

1620


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

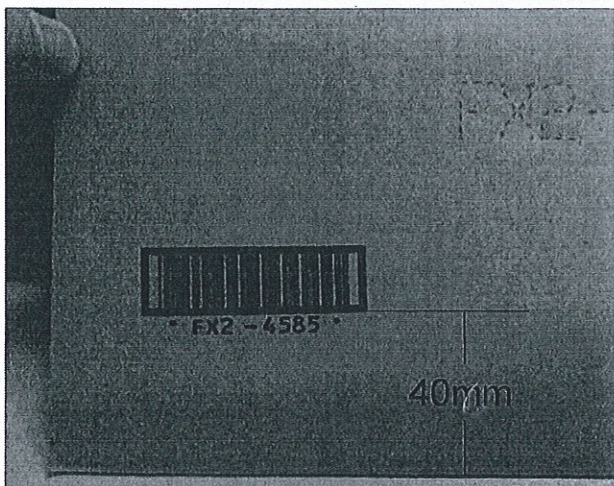
☐ Customer Claim

Control No.: 350

Date Issued: 20 12 15

Customer	CANON	Attention To	Mr. Gerald De Guzman
Item Code	FX2-4585-000	Department	PRODUCTION
Item Description	Z10 BACK_UP SHEET	Date of Detection	20 12 12
Job Order Number	WO-F-20-246-2	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM
☐ Major

☒ Minor


Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
5067	58	1.14%

Nature of Defect:

MISALIGN PRINT

Requirement:
Print location from cutting line is 20mm with ± 3 mm tolerance
Actual:
Print location is more than ± 3 mm tolerance

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ Date: _____	<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 checked="" type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others: _____	<input type="checkbox"/> Material <input checked="" type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by Ms. Noemi Cepeda QA Supervisor	Approved by Mr. Rexel Almaria QA Asst. Manager	Received by (Receiving Section) 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 1:	
	Why 2:	N/A	Why 2:	N/A
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:		Why 1:	
	Why 2:	N/A	Why 2:	N/A
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	SEE ATTACHED	Why 3:	SEE ATTACHED
	Why 4:		Why 4:	
	Why 5:		Why 5:	

**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)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

WARP OCCURRENCE

OUTFLOW ROOTCAUSE7 RANDOM OCCURRENCE f
9 OUTS PER SHEET**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

SEE ATTACHED

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Indices	N/A		

C. Reworking

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 16

PIC: A. Vergara

Identified Rootcause

> Delay timing on the machine because the boards used are warp

Recommendation

> Repalletized big E-flute sheet (It should not be exceeding on the pallet.

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 16	<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	21 03 18	<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

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed <input type="checkbox"/> Still Open	CLOSED	QA Supervisor	QA Asst. Manager	Line Leader
Re-Issue IRF DATE AND SIGNATURE		Date: 210414	Date: 210414	Date: 210414

Firefix

KANEPACKAGE PHILIPPINE, INC.

11/25/2020, 12:39 pm

SO No.:
 JO No.:
 ISSUED BY:
 DATE ISSUED:
 CUSTOMER

WO-F-20-246-2
 VILLANUEVA, NENE A.
 25-NOVEMBER-2020
 CANON BUSINESS MACHINE PHILS.

NETSUITE
 FMA TRANSFER TO FG
 BY: GILMAN
 DATE: 2012-12-12
 TIME: 13-11

Light Industry Science Park II,
 National Highway, Calamba, 4027 Laguna
 Tel: (049) 545 7166/67
 Fax: (049) 544-0010

Item Description: FX2-4585-000-RMFG Z10 Back Up Sheet
 Quantity: 5000 Piece
 Delivery Date: 11-DECEMBER-2020

Memo:
 BK Code: FX2-4585-000
 Blades:

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
555x795mm E Flute TX175/CM125 /TX175 0	559	0	0	0pcs 559	32014	818		Sum 12/12

PROCESS	Finished		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
	Date	Time			In-house	Supplier		
1.EQOS <u>2012/12</u>	12/12		559	2			RESC	
2.DETACH S1700	12/12		179	2			GP	GRADE. OR
3.DETACH	12/12		5000				N/S	
4.LOT NUMBERING	12/12		5000				14M1 RHOJ.	
5.SCREENING	12/12		4,885		182		thom / ERASID	
3.QA BUNDLE								

QUALITY REJECTION HISTORY

EN

NOTES

R-001-F07 REV.00

JO Received By(WHSE):

Signature over printed name/Date/Time

DATE: 12/12

Customer: CANON BUSINESS MACHINES (PHILS.), INC.

Part Code: REV. 02 Inspection Date: 201212

Quantity: 50 pcs.

Description: Z10-BACK_UP_SHEET

QA Inspector: QA-CG621

Job Order Number: W0-F-20-246-2

Disposition: QA PASSED

MP RoHS OK

KANEPACKAGE PHILIPPINES INC.

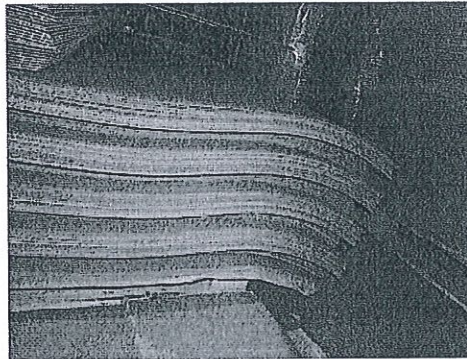
PRODUCTION OUT

BY: Shirley HeDATE: 12/12

NETSUITE

INVESTIGATION REPORT FOR MISALIGN PRINT OF CBMP FX2-4585-000 Z10 BACK_UP SHEET

DIRECT CAUSE PROCESS/MATERIAL	W1- One factor to be considered is the warp condition of materials issued and processed in EQOS.
	W2- Due to the type of materials used which is E flute that is prone to warpage.



**CONDITION OF MATERIALS USED
THAT IS PRONE TO WARPAGE**

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- There's a possibility that during sampling operator did not trap the occurrence of misalign print due to random occurrence. Because out of 5,067 pcs. Of lot Quantity, 58 pcs only was reject.
	W2- Eqos operator didn't notice the occurrence of misalign during running due to this item has a total of 9 outs per sheet.

PRODUCTION CORRECTIVE ACTION

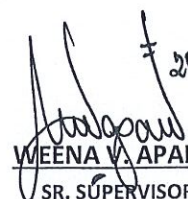
Continue the recondition and usage of Paper weight Jig.			
PIC:	WAREHOUSE & QA	TARGET DATE:	ON-GOING

Separate and recondition the materials once the operator encounter warpage.			
PIC:	PRODUCTION	TARGET DATE:	ON-GOING

PREPARED BY:


LEIANN MARIE AVILES
 IE STAFF

APPROVED BY:

 201215
WEENA V. APALLA
 SR. SUPERVISOR