

**KANEPACKAGE PHILIPPINE INC.**

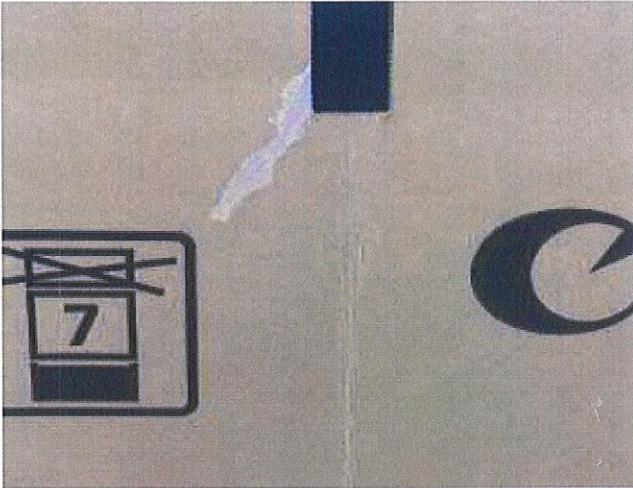
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 486

Date Issued: 211111

Customer	CBMP	Attention To	Mr. Gerald De Guzman
Item Code	FX2-5524-000	Department	Production
Item Description	Z10 BOX OUTER	Date of Detection	211110
Job Order Number	JO-F-21-332-7	Section Detected	QA-Screening

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

1100

50

4.55%

Nature of Defect:

PEEL OFF

Requirement:

NO PEEL OFF

Actual:

OCCURRENCE OF PEEL OFF

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 type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.:	<input type="checkbox"/> For Rework	<input checked="" 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)
 Rochelle Evangelista QA-IE Staff	 Roderick Ramos QA Supervisor	 Rexel Almarino QA Asst. Manager	 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:	Why 3:	
	Why 4:	Why 4:	
	Why 5:	Why 5:	
Design / Toolings	Why 1:	Why 1:	
	Why 2:	Why 2:	
	Why 3:	Why 3:	
	Why 4:	Why 4:	
	Why 5:	Why 5:	
Process / Material	Why 1:	Why 1:	
	Why 2:	Why 2:	
	Why 3:	Why 3:	
	Why 4:	Why 4:	
	Why 5:	Why 5:	

N/A

N/A

N/A

N/A

PLS. SEE ATTACHED

PLS. SEE ATTACHED

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

- GAP FROM CUTTING & CREASING BLADE
COLLECT SMALL SCRAP THAT EFFECT
IN CUTTING PERFORMANCE.

- ITEM PROCESS/DIEUT IN OPPOSITE
SIDE OR ROUGH SURFACE.

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			
WIP	N/A			
FG	N/A			

System	N/A	
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B. Orientation

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

Design / Tools	N/A	
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C. Reworking

Rework Quantity	N/A
Total Good	N/A
Rework Percentage (Good)	N/A

Process	PLS. SEE ATTACHED	
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II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 21 11 12

PIC: A. Vergara

Identified Rootcause**Recommendation**

There was an upset liner because the gap on the blade started to develop.

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	A. Vergara	21 11 13	<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 25	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	C.A. is effective

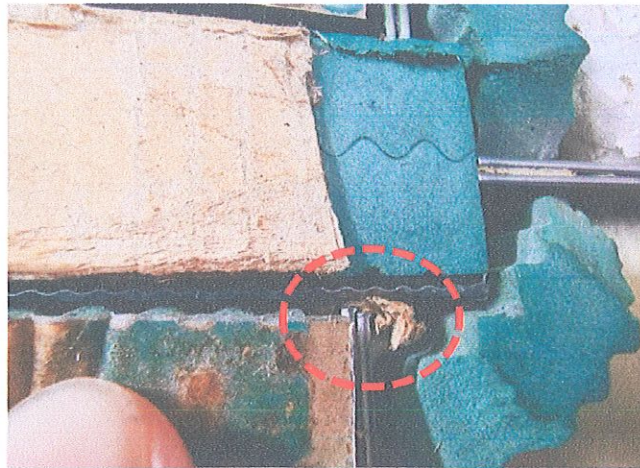
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improvement action.

IV. CLOSURE

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input checked="" type="checkbox"/> Closed	CLOSED	<input checked="" type="checkbox"/> Still Open	QA Supervisor	QA Asst. Manager	IRISH MAY L. ESTAREJA Line Leader
<input type="checkbox"/> Re-Issue IRF		Date: 21 11 25	Date: 21 11 25	Date: 21 11 25	Date: 21 11 25
DATE AND SIGNATURE					

INVESTIGATION REPORT FOR PEEL OFF OF CBMP FX2-5524-000 Z10 BOX OUTER

DIRECT CAUSE PROCESS/MATERIAL	W1- There is a gap from cutting to creasing line blade where the small scrap accumulated during mass production. The accumulated scrap in the gap of cutting and creasing blade effect in the cutting performance of cutting blade and because the item is underwent auto stripping in Diecut S1700 it caused Peel Off to the items.
	W2- Possible the gap is due to the hardness of materials (CBF NPK280) and during mass production the small scrap accumulated on that gap.



INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1- Operator did not notice the Peel Off since the item cut in opposite side or rough surface ^{on top} and only top portion per batch-pile are conducted sampling since the item is heavy.
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PRODUCTION CORRECTIVE ACTION

Repair of Diecut blade c/o Tooling custodian			
PIC:	PRODUCTION	TARGET DATE:	211113

PREPARED BY:


GERALD DE GUZMAN
 PROD ASST. SUPERVISOR

APPROVED BY:


WEENA V. APALLA
 SR. SUPERVISOR

BEFORE:



THERE WAS A GAP BETWEEN THE CREASING LINE AND THE CUTTING BLADE.

AFTER:



THE GAP BETWEEN THE CUTTING BLADE AND CREASING RULE IS CORRECTED.