



# 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.:

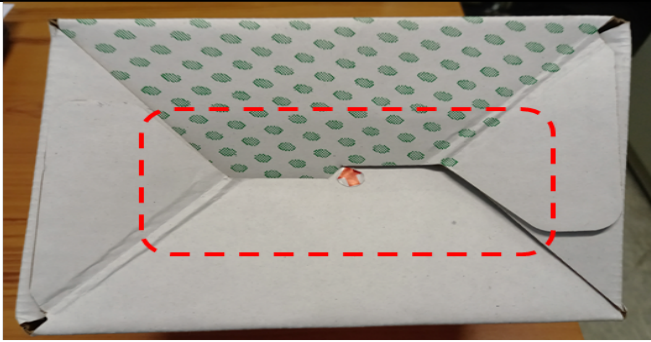
Date Issued

0033

241123

Customer	NIDEC SUBIC PHILIPPINES CORPORATION	Attention To	WEENA APALLA
Item Code	L00086480	Department	PRODUCTION
Item Description	FLEXWAVE BOX D	Date of Detection	241120
Job Order Number	JO24-M-01921-3	Section Detected	QA SCREENING

### ILLUSTRATION OF THE PROBLEM



**ACTUAL:** With cannot fit lock  
**REQUIREMENT:** Cannot fit lock not acceptable

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
3020	90	2.98

Nature of Defect:

CANNOT FIT LOCK

Requirement:

Cannot fit lock is not acceptable

Actual

Cannot fit lock due to misalign glue

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: <u>6</u> Date.: <u>240726</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 type="checkbox"/> Appearance <input checked="" 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	2024-12-20				Time	11:06
Title	n/a					
Attendees	N/A					
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:	PIC:
Identified Rootcause Eterna Lima did not follow the parameter	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			[ ] Yes [ ] No	1st				
2nd Verification of Action			[ ] Yes [ ] No	2nd				
3rd Verification of Action			[ ] Yes [ ] No	3rd				
Effectiveness of Action			[ ] Yes [ ] No	4th				
Remarks:				5th				

### IV. CLOSURE

Status	Remarks
Closed IRF	The die-cut process of the item was transferred to KP Lima; the process endorsed to Lima operators was not followed, resulting in the cannot-fit lock. There will be monitoring of cannot fit lock issue in this item and will issue new IRF/CAR to the concerned department.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO   250220 12:57 QA Head	KOHEI ISHII   250226 02:33 Top Management	GERALD DE GUZMAN   250303 03:13 Line Leader	REXEL ALMARIO   250507 11:25 Department Head
Date: 25252525-02-20	Date: 25252525-02-26	Date: 25252525-03-03	Date: 25252525-05-07