No. 5 Ri Telepho		GE PHILIPPINE INC. La Mesa, Calamba City, Laguna to 69	INVESTIGATION REPORT FORM (IRF) Inhouse Detection Control No.: 471 Date Issued: 21 09 30			
Customer	CANON		Attention To	Mr. Gerald De		21 09 30
Item Code	RX1-5781-000	1	Department	PRODUCTION		
Item Description	Z10 CARTON	CONTRACTOR OF THE STATE OF THE	Date of Detection	21 09 29	110 3	37 A 2 0/4 1625 / 1-
Job Order Number	JO-F-21-263-		Section Detected	QA - IN LINE	341 0	19 HOLLE
Job Order Number	ILLUSTRATION O			QA - IN LINE	D.A.	
	ILLUSTRATIONO	FINEFROBLEM	Major Lot Quantity (r	non) Poigot Our	Minor	Painat Paraentage
			Lot Quantity (p			Reject Percentage
			2,644 Nature of Defect:	Sala Second Income	7	1.39%
			Requirement:	SCum in HP logo	<u>al</u>	u e
	/ 3	No.		Scull III HP logo		
				W/ scum on	the HP Logo	
NO. OF OCCU	JRRENCE	DISPOSITION	AREA O	F OCCURRENCE / ORK	GIN	CONTENT
First		Hold	Slotter	Gluing		Material
Recurrence	NO A-Vermann	Special Acceptance	EQOS	Vertica	al	Dimension
No.:	nollsbran	For Rework	Diecut	Others	31	Appearance
Date:		Reject / Disposal	Detaching	Stoleans	19 .9s/4 .0s	Process / Method
Issued	by	Checked by	App	proved by		Received by (Receiving Section)
Adrian Ve QA-IE S		Mr. Roderick Ramos QA Supervisor	Mr. Re	exel Almario st. Manager	Y	211001 Gerald De Guzman Mad/ Supervisor
		I. INVESTIGAT	ION / ANALYSIS			
DIRECT CAUSE		on of occurrence, why it happened?)	INDIRECT	CAUSE: (Analyze the rea	ason of occurre	ence, why it leaked?)
Why 1: Why 2: Why 3: Why 4: Why 5:	۲/	/A	Why 1: Why 2: Why 3: Why 4: Why 5:	0 01 12	W/A	and Vermanillan of Alaton
Why 1: Why 2: Why 3: Why 4: Why 5:			Why 1: Why 2: Why 3: Why 4: Why 5:	S H FO SW	2/A	
Why 1: Why 2: Why 3: Why 4: Why 5:	PLS. 50	Why 1: Why 2: Why 3: Why 4:	PLS. S	TET R	TTALLED	

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)

						9 to help			
				FINAL CON	ICLUSION				
	OCCURREN	ICE ROOTCAUSE				OUTFLOW ROOTCAUSE			
	MCK ON THE			D FIBER	- PANDOMLY OCENTRONES				
IMMEDI	ATE ACTION: (Action to be do	ne to contain/ tempora	ry correct the pr	roblem found)	CORRECTI	VE ACTION: (Actions to be done to ensure that the problem	will not happen again)		
A. Sorting Re	sult					Actions to be done to eliminate recurrence	Who / When		
	Location	Total Stock	NG	Total Good					
RM	N/A					P/K			
WIP	N/A				System				
FG	N/A								
B. Orientation	1				1 2				
Date	21 10 06	0 06 Time 9:30~ 9:37 A.M.			Design /	N/A			
Title ORIENTATION REGARDING SCUM OF RX1-5781-000					Tools				
Attendees	EQOS OPERATORS	7.		True True					
C. Reworking									
Rework Qua	antity	N/A	1		Process	PLS. SEE ATTACHED			
Total Good		NIF	9						
Rework Per	centage (Good)	N/		Telletter []			100 EE		
II. QA	ROOTCAUSE VERIFICATI	ON (To be filled o	out by QA In-	-charge)	Date Conducte	d: 21 10 04 PIC: A. Vergara	Appropriate [
leone	Identifie	ed Rootcause		toseld []		Recommendation	La per		
	per stuck on the		more see	a a constant	401.45	Record Disposal	2000		

III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)						
	Checked by	Date	Implem	ented?	Remarks	
1st Verification of Action	A. Vergara	21 10 06	[/] Yes	[] No	C.A. is implemented	
2nd Verification of Action	· Ju		[]Yes	[] No	A/ 9	15 year 15 gard
3rd Verification of Action			[]Yes	[] No		A yello B
Effectiveness of Action	A. Vergara	21 11 05	[/] Yes	[] No	c.a. is effective	T ASM

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: REDADTA	AFAIT Approved by:	Process Owner Acknowled	dgment: (Receiving Section)		
of sed	Da Supervisor QA Ass. Manager Date: 21 11 08	RISH MAY L FOTAFEIA Line Leader	Department Head Date: 2 11 08		
DATE AND SIGNATURE 21 11 DE			OA 027 E01 DEV 01		

INVESTIGATION REPORT FOR SCUM OF **CBMP RX1-5781-000 Z10 CARTON**

W1- Scum occurs due to accumulated paper dust and fiber stick on the cyrel.

DIRECT CAUSE

PROCESS/MATERIAL W2- The paper dust and fiber on corrugated board transfer in cyrel during printing impression that caused scam to the items.

KNO	2/5	Time	Macrose Dayer (Donney / Digerooms /
-B./.!	K1 2057	Escert Ferrorts	Others
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mies .	Time	i	grand graint
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		huk 1159	-dering.
		1 m (m) (m) 5	aking well in
11:15	1500 1515	1315	the calety \$301.
1103	1244 1246		
	1245	11317 1327	Jump Fend reller
1100	2, 1140		lord chanty eyel
1115	1240 1254		blatted"
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17.30		11.3.	
		1.355 1401	I spot charming expell
		nt service service	
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	10	,	

	1310	1315	cleaning eyed due to sabeton 1 500+.
	1317	1327	Jump Feed soller. of charing eyel blothed
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	1355	12107	spot chaning expel
	1355 1413	1423	whishing amilorous dure to bibtted and int staine of the staine of the proof
			PR-002-F0

EQOS encounter 5-times down time with a total of 35mins due to Spot/Scum occurrence

INDIRECT CAUSE (OUTFLOW)

PROCESS/MATERIAL

W1- Upon detection of Spot/Scum operator immediate stop the machine and cleaned the cvrel

W2- Some of affected didn't notice since its occurs randomly.

PRODUCTION ACTION PLAN

Since the paper dust and fiber is uncontrollable our action plan is to alert the Eqos operator regarding this issue, do the frequent fast tapping of board but need to consider not to downtime the feeding of materials.

PIC:

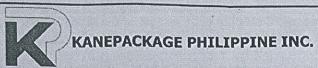
PRODUCTION

TARGET DATE:

211005

PREPARED BY:

APPROVED BY:



MINUTES OF THE MEETING					
Date: 211006 Time Start: 09:30 mm	Time Finished: 09:37 Am Venue: EBOS AMEA				
Name Section Sign TRANE TAMES CALVA PLOS TO 170 170 1000	Name Section Sign				
SHERVOH MANDATION EQUS CLEMAN BETARDO EQUS DAVID BONAYON EQUI					
	ON REGARDING SCUM OF L-5781-000 Z10 CARTON				
MINUTES:	page <u>1</u> of <u>1</u>				
The paper dust and fiber on corrugated board transfer CORRECTIVE ACTION: > Always aware to Scum defect specially in CBMP boxe > Do the frequent fast tapping of board but need to co > Report to the Leader in-charge once they encounter	onsider not to downtime the feeding of materials.				
FOLLOW UP MEETING: (date & time) for KPPI fill up only Prepared by: Reviewed by:	Noted by:				