



# 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

0016

241011

Customer	KOWA-EMORI PHILIPPINES, INC.	Attention To	WEENA APALLA
Item Code	HP33D1057-1 EQOS	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	241008
Job Order Number	JO24-M-01612-9	Section Detected	QA SCREENING

### ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
3000	160	5.33

Nature of Defect:

BURSTING ON EDGE

Requirement:

There should be no bursting

Actual

Bursting up to 20mm

**ACTUAL: With bursting**  
**REQUIREMENT: No bursting**

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>241008</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)
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	Rework PPM (Good)	0
FG	n/a	0	0	0		
B. Orientation						
Date	2024-12-12				Time	08:10
Title	Orientation regrading Bursting on Edge of Kowa Emori HP33D1057 1 Carton Box					
Attendees	All Production					
Prepared By:					Approved By:	
GERALD DE GUZMAN   250128					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: 2024-10-11	PIC: M.ASIS
Identified Rootcause Movement of reverse creasing matrix during running.	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	2024-11-06	[ / ] Yes [ ] No	1st	JO24-M-02017-28	241206	3	3000
2nd Verification of Action			[ ] Yes [ ] No	2nd	JO24-M-02017-29	241210	20	4000
3rd Verification of Action			[ ] Yes [ ] No	3rd	JO24-M-02017-55	241219	0	4000
Effectiveness of Action	M.ASIS	2025-01-06	[ / ] Yes [ ] No	4th	JO24-M-02017-56	241226	0	3500
Remarks: Included the checking of checklist for one-touch lock model in Eterna Machine Set-up and Operation (WI-PR-002-034). The revision was on Rev. 11 Page 1.				5th	JO24-M-02413-31	250106	0	3000

**IV. CLOSURE**

Status	Remarks
Closed IRF	Five consecutive lots running with minimal rejects only

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO   250310 12:53 QA Head	KOHEI ISHII   250313 09:07 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