0144-7	BRALO	PAKAL	17/21
PRODUCTION TRANSMITTAL JUNE 21, 2021							

210622	SHIMADZU	321-62392-12	230	0144-7	BRALO	PAKAL	17/21
PRODUCTION TRANSMITTAL JUNE 22, 2021							

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Item palletized because is has need to transfer in QA Screening-3.
	W2- Operator didn't expect that after the transfer of item it was remain in the pallet in almost 2 days since the MPD advised that there have enough returnable box.

PRODUCTION CORRECTIVE ACTION

> Since the item is transfer in Semi-Auto Gluing if possible the QA Online in Semi-Auto Gluing is the one who will check the item to avoid the palletizing.

> Cascading of information in all affected department, if there is revision process in the items.

PIC:	PRODUCTION/QA/MPD	TARGET DATE:	TO BE DISCUSS IN 4PM MEETING
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PREPARED BY:

210625
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

210625
WEENA V. APALLA
SR. SUPERVISOR