



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.: 0010 Date Issued: 240716

Customer	BROTHER INDUSTRIES PHILIPPINES, INC.	Attention To	WEENA APALLA
Item Code	D02X6G001	Department	PRODUCTION
Item Description	PRN CARTON (X3) E110 EU COC (FSC Recycled, FSC N	Date Issued	<u>240716</u>
Job Order Number	JO-24-IPD-00637-2	Section Detected	PRODUCTION

ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1300	64	4.92

Nature of Defect:

BURSTING

Requirement:

Without bursting

Actual

Bursting up to 16mm

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240711</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
Issued by	Checked by	Approved by	Received by (Receiving Section)
ERIKA ASIS 240716	CHARLENE JAN MARIE FLORES 240716	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 from S1700 Diecut then transfer to Eterna due to the improvement of creasing matrix application to avoid extra fold. r n r nW2 Eterna operator miss out to remove backing tape on the die blade. r n r nW3 Based on the initial investigation conducted of QA ME the caused of Bursting is the backing tape on the creasing blade portion since the item already have creasing matrix.



INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)

System / Training

Design / Toolings

Process / Material

WHY 1 : Eterna operator didn't notice the bursting since it occurs randomly and didn't expect since item already transfer in Eterna last June 21 2024.

FINAL CONCLUSION

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

WHO / WHEN

Process / Material

WHY 1: Removal of backing tape on the affected die blade.

Tooling Custodian // 2024-07-13

WHY 2: Discuss to all production Leaders and tooling custodian that die blade from Diecut S1700 that subject for transfer to Eterna will apply Request for Tooling Re layout form for the removal of backing tape before the process.

Gerald De Guzman // 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		
FG	n/a	0	0	0	Rework PPM (Good)	n/a

B. Orientation

Date	2024-07-19	Time	09:36
Title	Die blade from Diecut S1700 that subject for transfer to Eterna will apply Request for Tooling Re layout form for the removal of backing tape		
Attendees	Production Leaders		
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:	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	Bursting defect occurred again last October 4, 2024, with 36pcs rejects. New Issuance Control #: CAR 2425-PR-046			
Approved by:		Process Owner Acknowledgment: (Receiving Section)		
MICHAEL CASILLANO 250122 08:30 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: 25252525-01-22	Date: 25252525-02-26	Date: 25252525-03-03	Date: 25252525-05-07	