

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

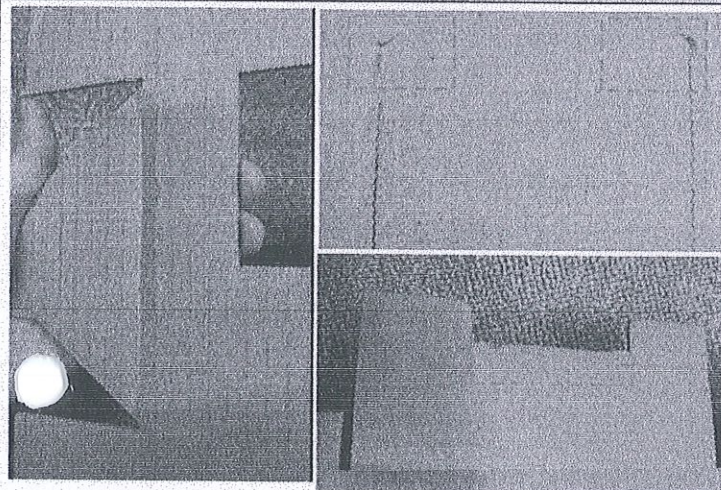
☐ Customer Claim

Control No.: 266

Date Issued: 20 08 10

Customer	CANON	Attention To	Mr. Gerald De Guzman
Item Code	RX1-5115-000	Department	PRODUCTION
Item Description	Z10 ACC BOX	Date of Detection	20 08 07
Job Order Number	WO-F-20-115-3	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM



<input type="checkbox"/>	Major	<input checked="" type="checkbox"/>	Minor
Lot Quantity (pcs.)		Reject Quantity (pcs.)	Reject Percentage
1,989		202	10.16%
Nature of Defect:			
BURSTING			
Requirement:			
No bursting on the item			
Actual:			
With bursting on the rough surface			

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.: 3	<input type="checkbox"/> For Rework	<input checked="" type="checkbox"/> Diecut ETERNA	<input checked="" type="checkbox"/> Appearance
Date: 20 08 10	<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	 Ms. Naomi Cepeda QA Supervisor	 Mr. Rexel Almario QA Asst. Manager	 Mr. Gerald De Guzman 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:	Why 1: Why 2: Why 3: Why 4: Why 5:	N/A
Design / Toolings	Why 1: Why 2: Why 3: Why 4: Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:	N/A
Process / Material	Why 1: Why 2: Why 3: Why 4: Why 5:	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****OUTFLOW ROOTCAUSE**

- BRITTLE MATERIALS

- OPERATOR DIDN'T TRAP THE BURSTING
BECAUSE OCCURRENCE ARE RANDOMLY.

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

Actions to be done to eliminate recurrence

Who / When

	Location	Total Stock	NG	Total Good
RM	N/A			
WIP	N/A			
FG	N/A			

System

N/A

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Issues	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 08 12

PIC: A. Vergara

Identified Rootcause

Recommendation

> tight pressure applied on the corrugated boards
because the sponge used on the diecut is hard
& thick since the sponge attached is gray ecor
tor

> change the sponge on the flaps from gray sponge
to operan cushion

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 08 13	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation is implemented
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	20 08 28	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Recommendation 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

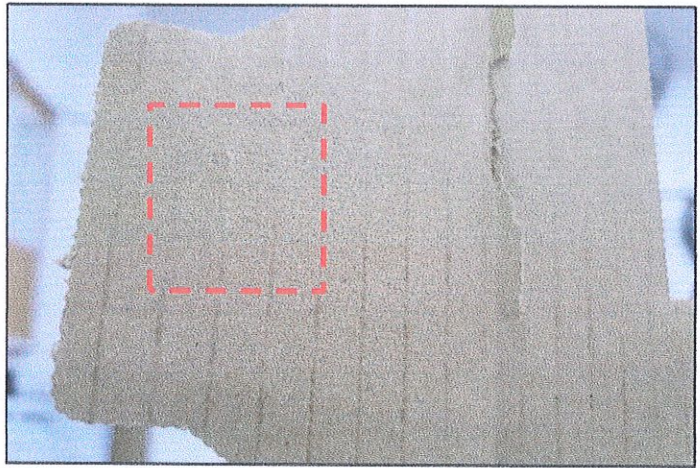
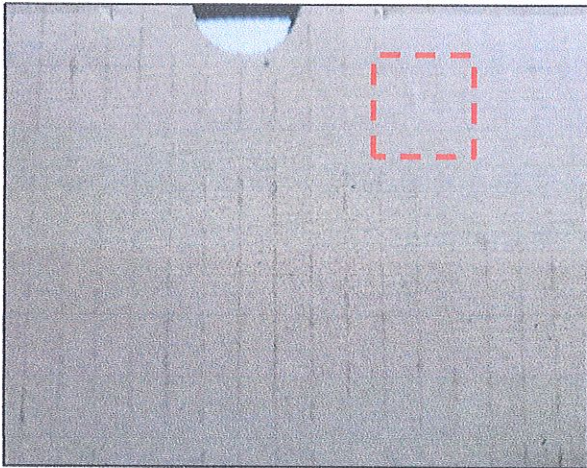
QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	CLOSED				
<input type="checkbox"/> Still Open		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Re-Issue IR		Date: 21 01 11	Date: 21 01 11	Date: 21 01 11	Date: 21 01 11

DATE AND
SIGNATURE

21 01 09

INVESTIGATION REPORT FOR BURSTING OF CBMP RX1-5115-000 Z10 ACC BOX

DIRECT CAUSE PROCESS/MATERIAL	W1- Obviously the bursting occurs due to brittleness of materials.
	W2- Have minimal bursting even in the portion did not touched by die-blade, why we conclude that the brittleness of materials is the caused of bursting.



INDIRECT CAUSE PROCESS/MATERIAL	W1- Operator didn't trap the bursting during sampling because possible occurrence are randomly.
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CORRECTIVE ACTION

Asking for the opinion & suggestion of 4pm team because this is materials problem.			
PIC:	4pm team	TARGET DATE:	

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
 SR. SUPERVISOR