



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

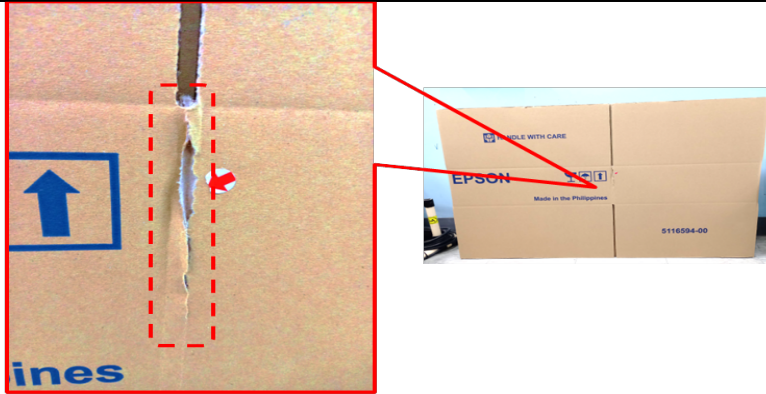
0017

241011

Customer	EPSON PRECISION PHILIPPINES INCORPORATED - IJP
Item Code	511659400-SF
Item Description	OUTER CARTON BOX
Job Order Number	JO24-M-01690-3.1

Attention To	WEENA APALLA
Department	PRODUCTION
Date of Detection	241008
Section Detected	QA SCREENING 5

ILLUSTRATION OF THE PROBLEM



ACTUAL: With bursting up to 30mm
REQUIREMENT: Bursting not acceptable

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
910	20	2.20

Nature of Defect:

BURSTING

Requirement:

Bursting not acceptable

Actual

Bursting on slot up to 30 mm

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 checked="" type="checkbox"/> EQOS <input 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	2024-11-06	Time	00:59
Title	Orientation to Eqos and Gluing Operator to be extra careful proper handing when handling long boxes with a small height dimension be		
Attendees	Eqos Gluing		

Prepared By:		Approved By:	
GERALD DE GUZMAN 241128		REXEL ALMARIO 250205	
		Department Head	



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

Date Conducted: 2024-10-21	PIC: L. Dioso
Identified Rootcause Mishandling of items during transport / manual handling has been identified as the primary contributor of tearing on the slot area.	Recommendation Re-aware production operators regarding on proper handling of items.

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	L.Dioso	2024-11-06	[/] Yes [] No	1st	JO24-M-02266-2	241214	0	200
2nd Verification of Action			[] Yes [] No	2nd	JO24-M-02324-16	241221	0	100
3rd Verification of Action			[] Yes [] No	3rd	JO24-M-02462-4	241221	0	180
Effectiveness of Action			[] Yes [] No	4th	JO24-M-02462-5	250108	6	1200
Remarks: Countermeasure is effective, only encountered minimal rejection of tear off. All relevant personnel was reoriented and trained regarding on the proper handling procedures.				5th	JO25-M-00317-5	250131	0	50

IV. CLOSURE

Status	Remarks
Closed IRF	The tear-off defect was traced to improper handling. Kindly monitor operators. To prevent tear off issues, kindly re-aware operators regarding on proper handling of items.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250415 10:05 QA Head	KOHEI ISHII 250416 10:07 Top Management	GERALD DE GUZMAN 250423 09:01 Line Leader	REXEL ALMARIO 250507 11:25 Department Head
Date: 25252525-04-15	Date: 25252525-04-16	Date: 25252525-04-23	Date: 25252525-05-07