

**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.: 179

Date Issued: 20 02 18

Customer	CANON	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	RX1-4585-000	Department	PRODUCTION
Item Description	Z10 BACK UP SHEET	Date of Detection	20 02 15
Job Order Number	WO-F-20-016-8	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

4511

26

0.58%

Nature of Defect:

BLOTTED PRINT

Requirement:

No ink in between of barcode line and it should be readable of barcode scanner

Actual:

The space between barcode lines have ink and cannot be read by scanner

NO. OF OCCURRENCE**DISPOSITION****AREA OF OCCURRENCE / ORIGIN****CONTENT**☐ First☐ Hold☐ Slotter☐ Gluing☐ Material☒ Recurrence☐ Special Acceptance☒ EQOS☐ Vertical☐ Dimension

No.: 2

☐ For Rework☐ Diecut☐ Others:☒ Appearance

Date: 20 02 18

☒ Reject / Disposal☐ Detaching☐ Process / Method

Issued by

Checked by

Approved by

Received by
(Receiving Section)
Adrian Vergara
QA-IE Staff
Mr. Roderick Ramos
QA Supervisor
Mr. Rexel Almario
QA Asst. ManagerMr. 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 1:	
	Why 2:		Why 2:	
	Why 3:	NOT A FACTOR	Why 3:	NOT A FACTOR
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:		Why 1:	
	Why 2:	- ITEM IS PRONE TO	Why 2:	- DESIGN APPROVED
	Why 3:	POOR PRINT BECAUSE THE	Why 3:	BY CUSTOMER
	Why 4:	PRINT IS ALIGN IN THE	Why 4:	
	Why 5:	GRAIN DIRECTION	Why 5:	
Process / Material	Why 1:	- BECAUSE THE PRINT IS ALIGN IN THE GRAIN	Why 1:	- ONLY THE TRIAL AND SAMPLING
	Why 2:	DIRECTION, THIS ITEM HAVE NO STANDARD SET-UP	Why 2:	UNDERGO OF BARCODE
	Why 3:	BETWEEN SKIP-OFF AND SKIP-ON MODE.	Why 3:	SCANNING IN EQOS.
	Why 4:	- THAT TIME THEY HAVE OCCURRENCE OF POOR PRINT TRAP	Why 4:	
	Why 5:	WHY THE LEADER INSTRUCTED THEM TO CHANGE THE SET-UP	Why 5:	

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

TO PREVENT POOR PRINT FROM SKIP-OFF MODE
LEADER INSTRUCTED THE OPERATOR TO TRY
THE SKIP-ON MODE.

OUTFLOW ROOTCAUSE

ONLY TRIAL AND SAMPLING UNDERGO OF
BARCODE SCANNING IN EQOS.

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	N/A			
FG	QA- SCREENING	4,511	26	4,485

Actions to be done to eliminate recurrence

Who / When

System

N/A

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Attachments	N/A		

Design /
Tools

CHANGE THE PRINT
LAYOUT
(SAMPLE ALREADY AVAILABLE)

C. Reworking

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

Process

FINALIZE THE STANDARD
SET-UP BETWEEN SKIP-OFF AND
SKIP-ON MODE IF THE SAMPLE
PROPOSAL IS APPROVED.

PRODUCTION
AFTER
APPROVED
THE
PROPOSAL
SAMPLE.

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

Date Conducted: 20 02 19

PIC: A. Vergara

Identified Rootcause

~ Blotted prints occurs due to tight impression
between grain direction & the rubber die, because
the grain direction (corrugated medium) is parallel
w/ the rollers of the machine & perpendicular w/
the rubber die layout

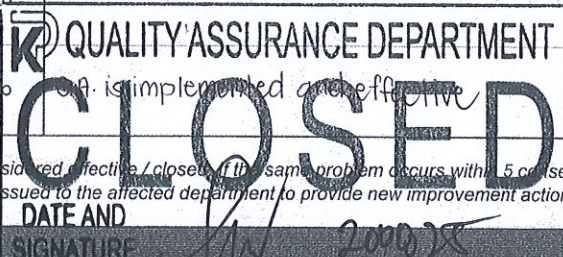
Recommendation

~ change design of the item where print location
will be change from horizontal orientation to
vertical orientation

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 17	[] Yes [X] No	With 4m application to customer waiting for approval
2nd Verification of Action	A. Vergara	20 07 09	[X] Yes [] No	4m Approved
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	20 08 12	[X] Yes [] No	QA is implemented and effective

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	No occurrence in 5 lots running but still need for 2nd verification	 QA Supervisor Date: 200825	 Line Leader Date: 200825 Department Head Date: 200825