


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

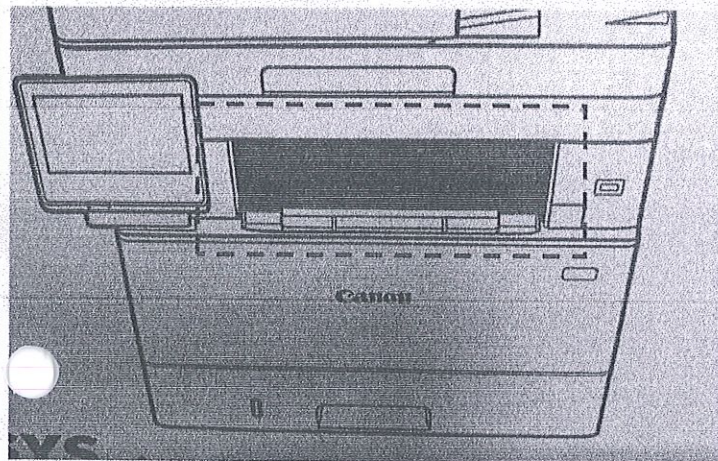
INVESTIGATION REPORT FORM (IRF)
☒ Inhouse Detection

☐ Customer Claim

Control No.: 219

Date Issued: 20 06 08

Customer	CANON	Attention To	Mr. Gerald De Guzman / Ms. Weena Apalla
Item Code	FX2-5110-000	Department	PRODUCTION
Item Description	BOX OUTER	Date of Detection	20 06 06
Job Order Number	WO-F-20-029-25	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM


<input type="checkbox"/> Major	<input checked="" type="checkbox"/> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
300	16	5.33%
Nature of Defect:		
SCUM		
Requirement:		
No poor application of ink and no whitening		
Actual:		
Application of Ink to the solid print is uneven		

NO. OF OCCURRENCE		DISPOSITION		AREA OF OCCURRENCE / ORIGIN		CONTENT	
<input checked="" type="checkbox"/> First		<input type="checkbox"/> Hold		<input type="checkbox"/> Slotter	<input type="checkbox"/> Gluing	<input type="checkbox"/> Material	
<input type="checkbox"/> Recurrence		<input type="checkbox"/> Special Acceptance		<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension	
No.: _____		<input type="checkbox"/> For Rework		<input type="checkbox"/> Diecut	<input type="checkbox"/> Others: _____	<input checked="" type="checkbox"/> Appearance	
Date: _____		<input checked="" type="checkbox"/> Reject / Disposal		<input type="checkbox"/> Detaching		<input type="checkbox"/> Process / Method	
Issued by		Checked by		Approved by		Received by (Receiving Section)	
 Adrian Vergara QA-IE Staff		 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: NOT A FACTOR Why 4: Why 5:	Why 1: Why 2: Why 3: NOT A FACTOR Why 4: Why 5:	
Design / Toolings	Why 1: Why 2: Why 3: NOT A FACTOR Why 4: Why 5:	Why 1: Why 2: Why 3: NOT A FACTOR Why 4: Why 5:	
Process / Material	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:	

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

- SCUM OCCURS BECAUSE THE INK VISCOSITY IN CYREL HAVE CHANGES ONCE THE CYREL IS NOT ENOUGH DRY AFTER CLEANING.

OUTFLOW ROOTCAUSE

- OPERATOR DIDNT EXPECT THAT IS ALREADY DEFECT BECAUSE IT SO DIFFERENT FROM THE SCUM SHOW ON DEFECT LIMIT STANDARD

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	QA - IN LINE	300	16	
FG	N/A			

Actions to be done to eliminate recurrence**Who / When****B. Orientation**

Date	20 06 11	Time	10:22 - 10:28
Title	ORIENTATION REGARDING CORRECTIVE ACTION FOR SCUM OF COMP FX2-5110-000 BOX OUTER		
Issues	EQOS OPERATORS		

Design / Tools**C. Reworking**

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

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

Date Conducted: 20 06 10

PIC: A. Vergara

Identified Rootcause**Recommendation**

~Scum issue occurs on the item that has solid print
~Imbalance solid printing color due to wet rubber die, rubber die becomes wet when the operator did not dry well the affected part during cleaning

~ Use extra rags for cleaning the rubber die
~ After cleaning of the rubber die the operator should conduct trial run to check if there is a scum

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 06 11	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	CA. is implemented. Training of Eqos operator was not pursue since QA control was not remove
2nd Verification of Action	A. Vergara	20 06 11	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation is implemented
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	20 07 15	<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.

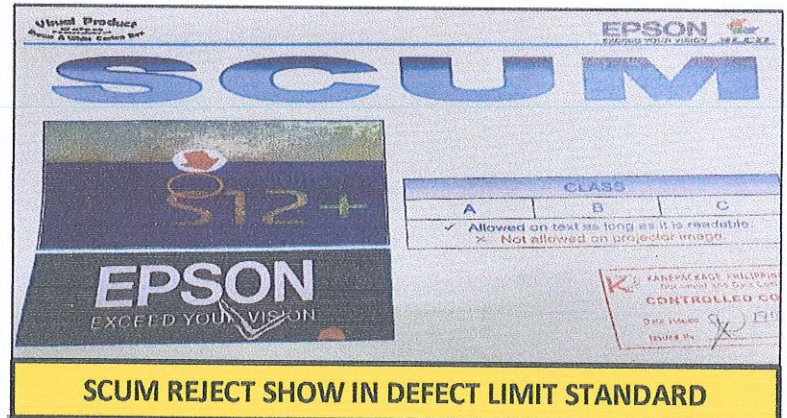
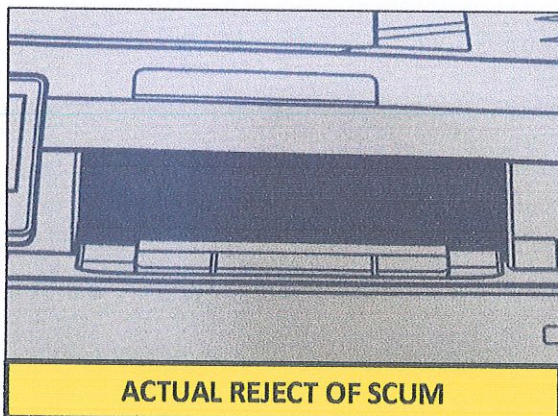
IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
<input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open <input type="checkbox"/> Re-Issue IRF		 QA Supervisor Date: 200805	 IRISH MAY L. ESTAREJA Line Leader Date: 200825 Department Head Date: 200825

INVESTIGATION REPORT FOR SCUM OF CBMP FX2-5110-000 BOX OUTER.

DIRECT CAUSE PROCESS/MATERIAL	W1- Scum occurs after operator clean the cyrel several times, due to machine stop because of machine adjustment and checking of items.
	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.

INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator proceed to mass production.
	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
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Request to QA for Egos operator training, regarding classification of reject related in printing process.

PIC:	QA	TARGET DATE:	
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