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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
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)

☒ Inhouse Detection ☐ Customer Claim
Control No.: 339 Date Issued: 20 12 01

Customer: CANON
Item Code: RJ1-1072-000
Item Description: FIXING ASSY BOX
Job Order Number: WO-F-20-239-5

Attention To: Mr. Gerald De Guzman
Department: PRODUCTION
Date of Detection: 20 11 28
Section Detected: QA - SCREENING

ILLUSTRATION OF THE PROBLEM



☐ Major ☒ Minor
Lot Quantity (pcs.): 217
Reject Quantity (pcs.): 50
Reject Percentage: 23.04%

Nature of Defect:
POOR PRINT

Requirement:
Poor print is maximum 5mm length and 2mm width and maximum of 3 pcs. only

Actual:
The whole image has poor print

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 2 Date: 20 12 01	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input checked="" type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching	<input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others:
			<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
 Adrian Vergara QA-IE Staff	 Ms. Noemi Cepeda QA Supervisor	 Mr. Rexel Almaric 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:
			N/A		
Design / Toolings	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		
			PLS. SEE ATTACHED		

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

- BLUNT CYREL

OUTFLOW ROOTCAUSE

- RANDOMLY OCCURRENCE AND MORE VISIBLE
IF THE PRIN IS DRY WELL

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

Design /
Tools

N/A

Process

PLS. SEE ATTACHED

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Attendees	N/A		

C. Working

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

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

Date Conducted: 20 12 03

PIC: A. Vergara

Identified Rootcause**Recommendation**

Incomplete ink transfer on the materials because
the rubber die is worn-out.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 12 04	[] Yes [1] No	W/ P.R. for the new set of cyrel
2nd Verification of Action	A. Vergara	21 02 08	[1] Yes [] No	C.A. is implemented
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	21 03 29	[1] 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

Status: <input checked="" type="checkbox"/> Closed <input type="checkbox"/> Open <input type="checkbox"/> Issue IRF	QUALITY ASSURANCE DEPARTMENT	Approved by: QA Supervisor Date: 21 04 14	Process Owner Acknowledgment: (Receiving Section) QA Asst. Manager Date: 21 04 14	Line Leader Date: 21 04 14	Department Head Date: 21 04 14
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DATE AND
SIGNATURE

21 04 14

DIRECT CAUSE PROCESS/MATERIAL	W1- Eqos process the RJ1-1074 & 1072 Fixing assy box on the same day, with almost same setup and ink viscosity of 9sec standard but only the 1072 have occurrence of poor print.
	W2- The next possible factor we checked is the cyrel condition because no problem in machine setup.
	W3- Upon checking of cyrel we found some scratches and we think it is already blunt.



PRODUCTION CORRECTIVE ACTION

- | | | | |
|---|-------------------|---------------------|---------------|
| <p>- Request for the cyrel replacement with the following instruction:</p> <ul style="list-style-type: none"> > Solid/big print character must be soft cyrel. > Small print character must be existing cyrel. | | | |
| PIC: | PRODUCTION | TARGET DATE: | 201203 |

[Signature] 201202
WEENA V. APALLA
SR. SUPERVISOR