



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

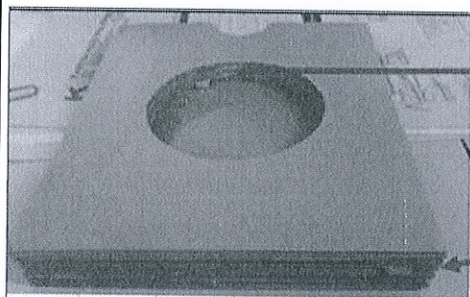
Control No.: 461

Date Issued: 21 09 03

Customer: NIDEC SUBIC
Item Code: N / A
Item Description: KIVA DUNNAGE BOTTOM
Job Order Number: JO-21-IPD-00611-5B

Attention To: Mr. Gerald De Guzman
Department: PRODUCTION / QA
Date of Detection: 21 09 03
Section Detected: CUSTOMER - NIDEC SUBIC

ILLUSTRATION OF THE PROBLEM



3 Layer's

5 layer's

☒ Major

☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

754

30

3.98%

Nature of Defect:

OFF SPECS.

Requirement:

Total number of layers is 6 pcs.; Total number of layers for Part B is 4 pcs.

Actual:

Total number of layers is 5 pcs.; Total number of layers for Part B is 3 pcs.

NO. OF OCCURRENCE

☒ First
☐ Recurrence

No.: _____
Date: _____

DISPOSITION

☐ Hold
☐ Special Acceptance
☐ For Rework
☒ Reject / Disposal

AREA OF OCCURRENCE / ORIGIN

☐ Slotter
☐ EQOS
☐ Diecut
☐ Detaching
☒ Gluing
☐ Vertical
☐ Others: _____

CONTENT

☐ Material
☒ Dimension
☒ Appearance
☐ 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:
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

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

— OPERATOR MISLOOK THE QUANTITY

— DUE TO 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			
RM	N/A				System	N/A	
WIP	N/A						
FG	N/A						

B. Orientation**Design / Tools**

Date	N/A	Time	N/A	Design / Tools	N/A	
Title	N/A					
Attendees	N/A					

C. Reworking**Process**

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

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

Date Conducted: 21 09 06

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The operator mislook the affected part
> The QA inspector did not verify the number of layers bonded

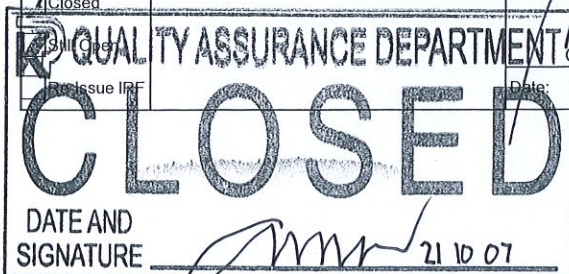
III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 09 08	<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 10 07	<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.

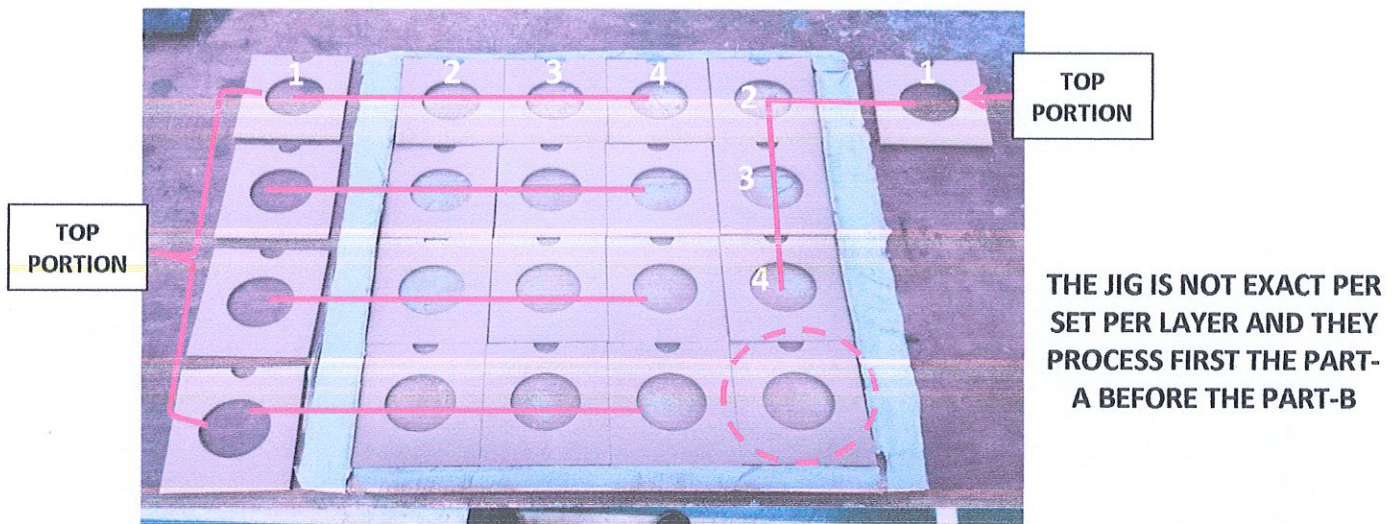
IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed			
		QA Supervisor	QA Asst. Manager
			IRISH MAY L. ESTAREJA Line Leader
			Department Head
		Date: 21 10 07	Date: 21 10 07



INVESTIGATION REPORT FOR OFF SPECS OF NIDEC SUBIC DUNNAGE BOTTOM

DIRECT CAUSE PROCESS/MATERIAL	W1- There's a factor that the operator mislook the quantity required for Part-B that caused Off Specs.
	W2- Because the jig they used in assembly of dunnage is not exact quantity per set per layer.



INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Operator did not notice the Off Specs since after curing time they palletized the item for QA Checking.
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PRODUCTION CORRECTIVE ACTION

1. Make Jig with exact quantity per set per layer for Top & Bottom Dunnage.
2. After Finish the Jig orient the operator for the proper usage of Jig and dispose the existing jig.

PIC:	PRODUCTION	TARGET DATE:	210908
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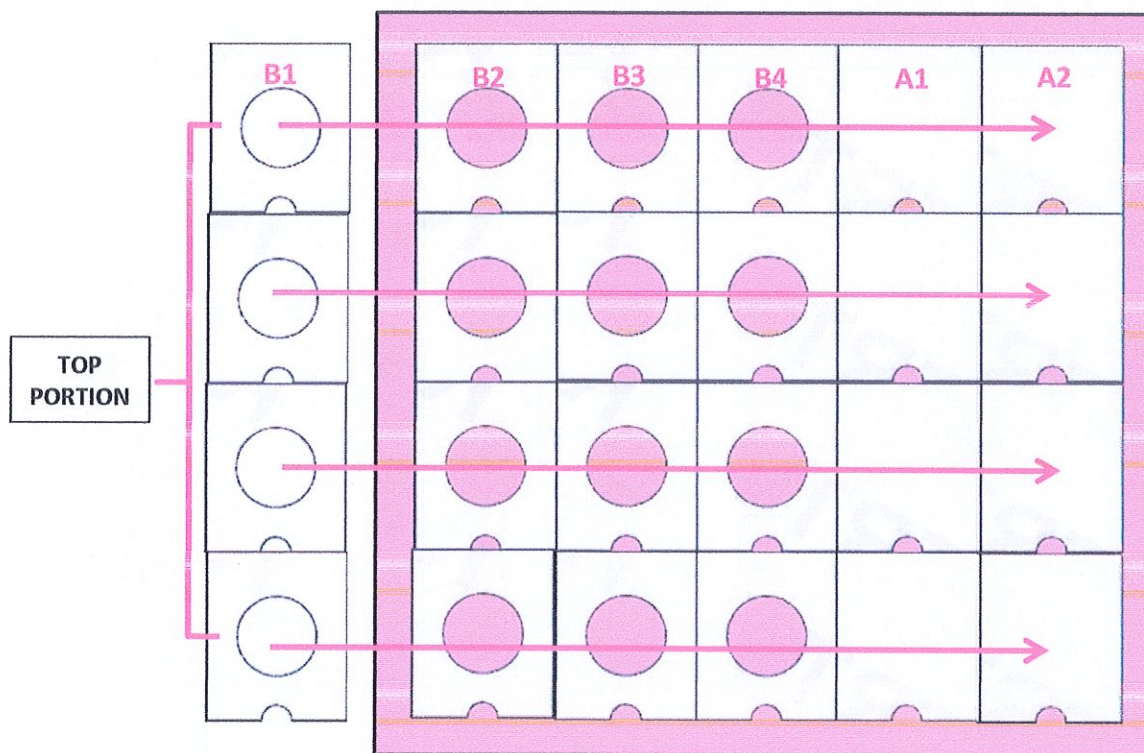
PREPARED BY:

[Signature] 210908
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR

FOUR SET JIG PROPOSAL



QA – ROOTCAUSE ANALYSIS:

5M REVIEW	
FACTOR	DETAILS
MAN	Overlook layer
METHOD	NO CHANGES
MACHINE	NO CHANGES
MATERIAL	NO CHANGES
ENVIRONMENT	NO CHANGES

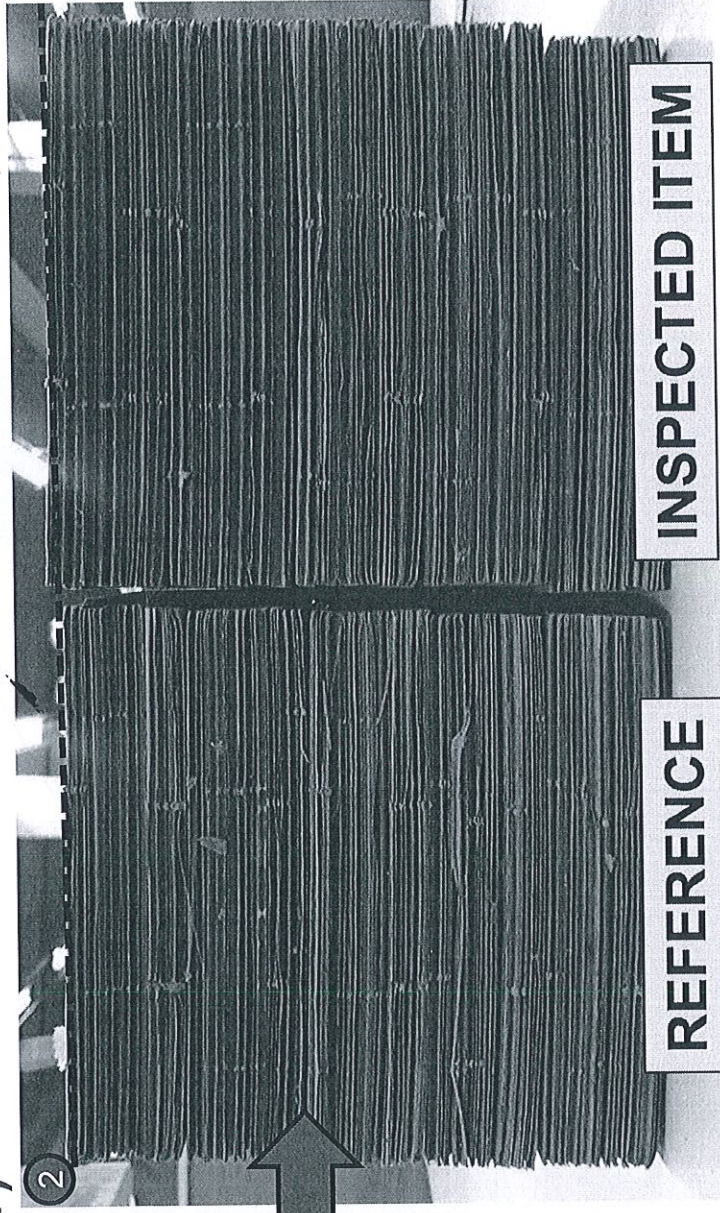
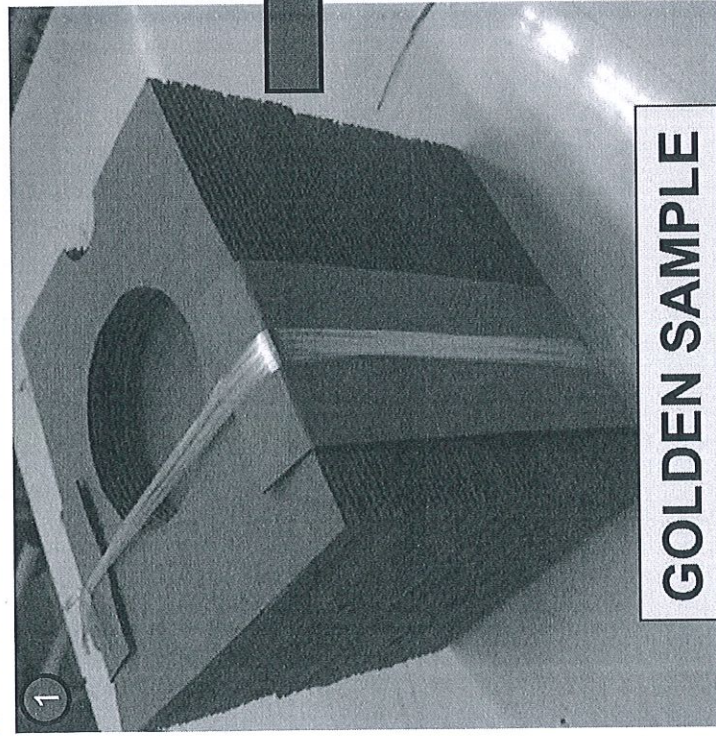
ROOTCAUSE ANALYSIS:

1. The QA Inspector overlook the missing layer of the item.
2. since the QA does not count 100% the layers of each dunnage.
3. Since they conduct 3 pieces of dimension checking per lot based on the standards.

QA - ACTION PLAN:

>Provision of golden sample (wherein the samples are bundled together) for height reference of QA prior bundling process.

(SAMPLE ILLUSTRATION ONLY)



NOTE: If the item is unequal with the height of the golden sample it is subject for 1 by 1 checking.

DUNNAGE HEIGHT JIGS:

