

**KANE PACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISI 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	Attention To	WEENA APALLA
Item Code	513850300	Department	PRODUCTION
Item Description	PAD, ASF	Date of Detection	241019
Job Order Number	JO-24-L-0225-1	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> <u>Date.: 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



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	2024-10-28			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. Diioso
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. Diioso	2024-12-04	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO-24-L-0243-5	241204	0	2000
2nd Verification of Action			<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	2nd	JO-24-L-0243-7	241206	0	2000
3rd Verification of Action			<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	3rd	JO-24-L-0243-6	241206	0	2000
Effectiveness of Action			<input type="checkbox"/> Yes <input checked="" type="checkbox"/> 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