

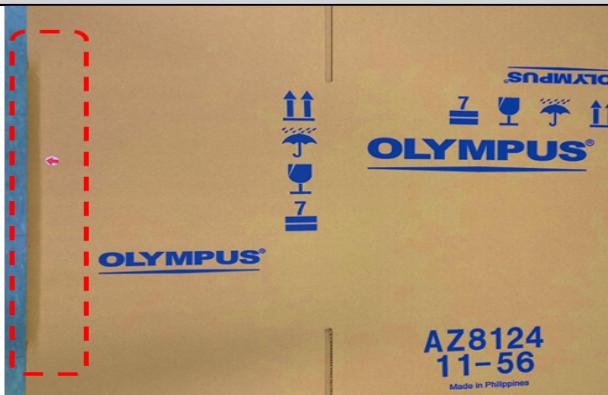
**KANE PACKAGE PHILIPPINE INC.**

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

ACTUAL: With heavy extra fold up to 280 mm
REQUIREMENT: Extra fold is not acceptable

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
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150	50	33.33
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Nature of Defect:

EXTRAFOLD

Requirement:

Extra fold is not acceptable

Actual

Heavy extra fold up to 280 mm

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>241116</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)
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		
FG	n/a	0	0	0	Rework PPM (Good)	n/a

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.

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 QA Head	N/A Top Management	N/A Line Leader	N/A Department Head	
Date: 25252525-10-17	Date: -	Date: -	Date: -	