

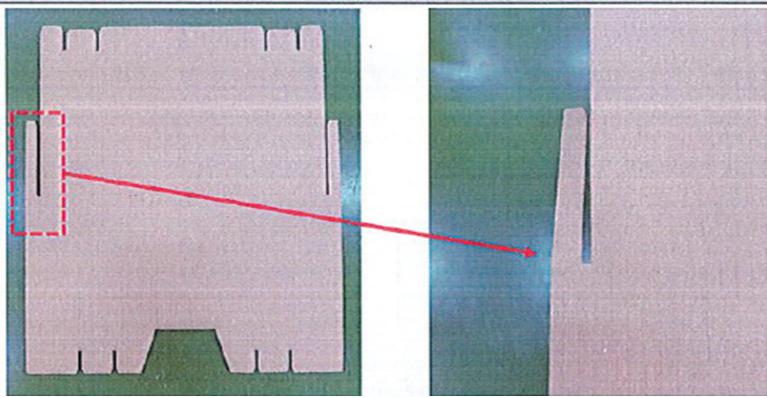
**KANE PACKAGE PHILIPPINE INC.**

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
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"/> 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"/> Gluing	<input type="checkbox"/> Dimension
Date.: <u>241005</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> EQOS	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Process / Method
		<input type="checkbox"/> Detaching	
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**

**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		
FG	n/a	0	0	0	Rework PPM (Good)	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	

**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)**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	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO-F-24-979-3	241107	3	1000
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO-F-24-979-3	241108	0	1000
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO-F-24-1002-3	241113	0	4300
Effectiveness of Action	M. ASIS	2024-12-07	<input type="checkbox"/> Yes <input type="checkbox"/> 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
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