

**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

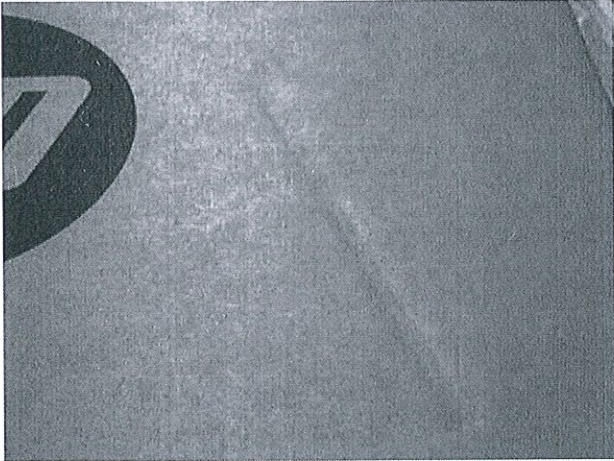
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 442

Date Issued: 21 07 14

Customer	CANON	Attention To	Mr. Gerald De Guzman
Item Code	RX1-5781-000	Department	PRODUCTION
Item Description	Z10 CARTON	Date of Detection	21 07 13
Job Order Number	JO-TO-21-IPD-00206-1	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
950	46	4.84%

Nature of Defect:

DENT

Requirement:

60mm length only

Actual:

150mm above length

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input checked="" type="checkbox"/> Gluing	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension
No.: _____	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Others: _____	<input checked="" type="checkbox"/> Appearance
Date: _____	<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 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 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: PLS. SEE ATTACHED Why 4: Why 5:	Why 1: Why 2: Why 3: PLS. SEE ATTACHED Why 4: Why 5:	

**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)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE**

EASY DETACH SCRAP OF SLOT DUE
TO CUTTING BLADE.

OUTFLOW ROOTCAUSE

NOT SO VISIBLE.

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****B. Orientation**

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

System

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 07 15

PIC: A. Vergara

Identified Rootcause**Recommendation**

> The scrap from the slot was left in die cut platform since there were no nickmark on the affected cutting blade

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 15	<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 09 29	<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.

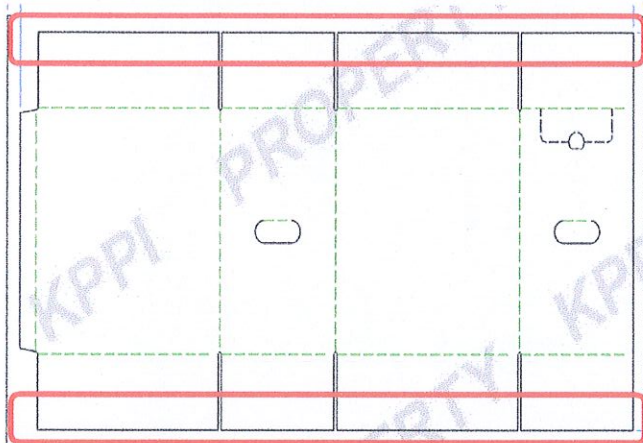
IV. CLOSURE

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 09 29	QA Ass. Manager Date: 21 09 29 IRISH MAY L. ESTAREJA Line Leader Date: 21 09 29 Department Head Date: 21 09 29

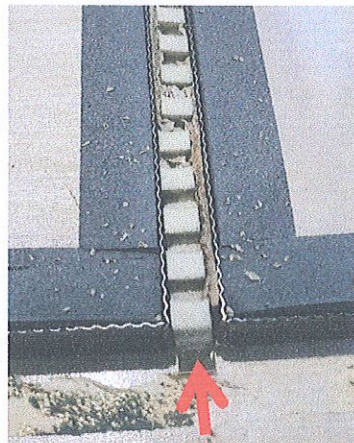
QUALITY ASSURANCE DEPARTMENT
CLOSED
DATE AND SIGNATURE 21 09 29

INVESTIGATION REPORT FOR DENT OF CBMP RX1-5781-000 Z10 CARTON

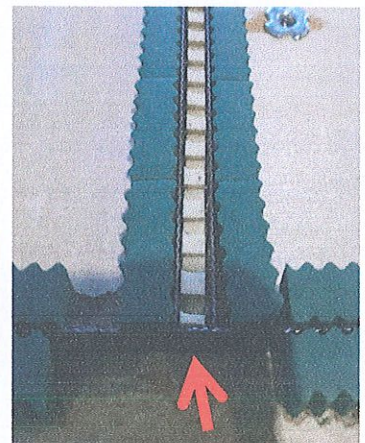
DIRECT CAUSE PROCESS/MATERIAL	W1- There is scrap from upper flap slot left in the stripping blade that caused dent in the item.
	W2- The scrap of slot in the upper flap got easily detached during auto stripping process.
	W3- There is discrepancy between drawing vs. actual blade which is the upper flap slot portion have cutting blade.



**NO CUTTING BLADE IN THE SLOT PORTION
BOTH FLAP**



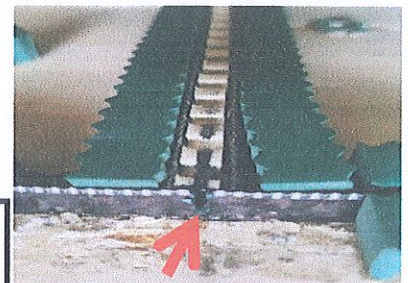
LOWER FLAP IS GOOD



**UPPER FLAP HAVE
CUTTING BLADE**

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Operator more focus on the Uncut and Peel Off problem since this item is under go auto stripping in Eterna and they didn't notice the dent because it is not so visible.
--	---

PRODUCTION CORRECTIVE ACTION



Put nick mark in the cutting blade on upper flap slot to eliminate easy detach of slot scarp.

PIC:	PRODUCTION	TARGET DATE:	210715 (DONE)
-------------	-------------------	---------------------	----------------------

PREPARED BY:

210715
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
SR. SUPERVISOR