

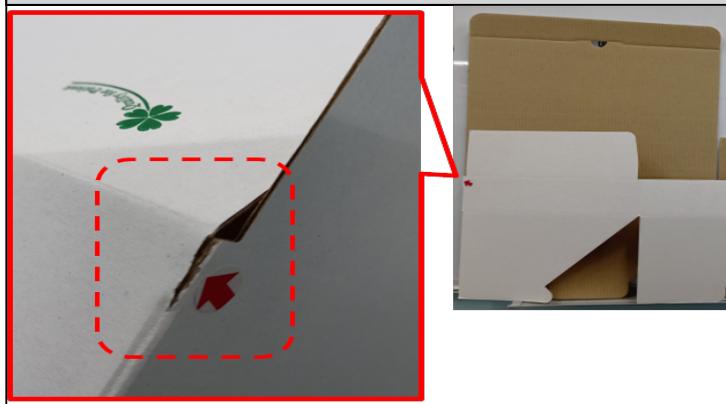
**KANE PACKAGE PHILIPPINE INC.**

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
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 %
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1000	29	2.90
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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"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence No.: <u>1</u>	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
Date.: <u>240614</u>	<input type="checkbox"/> For Rework	<input checked="" type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<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.



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		
FG	n/a	0	0	0	Rework PPM (Good)	n/a

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	

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INVESTIGATION REPORT FORM (IRF)**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			<input type="checkbox"/> Yes <input type="checkbox"/> No	1st				
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd				
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd				
Effectiveness of Action			<input type="checkbox"/> Yes <input type="checkbox"/> 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