

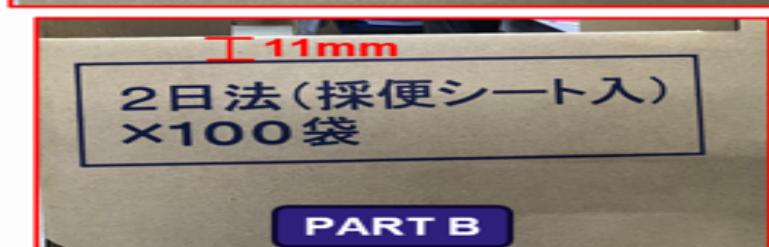
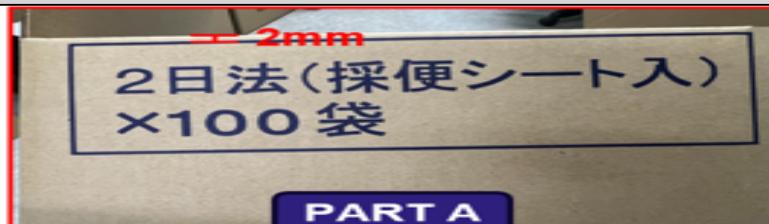
**KANE PACKAGE PHILIPPINE INC.**

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
0009	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	27	1.32

Nature of Defect:

MISALIGN DIECUT/CUT

Requirement:

Within print tolerance of ± 5

Actual

Above and below tolerance

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 checked="" type="checkbox"/> Dimension
Date.: <u>240708</u>	<input type="checkbox"/> For Rework	<input checked="" type="checkbox"/> Diecut	<input 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)
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

W1: We also consider misalign print in investigation but no factor found in Eqos since upon checking of CCTV Eqos operator follow on the Standard Height Limit Set in Eqos Feeder.
 W2: The factor that consider contributing random of misalign print is the abnormal lateral movement of Eterna die chase of almost 7mm due to worn out die chase spring.
 W3: The die chase movement corresponds on the misalignment based on the blade layout and print. Since only 8mm the gap of print to creasing line the movement of die chase resulted to random misalign diecut.

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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: Replacement of 6pcs worn out die chase spring.

Engineering Caledonian //
2024-07-31Include the die chase spring in Engineering Machine History Sheet of Eterna. This is the basis of
 WHY 2: Engineering for the monitoring of machine parts life span for those parts that only Caledonian can
 maintenance or check.

Engineering // 2024-07-31

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	2024-07-31			Time	17:31			
Title	n/a							
Attendees	n/a							
Prepared By:				Approved By:				
GERALD DE GUZMAN 240719				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: 2024-07-31	PIC: M. ASIS
Identified Rootcause Worn-out die-chase spring	Recommendation Replacement of die-chase spring

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		<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO24-M-01714-1	241010	0	500
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO24-M-01714-2	241015	0	2000
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO24-M-01714-3	241024	0	2500
Effectiveness of Action	M. ASIS		<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO24-M-01714-5	241022	0	2000
Remarks: Instead of Engineering Machine History Sheet of Eterna, Engineering Department submitted Preventive Maintenance Job Order - Eterna Diecut Machine (EN-002-F86)				5th	JO24-M-01714-6	241023	3	2000

IV. CLOSURE

Status	Remarks			
Closed IRF	Five consecutive lots running with 3 detected rejects only.			
Approved by:	Process Owner Acknowledgment: (Receiving Section)			
250224 01:55 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	