

**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.: 590

Date Issued: 22 07 07

Customer	CANON	Attention To	Gerald De Guzman
Item Code	FX2-5097-000	Department	Production
Item Description	Z10 BOX OUTER (PANEL A & B)	Date of Detection	22 07 06
Job Order Number	F-22-208-4-1	Section Detected	PRD-Manual Gluing

ILLUSTRATION OF THE PROBLEM☒ Major☐ Minor

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1520	90	5.92%

Nature of Defect:

PEEL OFF

Requirement:

the size of the peel off should not exceed 5mm

Actual:

25mm 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	Checked by	Approved by	Received by (Receiving Section)
 Rochelle Evangelista QA-IE Staff	 Roderick Ramos QA Sr. Supervisor	 Rexel Almario 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 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: PLS. SEE ATTACHED Why 3: 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

OUTFLOW ROOTCAUSE

- DULL CUTTING BLADE

- RANDOM RECURRING OF
PEEL OFF

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	Time	
N/A	N/A	
Title		
Attendees		

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: 7/8/22 PIC: QA IE

Identified Rootcause

Recommendation

Dull cutting blade.

N/A

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	QA IE	7/8/22	[X] Yes [] No	cutting blade replaced by looking working.
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.

QUALITY ASSURANCE DEPARTMENT

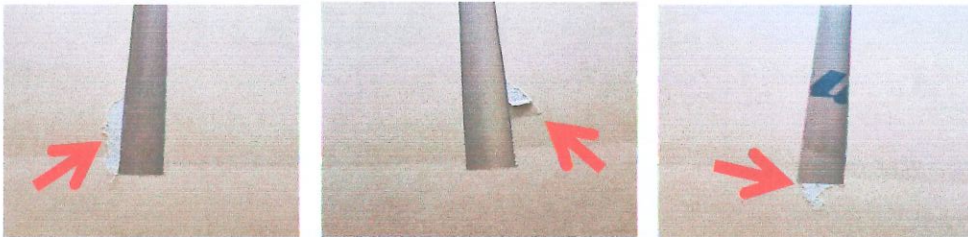
IV. CLOSURE

Status:	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)
Closed			
Still Open			
Re-issue IRF			
DATE AND SIGNATURE	DATE	DATE	DATE
	22/1/20	22/201	

INVESTIGATION REPORT FOR CBMP FX2-5097-000 Z10 BOX OUTER 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 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 RECURRING IN
DIFFERENT LOCATION**

	INITIAL PRESSURE: 95				
	SETUP BY:				
Updated as of:	Total shots:	Pressure Used	Operator	Checked by Tooling:	
220611	44117	95	MAK	MAK	
220615	48256	95	MAK	MAK	
220615	48294	95	MAK	MAK	
220617	48894	95	MAK	MAK	
220618	50349	95	MAK	MAK	
220620	50429	95	MAK	MAK	
220621	51469	95	MAK	MAK	
220622	52560	95	MAK	MAK	
220620	54379	95	MAK	MAK	
220704	55895	95	MAK	MAK	
220708	55963	95	MAK	MAK	
220708	56963	95	MAK	MAK	

**DIE-BLADE ALREADY HAVE
STEEL BACKING TAPE
ATTACHED WITH A TOTAL OF
56,963 SHOTS**

PRODUCTION CORRECTIVE ACTION

Replacement of Cutting Blade on slot portion c/o tooling custodian

PIC:	PRODUCTION	TARGET DATE:	220708 (ON GOING)
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PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
ASST. MANAGER