

2384


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

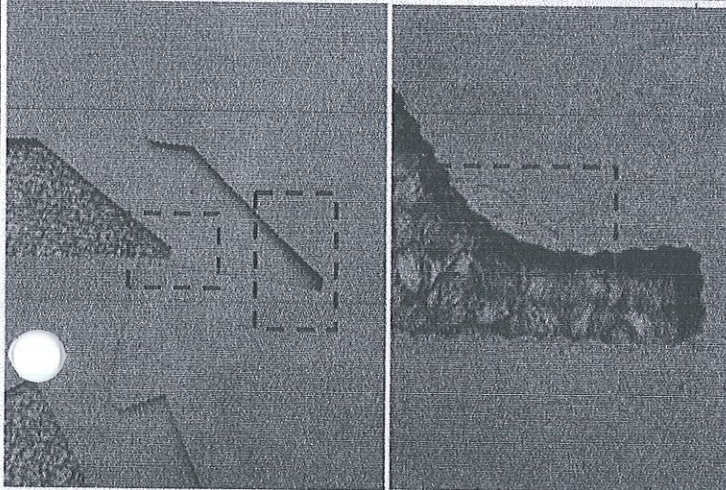
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 190

Date Issued: 20 02 26

Customer	CANON	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	RX1-5115-000	Department	PRODUCTION
Item Description	Z10_ACC_BOX	Date of Detection	20 02 25
Job Order Number	WO-F-20-032-1	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM

☐ Major

☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

3,255

459

14.10%

Nature of Defect:

Peel-off

Requirement:

No occurrence of peel-off on the item

Actual:

Peel-off occurs on the flaps and visible during assembly

NO. OF OCCURRENCE
DISPOSITION
AREA OF OCCURRENCE / ORIGIN
CONTENT
☒ First
☐ Recurrence

No.: _____

Date: _____

☐ Hold
☐ Special Acceptance
☐ For Rework
☒ Reject / Disposal

☐ Slotter
☐ EQOS
☐ Diecut
☒ Detaching
☐ Gluing
☐ Vertical
☐ Others: _____

☐ Material
☐ Dimension
☒ Appearance
☐ 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. Manager

 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

Design / Toolings

 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:

PLS. SEE ATTACHED

 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

 Why 1:
 Why 2:
 Why 3:
 Why 4:
 Why 5:

PLS. SEE ATTACHED

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

- UUCUT PORTION BECOME PEEL-OFF
DUE TO AUTO STRIPPING

OUTFLOW ROOTCAUSE

- NOT ALL 400'S ARE AFFECTED OF PEEL-OFF
AND ONLY IPC SAMPLING OF TOP PORTION
ARE REQUIRED IN EVERY BATCH OF 25PCS
RELEASED IN RECEIVER

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	3,255	459	2,796

Actions to be done to eliminate recurrence

Who / When

System

N/A

Design /
Tools

N/A

Process

PLS. SEE ATTACHED

B. Orientation

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

C. Reworking

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

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

Date Conducted: 20 02 28


PIC: A. Vergara

Identified Rootcause**Recommendation**

~ The Kraftliner was pulled down w/ the trimmings,
because there was undetached / not completely cut liner
since the pressure applied on the affected part is
not enough to pierce the liner

~ Additional Backing tape on the pattern of
the diecut blade of the item
~ Weld fully the connectors of the diecut blade

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 28	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	CA is fully implemented
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	<div> QUALITY ASSURANCE DEPARTMENT CLOSED DATE AND SIGNATURE 200804 [Signature]</div>
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	20 07 28	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> 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	NOEMI VICEPEDA	QA Supervisor	IRISH MAY L. ESTARAJA Line Leader
<input type="checkbox"/> Still Open		QA Asst. Manager	Department Head
<input type="checkbox"/> Re-Issue IRF		Date: 20 08 05	Date: 20 08 05

INVESTIGATION REPORT FOR BURSTING OF CBMP RX1-5115-000 Z10_ACC_BOX

DIRECT CAUSE PROCESS/MATERIAL	W1 - Uncut portion is inherent in diecut operation, because the blade become blunt or even the Eterna plate have deep marking of blade shots due to multiple usage of diecut blade.
	W2 - The uncut portion become Peel-Off due to auto stripping process of this item in Eterna.

INDIRECT CAUSE PROCESS/MATERIAL	W1 - Trial run approved by QA Patrol why they proceed in mass production.
	W2 - Operator did not notice the Peel-Off portion because it was too small and the item was die-cutted in the rough surface on top.
	W3 -Possible not all 4outs are affected of peel-off and only 1pc sampling of top portion are required in every batch of 25pcs released in receiver.

CORRECTIVE ACTION

> Replacement of the affected quantity.

PIC: Production / MPD

Target Date:

> Put backing tape in diecut blade to Peel-off or uncut portion.

PIC: Production

Target Date: Next Running