



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.:

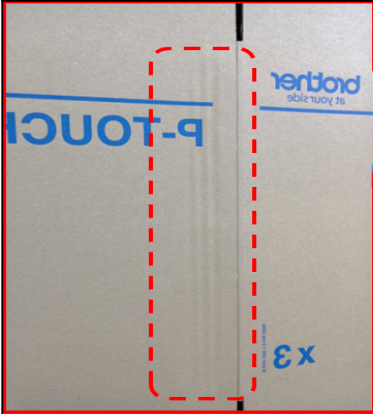
Date Issued

0019

241011

Customer	BROTHER INDUSTRIES PHILIPPINES, INC.	Attention To	WEENA APALLA
Item Code	DO2J9E001	Department	PRODUCTION
Item Description		Date of Detection	241008
Job Order Number	JO24-M-01616-7	Section Detected	QA SCREENING 2

ILLUSTRATION OF THE PROBLEM



ACTUAL: With dent mark
REQUIREMENT: No dent mark

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2650	100	3.77
Nature of Defect:		
DENT		
Requirement:		
No dent mark on class A surface		
Actual		
Dent mark on class A surface		

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 type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input checked="" 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 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	13:11
Title	Brother J9E reduce the standard palletizing quantity of this item to 300pcs (75 x 4) per caster pallet.					
Attendees	SD1800 operators					
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: 2024-10-07	PIC: L. Dioso
Identified Rootcause Dents were observed on multiple items of the Brother D02J9E001 printed carton. Findings indicated that the damage occurred during internal palletizing and handling processes.	Recommendation Reduce the palletizing quantity from 500 pcs to 300 pcs to minimize pressure and potential deformation.

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	2024-10-07	[/] Yes [] No	1st	JO24-M-01616-7	241007	0	2650
2nd Verification of Action			[] Yes [] No	2nd	JO24-M-01616-8	241010	0	2000
3rd Verification of Action			[] Yes [] No	3rd	JO24-M-01616-10	241012	0	2600
Effectiveness of Action			[] Yes [] No	4th	JO24-M-01616-12	241017	0	2000
Remarks: >Standard palletizing quantity has been revised from 500 pcs to 300 pcs per caster pallet for brother D02J9E001 item. >Operators was oriented regarding the changes of palletizing standard of D02J9E001.				5th	JO24-M-01616-13	241019	0	2000

IV. CLOSURE

Status	Remarks
Closed IRF	No dent-related rejects were observed in five (5) consecutive production runs after implementing corrective actions.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250424 08:02 QA Head	KOHEI ISHII 250425 09:51 Top Management	GERALD DE GUZMAN 250506 02:30 Line Leader	REXEL ALMARIO 250507 11:25 Department Head
Date: 25252525-04-24	Date: 25252525-04-25	Date: 25252525-05-06	Date: 25252525-05-07