

**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**

> Residual dirt on the plate

OUTFLOW ROOTCAUSE

> No occurrence found during trial run & sampling

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		
Idees	N/A		

Design / Tools

N/A

C. Reworking

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

Process

SEE ATTACHED FILE

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

Date Conducted: 20 12 18

PIC: A. Vergara

Identified Rootcause

> The scrap compress the smooth surface of the material because the scrap trap in the plate since the scrap stuck on the tape attached in the plate

Recommendation**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 19	[X] Yes [] No	C.A. is implemented
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	21 02 06	[X] 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)	
<input checked="" type="checkbox"/> Closed	<input type="checkbox"/> Still Open				
QA Supervisor		QA Asst. Manager		Line Leader	
Date: 210414		Date: 210414		Date: 210414	

DATE AND SIGNATURE

21 04 14

MANEPACKAGE PHILIPPIN

634-189



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

WO-F-20-247-4
Nene Villanueva
20-NOVEMBER-2020
CANON BUSINESS MACHINE PHILS.

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

Item Description:	RX1-4178-000-RMFG Z10 Carton (CM150)
Quantity:	1900 Piece
Delivery Date:	15-DECEMBER-2020

Memo :
BK Code : RX1-4178-000
Blades :

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
725 X 1445 CBF (TX200/CM150X3 /TX200) 0	1920	0	0	0pcs				

PROCESS	Finished		GOOD QTY	Trial Run	REJECT QTY		OPERATOR	Remarks
	Date	Time			In-house	Supplier		
1.EQOS Rous	12/15		1918	2	2		DHTMC	
201215 2.ETERNA JMAN	12/15		1,918	2			BLS	
3.DETACH								
4.CONVEYOR 1			1379	1			GIND, TUN, W. J. D. O. AMARUO - BON / BR, NICK	
5.LOT NUMBERING	12/14		600				KUMI REX.	
6.SCREENING	12/14		200 + 100 + 200 + 200		17	16	Rgc / Rms / Rspce	Conveyor 3 Double Pass Due to Vent
7.QA P'NDLE								By: N. C. ... Inspector of B

REJECTION HISTORY

1. 1399 transferred to GA - Jan 12/12
- 2.
- 3.
- 4.
- 5.

NOTES

- 1.
- 2.
- 3.
- 4.
- 5.

PR-001-F07 REV.00

JO Received By(WHSE):

Signature over printed name/Date/Time

Customer

CANON BUSINESS MACHINES (PHILS.), INC.

REV. 02

Part Code

Inspection Date

201216

Quantity	Unit Price	Total Price
10	100	1000
20	100	2000
30	100	3000
40	100	4000
50	100	5000
60	100	6000
70	100	7000
80	100	8000
90	100	9000
100	100	10000

200 pcs.

Description

~~Z10~~ CARTON

QA Inspector

QA-CG601

Job Order Number

Disposition

QA PASSED

MP

RoHS OK

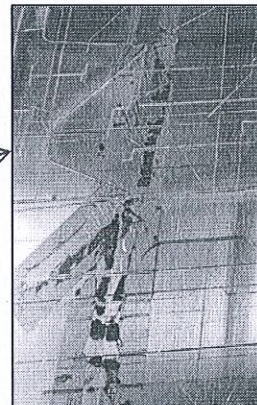
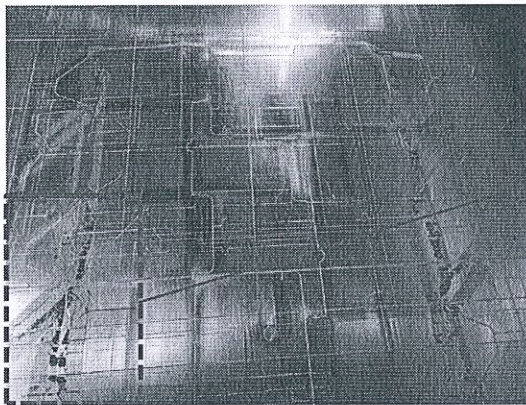
4-2-5-20-247-4



KANEPACKAGE PHILIPPINES INC.

INVESTIGATION REPORT FOR DENT MARK OF CBMP RX1-4178-000 RMFG Z10 CARTON BOX (CM150)

DIRECT CAUSE PROCESS/MATERIAL	W1- Due to residual dirt caused by the adhesive of the removed creasing matrix on the plate
	W2- Due to left scrap that stuck on the dirt of plate.



ETERNA plate where the left scrap sticks, and caused dent mark on materials.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Operator proceed to mass production because it was approved by QA patrol and they check only the dimension and cutting condition as requirement.
	W2- Operator did not notice the occurrence of dent mark because it is not too visible.
	W3- Operator did not notice the problem because during trial run no occurrence of dent.

PRODUCTION CORRECTIVE ACTION

Orient the operator to clean the plate when changing to make sure that it is clean and ready for mass production.

PIC:	PRODUCTION	TARGET DATE:	201219
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PREPARED BY:

LEI ANN MARIE AVILES
IE STAFF

APPROVED BY:

WEENA M. APALLA
SR. SUPERVISOR

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