

**KANEPACKAGE PHILIPPINE INC.**

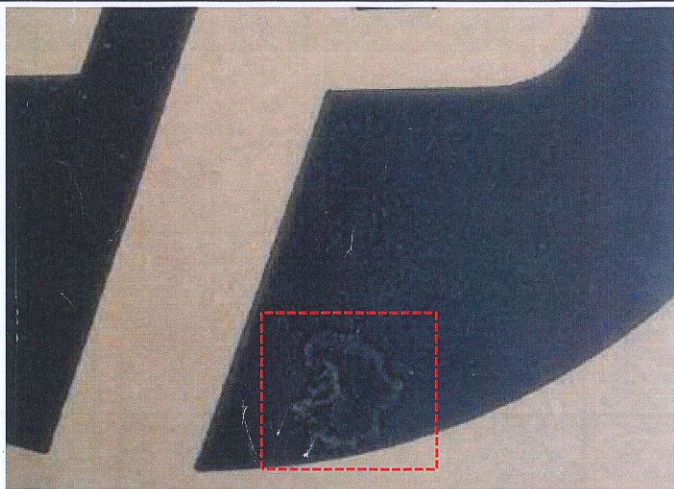
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 471

Date Issued: 21 09 30

Customer	CANON	Attention To	Mr. Gerald De Guzman
Item Code	RX1-5781-000	Department	PRODUCTION
Item Description	Z10 CARTON	Date of Detection	21 09 29
Job Order Number	JO-F-21-263-6	Section Detected	QA - IN LINE

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

2,644

37

1.39%

Nature of Defect:

SCUM

Requirement:

Scum in HP logo is not acceptable

Actual:

W/ scum on the HP Logo

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.: _____	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<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 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 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:

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

- ACCUMULATED PAPER DUST AND FIBER
STICK ON THE CYREL

OUTFLOW ROOTCAUSE

- RANDOMLY OCCURRED

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

P/A

B. Orientation

Date	21 10 06	Time	9:30 - 9:37 A.M.
Title	ORIENTATION REGARDING SCUM OF RX1-6781-000		
Attendees	EQOS OPERATORS		

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 10 04

PIC: A. Vergara

Identified Rootcause

Paper fiber stuck on the flexoplate

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

	Checked by	Date	Implemented?		Remarks
1st Verification of Action	A. Vergara	21 10 06	<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 11 05	<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		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Re-Issue IRF		Date: 21 11 08	Date: 21 11 08	Date: 21 11 08	Date: 21 11 08

DATE AND
SIGNATURE

21 11 05

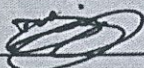

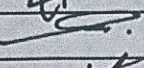

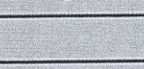


KANEPACKAGE PHILIPPINE INC.

MINUTES OF THE MEETING

Date: 2/10/06 Time Start: 09:30 am Time Finished: 09:37 am Venue: EROS AREA

ATTENDEES:

Name	Section	Sign	Name	Section	Sign
JESSE JAMES CALYA	EROS				
JOLITO ACEJO	EROS				
SHERWIN MANABATON	EROS				
CLEMAN BELARDO	EROS				
DAVID BONGAYON	EROS				

AGENDA:

ORIENTATION REGARDING SCUM OF CBMP RX1-5781-000 Z10 CARTON

MINUTES:

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ROOTCAUSE:

The paper dust and fiber on corrugated board transfer in cyrel during printing impression that caused scam to the items.

CORRECTIVE ACTION:

> Always aware to Scum defect specially in CBMP boxes.

> Do the frequent fast tapping of board but need to consider not to downtime the feeding of materials.

> Report to the Leader in-charge once they encounter Scum defect.

FOLLOW UP MEETING:

(date & time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:


GERALD DE GUZMAN