

**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.:

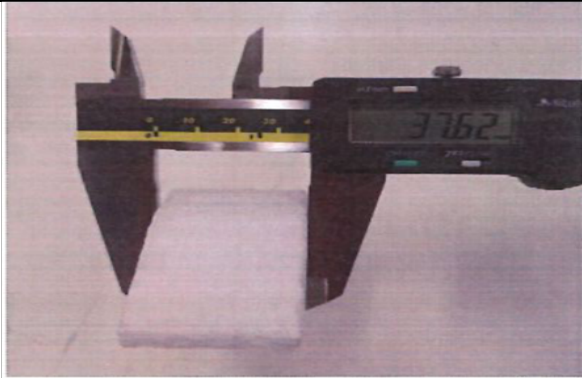
Date Issued

0024

241026

Customer	EPSON PRECISION PHILIPPINES INCORPORATED - IJP
Item Code	513850300
Item Description	PAD, ASF
Job Order Number	JO-24-L-0225-1

Attention To	WEENA APALLA
Department	PRODUCTION
Date of Detection	241019
Section Detected	QA SCREENING

**ILLUSTRATION OF THE PROBLEM****ACTUAL: 37mm-38mm****REQUIREMENT: 40mm tolerance: +/-1mm**

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2500	200	8.00

Nature of Defect:

OFF SPECS

Requirement:

40mm tolerance: +/-1mm

Actual

37mm-38mm

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>241019</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 type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input checked="" type="checkbox"/> Others <u>SLICING</u>	<input type="checkbox"/> Material <input checked="" type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO   241026	CHARLENE JAN MARIE FLORES   241029	MICHAEL CASILLANO   241031	GERALD DE GUZMAN   241128

**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	2024-10-28				Time	10:33
Title	Orientation regarding Off Specs of Epson 513850300 Pad ASF					
Attendees	Slicing Vertical Pressing Heating operator					
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: 2024-12-04	PIC: L. Dioso
Identified Rootcause The slicing discrepancy was due to a lack of observance regarding the proper scrap thickness selection.	Recommendation Create clear guidelines for identification and marking of acceptable Eperan good scraps. Revision of work instruction.

**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	2024-12-04	[ / ] Yes [ ] No	1st	JO-24-L-0243-5	241204	0	2000
2nd Verification of Action			[ ] Yes [ ] No	2nd	JO-24-L-0243-7	241206	0	2000
3rd Verification of Action			[ ] Yes [ ] No	3rd	JO-24-L-0243-6	241206	0	2000
Effectiveness of Action			[ ] Yes [ ] No	4th	JO-24-L-0243-8	241211	0	3000
Remarks: Corrective action was effective.				5th	JO-24-L-0243-9	241216	0	2000

**IV. CLOSURE**

Status	Remarks
Closed IRF	Corrective actions and operator awareness have been implemented to prevent recurrence and ensure proper material usage.

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 11:24 Department Head
Date: 25252525-04-15	Date: 25252525-04-16	Date: 25252525-04-23	Date: 25252525-05-07