


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.: 253

Date Issued: 20 07 21

Customer: CANON

Attention To: Mr. Gerald De Guzman / Ms. Weena Apalla

Item Code: RJ1-1072-000

Department: PRODUCTION

Item Description: FIXING ASSY BOX

Date of Detection: 20 07 20

Job Order Number: WO-F-20-107-1

Section Detected: QA - SCREENING

ILLUSTRATION OF THE PROBLEM
☐ Major

☒ Minor

Lot Quantity (pcs.):

712

Reject Quantity (pcs.):

28

Reject Percentage

3.93%

Nature of Defect:

POOR PRINT

Requirement:

No presence of lines on the Logo

Actual:

With linings on the logo

NO. OF OCCURRENCE
DISPOSITION
AREA OF OCCURRENCE / 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 by

 Received by
 (Receiving Section)

Adrian Vergara
 Adrian Vergara
 QA-IE Staff

QA Supervisor
 QA Supervisor

Mr. Rexel Almarino
 Mr. Rexel Almarino
 QA Asst. Manager

Mr. Gerald De Guzman / Ms. Weena Apalla
 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:

N/A

Why 1:

Why 2:

Why 3:

Why 4:

Why 5:

N/A

Design / Toolings

Why 1:

Why 2:

Why 3:

Why 4:

Why 5:

N/A

Why 1:

Why 2:

Why 3:

Why 4:

Why 5:

N/A

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:

PLS. SEE ATTACHED

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

- INK VISCOSITY BECAME LOW DURING MASS PRODUCTION

OUTFLOW ROOTCAUSE

- POSSIBLE OCCURRENCE ARE RANDOM AT THE LAST PIECES TO PROCESS.

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	N/A			

Actions to be done to eliminate recurrence**Who / When**

System

N/A

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Ass	N/A		

Design / Tools

N/A

C. Reworking

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

Process

PLS. SEE ATTACHED

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

Date Conducted: 20 07 22

PIC: A. Vergara

Identified Rootcause

The ink viscosity decrease immediately because the setup ink viscosity for solid print is 9secs. only

Recommendation

Increase ink viscosity to 10-11secs for solid print only since the item has two mylars

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

Checked by

Date

Implemented?

Remarks

1st Verification of Action

A. Vergara

20 07 30

☒ Yes ☐ No

C.A. is implemented

2nd Verification of Action

☐ Yes ☐ No

3rd Verification of Action

☐ Yes ☐ No

Effectiveness of Action

A. Vergara

20 09 27

☒ Yes ☐ No

C.A. is effective

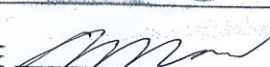
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improvement action.

IV. CLOSURE

QUALITY ASSURANCE DEPARTMENT

☒ Closed
☐ Still Open
☐ Issue IRF

CLOSED

DATE AND SIGNATURE  21 04 14

Approved by:

Process Owner Acknowledgment: (Receiving Section)

QA Supervisor

QA Asst. Manager

Line Leader

Department Head

Date:

Date:

Date:

INVESTIGATION REPORT FOR POOR PRINT OF CBMP RJ1-1072-000 FIXING ASSY BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- Based to operator observation possible that the viscosity of ink become low during mass production because only 28/712pcs (3.93%) are affected of poor print.
	W2- This item have separate cyrel mylar for solid print character (Logo) and non solid print character (Text) but same viscosity used 9sec as to Standard.
	W3- Possible that due to automatic water supplied of shower to Anilox the 9sec viscosity got lower that caused poor print specially in solid print character (Logo).

THIS WEEK	FHB 000101AB	CPB	UPPC	RED	9	6.35	6.2	4.0	SKIP
CBMP	CBM 070701AB	CBF	UPPC	BLACK	9	6.35	6.4	4.8	SKIP
CBMP	CBM 0710701AB	CBF	UPPC	BLACK	9	6.35	6.2	4.4	SKIP
EPSON	S15142000A	CBF	FUT	BLACK	9	6.35	6.2	4.0	SKIP

**EQOS DEVELOPMENT REMARKS SHEETS SHOWS THAT THE VISCOSITY ARE SAME AT CYREL
MYLAR A & B WITH SKIP-ON MODE**

INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator proceed to mass production.
	W2- Trial run approved by QA Patrol.
	W3- Eqos operator didn't notice the poor print because possible occurrence are randomly at the last pieces to process.

CORRECTIVE ACTION

Sir. Pedro Chavez (Authorize and Trained Eqos operator in Japan) advice that the Ink viscosity for the Solid Print Character is within 10-11sec, so if the shower supplied water in the anilox the changes in viscosity is within standard or minimal effect in the Solid Print Character.

PIC:	PRODUCTION, QA & ME	TARGET DATE:	FOR STUDY, BECAUSE WE HAVE ITEM THAT THE SOLID AND NON SOLID CHARACTER ARE ONE MYLAR ONLY.
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PREPARED BY:

[Signature]
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR