

**KANEPACKAGE PHILIPPINE INC.**

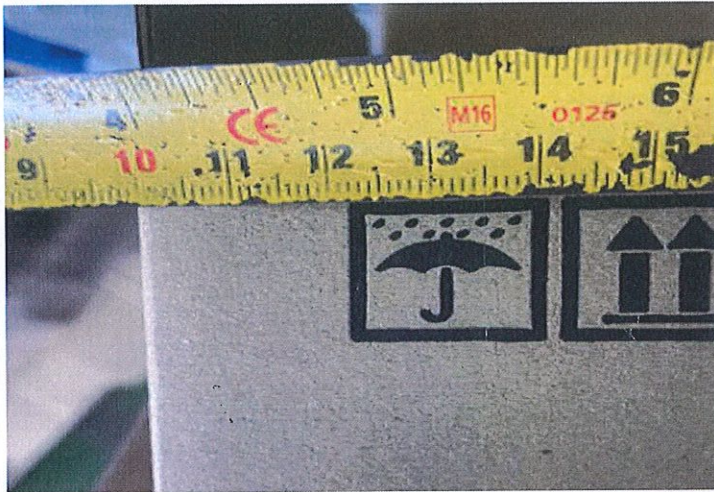
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 466

Date Issued: 210915

Customer	SANYO DENKI PHILS. INC.	Attention To	Mr. Gerald De Guzman
Item Code	00949344-01	Department	Production
Item Description	PRINT SPECIFICATION	Date of Detection	210914
Job Order Number	JO21-M-01485-125	Section Detected	SD1800 d1 QA-Screening

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

3,500

334

9.54%

Nature of Defect:

MISALIGN PRINT

Requirement:

should be 8mm distance from creasing line to the print with a print tolerance of
+/- 3mm

Actual:

Exceed the print tolerance by 11mm

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input checked="" type="checkbox"/> Dimension
No.: 4TH	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Appearance
Date: 210914	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
 Rochelle Evangelista QA-IE Staff	 Roderick Ramos QA Supervisor	 Rexel Amario QA Asst. Manager	 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**

- WARP MATERIALS

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	SD1800	3,500	173	3,327
FG	QA - SCREENING	4,000	186	3,814

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 09 17

PIC: A. Vergara

Identified Rootcause

The material used has a random occurrence of warp.

Recommendation

Recondition the materials by staggered piling & laying of weight jigs.

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 17	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation is implemented
2nd Verification of Action	A. Vergara	21 09 21	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	C.A. will not pursue since the GPR will decrease
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 11 02	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation 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: <input checked="" type="checkbox"/> Closed	Remarks:	Approved by:		Process Owner Acknowledgment: (Receiving Section)	
QUALITY ASSURANCE DEPARTMENT CLOSED DATE AND SIGNATURE: 21 11 02		QA Supervisor	QA Asst. Manager	IRISH MAY L. ESTAREJA Line Leader	Department Head
		Date: 21 11 03	Date: 21 11 03	Date: 21 11 03	Date: 21 11 03

INVESTIGATION REPORT FOR MISALIGN PRINT OF SANYO DENKI 00949344-01 PRINT SPECIFICATION

DIRECT CAUSE PROCESS/MATERIAL	W1- Eterna operator encounter machine error in feeder due to Warp Materials.
	W2- There's a factor that due to warp materials there is movement happened in printed sheet during Eterna process that caused misalignment.

Activity		Start		Finish	
1	Warm up Maintenance / Preparation	0324	0330	0400	
2	Welding	0331	0322		
3	Material Waiting / J.O				
4	Breakdown				
5	Upgrading (J.O, 17, 18, 19, 20, 21)	0322	0330		
6	Machine Set-up	0330	0334		
7	1. Take out pressure inside				
8	2. Set up wedge blade				
9	3. Set up wedge				
10	4. Take out wedge				
11	5. Tighten				
12	6. J.O. Checkup / Approval				

23 mine machine
error warp noise
stock up feeder
dries.

<p>INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL</p>	<p>W1- Even the operator notice the movement during sampling it is within the $\pm 3\text{mm}$ tolerance they did not trap the worst misalignment during sampling since the occurrence is randomly.</p>
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PRODUCTION CORRECTIVE ACTION

From 3-outs to 1-out since the 00949344-01 is common to 00902009-01. The 00902009-01 used 1-out cyrel and die-blade as counter measure to misalign print since the big sheets is prone in warpage and in almost a year no occurrence of misalign print in Sanyo Denki 00902009.

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

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR

Sheet size 3 outs = ? } BF
Sheet size 1 out = ? }