

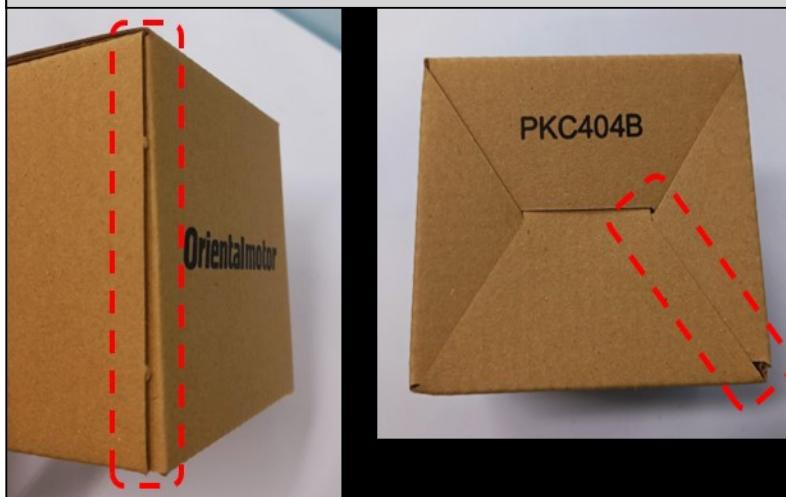
**KANE PACKAGE PHILIPPINE INC.**

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"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence No.: <u>1</u>	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
Date.: <u>240502</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<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**



## 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		
FG	n/a	1	1	-1	Rework PPM (Good)	n/a

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	

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**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	[ <input checked="" type="checkbox"/> ] Yes [ <input type="checkbox"/> ] No	1st	JO24-M-01327-3	240808	2	340
2nd Verification of Action			[ <input type="checkbox"/> ] Yes [ <input checked="" type="checkbox"/> ] No	2nd	JO24-M-01460-3	240829	0	2000
3rd Verification of Action			[ <input type="checkbox"/> ] Yes [ <input checked="" type="checkbox"/> ] No	3rd	JO24-M-01460-4	240830	0	2000
Effectiveness of Action	M. ASIS	2024-07-31	[ <input checked="" type="checkbox"/> ] Yes [ <input type="checkbox"/> ] 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
Date: 25252525-03-03	Date: 25252525-03-04
	Date: 25252525-03-18
	Date: 25252525-05-07