

**KANEPACKAGE PHILIPPINE INC.**

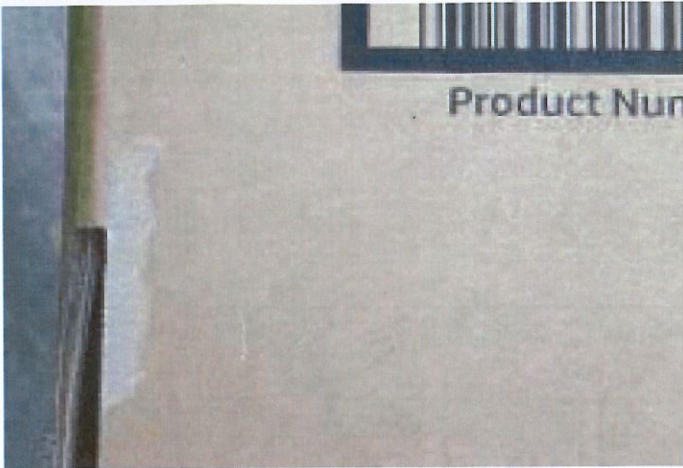
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 592

Date Issued: 22 07 08

Customer	CANON	Attention To	Gerald De Guzman
Item Code	RX1-5756-000	Department	Production
Item Description	Z10 CARTON BOX	Date of Detection	22 07 07
Job Order Number	JO - F - 22 - 224 - 11	Section Detected	PRD-MANUAL GLUING

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1000	89	8.90%

Nature of Defect:

PEEL OFF

Requirement:

Maximum of 20mm diameter for peel off

Actual:

exceeded the maximum requirement for peel off

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 checked="" type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others: _____	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by Rochelle Evangelista QA-IE Staff	Checked by Roderick Ramos QA Sr. Supervisor	Approved by Rexel Almario QA Asst. Manager	Received by (Receiving Section) 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**

- DULL CUTTING BLADE

OUTFLOW ROOTCAUSE

- RECURRING OCCURRENCE

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	N/A	N/A	N/A
WIP	N/A	N/A	N/A	N/A
FG	N/A	N/A	N/A	N/A

System

N/A

B. Orientation

Date	7/14/22	Time	.
Title	tooling instruction assessment regarding blade replacement		
Attendees	tooling instruction		

Design /
Tools

N/A

C. Reworking

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

Process

PLS. SEE ATTACHED

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

Date Conducted: 7/19/22

PIC: QA IE

Identified Rootcause

Recommendation

Dull cutting blade

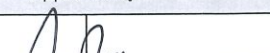

NA

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

	Checked by	Date	Implemented?		Remarks
1st Verification of Action	QA IE	7/14/22	<input type="checkbox"/> Yes	<input checked="" type="checkbox"/> No	no reminder signage in Vicmt S1700
2nd Verification of Action	QA IE	7/19/22	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	REMARKER in S1700 attached / posted
3rd Verification of Action			<input type="checkbox"/> Yes	<input type="checkbox"/> No	
Effectiveness of Action			<input type="checkbox"/> Yes	<input type="checkbox"/> 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.

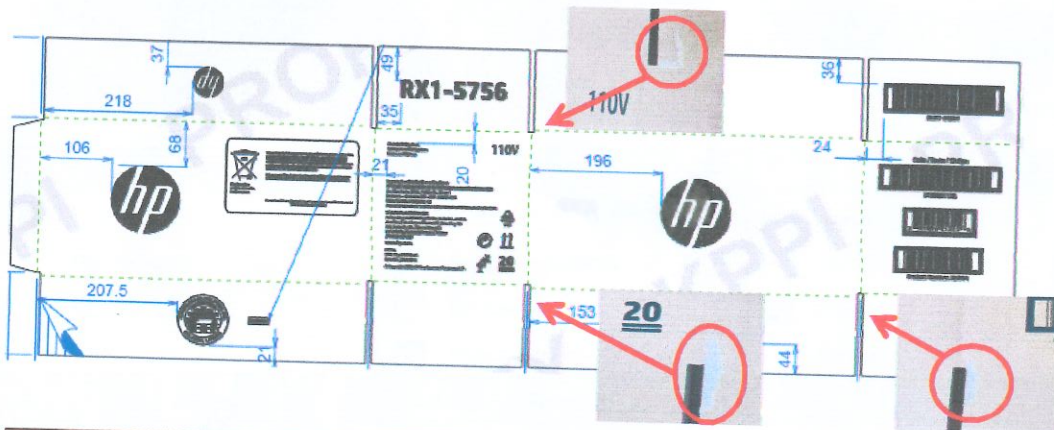
IV. CLOSURE

QUALITY ASSURANCE DEPARTMENT		Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input type="checkbox"/> Closed	CLOSED				
<input type="checkbox"/> Still Open					
<input type="checkbox"/> Re-Issue IRF					
QA Supervisor		QA Asst. Manager		Line Leader	Department Head
Date: 22/20		Date: 22/20		Date:	Date:

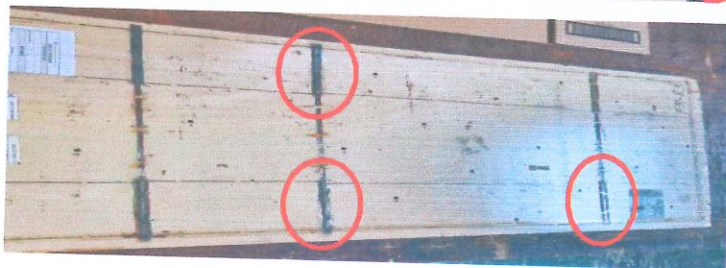
INVESTIGATION REPORT FOR CBMP RX1-5756-000 Z10 CARTON PEEL OFF

DIRECT CAUSE PROCESS/MATERIAL	W1	Due to the hardness of materials the cutting blade in Slot portion get dull.
	W2	Dull cutting blade result to Uncut then result to Peel Off the items since the item underwent auto stripping process in Diecut S1700.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	When operator notice the Peel Off they immediately attached backing tape on the affected area.
	W2	Peel off recurring in different location of slot and since occurrence is randomly there is out flow happened.
	W3	Diecut operator report to leader in-charge the issue to alert the next process, since they can't conduct sorting because the item is big sheets and quite heavy with 20pcs per batch released in delivery.



**PEEL OFF RECURRING IN
DIFFERENT LOCATION**



Specified as of:	Total shots:	Pressure Class:	Operator	Checked by Tooling:
2/20/20	31,001	95	me	CHAD
2/20/20	32,073	95	me	CHAD
2/20/20	33,096	95	MT	CHAD

**DIE-BLADE ALREADY HAVE
STEEL BACKING TAPE
ATTACHED WITH A SETUP
PRESSURE OF 95 AND
TOTAL OF 33,096 SHOTS**

PRODUCTION CORRECTIVE ACTION

1. Assessment of tooling custodian is blade replacement since all the slot have steel backing tape due to dull cutting blade.
2. Put Reminder signage in Diecut S1700 to be alert for the items underwent auto stripping since it was prone to Peel Off, specially CBMP items with hard materials and wave cutting blade. (7/18/2022) DONE

PIC:	PRODUCTION	TARGET DATE:	220714
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PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V APALLA
ASST. MANAGER