



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.:

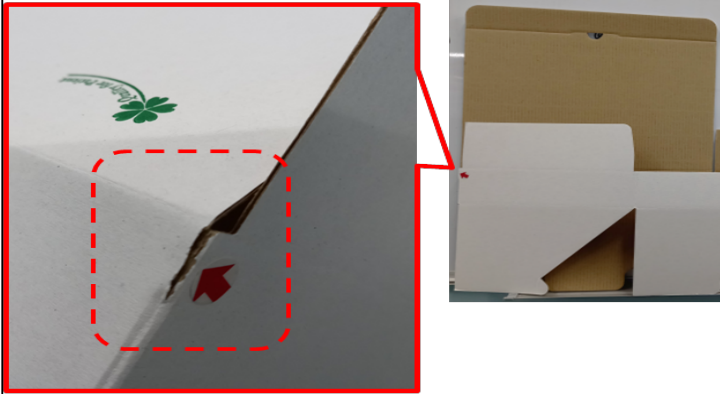
Date Issued

0006

240619

Customer	MERASENKO CORP.	Attention To	WEENA APALLA
Item Code	473MB-RMFG	Department	PRODUCTION
Item Description	OXYGEN TUBE 260X180X42.5; A	Date of Detection	240614
Job Order Number	JO24-C-00130-13A	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM



ACTUAL: With bursting up to 15mm
REQUIREMENT: Bursting up to 10mm acceptable

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1000	29	2.90
Nature of Defect:		
BURSTING		
Requirement:		
With bursting up to 15mm		
Actual		
Bursting up to 10mm is acceptable		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240614</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 checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO 240619	CHARLENE JAN MARIE FLORES 240625	RODERICK RAMOS 240627	GERALD DE GUZMAN 240705

I. INVESTIGATION / ANALYSIS

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

System / Training

Design / Toolings

Process / Material

WHY 1 : W1 Items process in S1700 and without application of creasing matrix in this condition it is impossible to have bursting at the outer portion or white kraft. r n r nW2 The factor we consider is tear off due to slanting of item in SD1800 feeder. r n r nW3 Based on interview in SD1800 operator they encounter tear off including in this item if there is slanting of item in SD1800 feeder. r n r nW4 Since this item have only 45.5mm height dimension and 913mm length it become prone to tear off when got slanted in SD1800 feeder.

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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

Process / Material

WHY 1: Conduct study in SD1800 on how to improve the occurrence of slanting of items in feeder area of SD1800 then give update to QA for the Corrective Action

Production Leader // 2024-07-19

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	2024-07-19				Time	09:20
Title	n/a					
Attendees	SD1800 operators					
Prepared By:					Approved By:	
GERALD DE GUZMAN 240711					WEENA APALLA 240724	
					Department Head	



II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted:	PIC:
Identified Rootcause	Recommendation

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			[] Yes [] No	1st				
2nd Verification of Action			[] Yes [] No	2nd				
3rd Verification of Action			[] Yes [] No	3rd				
Effectiveness of Action			[] Yes [] No	4th				
Remarks:				5th				

IV. CLOSURE

Status	Remarks
Closed IRF	Defect detected last June 2024. Since then, the item only ran once in October (JO-24-IPD-00919-19), with no detected defects out of 1000 pcs. Now, 3 consecutive months with no running,

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
REXEL ALMARIO 250130 08:59 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: 25252525-01-30	Date: 25252525-02-26	Date: 25252525-03-03	Date: 25252525-05-07