

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 5457-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)

Control No.:

Date Issued

0002

240507

Customer	KOYAMA TRADING PHIL., INC.	Attention To	WEENA APALLA
Item Code	PKC404B-B	Department	PRODUCTION
Item Description	MOTOR INNER BOX	Date of Detection	240502
Job Order Number	JO-24-IPD-00399-2	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
4000	60	1.50

Nature of Defect:

MISALIGN GLUE

Requirement:

Gluing should be aligned

Actual

Actual has gap due to misalign glue

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240502</u>	<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)
LESTER JOHN DIOSO 240507	CHARLENE JAN MARIE FLORES 240507	RODERICK RAMOS 240507	GERALD DE GUZMAN 240527

I. INVESTIGATION / ANALYSIS**DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)****System / Training****Design / Toolings****Process / Material**

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 5457-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)**INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)**

System / Training

Design / Toolings

Process / Material

FINAL CONCLUSION

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

WHO / WHEN

Process / Material

WHY 1: Improve the creasing line by applying a creasing matrix even the creasing blade hits the grain direction line it will not result in misalignment during folding due to creasing matrix. r n r nCorrective Action apply after finish the replacement of Eterna die chase spring.

Production Leaders // 2024-07-15

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

A. Sorting Result

C. Reworking

	Location	Total Stock	NG	Total Good	Rework Quantity	n/a
RM	n/a	1	1	1	Total Good	n/a
WIP	n/a	1	1	-1	Rework PPM (Good)	n/a
FG	n/a	1	1	-1		

B. Orientation

Date	2024-06-14	Time	15:44
Title	Orient and aware the SD1800 operator regarding this issue of misalign gluing of PKC404B Motor Inner Box		
Attendees	SD1800 operators		

Prepared By:

Approved By:

GERALD DE GUZMAN | 240613

WEENA APALLA | 240702

Department Head

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 5457-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)**II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)**

Date Conducted: 2024-07-31	PIC: M.ASIS
Identified Rootcause Creasing blade hit the grain direction line	Recommendation n/a

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

	Checked By:	Date	Implemented?	Running	JO Number	Date	NG Qty	Lot Qty
1st Verification of Action	M. ASIS	2024-07-31	[/] Yes [] No	1st	JO24-M-01327-3	240808	2	340
2nd Verification of Action			[] Yes [] No	2nd	JO24-M-01460-3	240829	0	2000
3rd Verification of Action			[] Yes [] No	3rd	JO24-M-01460-4	240830	0	2000
Effectiveness of Action	M. ASIS	2024-07-31	[/] Yes [] No	4th	JO24-M-01593-7	240925	0	3800
Remarks: Replacement of Eterna die-chase spring was last July 31, 2024.				5th	JO24-M-01627-1	241004	0	2000

IV. CLOSURE

Status	Remarks
Closed IRF	Five consecutive lots running with only 2 rejects.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250303 10:23 QA Head	KOHEI ISHII 250304 02:24 Top Management	GERALD DE GUZMAN 250318 03:36 Line Leader	REXEL ALMARIO 250507 11:28 Department Head
Date: 25252525-03-03	Date: 25252525-03-04	Date: 25252525-03-18	Date: 25252525-05-07