1822

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

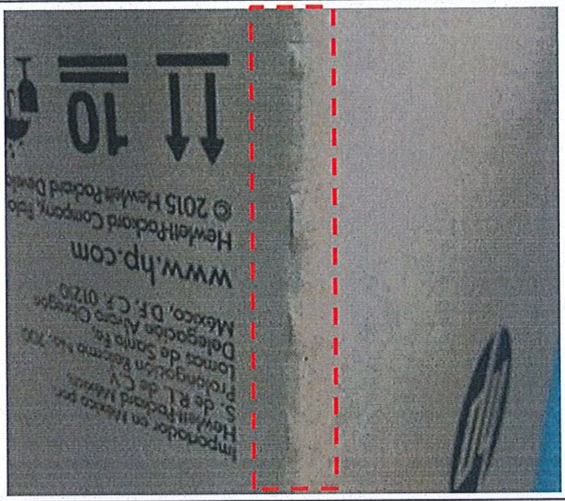
INVESTIGATION REPORT FORM (IRF)

[x] Inhouse Detection   [ ] Customer Claim

Control No.: 356   Date Issued: 20 12 21

Customer	CANON	Attention To	Ms. Weena Apalla
Item Code	RX1-4178-000	Department	PRODUCTION
Item Description	Z10 CARTON	Date of Detection	20 12 18
Job Order Number	WO-F-20-247-4	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM



[ ] Major   [x] Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1900	31	1.63%

Nature of Defect:

BURSTING

Requirement:

No bursting on the outer portion of the box

Actual:

W/ bursting on the outer side of the box

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
[x] First	[ ] Hold	[ ] Slotter	[x] Gluing	[ ] Material
[ ] Recurrence	[ ] Special Acceptance	[ ] EQOS	[ ] Vertical	[ ] Dimension
No.:________	[ ] For Rework	[ ] Diecut	[ ] Others:	[x] Appearance
Date:________	[x] 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	Ms. Weena Apalla 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: See Attached File Why 4: Why 5:	Why 1: Why 2: Why 3: See Attached File Why 4: Why 5:

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FINAL CONCLUSION

OCCURRENCE ROOTCAUSE	OUTFLOW ROOTCAUSE
> The item undergone gluing conveyor twice	> occurrence of bursting is randomly

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

A. Sorting Result

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

B. Orientation

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

C. Reworking

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

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

	Actions to be done to eliminate recurrence	Who / When
System	N/A	
Design / Tools	N/A	
Process	See Attached File	

Date Conducted: 20 12 22 PIC: A. Vergara

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

Identified Rootcause	Recommendation
> The boxes undergone gluing conveyor twice to eliminate the dentmark	

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	20 02 19	[/] 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	[/] 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:	Remarks:	Approved by:		Process Owner Acknowledgment: (Receiving Section)	
[ ] Closed		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
[ ] Still Open					
[ ] Re-issue IRF		Date: 210414	Date: 210414	Date: 210414	Date: 210414

QUALITY ASSURANCE DEPARTMENT
CLOSED
DATE AND SIGNATURE 21 04 14

- 135 - [illegible] 12/13 NETSUITE 11/20/2020, 9:42 am
QA TRANSFER TO FG
BY: Janine [illegible]
DATE: 201216
TIME: 11:09 pm

...KAGE PHILIPPINE, INC.

38pcs ~~@ 34 - 189~~

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

...O No. :	
JO No :	WO-F-20-247-4
ISSUED BY :	Nene Villanueva
DATE ISSUED :	20-NOVEMBER-2020
CUSTOMER	CANON BUSINESS MACHINE PHILS.

lepp

~~200 x 1~~
~~105 x 1~~

1922

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

Material Description	Qty To Be Used	Cut Size	No. of Cuts	Actual Qty Used	DR No.	Supplier	Batch No.	Issued By
'25 X 1445 CBF (TX200/CM150X3 TX200) 0	1920	0	0	0pcs 1920	163388	Pw		[illegible] 12/15

PROCESS	Finished Date	Finished Time	GOOD QTY	Trial Run	REJECT QTY In-house	REJECT QTY Supplier	OPERATOR	Remarks
.EQOS [illegible] 12/15	12/15		1918	2	2	—	DHTMC	
201215 .ETERNA JUN [illegible]	12/15		1,918	2			BLS	
.DETACH								
.CONVEYOR 1			1399 234 238	1 1			GINO, [illegible] AMANDO, [illegible], RICK	
.LOT NUMBERING	12/14		600 + 305 + 400 + 38				[illegible] REX. Darrel Jeff	
SCREENING	12/14		200/200/200/200		17	16	Rgc / Rhos / aspe	Conveyor 3 Double Pass Due to Dent Mark
QA BUNDLE	~~12/17~~ 12/17		305 ~~[illegible]~~ 600 38	—	9	6 —	lepp	By: N. C[illegible] Approved By Sir Yuji.

REJECTION HISTORY 46 20 - OSTIA, ASPe

- 1399 transferred to QA 3pm 12/14
- 234 TRANSFERRED TO QA charlotte 12/14
- 238 TRANSFERRED TO QA Jhen -12/17

NOTES

NETSUITE
QA TRANSFER TO FG
BY: Gillian 305
DATE: 201217
TIME: 8:18

NETSUITE
QA TRANSFER TO FG
BY: Janine FG 896
DATE: 201217 (1600)
TIME: 7:00 pm

Customer
CANON BUSINESS MACHINES (PHILS.), INC.
Part Code | REV. 02 | Inspection Date 201216

Customer
CANON BUSINESS MACHINES (PHILS.), I...
Part Code | REV. 02 | Inspection Date 12/17 20121...
RX1-4178-000
Quantity 20...
Description Z10_CARTON
QA Inspector QA-...
...IS OK
Disposition
Job Order Number

...-001-F07 REV.00

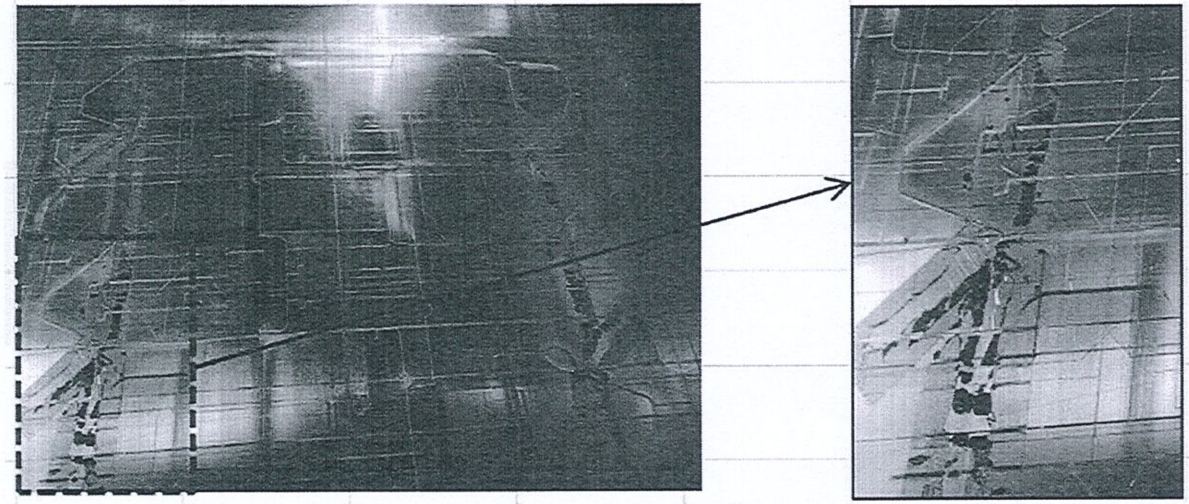
JO Received By(WHSE):
Signature over printed name/Date/Time

NETSUITE
QA TRANSFER TO FG
BY: Janine FG 38
DATE: 201217
TIME: 10:41 pm

WAREHOUSE
NAME: Rolle DATE: 12/15

PRD - ROOTCAUSE ANALYSIS:

DIRECT CAUSE PROCESS / MATERIAL	**W1** – The materials was overpressed
	W2 – The WIP undergone gluing conveyor process twice
	W3 – Since the materials has a dent on the surface
	W4 – Due to residual dirt caused by the adhesive of the removed creasing matrix on the plate
	W5 – 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 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

PRD - 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:**	20 12 19