

**KANE PACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISI 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
0003	240520

Customer	SUPERFLEX LOGISTICS, INC	Attention To	WEENA APALLA
Item Code	PKC404B-B	Department	PRODUCTION
Item Description	MOTOR INNER BOX	Date of Detection	240511
Job Order Number	JO-24-IPD-00399-9	Section Detected	QA SCREENING

**ILLUSTRATION OF THE PROBLEM**

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
4000	175	4.38

## Nature of Defect:

MISALIGN DIECUT/CUT

## Requirement:

Print should be center line with  $\pm 2$ mm tolerance

## Actual

Off-center

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240511</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 checked="" type="checkbox"/> Diecut <input type="checkbox"/> Detaching	<input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others
Issued by	Checked by	Approved by	Received by (Receiving Section)
ERIKA ASIS   240520	CHARLENE JAN MARIE FLORES   240520	RODERICK RAMOS   240521	GERALD DE GUZMAN   240527

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

WHY 1 : W1 The factor we consider is misalign diecut due to abnormal lateral movement of Eterna die chase. r n r nW2 The die chase moved up to 7mm in the lateral direction (Left Right) during mass production even though it was locked. r n r nW3 According to Caledonian the 6pcs die chase springs on the cylinder are already worn out that caused die chase movement even if it is locked.



## INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)

System / Training

Design / Toolings

Process / Material

WHY 1 : Eterna operator didn't notice the problem due to randomly occurrence.

## FINAL CONCLUSION

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

WHO / WHEN

Process / Material

WHY 1: Replacement of 6pcs die chase spring.

Engineering Caledonian //  
2024-06-30WHY 2: Include the die chase spring in Engineering Machine History Sheet of Eterna. This is the basis of  
Engineering for the monitoring of machine parts life span for those parts that only Caledonian can  
maintain or check.Engineering Caledonian //  
2024-06-30

## 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	0	0	0	Total Good	n/a
WIP	n/a	0	0	0	Rework PPM (Good)	n/a
FG	n/a	0	0	0		

  

B. Orientation								
Date	2024-06-14			Time	05:54			
Title	Temporarily transfer of process in Diecut S1700 while the Eterna die chase spring didn't replace							
Attendees	N/A							

  

Prepared By:			Approved By:		
GERALD DE GUZMAN   240611			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 Worn-out 6pcs die-chase springs on the cylinder	Recommendation Replacement of die-chase spring

**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	2024-08-08	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO24-M-01460-3	240808	0	2000
2nd Verification of Action	M. ASIS	2024-09-25	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO24-M-01460-4	240808	0	2000
3rd Verification of Action	M. ASIS	2024-10-04	<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO24-M-01327-3	240808	0	340
Effectiveness of Action	M. ASIS	2024-10-04	<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO24-M-01593-7	240925	0	3800

Remarks: Instead of Engineering Machine History Sheet of Eterna, Engineering Department submitted Preventive Maintenance Job Order - Eterna Diecut Machine (EN-002-F86)

**IV. CLOSURE**

Status	Remarks
Closed IRF	Five consecutive lots running with no rejects.
Approved by:	Process Owner Acknowledgment: (Receiving Section)
MICHAEL CASILLANO   250221 07:40 QA Head	KOHEI ISHII   250226 02:32 Top Management
Date: 25252525-02-21	Date: 25252525-02-26
	Date: 25252525-03-03
	Date: 25252525-05-07