



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.:

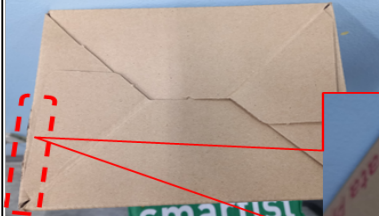
Date Issued

0004

240523

Customer	KOWA-EMORI PHILIPPINES, INC.	Attention To	WEENA APALLA
Item Code	HP01D2000-3 EQOS	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	240517
Job Order Number	JO24-M-00602-5	Section Detected	QA SCREENING 2

ILLUSTRATION OF THE PROBLEM



ACTUAL: Bursting
above 10 mm
REQUIREMENT:
Maximum
tolerance up to
10mm only

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
9000	82	0.91

Nature of Defect:

BURSTING

Requirement:

Maximum tolerance up to 10 mm only

Actual

Bursting above 10 mm

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240517</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	<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 240523	CHARLENE JAN MARIE FLORES 240523	RODERICK RAMOS 240527	GERALD DE GUZMAN 240528

I. INVESTIGATION / ANALYSIS

DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)

System / Training

Design / Toolings

W1 The factor we consider cannot fit lock is 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 Due to the die chase movement the creasing blade didn't hit the center of creasing matrix that may caused bursting.

Process / Material

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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

Design / Toolings

WHY 1: Replacement of 6pcs die chase spring.

ENGINEERING // 2024-07-15

WHY 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 maintenance or check.

ENGINEERING // 2024-06-15

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

A. Sorting Result

	Location	Total Stock	NG	Total Good
RM	n/a	1	1	-1
WIP	n/a	1	1	1
FG	n/a	1	1	1

C. Reworking

Rework Quantity	n/a
Total Good	n/a
Rework PPM (Good)	n/a

B. Orientation

Date	2024-07-15	Time	10:15
Title	n/a		
Attendees	N/A		

Prepared By:

Approved By:

GERALD DE GUZMAN | 240627

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 6pcs 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	2024-07-31	[/] Yes [] No	1st	JO24-M-01211-1	240802	0	7000
2nd Verification of Action			[] Yes [] No	2nd	JO24-M-01211-2	240803	0	9000
3rd Verification of Action			[] Yes [] No	3rd	JO24-M-01211-3	240808	0	9000
Effectiveness of Action	M. ASIS	2024-08-13	[/] Yes [] No	4th	JO24-M-01211-4	240808	0	9000
Remarks: Instead of Engineering Machine History Sheet of Eterna, Engineering Department submitted Preventive Maintenance Job Order - Eterna Diecut Machine (EN-002-F86)				5th	JO24-M-01211-5	240813	0	6000

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	GERALD DE GUZMAN 250303 03:13 Line Leader	REXEL ALMARIO 250507 11:28 Department Head
Date: 25252525-02-21	Date: 25252525-02-26	Date: 25252525-03-03	Date: 25252525-05-07