

**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

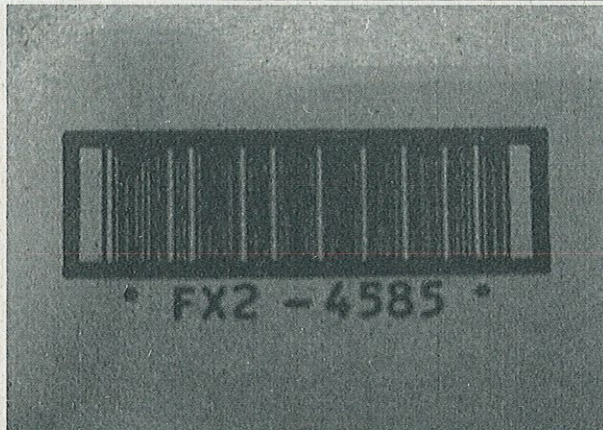
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 440

Date Issued: 21 07 07

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 07 06
Job Order Number	JO-F-21-217-2	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM

☐ Major ☒ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
6,327	39	0.61

Nature of Defect:

BLOTTED PRINT

Requirement:

No blotted print

Actual:

W/ blotted print

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 07 07	<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	 Mr. Rexel Almaro 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**

INTENSIVE THICK APPLICATION OF
INK ON THE START OF THE PROCESS

OUTFLOW ROOTCAUSE

NOT ALL THE 9 OUTS PER SHEET
ARE AFFECTED

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

Date	N/A	Time	N/A	Design / Tools	N/A
Title	N/A				
Attendees	N/A				

C. Reworking

Rework Quantity	N/A					
Total Good	N/A			Process	PLS. SEE ATTACHED	
Rework Percentage (Good)	N/A					

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

Date Conducted: 21 07 08

PIC: A. Vergara

Identified Rootcause

Recommendation

Thick application of ink on the substrate
during start of the printing

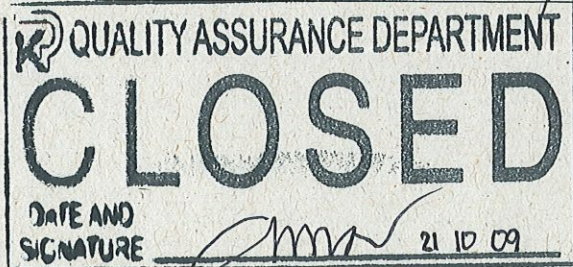
III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 07 08	[X] Yes [] No	C.A. is implemented
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action	A. Vergara	21 10 09	[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		QA Supervisor	QA Ass. Manager
<input type="checkbox"/> Re-Issue IRF		Date: 21 10 11	Date: 21 10 11
			IRISH MAVELESA, J.A.
			Department Head
			Date: 21 10 11



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

DIRECT CAUSE PROCESS/MATERIAL	W1- It is inherent in printing process to have thick application of ink during start of the process.
	W2- Because the anilox roller started to rotate many times before the sheets got feed, why the application of ink during start got thick specially for this item that only have 1 small character print.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- The occurrence is during start of the process only with 39 out 6,327pcs affected or 0.60%.
	W2- Eqos operator did not separate the affected of blotted since not all of 9-outs per sheet are affected.

PRODUCTION ACTION PLAN

> Because this is inherent in Eqos printing machine our suggestion is additional 3-sheets of overrun for this item just to avoid balance requirement, since only 3-sheets are the existing overrun.			
PIC:	PRODUCTION	TARGET DATE:	TO BE DISCUSS IN 4PM MEETING

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
 SR. SUPERVISOR

UPDATES:

PR-001-F12-REV.00

2004

Kanepackage Philippine Inc

SO F. 10-F-21-317

JOB ORDER

ITEM CODE: FX2-4585-000

JOB ORDER: JOF-21-317-5

DATE RELEASED: 2003-07-20

QTY: 4500

DELIVERY DATE: 2003-07-20

CREATED BY: VITAMIN, Maria Adina

Raw Material Code: 555X795 EF TX175

QTY TO BE USED: 500

OVER RUN: 36

CUT SIZE: N/A

DR# 37401

SUPPLIER: JAW

Tooling Reference # 3-11/128

Control/Batch #: 17/28

RM Issued By: 17/28

PROCESS / MACHINE	DATE	INCHARGE	GOOD QTY	REJECTED QTY	REMARKS
		Operator	MEQA	HOUSE	SUPPLIER
1. EDDS	3/03	17/28	500		
2. DIE CUT STERNA	3/03	17/28	500		
3. DIE CUTTING 1	3/03	17/28	4500		
4. LOT NUMBERING	3/03	17/28	4500		
5. SCREENING					
6.					
7.					
8.					
9.					
10.					

PRODUCTION OUT

BY: 17/28

DATE: 3/03

REMARKS: 1. 5000 PCS

PR-001-F12-REV.00

REMARKS: additional 3 sheets was included on the J.O. Before overrun is 3pcs only.