



KANEPACKAGE PHILIPPINE INC.

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 5457-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)

Control No.:		Date Issued	
0012		240806	
Customer	CANON BUSINESS MACHINE PHILS.	Attention To	WEENA APALLA
Item Code	RX1-5755-000	Department	PRODUCTION
Item Description	Z10 CARTON	Date of Detection	240801
Job Order Number	JO-F-24-516-1	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1050	33	3.14
Nature of Defect:		
OVER LAP		
Requirement:		
Should be no overlap		
Actual		
+5mm overlap from folding area		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240801</u>	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input checked="" type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
ERIKA ASIS 240806	CHARLENE JAN MARIE FLORES 240806	RODERICK RAMOS 240806	GERALD DE GUZMAN 240808

I. INVESTIGATION / ANALYSIS

DIRECT CAUSE: (Analyze the reason of occurence, why it happened?)

System / Training

Design / Toolings

Process / Material

WHY 1 : W1 Based on investigation the defect is not overlap due to due to closed gap since in actual the gap in glue tab is sufficient. r n r nW2 The factor we consider in this defect is that misalign creasing of glue tab. r n r nW3 When the creasing blade hit the grain direction line which is hard portion the glue tab got misalign during pre folding in Gluing process. r n r nW4 Due to misalign creasing of glue tab the attachment at end portion of glue tab was detach and looks like overlap.

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INVESTIGATION REPORT FORM (IRF)**INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)**

System / Training

Design / Toolings

Process / Material

WHY 1 : N/A

FINAL CONCLUSION

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

WHO / WHEN

Process / Material

WHY 1: Problem is un controllable since the Diecut process of this item is in Diecut S1700 but it was reworkable by re folding the glue tab and applying small amount of glue.

QA Production // 2024-09-16

WHY 2: Inclusion in (WI PR 004 018) Work and Safety Instruction for Manual Gluing of Canon Carton Box the rework process of this defect by re folding the glue tab and applying small amount of glue.

Production IE // 2024-08-30

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

A. Sorting Result

C. Reworking

	Location	Total Stock	NG	Total Good	Rework Quantity	n/a
RM	n/a	0	0	0	Total Good	n/a
WIP	n/a	0	0	0	Rework PPM (Good)	n/a
FG	n/a	0	0	0		

B. Orientation

Date	2024-09-16	Time	15:25
Title	n/a		
Attendees	N/A		
Prepared By:		Approved By:	
GERALD DE GUZMAN 240905		REXEL ALMARIO 250205	
		Department Head	

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INVESTIGATION REPORT FORM (IRF)**II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)**

Date Conducted: 2024-08-30	PIC: M. ASIS
Identified Rootcause Misalign creasing of glue tab	Recommendation N/A

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

	Checked By:	Date	Implemented?	Running	JO Number	Date	NG Qty	Lot Qty
1st Verification of Action	M. ASIS	2024-09-03	[/] Yes [] No	1st	JO-F-24-619-1	240903	0	400
2nd Verification of Action			[] Yes [] No	2nd	JO-F-24-689-1	240912	0	1100
3rd Verification of Action			[] Yes [] No	3rd	JO-F-24-764-1	240927	0	800
Effectiveness of Action	M. ASIS	2024-10-29	[/] Yes [] No	4th	JO-F-24-764-2	241007	0	1100
Remarks:				5th	JO-F-24-872-1	241029	0	350

IV. CLOSURE

Status	Remarks
Closed IRF	Five consecutive lots running with no rejects.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250224 01:57 QA Head	KOHEI ISHII 250226 02:32 Top Management	GERALD DE GUZMAN 250303 03:13 Line Leader	REXEL ALMARIO 250507 11:27 Department Head
Date: 25252525-02-24	Date: 25252525-02-26	Date: 25252525-03-03	Date: 25252525-05-07