

**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)

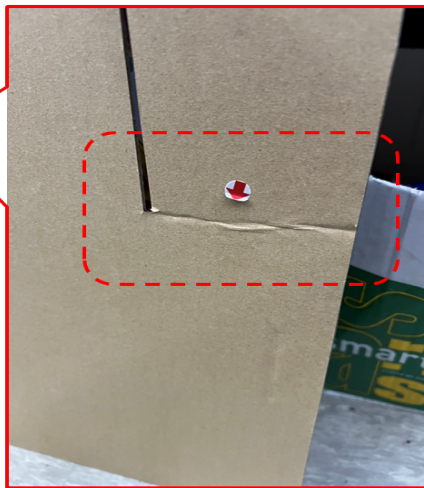
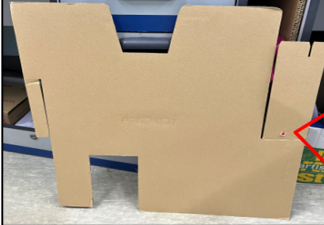
Control No.:

Date Issued

0025

241030

Customer	CANON BUSINESS MACHINE PHILS.	Attention To	WEENA APALLA
Item Code	3CB-0059-000	Department	PRODUCTION
Item Description	PARTITION	Date of Detection	241022
Job Order Number	JO-F-24-919-2	Section Detected	QA SCREENING 3

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2500	313	12.52

Nature of Defect:

SCORING

Requirement:

SCORING NOT ACCEPTABLE

Actual

WITH SCORING UP TO 75 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>241022</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 type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
ERIKA ASIS 241030	CHARLENE JAN MARIE FLORES 241109	MICHAEL CASILLANO 241112	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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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	2025-01-16				Time	08:10
Title	Production Weekly Assembly Meeting					
Attendees	All Production					
Prepared By:					Approved By:	
GERALD DE GUZMAN 250128					REXEL ALMARIO 250205	
					Department Head	



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

Date Conducted: 2025-02-08	PIC: L. Dioso
Identified Rootcause Excessive pulling force was applied during the detachment of die-cut boards, resulting in scoring damage.	Recommendation Current work instruction for detaching is too common and does not consider the specific handling requirements for CBMP 3CB and 6CB items. Need to revise detaching work instruction, inclusion of note for proper detaching of cbmp 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	2025-02-08	[/] Yes [] No	1st	JO-F-25-89-5	250208	0	4000
2nd Verification of Action			[] Yes [] No	2nd	JO-F-25-96-7	250216	0	4000
3rd Verification of Action			[] Yes [] No	3rd	JO-F-25-140-6	250216	0	3000
Effectiveness of Action			[] Yes [] No	4th	JO-F-25-171-10	250221	0	4500
Remarks: The detachment work instruction was revised to include specific note regarding on proper detaching for CBMP items. No encountered scoring for 5 production running.				5th	JO-F-25-215-7	250306	0	3000

IV. CLOSURE

Status	Remarks
Closed IRF	No scoring issues were encountered in the last five production runs.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250425 10:01 QA Head	KOHEI ISHII 250523 02:41 Top Management	GERALD DE GUZMAN 250603 08:41 Line Leader	REXEL ALMARIO 251017 09:41 Department Head
Date: 25252525-04-25	Date: 25252525-05-23	Date: 25252525-06-03	Date: 25252525-10-17