



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

0005

240529

Customer	KOWA-EMORI PHILIPPINES, INC.	Attention To	WEENA APALLA
Item Code	HP01D2200C-1	Department	PRODUCTION
Item Description	CARTON BOX W/ PRINT	Date of Detection	240527
Job Order Number	JO24-M-00602-59	Section Detected	QA SCREENING 4

ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
6000	49	0.82
Nature of Defect:		
GLUE STAIN		
Requirement:		
There should be no glue stain		
Actual		
Glue stain on Class A part		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240527</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)
ERIKA ASIS 240529	CHARLENE JAN MARIE FLORES 240603	RODERICK RAMOS 240604	GERALD DE GUZMAN 240610

I. INVESTIGATION / ANALYSIS

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

System / Training

Design / Toolings

Process / Material

WHY 1 : W1 Based on the Glue Stain position its occurs during 2nd gluing process in Conveyor 1. r n r nW2 There s a factor that operator apply glue during 2nd process gluing on the top of conveyor. r n r nW3 The glue from eperan spreader drop in conveyor during application that caused Glue Stain.



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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: Orient the Conveyor 1 operator to use only the table beside the conveyor during application of glue to avoid the glue drop in conveyor.

PRODUCTION LEADERS //
2024-06-28

WHY 2: Post awareness signage on the top of conveyor to avoid glue application on that portion.

GERALD DE GUZMAN //
2024-07-01

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	0	0	0
WIP	n/a	0	0	0
FG	n/a	0	0	0

C. Reworking

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

B. Orientation

Date	2024-07-01	Time	00:02
Title	Orientation regarding only the table beside the conveyor are required to use during application of glue to avoid the glue drop in conveyor.		
Attendees	Conveyor 1 operator		

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: 2024-08-22	PIC: M. ASIS
Identified Rootcause Eperan spreader drops in the conveyor	Recommendation Orient the conveyor operator where is the proper area for gluing application process.

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	2024-07-03	[/] Yes [] No	1st	JO24-M-00820-62	240705	0	2250
2nd Verification of Action			[] Yes [] No	2nd	JO-24-IPD-00577-1	240705	0	6000
3rd Verification of Action			[] Yes [] No	3rd	JO-24-IPD-00577-2	240713	0	4500
Effectiveness of Action	M. ASIS	2024-08-22	[/] Yes [] No	4th	JO-24-IPD-00577-3	240716	0	4500
Remarks:				5th	JO24-M-01211-7	240731	10	3000

IV. CLOSURE

Status	Remarks
Closed IRF	Corrective Actions were implemented. 5 consecutive running with minimal defect encountered (JO24-M-01211-7 10pcs. NG /3000 pcs) Attached here the copy of attendance in the said orientation and guidelines for the glue application

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250220 12:58 QA Head	KOHEI ISHII 250226 02:32 Top Management	GERALD DE GUZMAN 250303 03:13 Line Leader	REXEL ALMARIO 250507 11:27 Department Head
Date: 25252525-02-20	Date: 25252525-02-26	Date: 25252525-03-03	Date: 25252525-05-07