



# 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.:

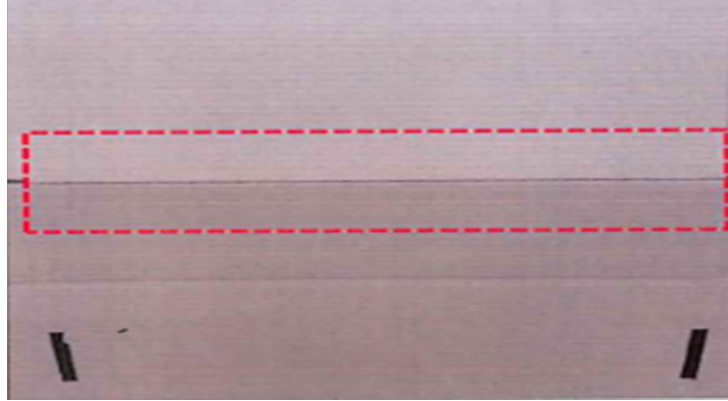
Date Issued

0026

241109

Customer	SUPERFLEX LOGISTICS, INC	Attention To	WEENA APALLA
Item Code	PKG-PRO-31-RMFG	Department	PRODUCTION
Item Description	A585 BOX	Date of Detection	241104
Job Order Number	JO-24-IPD-01012-1	Section Detected	QA SCREENING

### ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
100	25	25.00

Nature of Defect:

OVER CUT

Requirement:

Should be creasing line

Actual

Overcut on creasing line

**ACTUAL: Overcut**

**REQUIREMENT: No overcut**

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>241104</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)
LESTER JOHN DIOSO   241109	CHARLENE JAN MARIE FLORES   241111	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**

**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)**

**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	2024-12-20				Time	23:38
Title	n/a					
Attendees	n/a					
Prepared By:					Approved By:	
GERALD DE GUZMAN   250128					REXEL ALMARIO   250205	
					Department Head	

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

Date Conducted: 2025-02-28	PIC: L. Dioso
Identified Rootcause Actual installed creasing blade height was 23.3mm, while the cutting blade height was 23.8mm, giving a minimal height difference of 0.5mm, making it prone to overcut.	Recommendation Replacement of creasing blades.

**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	2025-02-28	[ / ] Yes [ ] No	1st	JO25-M-00802-1	250228	0	100
2nd Verification of Action			[ ] Yes [ ] No	2nd				
3rd Verification of Action			[ ] Yes [ ] No	3rd				
Effectiveness of Action			[ ] Yes [ ] No	4th				
Remarks: Blade adjustment was implemented. Item is slow moving product with only one-active running.				5th				

**IV. CLOSURE**

Status	Remarks
Closed IRF	PKG-PRO-31-RMFG A585 BOX is a slow-moving item with only one recorded production run.

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 11:24 Department Head
Date: 25252525-04-24	Date: 25252525-04-25	Date: 25252525-05-06	Date: 25252525-05-07