

**KANEPACKAGE PHILIPPINE INC.**

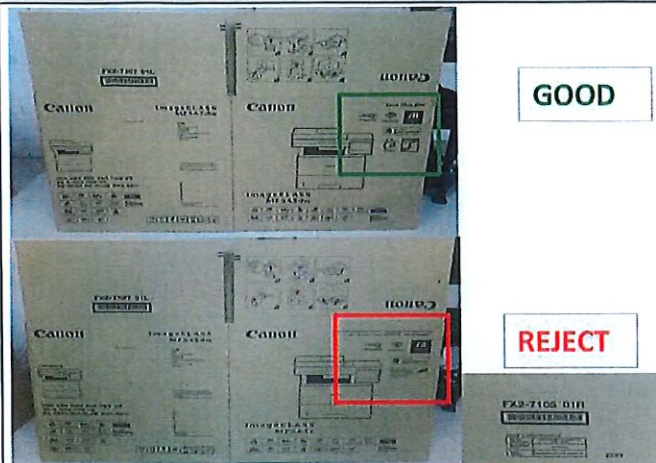
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.:IRF-01014

Date Issued: 220525

Customer	CANON	Attention To	SIR, DICK RAMOS
Item Code	FX2-5107-000	Department	QA
Item Description	Z10 OUTER BOX	Date of Detection	220524
Job Order Number	22-00095-3	Section Detected	KP FPIP

ILLUSTRATION OF THE PROBLEM

<div><div></div></div> Major	<div><div></div></div> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
18	3	16.67%
Nature of Defect:		
MIXED PANEL		
Requirement:		
SHOULD BE FX2-7107 PANEL A AND B ONLY		
Actual:		
MIXED PANEL (7107 PANEL A / 7105 PANEL B)		

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: _____ Date: _____	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input checked="" type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others: _____	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
		QA Asst. Manager	

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: No detection of mixed panels. (During 100% Inspection). Why 2: The QA Inspector did not conduct detailed checking on both panels of the items and the carton box did not underwent barcode scanning. Why 3: During checking, the Inspector focus only on the pokayoke to ensure that there is no double panel. He does not check the code of each panel and the scanner machine is cannot be used. Why 4: Proper sequence of inspection for CBMP Carton boxes was not completely follow. (Note: Proper checking and checkpoints that are needed to be is incorporated on that W.I.) 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: Wrong attachment of panels (During gluing). Why 2: There were mixed FX2-7105 Panel B on the FX2-7107 Panel B. Why 3: Line clearance was not fully implemented on the process that resulted to mixing of panels from different code. Why 4: Why 5:	Why 1: The operator overlook the pokayoke mark indicated on the glue tab. Why 2: Assigned operator did not read the pokayoke to identify that there are mixed / wrong panel on the staired pile. Why 3: Work Instruction for gluing 2-joints carton boxes was skipped. 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**

Line clearance was not completely followed

OUTFLOW ROOTCAUSE

>Proper sequence checking was not followed
>Work Instruction for 2-joints carton boxes was skipped

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	1. Orient QA Inspector for the sequence inspection for CBMP items. 2. Usage of barcode scanning machine to ensure that the panel adhere is correct.	22 05 27
WIP	N / A						22 06 30
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	Process	1. Strictly follow the Procedure for Line Clearance. 2. Always check the pokayoke mark indicated on the glue tab	22 05 27
Total Good	N / A			
Rework Percentage (Good)	N / A			

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

Date Conducted: _____ PIC: _____

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action			[] Yes [] No	
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action			[] Yes [] No	

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 type="checkbox"/> Closed					
<input type="checkbox"/> Still Open		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Re-Issue IRF		Date:	Date:	Date:	Date:



KANEPACKAGE PHILIPPINE, INC.

ATTENDANCE SHEET

Submitted by:

J. Pamplona

Date:

21.05.27

ACTIVITY

Re-orientation of Sequence checking for CBMP Carton Boxes.

Attendees

	FIRST NAME	LAST NAME	DIV. / DEPT.	SIGNATURE
1	Dave	VILLARUZ	QA	
2	Mark	MAGAYANES	QA	
3	Marinel	HERNANDEZ	QA	
4	MARK JOSEPH	LAVADO	QA	
5	MARC MATTHEW	LIPRON	QA	
6	RHOEMER	BUAN	QA	
7	Jexter	TAMPON	QA	
8	ARTCHE	SERIOS	QA	
9	RAMON	PACULO	QA	
10	MICHAEL	VERDAD	QA	
11	Maitan	Jana	QA	
12	RIC RYAN	PANSUNDO	QA	
13	VICKTORDE	VILLARAND	QA	
14	Francis	ALCANTARA	QA	
15	ROSE ANNE	CLANARES	QA	
16	MAIVA	CANACA	QA	
17	JAMICA	TABOT	QA	
18	LWEX	VILLAMUEVA	QA	
19	MANN	PON	QA	
20	JERICK	ROCHA	QA	
21				



KANEPACKAGE PHILIPPINE, INC.

ATTENDANCE SHEET

Submitted by:

J. Samiento

Date:

220527

ACTIVITY

Orientation to avoid Mixing and Double Panel for CBMP
Carton Boxes

Attendees

	FIRST NAME	LAST NAME	DIV. / DEPT.	SIGNATURE
1.	JEFFREY	EDADES	PROD / GLUING	
2.	AMEL LEON	GARCIA	Phen / GLUING	
3.	MARK RYAN	DUBAN	Prod / GLUING	
4.	JAYSON	BUAL	Prod / Gluing	
5.	WINSTON	NEMENZO	PROD / CONVEYER	
6.				
7.				
8.				
9.				
10.				
11.				
12.				
13.				
14.				
15.				
16.				
17.				
18.				
19.				
20.				

Note: This form is confidential. Do not use as scratch paper.

Page 1 of