

2554


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.: 374

Date Issued: 21 01 27

Customer	CANON	Attention To	Mr. Gerald De Guzman
Item Code	FX2-4585-000	Department	PRODUCTION
Item Description	Z10 BACK UP SHEET	Date of Detection	21 01 26
Job Order Number	JO-F-21006-1	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM
☐ Major

☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

5,400

156

2.89%

Nature of Defect:

POOR PRINT

Requirement:

Missing text is not acceptable

Actual:

W/ missing text

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Gluing	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension
No.: 2	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Others:	<input checked="" type="checkbox"/> Appearance
Date: 21 01 27	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching		<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 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 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	N/A	Why 3:	N/A
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:		Why 1:	
	Why 2:		Why 2:	
	Why 3:	PLS. SEE ATTACHED	Why 3:	PLS. SEE ATTACHED
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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

— ACCUMULATED FIBERS IN THE CYREL

— RANDOMLY OCCURRENCE

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**Actions to be done to eliminate recurrence****Who / When**

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

System		
	N/A	

B. Orientation

Date	N/A	Time	N/A
Title	N/A		
Issues	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: 21 01 29

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The rubber die was contaminated of fibers.
This fibre came from the corrugated materials

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 02 02	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. 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 04 23	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> 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)
<input checked="" type="checkbox"/> Closed			
<input type="checkbox"/> Still Open			
<input type="checkbox"/> Re-Issue IRF			

DATE AND
SIGNATURE

21 05 14

INVESTIGATION REPORT FOR POOR PRINT OF CBMP FX2-4585-000 Z10 BACK UP SHEET

DIRECT CAUSE PROCESS/MATERIAL	W1-The surface of materials is rough and there's a lot of fibers.
	W2- Possible the accumulated fibers stick in the cyrel during mass production that caused of poor print.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Operator immediately stop and clean the cyrel upon detection.
	W2- He did not separate the affected sheets since the affected is 3 out of 9outs and the barcode are readable.

PRODUCTION CORRECTIVE ACTION

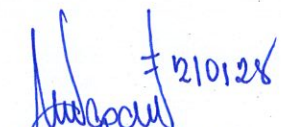
> Orient/Alert the operator regarding this issue and advice them to put cross mark in the affected outs once they encounter the same problem.

PIC:	PRODUCTION	TARGET DATE:	210130
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PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
 SR. SUPERVISOR



KANEPACKAGE PHILIPPINE INC.

MINUTES OF THE MEETING

Date: 2/02/02

Time Start: 0912H

Time Finished: 0920H

Venue: EGOS AREA

ATTENDEES:

Name	Section	Sign	Name	Section	Sign
HENRY CLAVE	EGOS	H			
DAVID BONATON	EGOS				
RAMON PAMBAN	EGOS				
JOHITO	EGOS				
Marian Pamban	EGOS				

AGENDA:

ORIENTATION REGARDING PEEL OFF OF EPSONT TP 5116596-00 OUTER CARTON BOX & POOR PRINT OF CBMP FX2-4585-000 Z10 BACK UP SHEET

page 1 of 1

MINUTES:

ROOTCAUSE:

> For 5116596-00 OCB "PEEL OFF" the warp materials bump in the feeder gate that caused peel off

> For the FX2-4585-000 "POOR PRINT" the surface of materials is rough and there's a lot of fibers, the accumulated fibers stick in the cyrel during mass production that caused of poor print.

CORRECTIVE ACTION:

For 5116596-00 OCB "PEEL OFF":

- Continues the pre-folding of warp materials of RSC Box.
- During sampling the long corrugated board within 2,000mm, are need to fold in the middle to check the end portion.
- Once the main operator notice the poor print immediately stop the process, separate the affected item, and alert the feeder operator regarding the problem.
- If the occurrence is frequently immediately report to Production Leader In-charge.

For the FX2-4585-000 "POOR PRINT":

- Put cross mark in the affected outs.
- Once the main operator notice the poor print immediately stop the process, separate the affected item, and alert the feeder operator regarding the problem.
- If the occurrence is frequently immediately report to Production Leader In-charge.

FOLLOW UP MEETING:

(date & time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:

GERALD DE GUZMAN