

**KANEPACKAGE PHILIPPINE INC.**

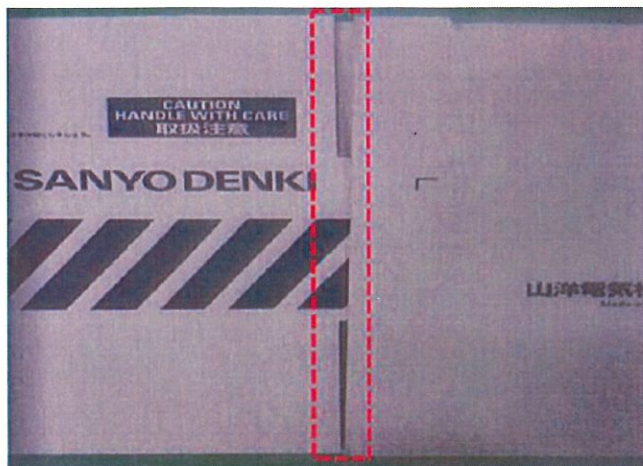
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 610

Date Issued: 22 08 04

Customer	SANYO DENKI	Attention To	Gerald De Guzman
Item Code	00939007-01	Department	PRODUCTION
Item Description	CORRUGATED CARTON	Date of Detection	22 08 03
Job Order Number	JO22-M-01548-13	Section Detected	QA-SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1,000	43	4.30%
Nature of Defect:		
MISALIGN GLUE		
Requirement:		
not misalign glue		
Actual:		
misalign gluing		

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input checked="" type="checkbox"/> Gluing	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension
No.:	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Others:	<input checked="" type="checkbox"/> Appearance
Date:	<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 Sr. Supervisor	Rexel Almario 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:	

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.: 609

Date Issued: 22 07 28

Customer	SANYO DENKI	Attention To	Gerald De Guzman
Item Code	00939007-01	Department	PRODUCTION
Item Description	CORRUGATED CARTON	Date of Detection	22 08 02
Job Order Number	JO22-M-01548-13	Section Detected	QA-SCREENING

ILLUSTRATION OF THE PROBLEM



☒ Major

☐ Minor

Lot Quantity (pcs.)

1,000

Reject Quantity (pcs.)

85

Reject Percentage

8.50%

Nature of Defect:

GLUE STAIN

Requirement:

No occurrence of glue stain

Actual:

occurrence of glue stain

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)

Rochelle Evangelista
QA IE Staff

Roderick Ramos
QA Sr. Supervisor

Rexel Almario
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:
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

- ITEM PROCESS IN MANUAL GLWING AND
PILE IT HIGHER THAN USUAL.

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				
WIP				
FG				

Actions to be done to eliminate recurrence

Who / When

System

N/A

B. Orientation

Date	Time
Title	
Attendees	

Design /
Tools

N/A

C. Reworking

Rework Quantity	
Total Good	
Rework Percentage (Good)	

Process

PLS. SEE ATTACHED

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

Date Conducted: _____ PIC: _____

Identified Rootcause

High Piling of item.

Recommendation

N/A

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	R. PANGKUSTA	220825	[X] Yes [] 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.

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			
DATE AND SIGNATURE	DATE	DATE	DATE
221130		22/201	

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

DIRECT CAUSE PROCESS/MATERIAL	W1	SA2600 has many items that time and ask support to Leaders since only one machine is running that time.
	W2	Leader asked the Manual Gluing operator to get items in SA2600 since no available items for process in Manual Gluing.
	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.
--	-----------	---

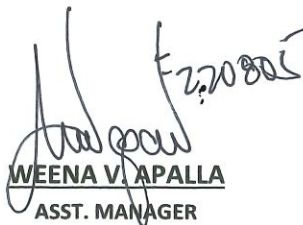
PRODUCTION CORRECTIVE ACTION

<p>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.</p> <p>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.</p> <p>3. Piling height standard (guidelines by pictures) TO: 220812</p>			
PIC:	PRODUCTION	TARGET DATE:	220809

PREPARED BY:


GERALD DE GUZMAN
 PROD-ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
 ASST. MANAGER