

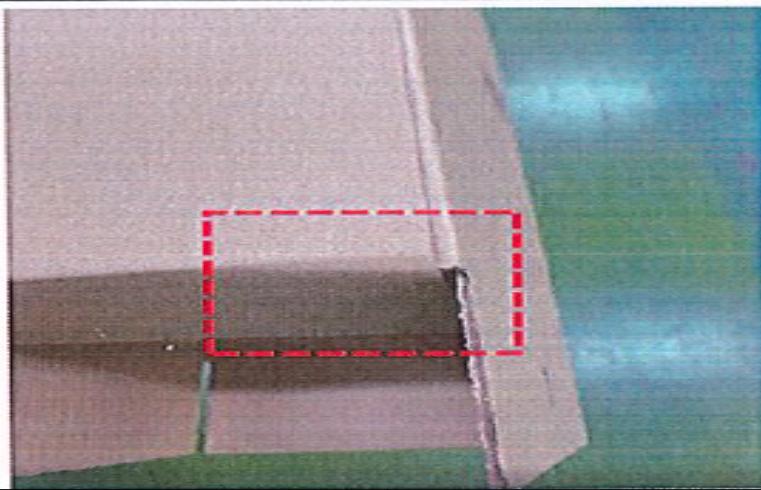
**KANE PACKAGE PHILIPPINE INC.**

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
0028	241116

Customer	KOWA-EMORI PHILIPPINES, INC.	Attention To	WEENA APALLA
Item Code	HP01D5601 CARTON BOX	Department	PRODUCTION
Item Description		Date of Detection	241113
Job Order Number	JO24-M-01800-47	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
400	35	8.75
Nature of Defect:		
MISALIGN SLOT		
Requirement:		
NO MISALIGN SLOT		
Actual		
MISALIGN SLOT		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input checked="" type="checkbox"/> Gluing
<input type="checkbox"/> Recurrence No.: <u>1</u>	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Material
Date.: <u>241113</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Dimension
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<input type="checkbox"/> Appearance
			<input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
ERIKA ASIS 241116	CHARLENE JAN MARIE FLORES 241118	MICHAEL CASILLANO 241118	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		
FG	n/a	0	0	0	Rework PPM (Good)	0

B. Orientation

Date	2025-01-23	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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INVESTIGATION REPORT FORM (IRF)**II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)**

Date Conducted: 2025-01-22	PIC: M.ASIS
Identified Rootcause Loose Fitting of Rotary Blade	Recommendation N/A

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	M.ASIS	2025-01-23	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO25-M-00245-11	250206	0	400
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO25-M-00564-36	250215	0	400
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO25-M-00564-37	250222	0	450
Effectiveness of Action	M.ASIS	2025-01-23	<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO25-M-00759-8	250304	0	400
Remarks: N/A				5th	JO25-M-00986-2	250325	0	400

IV. CLOSURE

Status	Remarks			
Closed IRF	5 lots consecutive running with no defects. Implemented corrective action is effective			
Approved by:	Process Owner Acknowledgment: (Receiving Section)			
250430 05:25 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: 25252525-04-30	Date: 25252525-05-23	Date: 25252525-06-03	Date: 25252525-10-17	