

**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

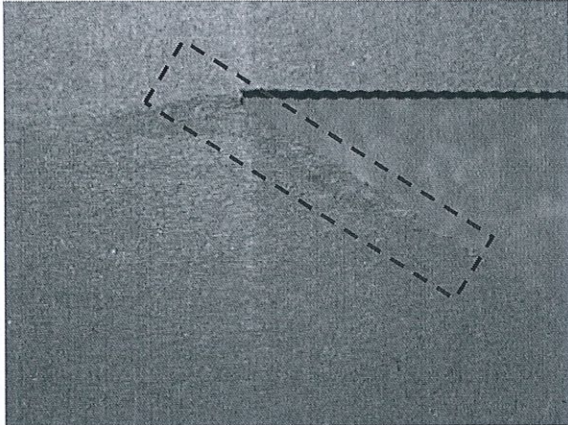
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 437

Date Issued: 21 06 24

Customer	CANON	Attention To	Mr. Gerald De Guzman
Item Code	RX1-5115-000	Department	PRODUCTION
Item Description	Z10 ACC BOX	Date of Detection	21 06 23
Job Order Number	JO-F-21-188-5	Section Detected	SCREENING

ILLUSTRATION OF THE PROBLEM

☐ Major☒ Minor

Lot Quantity (pcs.)

4,100

Reject Quantity (pcs.)

104

Reject Percentage

2.53%

Nature of Defect:

PEEL OFF

Requirement:

No peel off on the item

Actual:

W/ peel off on the smooth surface

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.: 4	<input type="checkbox"/> For Rework	<input checked="" type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Appearance
Date: 21 06 23	<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	 Mr. Roderick Ramos QA Supervisor 21/06/25	 Mr. Rexel Almarin 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: P/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: PLS. SEE ATTACHED Why 3: Why 4: Why 5:	Why 1: Why 2: PLS. SEE ATTACHED Why 3: Why 4: Why 5:

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

- BROKEN BACKING TAPE

OUTFLOW ROOTCAUSE

- THIN DIMENSION OF PEEL OFF

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		
Attendees	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 Oct 25

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The applied pressure is not enough because the applied backing tape is not thin.

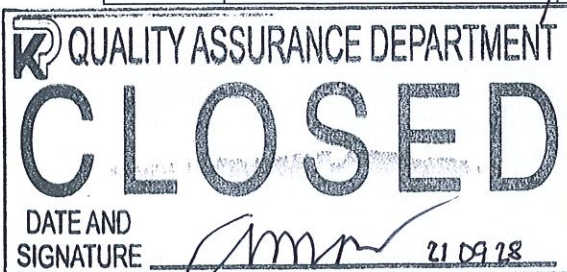
III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 Oct 29	[X] Yes [] No	C.A. is effective
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	21 Oct 28	[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

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 Oct 28	 QA Asst. Manager Date: 21 Oct 28
		 IRISH MAY L. ESTAREJA Line Leader Date: 21 Oct 28	 Department Head Date: 21 Oct 28



INVESTIGATION REPORT FOR PEEL OFF OF CBMP RX1-5115-000 Z10 ACC BOX

DIRECT CAUSE PROCESS/MATERIAL

W1- Due to operator encountered Uncut during mass production.

W2- Due to lack of backing tape caused by decrease in the pressure.

W3- Due to the pressure was set to 1.5 tons instead of 2 tons to avoid bursting and easy detach of scrap in delivery area.

Machine Speed	1800
Machine Pressure	2.15

Operator	GIL REX MARK
Job Order No.	21-04-5
Customer	CBMP
Item Description	RX1 5115
Quantity	1025
Condition Sheet	
Actual Machine Speed	1800
Actual Machine Pressure	2.15
Sheet Size	1130X740
Material	R.P

PRESSURE SET TO 2 TONS TO 1.5 TONS

HEET	Machine Ratio (Stripper / Other)
1. 1800	1.5 min stripping
2. 1800	2.0 min stripping
3. 1800	2.5 min stripping
4. 1800	3.0 min stripping
5. 1800	3.5 min stripping
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