



# 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.:

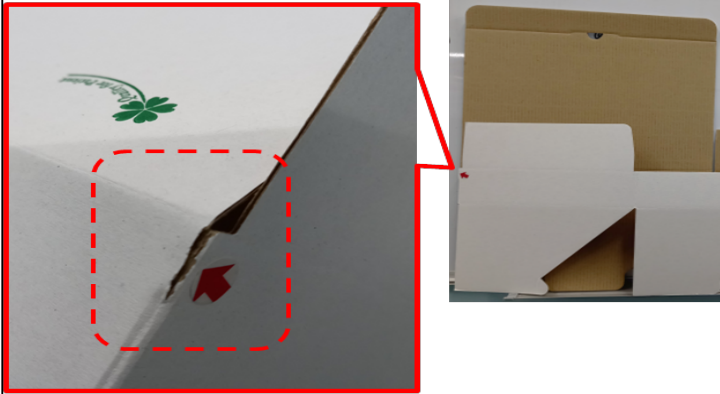
Date Issued

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



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

**ACTUAL:** With bursting up to 15mm

**REQUIREMENT:** Bursting up to 10mm 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



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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			[ ] 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