



# 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.:

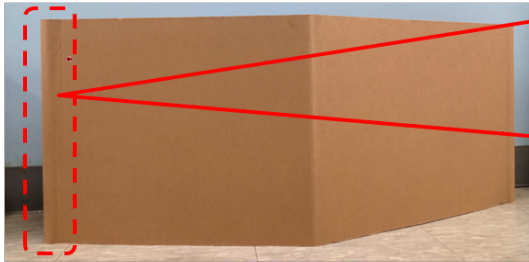
Date Issued

0007

240702

Customer	CANON BUSINESS MACHINE PHILS.	Attention To	WEENA APALLA
Item Code	RX1-5732-000	Department	PRODUCTION
Item Description	Z10 SLEEVE	Date of Detection	240628
Job Order Number	JO-F-24-302-21	Section Detected	QA SCREENING

### ILLUSTRATION OF THE PROBLEM



**ACTUAL:** Extra fold found on the creasing side of the item  
**REQUIREMENT:** No extra fold.



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
600	26	4.33
Nature of Defect:		
EXTRAFOLD		
Requirement:		
No extra fold.		
Actual		
Extra fold found on the creasing side of the item.		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN		CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240628</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)	
LESTER JOHN DIOSO   240702	CHARLENE JAN MARIE FLORES   240705	RODERICK RAMOS   240709	GERALD DE GUZMAN   240711	

### I. INVESTIGATION / ANALYSIS

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

#### System / Training

#### Design / Toolings

#### Process / Material

WHY 1 : W1 Based on investigation conducted to actual process the caused of Extra fold is the delamination of board during pre folding. r n r nW2 During pre folding of sleeve we heard random of crunchy sound then upon checking its automatically have extra fold due to delamination.

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**INVESTIGATION REPORT FORM (IRF)****INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)****System / Training****Design / Toolings****Process / Material**

WHY 1 : That condition result to overlap/closed gap and since operator didn't expect that this item was affected of extra fold they conducted pre folding (HILOT) that resulting pain in their hands due to the hardness of the material.

**FINAL CONCLUSION****CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)****WHO / WHEN****Process / Material**

WHY 1: All affected of delamination was separate and reject consider as supplier reject.

Production // 2024-07-17

WHY 2: Coordinate to QA regarding improvement on supplier side since this item is actual sheets with creasing from supplier.

QA // 2024-07-17

**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	2024-07-16	Time	14:05
Title	Orientatioin Regarding Investigation for the Extra Fold of CBMP RX1 5732 000 Z10 Sleeve		
Attendees	Manual Gluing Operator		
Prepared By:		Approved By:	
GERALD DE GUZMAN   240717		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	

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO   250224 09:23 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: 25252525-02-24	Date: 25252525-02-26	Date: 25252525-03-03	Date: 25252525-05-07