					*		
	KANEPACKAG	SE PHILIPPINE INC.	INVESTIGATION REPORT FORM (IRF)				
K	Telephone No. (049) 545-7166 to Fax No. (049) 545-6302		Inhouse Detection	in	Customer Claim		
	Fax No. (049) 545-6302		Control No.: 610	Date I	ssued: 22 08 04		
Customer		, SANYO DENKI	Attention To	Attention To Gerald De Guz			
Item Code	9	00939007-01	Department PRODUCTION				
Item Desc	cription	CORRUGATED CARTON	Date of Detection		22 08 03		
Job Order	r Number	JO22-M-01548-13	Section Detected QA-SCREENING				
	ILLUSTRATION O	F THE PROBLEM	Major		Minor		
	F-1		Lot Quantity (pcs.)	Reject Quantity (	pcs.) Reject Percentage		
			1,000	43	4.30%		
	HANDLE WITH CARE		Nature of Defect:	Charles and a second			
*****	HANDLE WITH CARE		record roots so re-sol				
SA	ANYODENK			MISALIGN GLI	JE		
			Requirement:				
		LLIMBERE	Noqui on one				
		LADOP AS NOT	not misalign glue				
			Actual:	ALIA TELEPINA			
			Actual.				
				misalign gluin	g		
	NO. OF OCCURRENCE	DISPOSITION	AREA OF OC	CURRENCE / ORIGIN	CONTENT		
	irst	Hold	Slotter	Gluing	Material		
	ecurrence	Special Acceptance	EQOS	Vertical	Dimension		
	lo.:	For Rework	Diecut	Others:			
	000000			Others.	Appearance		
Di	rate:	Reject / Disposal	Detaching	Participation and the second	Process / Method Received by		
	Issued by	Checked by	Approved	з бу	(Receiving Section)		
		Mally 220get		16	10802 2080d		
	Rochelle Evangelista	Roderick Ramos	Rexel Alm	1	Gerald De Guzman		
	QA-IE Staff	QA Sr. Supervisor	QA Asst. Ma	anager	Head/ Supervisor		
	NDECT CALLSE: /Analyze the resea		TON / ANALYSIS	SE: (Anglyza the reason of	of occurrence, why it leaked?)		
100 march 1989		on of occurrence, why it happened?)		SE: (Analyze the reason o	or occurrence, why it leaked?)		
	/hy 1:		Why 1:				
Tai	/hy 2:	/4	Why 2:	41/			
/ mea		, ,	Why 3:	N/	4		
100.5	/hy 4:		Why 4:				
	/hy 5:		Why 5:.				
	/hy 1:		Why 1:				
riloo W	/hy 2:	<sup>2</sup> /*	Why 2:	1/2			
Design / Toolings	/hy 3:	/*	Why 3:	,			
Desi	/hy 4:		Why 4:				
WI	/hy 5:		Why 5:				
100 000	/hy 1:		Why 1:				
/ateri	/hy 2:	5	Why 2:	PLS. SEE	ATTAINED		
Process / Material	/hy 3: PLS.	STE ATTACHED	Why 3:	FLS. SEE	/ II (MONC)		
Noce M	/hy 4:		Why 4:	125			
<u></u>			144				

No. 5 Ring Roa	PACKAGE PHILIPPINE INC. of LISP II, Brgy. La Mesa, Calamba City, Laguna (049) 545-7166 to 69 545-6302	INVESTIGA  Inhouse Detection  Control No.: 609	TION REPORT  Custo  Date Issued:	FORM (IRF) mer Claim 22 07 28			
Customer	* SANYO DENKI	Attention To	Gerald D	e Guzman			
Item Code	00939007-01	Department	PRODU	JCTION			
Item Description	CORRUGATED CARTON	Date of Detection	22 0	8 02			
Job Order Number	JO22-M-01548-13	Section Detected QA-SCREENING					
ILLU	JSTRATION OF THE PROBLEM	Major	Minor				
NK		Lot Quantity (pcs.)  1,000  Nature of Defect:	Reject Quantity (pcs.) 85	Reject Percentage 8.50%			
		Requirement:					
		family 1	No occurrence of glue stain				
		Actual:					
		occurrence of glue stain					
NO. OF OCCURREN	NCE DISPOSITION	AREA OF OCCUI	RRENCE / 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			
Rochelle Edangelis QA/E Staff	QA Sr. Supervisor	Rexel Almario QA Asst. Manag		rald De Guzman			
PIDEOT ON A	地名美国西美国西西西西西西西西西西西西西西西西西西西西西西西西西西西西西西西西西	TION / ANALYSIS	The Land Fresh III				
Why 1:	lyze the reason of occurrence, why it happened?)	INDIRECT CAUSE: (	(Analyze the reason of occurre	nce, why it leaked?)			
Why 2:  Why 4:  Why 5:	P/A	Why 2: Why 3: Why 4: Why 5:	rs/k				
Why 1:  Sb LL Why 2:		Why 1: Why 2:		*			
Why 2: Why 3: Why 4:	P/L	Why 3:	PA				
Why 4:	X =	Why 4:					
Why 5:		Why 5:					
Why 1:		Why 1:					
Why 2: Why 3: Why 4:		Why 2:					
Why 3:	PLS. SEE ATTAGLED	Why 3: PLS. SEE ATTACHED					
Why 4:		Why 4:					
区 Why 5:		Why 5:					

## 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 CON	ICLUSION			
	OCCURRENCE RÓOTCAUS	E			OUTFLOW ROOTCAUSE		
- FICT PROCESS	OF MANUAL G	EWING	- PANDOMLY DECUMENCE				
IMMEDIATE ACTION: (A	action to be done to contain/ tempor	rary correct the pro	oblem found)	CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)			
A. Sorting Result				Act	tions to be done to eliminate recurrence	Who / When	
Loca	ation Total Stock	NG	Total Good				
RM				0 1	. 2 .		
WIP				System	P/A		
FG					TO A CONTROL OF THE ANALYSIS O		
B. Orientation							
Date	Time			Design /	N/A		
Title				Tools	/4		
Attendees	1						
C. Reworking							
Rework Quantity				Droope	PLS. SEE ATTACHED		
Total Good				Process	1 2 100 111101110		
Rework Percentage (Good)							
II. QA ROOTCAUSE V	ERIFICATION (To be filled	out by QA In-	charge)	Date Conducted:_	PIC:	_	
	Identified Rootcause			Recommendation			
High	Pilling of item	•			M		
	III. CORRI	ECTIVE ACTIO	N VERIFICATION	ON (To be filled or	ut by QA In-charge)		
	Checked by	Date	Implem	ented?	Remarks		
1st Verification of Action	L. EVANGERISTA	220825	[ Yes	[ ] No	r/k		

	Checked by	Date	Implem	nented?	Remarks
1st Verification of Action	L. EVANGENITA	290842	[ XYes	[ ¸ ] No	N/A
2nd Verification of Action			[ ]Yes	[ ] No	
3rd Verification of Action			[ ]Yes	[ ] No	
Effectiveness of Action			[ ]Yes	[ ] No	

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.

MOLIALITY	ACCUD	ANCE	VEDA:	371.400	7	IV. CLC	OSURE	Market and a second	
Status	Remark	AINCE L	JEPAH	KIMENT		Appro	ved by:	Process Owner Acknowled	dgment: (Receiving Section)
Closed Still open		S	-	QAS	per	visor Ma	QA Asst. Manager	Line Leader	Department Head
PRE-IDATEFAND			1.4	Date:		/	Date: 22/20)	Date:	Date:
SIGNATURE	X	291130			/			\$F	

## INVESTIGATION REPORT FOR MISALIGN & GLUE STAIN OF SANYO DENKI 00939007-01 CORRUGATED CARTON

	W1	SA2600 has many items that time and ask support to Leaders since only one machine is running that time.					
DIRECT CAUSE	W2	Leader asked the Manual Gluing operator to get items in SA2600 since no available items for process in Manual Gluing.					
PROCESS/MATERIAL	W3	There is a factor that the Manual Gluing operator Pile the item higher than usual after glue application.					
	W4	Since item is small and pile it higher there is possibility that the item slip after putting weight jig that caused misalign and glue stain.					

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	Manual Gluing operator didn't notice the random occurrence of misalign and glue stain since their frequency of sampling is only at the first, middle and last of mass production.
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## PRODUCTION CORRECTIVE ACTION

- 1. Orient the Manual Gluing operator to pile the item according to standard gluing quantity per batch per flute, and palletize the remaining batch after applying weight jig to the next batch specially in small boxes.
- 2 Orient the Production Leader to always priority the gluing process of RSC Box in SA2600 since the machine have glue applicator and Jogger that avoid misalign and excess glue.

3. Piling height Gendard (quidelines by pictures) 10: 220313

PIC: PRODUCTION TARGET DATE: 220809

PREPARED BY:

GERALD DE GUZMAN PROD-ASST: SUPERVISOR APPROVED BY:

WEENA V. APALLA ASST. MANAGER