

**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.: 623

Date Issued: 22 09 14

Customer	NIDEC SUBIC	Attention To	Gerald De Guzman
Item Code	VR-D	Department	PRODUCTION
Item Description	RYZXD000003 BOX	Date of Detection	22 09 13
Job Order Number	JO22-M-01958-27	Section Detected	QA-SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1,000	40	4.00%

Nature of Defect:

INK STAIN

Requirement:

No occurrence of ink stain

Actual:

black stain on different areas of the item

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.:	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<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 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	PLS. SEE ATTACHED	Why 3:	PLS. SEE ATTACHED
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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

- REMAINING RESIDUE OF BLACK INK

- 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**Actions to be done to eliminate recurrence****Who / When**

	Location	Total Stock	NG	Total Good
RM				
WIP				
FG				

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**Recommendation**

N/A

N/A

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	R. EVANGELISTA	220916	<input checked="" type="checkbox"/> 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	CLOSED	 230105				
<input type="checkbox"/> Still Open			QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Revisable IRF			Date:	Date:	Date:	Date:

SIGNATURE

INVESTIGATION REPORT FOR INK STAIN OF NIDEC SUBIC VR-D BOX

DIRECT CAUSE PROCESS/MATERIAL	W1	Since Egos printing unit-2 was down due to motor problem, dark and light color of ink process in Printing unit-1 only to serve the schedule requirement.
	W2	After finished the black color items, operator change to green color to process the Nidec Subic box.
	W3	Even operator washed the machine for 5mins still there is remaining residue of black ink that caused ink stain.

9/12/2022	CLEMAR	Nidec		NSP003701AB	BF/WK	Black / 9 sec	6.35mm	6.3	1.9	Skip
9/12/2022	CLEMAR	Nidec		NSP003601AB	BF/WK	Black / 9 sec	6.35mm	6.3	1.8	Skip
9/12/2022	CLEMAR	MITSUMI		19Y928G	BF/Uppc	Black / 9 sec	6.35mm	6.3	1.8	Skip
9/12/2022	CLEMAR	MITSUMI		19Y928H	BF/Uppc	Black / 9 sec	6.35mm	6.3	1.8	Skip
9/12/2022	CLEMAR	Nidec		NSP003701AB	BF/WK	P-Green / 9sec	6.35mm	6.3	1.8	Skip
9/12/2022	CLEMAR	Nidec		NSP003601AB	BF/WK	P-Green / 9sec	6.35mm	6.3	1.8	Skip
9/12/2022	CLEMAR	Nidec		NSP002901AB	BF/WK	P-Green / 9sec	6.35mm	6.3	1.8	Skip
9/12/2022	CLEMAR	Nidec		NSP003001AB	BF/WK	P-Green / 9sec	6.35mm	6.3	1.7	Skip
9/12/2022	CLEMAR	Nidec		NSP0028001B	BF/WK	P-Green / 9sec	6.35mm	6.3	1.7	Skip


INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	Operator didn't notice the occurrence of ink stain since its occurs randomly in different location together with machine speed of 100bpm Skip On mode.
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PRODUCTION CORRECTIVE ACTION

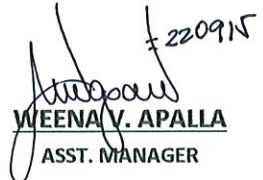
Orient the operator that if only one printing unit is available, machine cleaning standard must be adjusted to 10minutes from current of 5minutes.

PIC:	PRODUCTION	TARGET DATE:	220916
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PREPARED BY:


GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
ASST. MANAGER