

**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)

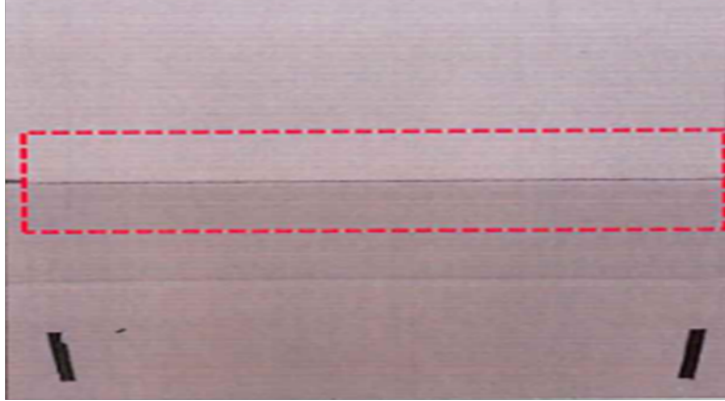
Control No.:

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**



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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	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	



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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