

**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.: 163

Date Issued: 20 02 07

Customer	CANON	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	RX1-4518-000	Department	PRODUCTION
Item Description	Z10 CARTON	Date of Detection	20 02 06
Job Order Number	WO-F-20-016-14	Section Detected	PRD - GLUING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

700

46

6.57%

Nature of Defect:

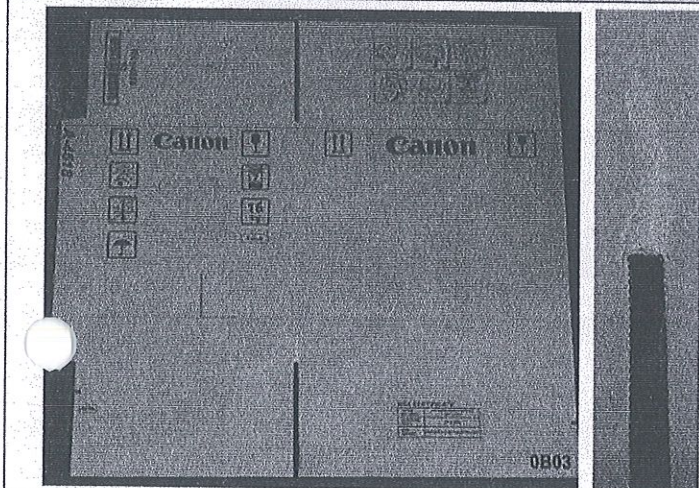
PEEL-OFF

Requirement:

Peel-off should not be exceeded on 100mm x 5mm

Actual:

100mm x 20mm peel off on the bottom slot of the box



NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
☒ First ☐ Recurrence No.: _____ Date: _____	☐ Hold ☐ Special Acceptance ☐ For Rework ☒ Reject / Disposal	☐ Slotter ☐ EQOS ☒ Diecut S1700 ☐ Detaching ☐ Gluing ☐ Vertical ☐ Others:	☐ Material ☐ Dimension ☒ Appearance ☐ Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by Mr. Roderick Ramos QA Supervisor	Approved by Mr. Rexel Almarino QA Asst. Manager	Received by (Receiving Section) Mr. Gerald De Guzman / Ms. Weena Apalla 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:	NOT A FACTOR	Why 1: Why 2: Why 3: Why 4: Why 5:	NOT A FACTOR
Design / Toolings	Why 1: Why 2: Why 3: Why 4: Why 5:	NOT A FACTOR	Why 1: Why 2: Why 3: Why 4: Why 5:	NOT A FACTOR
Process / Material	Why 1: Why 2: Why 3: Why 4: Why 5:	- INSUFFICIENT CUTTING OF DIE-BLADE DUE TO HARDNESS OF MATERIALS. - THE BACKING TAPE AND EVEN THE STEEL PLATE (LATA) WAS BREAK DURING MASS PRODUCTION. - THE UNCUT PORTION BECAME PEEL-OFF DUE TO AUTO STRIPPING PROBLESS.	Why 1: Why 2: Why 3: Why 4: Why 5:	- ITEM WAS DIE-CUTTED FACING IN THE ROUGH SURFACE ON TOP WHY THE OPERATOR DID NOT NOTICE ALL AFFECTED OF PEEL-OFF.

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

- THE UNCUT BECAME PEEL-OFF DUE TO STRIPPING PROCESS.

OUTFLOW ROOTCAUSE

- OPERATOR DID NOT NOTICE ALL THE AFFECTED OF PEEL-OFF BECAUSE ITEM WAS DIE-CUTTED IN ROUGH SURFACE ON TOP.

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	PRD-GLUING	700	46	654
FG	N/A			

Actions to be done to eliminate recurrence

Who / When

System

N/A

B. Orientation

Date	N/A	Time	N/A
Attendees	N/A		

Design / Tools

N/A

C. Reworking

Rework Quantity	N/A
Total Good	N/A
Rework Percentage (Good)	N/A

Process

- USE AND CHECK THE EFFECTIVENESS OF STEEL BACKING TAPE.
- 2ND OPTION IF STEEL BACKING TAPE IS NOT EFFECTIVE, PUT ADDITIONAL CUTTING BLADE FOR THE MANUAL DETACH OF AFFECTED PORTION (SLOT)

3PM
TERM
in
PRODUCTION
(ON-GOING)

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

Date Conducted: 20 02 08

PIC: A. Vergara

Identified Rootcause

~ Waved Blade Actual Height is 23.70mm, based on the drawing the standard should be 23.8 - still Good
~ The impact of the diecut blade is not enough to pierce the kraftliner even the pressure set is 80 ~ 90 Pa

Recommendation

~ Please refer to the corrective action
~ To monitor also the endurance capacity of backing tape to standardize the frequency of backing replacement

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 02 08	[] Yes [X] No	Waiting for next running
2nd Verification of Action	A. Vergara	20 02 15	[X] Yes [] No	QA is already implemented
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	20 03 11	[X] Yes [] No	QA is effective

QUALITY ASSURANCE DEPARTMENT
CLOSED
DATE AND SIGNATURE: [Signature] 200713

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)
☒ Closed ☐ Still Open ☐ Re-Issue IRF	It is running no occurrence of peel off	QA Supervisor: [Signature] Date: 20 07 08 QA Asst. Manager: [Signature] Date: 20 07 08 Line Leader: [Signature] Date: 200713 Department Head: [Signature] Date: 20 07 13	