

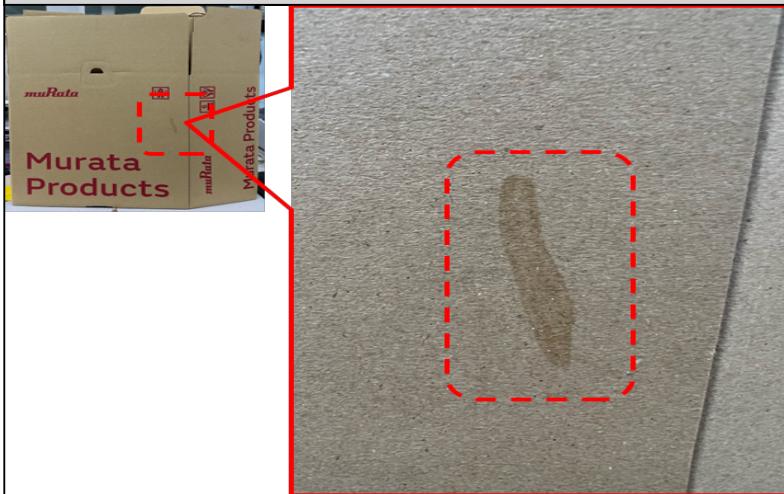
**KANE PACKAGE PHILIPPINE INC.**

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
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"/> Hold	<input type="checkbox"/> Slotter	<input checked="" type="checkbox"/> Gluing
<input type="checkbox"/> Recurrence No.: <u>1</u>	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Material
Date.: <u>240527</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Dimension
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<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**

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 WHY 1 : 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.

**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					C. Reworking			
RM	Location n/a	Total Stock 0	NG 0	Total Good 0	Rework Quantity Total Good	n/a		
WIP	n/a	0	0	0		n/a		
FG	n/a	0	0	0	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				



## 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	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO24-M-00820-62	240705	0	2250
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO-24-IPD-00577-1	240705	0	6000
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO-24-IPD-00577-2	240713	0	4500
Effectiveness of Action	M. ASIS	2024-08-22	<input type="checkbox"/> Yes <input type="checkbox"/> 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