

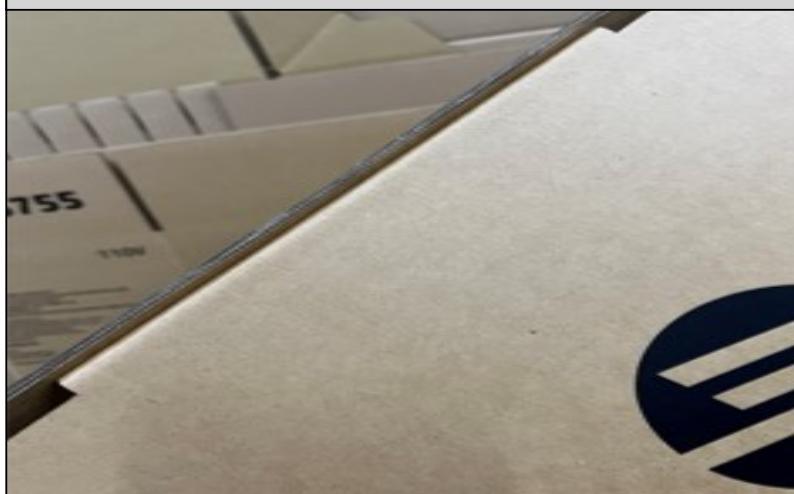
**KANE PACKAGE PHILIPPINE INC.**

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
0012	240806

Customer	CANON BUSINESS MACHINE PHILS.	Attention To	WEENA APALLA
Item Code	RX1-5755-000	Department	PRODUCTION
Item Description	Z10 CARTON	Date of Detection	240801
Job Order Number	JO-F-24-516-1	Section Detected	QA SCREENING

**ILLUSTRATION OF THE PROBLEM**

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
--------------------	------------------	----------

1050	33	3.14
------	----	------

Nature of Defect:

OVER LAP

Requirement:

Should be no overlap

Actual

+5mm overlap from folding area

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u>  <u>Date.: 240801</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   240806	CHARLENE JAN MARIE FLORES   240806	RODERICK RAMOS   240806	GERALD DE GUZMAN   240808

**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 the defect is not overlap due to due to closed gap since in actual the gap in glue tab is sufficient. r n r nW2 The factor we consider in this defect is that misalign creasing of glue tab. r n r nW3 When the creasing blade hit the grain direction line which is hard portion the glue tab got misalign during pre folding in Gluing process. r n r nW4 Due to misalign creasing of glue tab the attachment at end portion of glue tab was detach and looks like overlap.

**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)****INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)****System / Training****Design / Toolings****Process / Material**

WHY 1 : N/A

**FINAL CONCLUSION****CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)****WHO / WHEN****Process / Material**

WHY 1:	Problem is uncontrollable since the Diecut process of this item is in Diecut S1700 but it was reworkable by re folding the glue tab and applying small amount of glue.	QA Production // 2024-09-16
WHY 2:	Inclusion in (WI PR 004 018) Work and Safety Instruction for Manual Gluing of Canon Carton Box the rework process of this defect by re folding the glue tab and applying small amount of glue.	Production IE // 2024-08-30

**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	2024-09-16	Time	15:25
Title	n/a		
Attendees	N/A		
Prepared By:		Approved By:	
GERALD DE GUZMAN   240905		REXEL ALMARIO   250205	
			Department Head

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

Date Conducted: 2024-08-30	PIC: M. ASIS
Identified Rootcause Misalign creasing of 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	2024-09-03	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO-F-24-619-1	240903	0	400
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO-F-24-689-1	240912	0	1100
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO-F-24-764-1	240927	0	800
Effectiveness of Action	M. ASIS	2024-10-29	<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO-F-24-764-2	241007	0	1100

Remarks:

5th JO-F-24-872-1 241029 0 350

**IV. CLOSURE**

Status	Remarks			
Closed IRF	Five consecutive lots running with no rejects.			
Approved by:		Process Owner Acknowledgment: (Receiving Section)		
MICHAEL CASILLANO   250224 01:57 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	