



KANE PACKAGE PHILIPPINE INC.

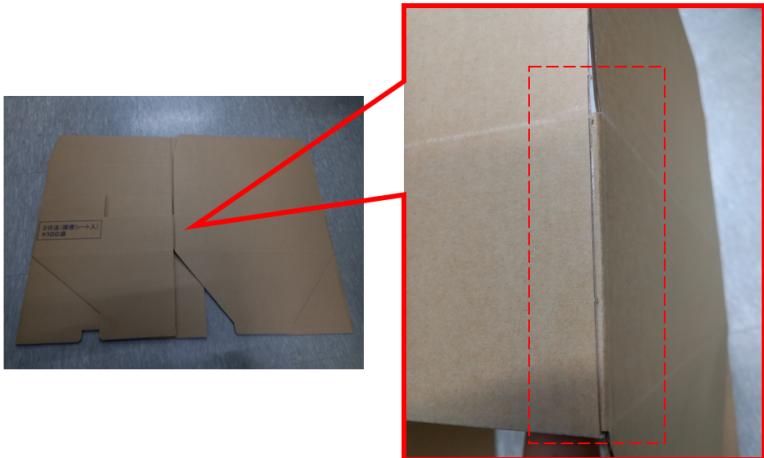
No. 5 Ring Road LISI II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 5457-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)

Control No.: 0008 Date Issued: 240711

Customer	ARKRAY	Attention To	WEENA APALLA
Item Code	84-05467A	Department	PRODUCTION
Item Description	INNER BOX F821629-1	Date of Detection	240708
Job Order Number	JO24-M-01076-4	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2050	40	1.95

Nature of Defect:

MISALIGN GLUE

Requirement:

No misalign glue

Actual

With misalign glue

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240708</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
Issued by	Checked by	Approved by	Received by (Receiving Section)
ERIKA ASIS 240711	CHARLENE JAN MARIE FLORES 240715	RODERICK RAMOS 240716	GERALD DE GUZMAN 240717

I. INVESTIGATION / ANALYSIS

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

System / Training

Design / Toolings

Process / Material

WHY 1 : W1 Item already have existing improvement of putting nick mark in vertical and horizontal portion of glue tab as alignment reference during Gluing process. r n r nW2 The horizontal nick mark is effective since its visible but the vertical nick mark is not so visible possible because its along grain direction. r n r nw3 Based on investigation and interview to manual gluing operator there is difficulty to align the vertical gluing alignment of this item since the design is off set lower flap and the applied vertical nick mark in the glue tab is not visible.

**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: Attachment of note in the die blade that inform the leader next running for the improvement of creasing matrix application on the glue tab.	Gerald De Guzman // 2024-07-23
WHY 2: Since the diecut process of this item is in Eterna the corrective action is the application of creasing matrix on the glue tab portion for more visible marking reference in gluing alignment.	Production leader Operator // 2024-08-09

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

A. Sorting Result					C. Reworking			
RM	Location n/a	Total Stock 0	NG 0	Total Good 0	Rework Quantity Total Good	n/a		
WIP	n/a	0	0	0		n/a		
FG	n/a	0	0	0	Rework PPM (Good)	n/a		
B. Orientation								
Date	2024-08-09			Time	11:11			
Title	n/a							
Attendees	n/a							
Prepared By:				Approved By:				
GERALD DE GUZMAN 240724				REXEL ALMARIO 250205				
				Department Head				

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INVESTIGATION REPORT FORM (IRF)**II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)**

Date Conducted: 2024-08-09	PIC: M. ASIS
Identified Rootcause Vertical nick mark is not visible in the glue tab	Recommendation N/A

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	M. ASIS	2024-10-10	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO24-M-01714-1	241010	0	500
2nd Verification of Action	M. ASIS	2024-10-22	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO24-M-01714-2	241015	0	2000
3rd Verification of Action	M. ASIS	2024-10-24	<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO24-M-01714-5	241022	0	2000
Effectiveness of Action	M. ASIS	2024-10-31	<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO24-M-01714-3	241024	0	2500

Remarks: Instead of Engineering Machine History Sheet of Eterna, Engineering Department submitted Preventive Maintenance Job Order - Eterna Diecut Machine (EN-002-F86)

IV. CLOSURE

Status	Remarks		
Closed IRF	Five consecutive lots running with no rejects.		
Approved by:	Process Owner Acknowledgment: (Receiving Section)		
MICHAEL CASILLANO 250310 01:09 QA Head	KOHEI ISHII 250313 09:05 Top Management	GERALD DE GUZMAN 250318 03:36 Line Leader	REXEL ALMARIO 250507 11:27 Department Head
Date: 25252525-03-10	Date: 25252525-03-13	Date: 25252525-03-18	Date: 25252525-05-07