

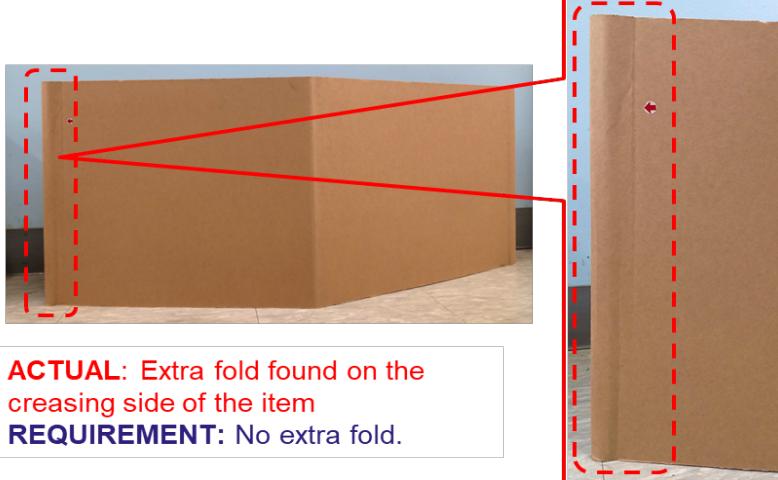
**KANE PACKAGE PHILIPPINE INC.**

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
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

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"/> 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>240628</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)
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.



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

B. Orientation

Date	2024-07-16	Time	14:05
Title	Orientation 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			<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				
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	