



# 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.:

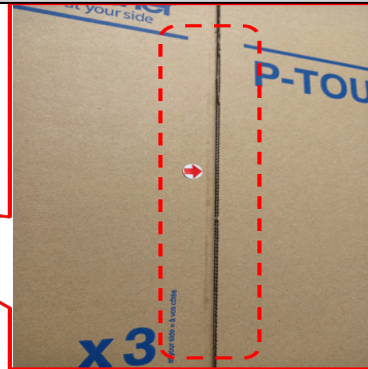
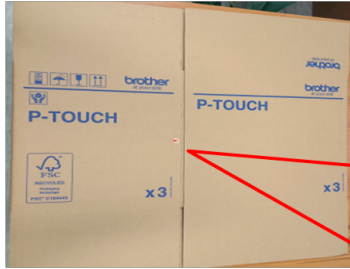
Date Issued

0032

241123

|                  |                                      |                   |              |
|------------------|--------------------------------------|-------------------|--------------|
| Customer         | BROTHER INDUSTRIES PHILIPPINES, INC. | Attention To      | WEENA APALLA |
| Item Code        | D02J9E001                            | Department        | PRODUCTION   |
| Item Description | PRINTED CARTON (X3) N10 US COC       | Date of Detection | 241116       |
| Job Order Number | JO24-M-01809-11                      | Section Detected  | QA SCREENING |

### ILLUSTRATION OF THE PROBLEM



**ACTUAL:** With oil stain up to 3mm x 275mm

**REQUIREMENT:** Acceptable small spot is 2mm x 3mm only

|                    |                  |          |
|--------------------|------------------|----------|
| Lot Quantity (pcs) | Reject Qty (pcs) | Reject % |
| 2000               | 19               | 0.95     |

Nature of Defect:

OIL STAIN

Requirement:

Acceptable small spot is 2mm x 3mm only

Actual

With oil stain up to 3mm x 275mm

| NO. OF OCCURENCE   | DISPOSITION  | AREA OF OCCURENCE / ORIGIN   | CONTENT  |
|--|--|--|--|
| <input checked="" type="checkbox"/> First<br><input type="checkbox"/> Recurrence No.: <u>1</u><br>Date.: <u>241116</u> | <input type="checkbox"/> Hold<br><input type="checkbox"/> Special Acceptance<br><input type="checkbox"/> For Rework<br><input checked="" type="checkbox"/> Reject / Disposal | <input type="checkbox"/> Slotter<br><input type="checkbox"/> EQOS<br><input type="checkbox"/> Diecut<br><input type="checkbox"/> Detaching<br><input checked="" type="checkbox"/> Gluing<br><input type="checkbox"/> Vertical<br><input type="checkbox"/> Others | <input type="checkbox"/> Material<br><input type="checkbox"/> Dimension<br><input checked="" type="checkbox"/> Appearance<br><input type="checkbox"/> Process / Method |
| Issued by  | Checked by   | Approved by  | Received by (Receiving Section)  |
| LESTER JOHN DIOSO   241123   | CHARLENE JAN MARIE FLORES   241125   | 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**

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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          | Rework PPM (Good)      | 0     |
| FG                        | n/a                                | 0           | 0  | 0          |                        |       |
| B. Orientation            |                                    |             |    |            |                        |       |
| Date                      | 2024-12-05                         |             |    |            | Time                   | 08:16 |
| Title                     | Production Weekly Assembly Meeting |             |    |            |                        |       |
| Attendees                 | All Production                     |             |    |            |                        |       |
| Prepared By:              |                                    |             |    |            | Approved By:           |       |
| GERALD DE GUZMAN   250128 |                                    |             |    |            | REXEL ALMARIO   250205 |       |
|                           |                                    |             |    |            | Department Head        |       |



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

|   |   |
|---|---|
| Date Conducted: 2025-04-03  | PIC: L. Dioso   |
| Identified Rootcause<br>Excessive oil applied to the glue applicator during the Daily Maintenance Checklist (DMC) dripped during mass production. Insufficient checkpoints on Daily Maintenance Checklist, checking of Glue Applicator for oil leaks is not included. | Recommendation<br>Revise the SA2600 Daily Maintenance Checklist (DMC) to include a checkpoint for inspecting the glue applicator for any oil leaks. |

**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    | 2025-04-03 | [ / ] Yes [ ] No | 1st     | JO25-M-01159-4  | 250403 | 0      | 1000    |
| 2nd Verification of Action  |             |            | [ ] Yes [ ] No   | 2nd     | JO25-M-01159-6  | 250405 | 0      | 1400    |
| 3rd Verification of Action  |             |            | [ ] Yes [ ] No   | 3rd     | JO25-M-01159-8  | 250407 | 0      | 2000    |
| Effectiveness of Action   |             |            | [ ] Yes [ ] No   | 4th     | JO25-M-01159-9  | 250408 | 0      | 1100    |
| Remarks: SA2600 Daily Machine Checklist has been revised to include oil leak checks on the glue applicator and is now in use. Operators have been informed of the update. |             |            |                  | 5th     | JO25-M-01159-11 | 250411 | 0      | 1200    |

**IV. CLOSURE**

| Status     | Remarks  |
|------------|--|
| Still Open | No encountered oil stain for the last five production running. |

| Approved by:                                   |  | Process Owner Acknowledgment: (Receiving Section) |                        |
|--|--|---|------------------------|
| MICHAEL CASILLANO   250425<br>10:01<br>QA Head | KOHEI ISHII   250523 02:41<br>Top Management | GERALD DE GUZMAN   250603<br>08:42<br>Line Leader | N/A<br>Department Head |
| Date: 25252525-04-25                           | Date: 25252525-05-23                         | Date: 25252525-06-03                              | Date: -                |