

**KANEPACKAGE PHILIPPINE INC.**

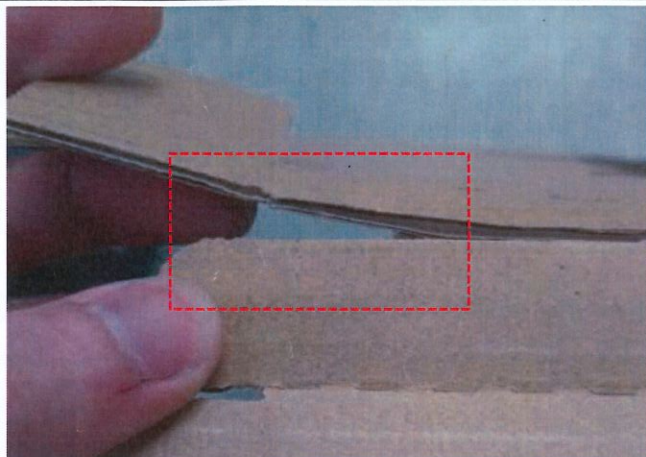
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

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

Control No.: 588

Date Issued: 22 07 05

Customer	BROTHER	Attention To	Mr. Gerald De Guzman
Item Code	D028CY001	Department	PRODUCTION
Item Description	CARDBOARD C TOP R (PART A)	Date of Detection	22 07 04
Job Order Number	JO22-M-01329-33	Section Detected	QA - SCREENING

ILLUSTRATION OF THE PROBLEM☐ Major☒ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

696

217

31.18%

Nature of Defect:

OVER CUT

Requirement:

No overcut for half cut

Actual:

W/ Overcut

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"/> Gluing	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension
No.: _____	<input type="checkbox"/> For Rework	<input checked="" type="checkbox"/> Diecut	<input type="checkbox"/> Others: _____	<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)	
 Adrian Vergara QA-IE Staff	Mr. Roderick Ramos QA Supervisor	QA Asst. Manager	 Mr. 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:	N/A
	Why 4:	Why 4:	
	Why 5:	Why 5:	
Design / Toolings	Why 1:	Why 1:	
	Why 2:	Why 2:	
	Why 3:	Why 3:	N/A
	Why 4:	Why 4:	
	Why 5:	Why 5:	
Process / Material	Why 1:	Why 1:	
	Why 2:	Why 2:	
	Why 3:	Why 3:	PLS. SEE ATTACHED
	Why 4:	Why 4:	
	Why 5:	Why 5:	

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

- STEEL BACKING TAPE IN THE CUTTING
BLADE EFFECT IN THE CUTTING CONDITION
OF HALF CUT RESULT TO OVERCUT

OUTFLOW ROOTCAUSE

- RANDOMLY 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				System	N/A	
WIP	N/A						
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					
Total Good	N/A			Process	PLS. SEE ATTACHED	
Rework Percentage (Good)	N/A					

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

Date Conducted: 22 07 06

PIC: A. Vergara

Identified Rootcause

Recommendation

Over impression from half-cut blade due to
uneven application of backing tape.

N/A

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

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	R. EVANGELISA	220706	[X] Yes [] No	N/A
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 checked="" type="checkbox"/> Closed			
<input type="checkbox"/> Still Open		QA Supervisor	Line Leader
<input type="checkbox"/> Re-Issue IRF		QA Asst. Manager	Department Head
		Date: 220701	Date:

DATE AND
SIGNATURE

22 11 30

QA-027-F01 REV.0:

INVESTIGATION REPORT FOR BROTHER D028CY001 CARDBOARD C TOP R (PART A) OVER CUT

DIRECT CAUSE PROCESS/MATERIAL	W1	There is a factor that steel backing tape in the cutting blade near in half cut blade effect in half cut condition result to overcut.
	W2	Items prone to over cut since the materials is single wall (B-flute).

STEEL BACKING TAPE
IN CUTTING BLADE
DUE TO UNCUT
CONDITION



HALF CUT BLADE WHERE THE
OVER CUT OCCURS

Updated as of:	Total shots:	Pressure Used	Operator	Checked by Tooling:
220619	15083	85	TOTIC MIKE	ALDI
220621	15097	85	MIKE	ALDI
220622	15117	85	MIKE	ALDI
220624	15353	85	Vino	ALDI
0627	15770	85	YAN	ALDI
220628	16092	75	YAN	ALDI
220701	16743	75	DETS	ALDI

NO PROBLEM IN
PRESSURE SETUP
SINCE ALL SETUP
RANGE TO 75 -85
DEPEND ON
MATERIALS
HARDNESS

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	The random over cut didn't trap during sampling in diecut since its trigger to occurs during reverse folding in Brother Assy.
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PRODUCTION CORRECTIVE ACTION

1. Remove the backing tape in half cut blade to reduce the pressure in half cut portion. (TD: 220706 Done)
2. Revision of Half Cut to Perforation Line to totally eliminate the over cut issue since the half cut is prone to over cut due to single wall (B-flute) materials. (Discuss in 4pm meeting)

PIC: **PRODUCTION**

PREPARED BY:

[Signature]
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

[Signature] 22 0706
WEENA X. APALLA
ASST. MANAGER