

**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
0015	241011

Customer	KOWA-EMORI PHILIPPINES, INC.	Attention To	WEENA APALLA
Item Code	HP01D2000-3 EQOS	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	241008
Job Order Number	JO24-M-01612-15	Section Detected	QA SCREENING

**ILLUSTRATION OF THE PROBLEM**

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
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9000	150	1.67
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**Nature of Defect:**

BURSTING

**Requirement:**

Bursting not acceptable on class A

**Actual**

With bursting up to 20 mm

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"/> EQOS	<input type="checkbox"/> Dimension
Date.: <u>241008</u>	<input type="checkbox"/> For Rework	<input checked="" type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO   241011	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		
FG	n/a	0	0	0	Rework PPM (Good)	0

**B. Orientation**

Date	2024-10-07	Time	11:49
Title	n/a		
Attendees	N/A		
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: 2024-10-15	PIC: M. ASIS
Identified Rootcause 0.6mm difference from 23.8 mm cutting blade and 23.2 mm actual creasing blade.	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	2024-10-19	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO24-M-01800-1	241106	0	9000
2nd Verification of Action			<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	2nd	JO24-M-01800-2	241108	0	9000
3rd Verification of Action			<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	3rd	JO24-M-01800-3	241111	0	9000
Effectiveness of Action			<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	4th	JO24-M-01800-4	241114	0	9000

Remarks: Attached here are the following evidence:

1. Technical Report (ME-TR-0015) Bursting Improvement from ME  
 2. ATTACHMENT 1 Standard Diecut Blade and Rule that includes in PM-DT-005. Note: DT-005-F11 does not exist according to DDC.

**IV. CLOSURE**

Status	Remarks			
Closed IRF	Five consecutive lots running with no rejects. Attached here are the evidence.			
Approved by:		Process Owner Acknowledgment: (Receiving Section)		
MICHAEL CASILLANO   250310 12:53 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