



# 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.:

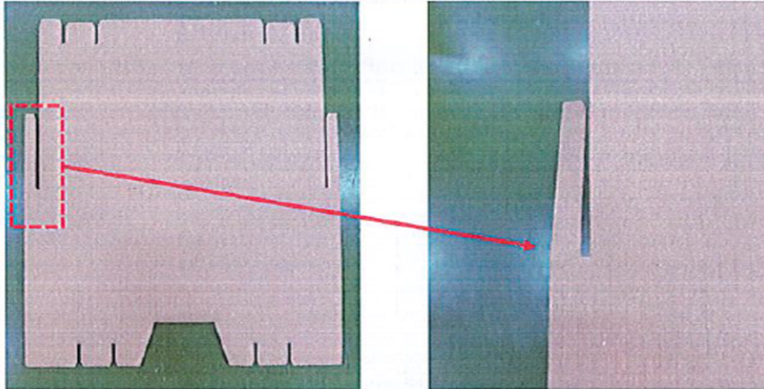
Date Issued

0014

241010

Customer	CANON BUSINESS MACHINE PHILS.	Attention To	WEENA APALLA
Item Code	3CB-0004-000	Department	PRODUCTION
Item Description	PARTITION	Date of Detection	241005
Job Order Number	JO-F-24-819-2	Section Detected	QA SCREENING

### ILLUSTRATION OF THE PROBLEM



**ACTUAL:** Heavy scoring

**REQUIREMENT:** There should be no scoring

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1000	69	6.90

Nature of Defect:

SCORING

Requirement:

There should be no scoring

Actual

Heavy scoring

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>241005</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 checked="" type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO   241010	CHARLENE JAN MARIE FLORES   241011	MICHAEL CASILLANO   241015	GERALD DE GUZMAN   241016

### I. INVESTIGATION / ANALYSIS

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

**System / Training**

**Design / Toolings**

**Process / Material**



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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**

**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	0
WIP	n/a	0	0	0	Rework PPM (Good)	0
FG	n/a	0	0	0		
B. Orientation						
Date	2024-10-24				Time	11:41
Title	Orientation regarding to criticality of this item in scoring.					
Attendees	Tooling Diecut Detaching					
Prepared By:					Approved By:	
GERALD DE GUZMAN   241128					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: 2024-10-24	PIC: M. ASIS
Identified Rootcause Nick mark on the slot portion	Recommendation Repairing of the die-blade

**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	2024-11-07	[ / ] Yes [ ] No	1st	JO-F-24-979-3	241107	3	1000
2nd Verification of Action			[ ] Yes [ ] No	2nd	JO-F-24-979-3	241108	0	1000
3rd Verification of Action			[ ] Yes [ ] No	3rd	JO-F-24-1002-3	241113	0	4300
Effectiveness of Action	M. ASIS	2024-12-07	[ / ] Yes [ ] No	4th	JO-F-24-1039-1	241126	0	4500
Remarks: The corrective action implemented on-time was the repairing of the die-blade.				5th	JO-F-24-1085-1	241207	0	3000

**IV. CLOSURE**

Status	Remarks
Closed IRF	Five consecutive lots running with only 3pcs NG.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO   250310 12:52 QA Head	KOHEI ISHII   250313 09:06 Top Management	GERALD DE GUZMAN   250318 03:36 Line Leader	REXEL ALMARIO   250507 11:25 Department Head
Date: 25252525-03-10	Date: 25252525-03-13	Date: 25252525-03-18	Date: 25252525-05-07