

**KANEPACKAGE PHILIPPINE INC.**

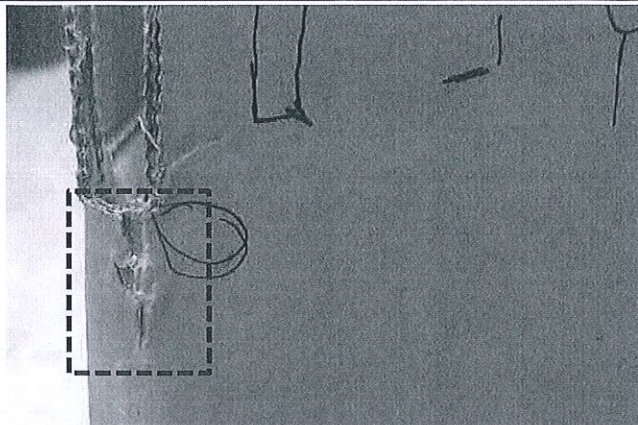
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 433

Date Issued: 21 06 11

Customer	CANON	Attention To	Mr. Gerald De Guzman
Item Code	RX1-5781-000	Department	PRODUCTION
Item Description	Z10 CARTON	Date of Detection	21 06 10
Job Order Number	JO-F-21-191-1	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

2,600

170

6.54%

Nature of Defect:

BURSTING

Requirement:

Bursting is not acceptable

Actual:

Bursting length is 15mm

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 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 type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by Adrian Vergara QA-IE Staff	Checked by Mr. Roderick Ramos QA Supervisor	Approved by Mr. Razel 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 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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INVESTIGATION REPORT FORM (IRF)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

Due to broken creasing matrix &
over impression of die cut blade

OUTFLOW ROOTCAUSE

No detection of the defect since
it will be trap only in gluing process

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		
Attendees	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: 21 06 15

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The creasing matrix is worn-out (also the
steel plate
> Due to over impression of die blade in the
sheets

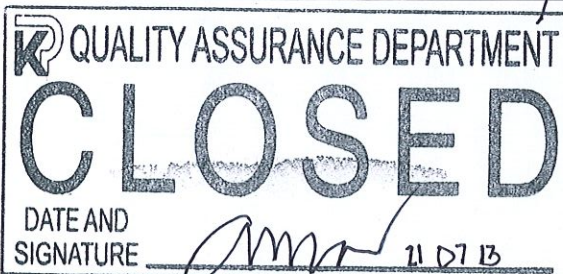
III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 06 17	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is implemented
2nd Verification of Action	A. Vergara	21 06 21	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	change slot design will not pursue
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	
Effectiveness of Action	A. Vergara	21 07 13	<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		 QA Supervisor Date: 21 07 13	 QA Asst. Manager Date: 21 07 13 IRISH MAY L. ESTAREJA Line Leader Date: 21 07 13 Department Head Date: 21 07 13



INVESTIGATION REPORT FOR BURSTING OF CBMP RX1-5781-000

DIRECT CAUSE PROCESS/MATERIAL	W1- Due to uncut encountered in slot during mass production.	W1- Due to un-sticking of creasing matrix on plate.
	W2- Due to the blade used is not continuous or it is rectangular slot.	
	W3- Due to the applied pressure was 1.5 tons.	

Job Order No.	210617
Customer	AVI
Item Description	AVI / 210617 / 000
Quantity	1000
Condition Sheet	1/100
Actual Machine Speed	1.5
Actual Machine Pressure	210617 / 1.5
Material	210617
Steel Plate No.	210617
Remarks	1. 1.5 tons 2. 1.5 tons

Actual Machine Ratio of Eterna with indication of downtime during mass production.

SHEET		Machine
		ETERNA
Start	Finish	Machine Breakdown / Downtime / Others
20:25	20:45	REPAIR BLADE DUE TO TOTAL OFF PUT BUCKING TYPE W/ TAKEOUT BLADE
20:45	20:55	W/ 15X PUT BUCKING TYPE DUE TO UNCLUT



Operator put tape on the creasing matrix to avoid extra movement during diecutting.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Eterna operator did not notice the occurrence since it can be found after gluing or assembly.
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PRODUCTION CORRECTIVE ACTION

> Change to new plate and creasing matrix since the previous plate was used as common plate before when Eterna were lacking on steel plate.

PIC:	Production	TARGET DATE:	210615
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> Monitor the next running of this item and study the effect of the pressure used.

PIC:	Production and ME	TARGET DATE:	210616
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> Coordinate to ME regarding changing of rectangular slot to rounded slot.

PIC:	Production and ME	TARGET DATE:	For Discussion
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> Create Eterna Plate Condition Checksheet and will conduct weekly checking of Eterna Plate condition care of Production Leader-in-Charge.

PIC:	Production	TARGET DATE:	210618
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PREPARED BY:

LEIANN MARIE AVILES
PROD IE

APPROVED BY:

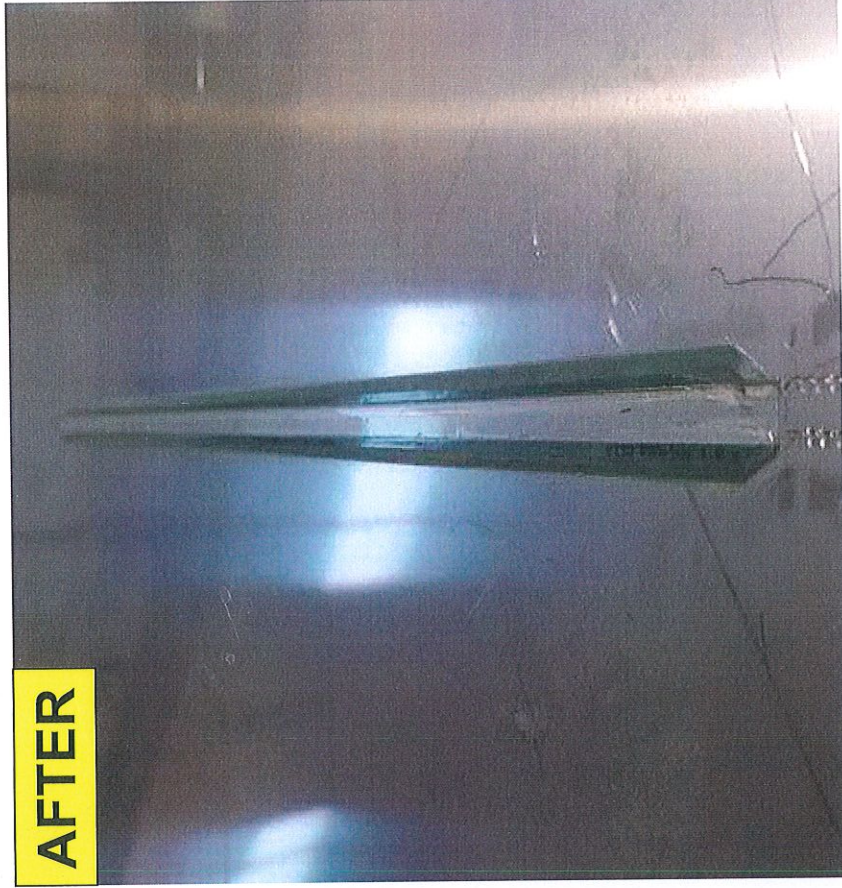
VEENA VAPALLA
SR. SUPERVISOR

UPDATES:

BEFORE



AFTER



Based on the latest running of the item there is no recorded bursting on the same location.

ETERNA PLATE CONDITION CHECKSHEET

STEEL PLATE	26-Jun	03-Jul	10-Jul	17-Jul	24-Jul	31-Jul	07-Aug	14-Aug	21-Aug	28-Aug	04-Sep	11-Sep	18-Sep	25-Sep	02-Oct	09-Oct
COMMON TO PLATE																
SPECIFIC PLATE																
EMORI																
HP01D2000																
HP01D2200																
HP33D1010																
D2200-1																
D1014-1																
D1027-1																
CBMP																
RX1-5781-000																
NIDEC																
FLEXWAVE A																
FLEXWAVE B																
FLEXWAVE C																
FLEXWAVE D																
MERASENKO																
PRODUCT BOX V																
Leader-in-Charge																
Signature																

Legend : ✓ = Good X = No Good / Worn-out

Note:

1. Production Leader-in-Charge shall check the condition of the Steel Plate and update the Eterna Plate Condition Sheet. Checking shall be done every Saturday End of the Shift.
2. Parameter(s) found during inspection must be reported to the Supervisor and/or to Production IE staff. Do not proceed to Mass production until the Worn-out plate was changed.
3. This form shall return back to Production IE Staff after checking for verification.