



# 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

0031

241121

Customer INA MICRO OPTO CORP.

Attention To WEENA APALLA

Item Code AZ812400

Department PRODUCTION

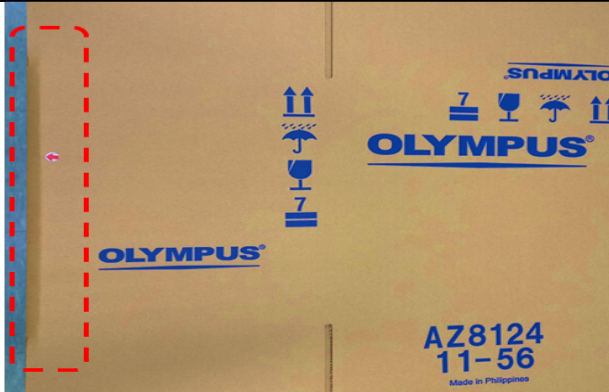
Item Description CARTON

Date of Detection 241116

Job Order Number JO-24-IPD-01058-4

Section Detected QA SCREENING

### ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)

Reject Qty (pcs)

Reject %

150

50

33.33

Nature of Defect:

EXTRAFOLD

Requirement:

Extra fold is not acceptable

Actual

Heavy extra fold up to 280 mm

**ACTUAL:** With heavy extra fold up to 280 mm

**REQUIREMENT:** Extra fold is not acceptable

NO. OF OCCURENCE

DISPOSITION

AREA OF OCCURENCE / ORIGIN

CONTENT

☒ First  
☐ Recurrence No.: 1  
Date.: 241116

☐ Hold  
☐ Special Acceptance  
☐ For Rework  
☒ Reject / Disposal

☐ Slotter  
☐ EQOS  
☐ Diecut  
☐ Detaching  
☒ Gluing  
☐ Vertical  
☐ Others

☐ Material  
☐ Dimension  
☐ Appearance  
☒ Process / Method

Issued by

Checked by

Approved by

Received by (Receiving Section)

LESTER JOHN DIOSO | 241121

CHARLENE JAN MARIE FLORES | 241122

MICHAEL CASILLANO | 241126

GERALD DE GUZMAN | 241128

### I. INVESTIGATION / ANALYSIS

**DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)**

**System / Training**

**Design / Toolings**

**Process / Material**

WHY 1 : W1 Operator conduct pre folding (hilot). r nW2 Operator is having difficulty folding along the creasing line. r nW3 Misalignment of creasing line happened that caused close and wide gap. r nW4 EQOS creasing roller hit the grain direction line of the board which is the hardest part.



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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	n/a
WIP	n/a	0	0	0	Rework PPM (Good)	n/a
FG	n/a	0	0	0		
B. Orientation						
Date	2024-11-27				Time	11:22
Title	n/a					
Attendees	N/A					
Prepared By:					Approved By:	
GERALD DE GUZMAN   241128					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: 2024-11-28	PIC: M.ASIS
Identified Rootcause EQOS creasing roller hit the grain direction line of the board.	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	2024-12-02	[ <input type="checkbox"/> ] Yes [ <input type="checkbox"/> ] No	1st	JO-24-IPD-01275-2	250110	0	300
2nd Verification of Action	M.ASIS	2024-12-16	[ <input type="checkbox"/> ] Yes [ <input type="checkbox"/> ] No	2nd	JO25-M-00308-1	250204	0	350
3rd Verification of Action	M.ASIS	2025-01-06	[ <input type="checkbox"/> ] Yes [ <input type="checkbox"/> ] No	3rd	JO25-M-00370-1	250208	0	300
Effectiveness of Action	M.ASIS	2025-05-21	[ <input type="checkbox"/> ] Yes [ <input type="checkbox"/> ] No	4th	JO25-M-01644-2	250507	0	350
Remarks: The proposed of die-blade for this item for the improvement of creasing (the creasing impression already reached the maximum impression of 0.1mm) was declined since the item was slow moving and has small quantity.  The new corrective action from the production was re-orientation of pre-folding for this item. After the re-orientation, no extra fold issue was encountered.				5th	JO25-M-01910-1	250521	0	250

**IV. CLOSURE**

Status	Remarks
Still Open	Five consecutive running with no extra fold issue encountered

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
REXEL ALMARIO   251017 09:37	N/A	N/A	N/A
QA Head	Top Management	Line Leader	Department Head
Date: 25252525-10-17	Date: -	Date: -	Date: -