

**KANEPACKAGE PHILIPPINE INC.**

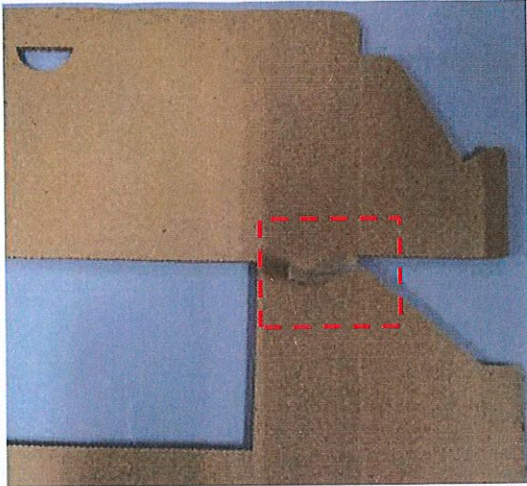
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 312

Date Issued: 20 10 09

Customer	CANON	Attention To	Mr. Gerald De Guzman
Item Code	RX1-5115-000	Department	PRODUCTION
Item Description	Z10 ACC BOX	Date of Detection	20 10 08
Job Order Number	WO-F-20-179-2	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

3,812

Reject Quantity (pcs.)

183

Reject Percentage

4.80%

Nature of Defect:

Peel Off

Requirement:

No peel off on the item

Actual:

W/ peel off on the smooth surface

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
☐ First	☐ Hold	☐ Slotter	☐ Gluing	☐ Material
☒ Recurrence	☐ Special Acceptance	☐ EQOS	☐ Vertical	☐ Dimension
No.: 3	☐ For Rework	☒ Diecut	☐ Others:	☒ Appearance
Date: 20 10 08	☒ Reject / Disposal	☐ Detaching		☐ Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)	
 Adrian Vergara QA-IE Staff	 Ms. Noemi 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: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A Why 4: Why 5:
Design / Toolings	Why 1: Why 2: Why 3: N/A Why 4: Why 5:	Why 1: Why 2: Why 3: N/A 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****OUTFLOW ROOTCAUSE**

- UNICUT PORTION

- PEEL OF NOT VISIBLE BECAUSE IT WAS IN THE BOTTOM PORTION DURING RELEASE IN ETERNA

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		
Attendees	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: 201012 PIC: A. Vergara

Identified Rootcause**Recommendation**

> There was an uncut liner on the smooth surface because the blade does not get through the liner, because the dent on steel plate is deep & the backing tape attached on the diecut blade is thin

> standardize lifespan of steel plate

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	201012	☒ Yes ☐ No	C.A. is implemented
2nd Verification of Action			☐ Yes ☐ No	
3rd Verification of Action			☐ Yes ☐ No	
Effectiveness of Action	A. Vergara	201103	☒ 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		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
☒ Closed	CLOSED	QA Supervisor	QA Asst. Manager	Line Leader	Department Head
☐ Still Open		Date: 2/01/11	Date: 2/01/11	Date: 2/01/11	Date: 2/01/11
☐ Re-Issue IRF					

DATE AND SIGNATURE mm 2/01/09

JEPACKAGE PHILIPPINE, INC. (2)

D BY :
ISSUED :
OMERWO-F-20-179-2
Nene Villanueva
24-SEPTEMBER-2020
CANON BUSINESS MACHINE PHILS.Bal mtds
137210/2Light Industry Science Park II,
National Highway, Calamba, 4027 Laguna
Tel: (049) 545 7166/67
Fax: (049) 544-0010

Description: RX1-5115-000-RMFG Z10 Acc Box
 Quantity: 3800 Piece
 Issued Date: 5-OCTOBER-2020

Memo :
 BK Code : RX1-5115-000
 Blades :

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
5115-000 1130x740mm BFlute J/CM125/TX200 0	953	0	0	0pcs 953	259083	SP		ans 10/6

PROCESS	Finished		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
	Date	Time			In-house	Supplier		
1. ETERNA Zandro 20/006	10/06		953	2			PER	
2. DETACH	10/67		2525				N/S	
3. LOT NUMBERING	10/7		2500				KIM/KENNEDY	
4. SCREENING	10/8		1200				JIMMY JIMMY DANE	
5. QA BUNDLE			200	(1464)	187	7	KENNEDY JOVEN	BAL
			936	3				

REJECTION HISTORY

1.
2.
3.
4.

NOTES

1.
2.
3.
4.
5.

NETSUITE
 QA TRANSFER TO FG
 BY: Larine FG 2336
 DATE: 201008
 TIME: 10:46am

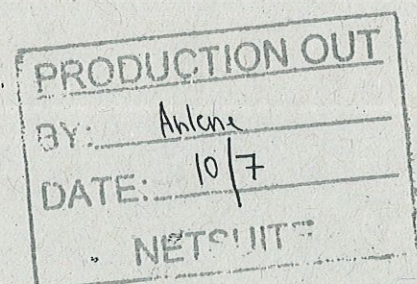
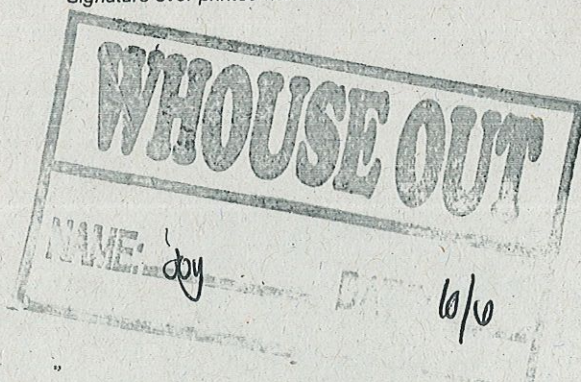
PR-001-F07 REV.00

JO Received By(WHSE):

Signature over printed name/Date/Time

JO Returned to(QA):

Signature over printed name/Date/Time



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

DIRECT CAUSE PROCESS/MATERIAL	W1- Peel Off occurs because the auto stripping blade of Eterna hit the uncut portion.
	W2- Uncut portion is due to repeated shot of die-blade in Eterna plate.
	W3- Repeated shot of die-blade in Eterna plate left a cutting mark.
	W4- Once the cutting mark in the Eterna plate is deep it cause uncut to the items.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Eterna operator didn't notice the Peel Off because it was in the bottom portion during release in Eterna.
	W2- They cant reverse the piling during palletizing due to spread out of items, because it was 4outs and auto stripped.

PRODUCTION CORRECTIVE ACTION

Put backing tape to the Eterna Pattern in uncut portion to eliminate the uncut.			
PIC:	PRODUCTION	TARGET DATE:	201007 (Done by Sherwin)

Check the condition of Eterna plate.			
PIC:	PRODUCTION	TARGET DATE:	201013

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
 SR. SUPERVISOR