

**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

0011

240717

Customer	KOWA-EMORI PHILIPPINES, INC.	Attention To	WEENA APALLA
Item Code	HP01D2200C-1	Department	PRODUCTION
Item Description	CARTON BOX W/ PRINT	Date of Detection	240712
Job Order Number	JO-24-IPD-00577-3	Section Detected	PRODUCTION

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
4500	76	1.69

Nature of Defect:

PEEL OFF

Requirement:

No peel off

Actual

Peel off up to 10mm

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>240712</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	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
ERIKA ASIS 240717	CHARLENE JAN MARIE FLORES 240718	RODERICK RAMOS 240718	GERALD DE GUZMAN 240719

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 and interview to Eterna operator they notice the peel off in the middle of mass production upon sampling they conducted sorting and they found out that its occurs randomly. r n r nW2 Eterna operator inform the leader in charge and leader in charge alert the next process SD 1800 to the possible random occurrence of peel off. r n r nW3 Peel off occurs due to the repeated shot of die blade that result to compression or breakage of backing tape attached in Eterna pattern. r n r nW4 The affected portion got uncut kraft liner that resulted to peel off since item underwent auto stripping process.

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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: Eterna operator put additional backing tape in the Eterna pattern on the portion of feel off.

Eterna Operator // 2024-07-09

WHY 2: Since this scenario is uncontrollable our corrective action is to check the die blade condition.

Production Leaders Tooling
Custodian // 2024-07-23

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	2024-07-23	Time	11:19
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: 2024-07-31	PIC: M. ASIS
Identified Rootcause Uncut kraft liner resulted to peel off since item went in auto stripping process	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	2024-07-31	[/] Yes [] No	1st	JO24-M-01211-7	240731	0	3000
2nd Verification of Action	M. ASIS	2024-08-15	[/] Yes [] No	2nd	JO24-M-01211-8	240806	0	3000
3rd Verification of Action			[/] Yes [] No	3rd	JO24-M-01211-9	240807	0	3000
Effectiveness of Action	M. ASIS	2024-08-15	[/] Yes [] No	4th	JO24-M-01211-10	240809	0	3000
Remarks: N/A				5th	JO24-M-01211-11	240815	0	3000

IV. CLOSURE

Status	Remarks
Closed IRF	Five consecutive lots running with no detected rejects.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250224 01:56 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