



# KANEPACKAGE PHILIPPINE INC.

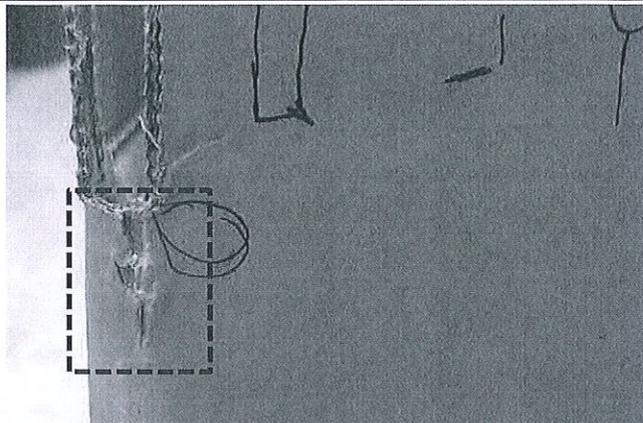
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
Telephone No. (049) 545-7166 to 69  
Fax No. (049) 545-6302

## 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



<input type="checkbox"/> Major <input checked="" type="checkbox"/> 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	Checked by	Approved by	Received by (Receiving Section)	
 Adrian Vergara QA-IE Staff	 Mr. Roderick Ramos QA Supervisor	 Mr. Razel Almaria 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 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				System	N/A
WIP	N/A					
FG	N/A					

## B. Orientation

## Design / Tools

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

## C. Reworking

## Process

Rework Quantity	Total Good	Rework Percentage (Good)
N/A	N/A	N/A
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 dieblade in the sheets

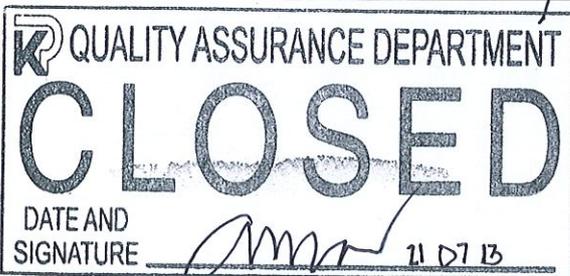
## III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	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



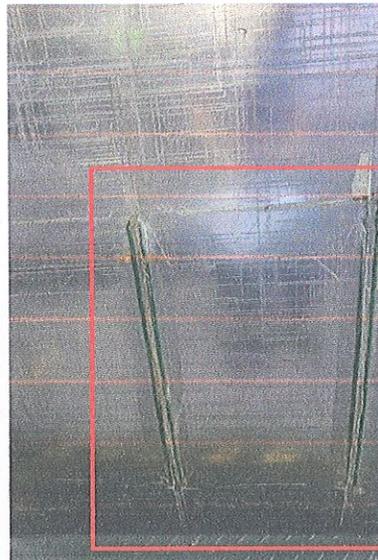
# INVESTIGATION REPORT FOR BURSTING OF CBMP RX1-5781-000

<b>DIRECT CAUSE PROCESS/MATERIAL</b>	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.	

Eterna Machine / Report	
Job Order No.	210617
Customer	AVI
Form/Draw/Spec	AVI 0201 000
Quantity	1000
Condition Sheet	
Actual Machine Speed	1900
Actual Machine Pressure	1.5
Start Date	2017-11-17
Material	202
Steel Plate No.	AVI 202 1251
Remarks	<input type="checkbox"/> BFI <input type="checkbox"/> Sample <input type="checkbox"/> Testing
Activity	Time
Warm-up / Maintenance / Preparation	Start Finish
7A	20:00 20:25
Quoting	
Material Transfer / ID	
Revisions	20:24 20:15
Updating CAD / D Sheet / M Plan	
Machine Setup	
1. Take out previous order	
2. Set up new blade	
3. Set up stopper	
4. Take out stopper	
5. Trial Run	20:25 20:22
6. QA Checking Approval	
Mass Production	
1	21:45 00:20
2	
3	Machine ERROR (42X) (27min)
4	DUE TO LEFT HAND SCRAP STRIPPER AREA

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

1 SHEET		Machine ETERNA
Time		Machine Breakdown / Downtime / Others
Start	Finish	
20:25	20:43	REPAIR BLADE DUE TO TOOL OFF PUT BACKING TYPE W/ TAKEOUT BLADE
21:45	00:20	W/ 15X PUT BACKING TYPE DUE TO UN CUT



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

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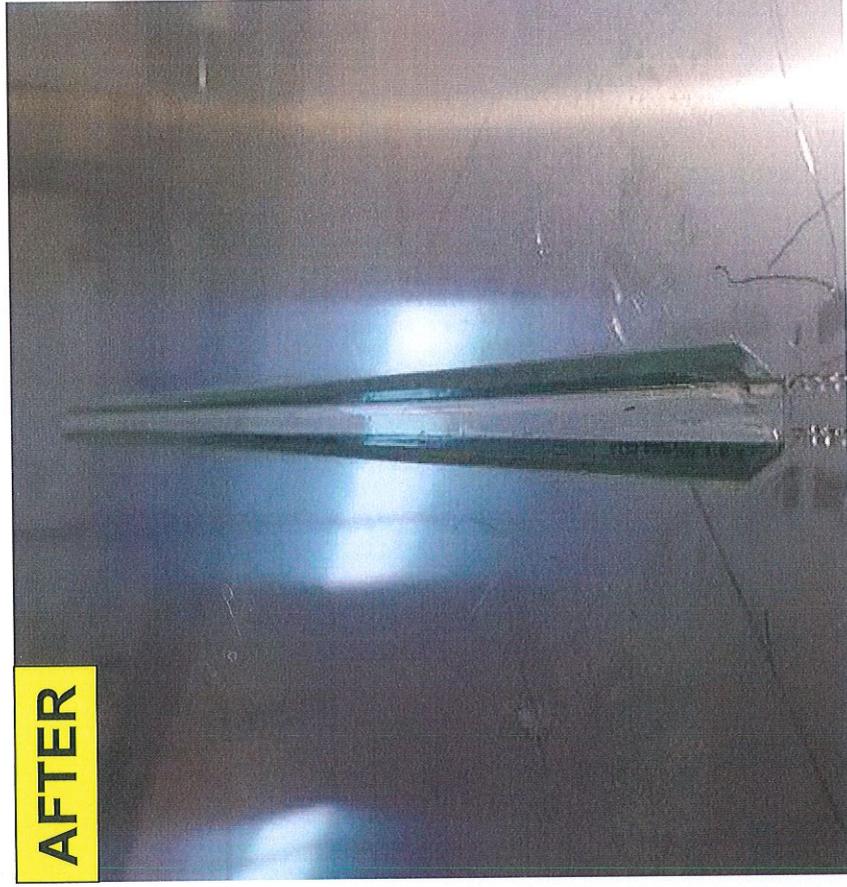
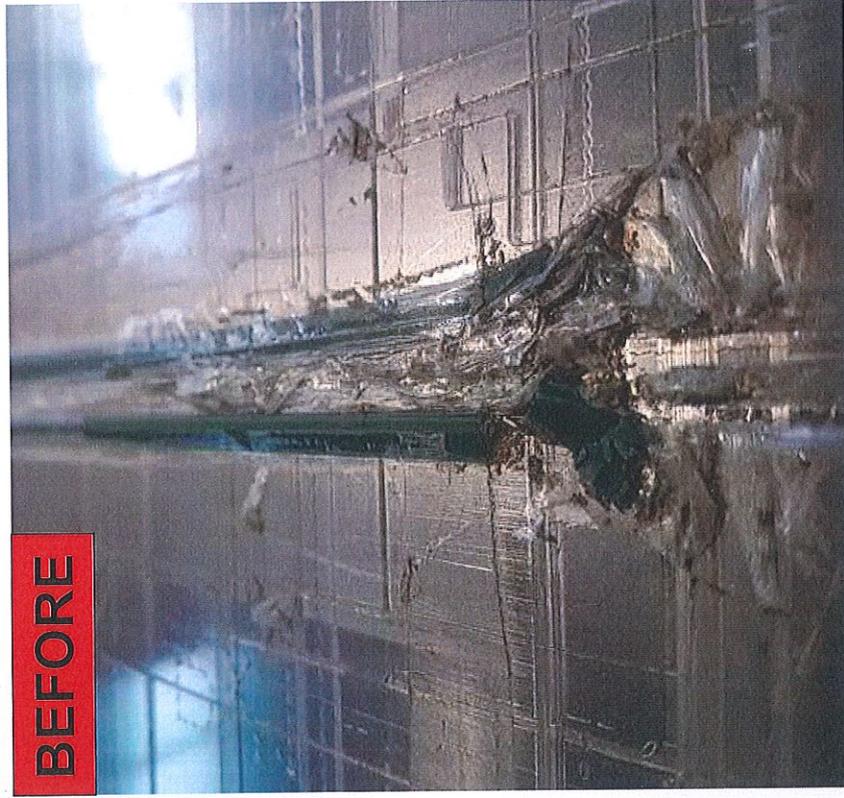
## PRODUCTION CORRECTIVE ACTION

> Change to new plate and creasing matrix since the previous plate was used as common plate before when Eterna were lacking on steel plate.			
<b>PIC:</b>	Production	<b>TARGET DATE:</b>	210615
> Monitor the next running of this item and study the effect of the pressure used.			
<b>PIC:</b>	Production and ME	<b>TARGET DATE:</b>	210616
> Coordinate to ME regarding changing of rectangular slot to rounded slot.			
<b>PIC:</b>	Production and ME	<b>TARGET DATE:</b>	For Discussion
> Create Eterna Plate Condition Checksheet and will conduct weekly checking of Eterna Plate condition care of Production Leader-in-Charge.			
<b>PIC:</b>	Production	<b>TARGET DATE:</b>	210618

PREPARED BY: 210617  
**LEIANN MARIE AVILES**  
PROD IE

APPROVED BY: 210618  
**WEENA V. PALLA**  
SR. SUPERVISOR

# UPDATES:



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

