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KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy, La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69			INVESTIGATION REPORT FORM (IRF) Inhouse Detection Customer Claim		
Fax No.	(049) 545-6302	Control No.: 219	Date Issued:	20 06 08	
Customer	CANON	Attention To	Mr. Gerald De Guzman / Ms		
Item Code	FX2-5110-000	Department	PRODUCTION	o recona Apana	
Item Description	BOX OUTER	Date of Detection	20 06 06		
Job Order Number	WO-F-20-029-25	Section Detected			
7-12	ILLUSTRATION OF THE PROBLEM				
	12703TATION OF THE PROPERTY	Major Let Overable (see)	Minor	·	
		Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage	
		Nature of Defect:	16	5.33%	
		Nature of Derect.			
			SCUM		
		Requirement.			
	Canan	Nor	poor application of ink and no wh	nitening	
	Q q Q	Actual:		(
AY7(~\ ___\\		Appli	ication of lnk to the solid print is	uneven	
NO. OF OCCU	JRRENCE DISPOSITION	AREA OF OCC	URRENCE / ORIGIN	CONTENT	
First	Hold	Slotter	Gluing	Material	
Recurrence	Special Acceptance	EQOS	Vertical	Dimension	
No.:	For Rework	Diecut	Others:	Appearance	
Date:	Reject / Disposal	Detaching		Process / Method	
Issued	by Checked by	Approved b	yy —	Received by (Receiving Section)	
Adrian Ve QA-IE-S		Mr. Rexel Alm QA Asst. Mana	ario Mr. Gerald De	Suzmen-/ Ms. Weena Apalla ead/ Supervisor	
		GATION / ANALYSIS			
	: (Analyze the reason of occurrence, why it happened?)	INDIRECT CAUSE	: (Analyze the reason of occurre	ence, why it leaked?)	
Why 1:		Why 1:			
Why 2:		Why 2:			
System / Training Myh 3: Why 3:	NOT & FACTOR	Why 3:	T A PAC	TOR	
Why 4:		Why 4:			
Why 5:		Why 5:			
Why 1:		Why 1:		44	
Why 2:		Why 2: Why 3: NOT A FACTOR Why 4:			
Why 2: Why 3: Why 4:	NOT A FACTOR				
05 Why 4:					
Why 5:		Why 5:			
Why 1:		Why 1:			
Why 2:		Why 2:			
2					
Why 3:	PLS. SEE ATTACHED	Why 3: PLS.	SEE ATTAC	HOD	
My 3: Why 2: Why 4:	PLS. SEE ATTACHED	Why 3: PLS. Why 4:	SEE ATTAC	HED	

KANEPACKAGE PHILIPPINE INC.

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INVESTIGATION REPORT FORM (IRF)

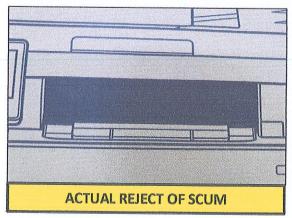
					FINAL CO	ICLUSION			
	C	CCURRENCE	ROOTCAUSE	<u> </u>			OUTFLOW ROOTCAUSE	Ē	
CYNEL	OCCURS HAVE G GH PAC	HANGES 6	ONCE THE	CYNEL		REU	TENATOR DIDT EXPECT. JECT BECAUSE IT 30 DI SOUM SHOW ON DEFECT	FFERENT	From
IMMEDIAT	TE ACTION: (A	ction to be done to	contain/ tempora	ry correct the pro	blem found)	CORRECT	TIVE ACTION: (Actions to be done to ensure that	the problem will not ha	appen agaln)
Sorting Resu	ult			er ver grand in			Actions to be done to eliminate recurrence	:e	Who / When
	Loca	ation	Total Stock	NG	Total Good				
М	NIF	}				System	11/4		
VIP	QA-IN	LINE	300	16		dystem	P/A		
·G	14	n							
Orientation	_				10 10 10 10 10				
water that the same that the	20 06 11		Time	10:22 - 10:		Design /	N/A		
itle	CCUM OF	ON REGARD JBMP FX2-	5110-000	BOX OUTE	TION FOR	Tools			
Jees	EQUS OF	GRATORS	No control and the control						
Reworking									
ework Quant	tity		N/A			Process	PLS. SET A	TALLED	D
otal Good			N/A						
ework Perce	entage (Good)	The second	N/A						

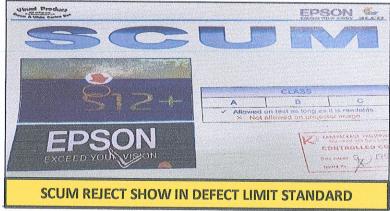
II. QA R	ROOTCAUSE \			out by QA In-	charge)	Date Conduc	sted: 20 0 (o 10) PIC: A-V	evgara	
Scum is	ssue occi	Identified F	ne item	that ha	s solid	~ Use ex	Recommendation Atra rook for chaving t	he ruhner	die perator
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INVESTIGATION REPORT FOR SCUM OF CBMP FX2-5110-000 BOX OUTER.

	$\mathbf{W1} ext{-}$ Scum occurs after operator clean the cyrel several times, due to machine stop because of machine adjustment and checking of items.
DIRECT CAUSE PROCESS/MATERIAL	W2 - The first 2 to 3pcs are possible become Scum, because sometimes cyrel is not enough dry.
	W3- The ink viscosity in cyrel have changes once the cyrel is not enough dry after cleaning.

	W1- Operator proceed to mass production.		
the second of the second secon	W2 - Trial run approved by QA Patrol.		
	W3 - Operator did not expect that is already reject, because it so different from the Scum show on defect limit standard.		





CORRECTIVE ACTION

Orient the operator to use another or new rags to dry enough the cyrel after cleaning.

PIC:	Production	TARGET DATE:	200611

Request to QA for Eqos operator training, regarding classification of reject related in printing process.

PIC:	QA	TARGET DATE:	