



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.:

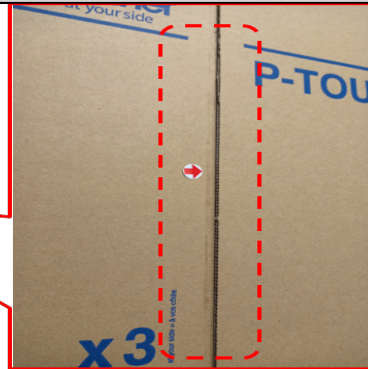
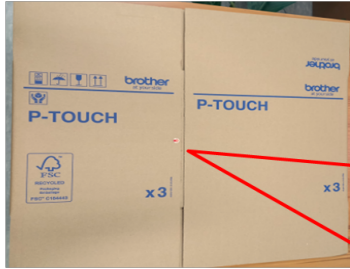
Date Issued

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 <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>241116</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 type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input checked="" type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input checked="" type="checkbox"/> Appearance <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 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 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
Closed IRF	No encountered oil stain for the last five production running.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250425 10:01 QA Head	KOHEI ISHII 250523 02:41 Top Management	GERALD DE GUZMAN 250603 08:42 Line Leader	REXEL ALMARIO 251017 09:41 Department Head
Date: 25252525-04-25	Date: 25252525-05-23	Date: 25252525-06-03	Date: 25252525-10-17