

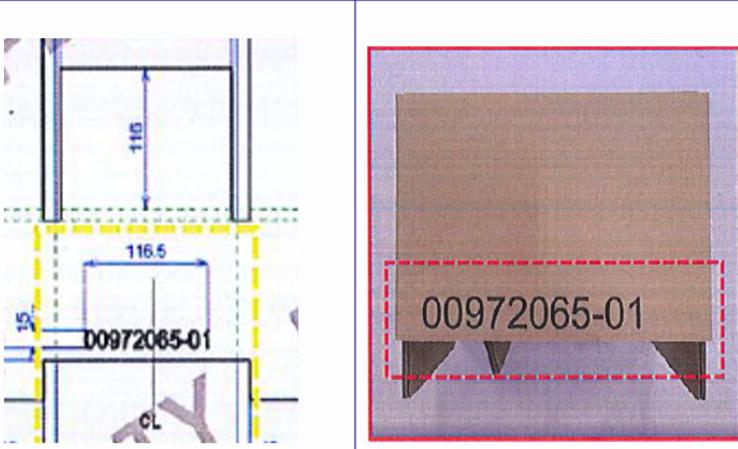
**KANE PACKAGE PHILIPPINE INC.**

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
0035	241128

Customer	SANYO DENKI PHILS INC.	Attention To	REXEL ALMARIO
Item Code	00972065-01	Department	PRODUCTION
Item Description	TOP PAD	Date of Detection	241125
Job Order Number	JO24-M-02011-8	Section Detected	QA SCREENING 6

**ILLUSTRATION OF THE PROBLEM****GOOD****NO GOOD**

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
240	90	37.50

Nature of Defect:

MISALIGN PRINT

Requirement:

PRINT SHOULD BE IN THE CENTER LINE

Actual

PRINT WAS FOUND NEAR THE CREEPING LINE

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence No.: <u>1</u>	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
Date.: <u>241125</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
ERIKA ASIS   241128	CHARLENE JAN MARIE FLORES   241129	MICHAEL CASILLANO   241202	GERALD DE GUZMAN   241206

**I. INVESTIGATION / ANALYSIS****DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)****System / Training****Design / Toolings****Process / Material**



## 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		
FG	n/a	0	0	0	Rework PPM (Good)	0

B. Orientation

Date	2025-01-20	Time	06:37
Title	New auto slitter operation trial		
Attendees	Slitter operator		
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: 2025-02-06	PIC: L. Diioso
Identified Rootcause  Boards were not feeding consistently plus there is a lateral printing movement during EQOS process. Width of the cut boards was uneven due to inconsistent cutting during slitter process.	Recommendation  Old slitter produced inconsistent cuts during the slitting process. Since there is a new automatic slitter, the newly slitter machine was implemented immediately.

**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. Diioso	2025-02-06	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO25-M-00254-174	250206	0	500
2nd Verification of Action			<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	2nd	JO25-M-00254-176	250211	0	1080
3rd Verification of Action			<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	3rd	JO25-M-00254-178	250221	0	200
Effectiveness of Action			<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	4th	JO25-M-00254-195	250221	0	20
Remarks: Replaced old slitter due to inconsistent cutting. New automatic slitter implemented immediately to ensure accurate board dimensions and prevent print misalignment.				5th	JO25-M-00641-46	250225	0	500

**IV. CLOSURE**

Status	Remarks		
Closed IRF	No misalign print for 00972065-01 issues were encountered in the last five production runs.		
Approved by:	Process Owner Acknowledgment: (Receiving Section)		
MICHAEL CASILLANO   250425 10:01 QA Head Date: 25252525-04-25	KOHEI ISHII   250523 02:41 Top Management Date: 25252525-05-23	GERALD DE GUZMAN   250603 08:41 Line Leader Date: 25252525-06-03	REXEL ALMARIO   251017 09:41 Department Head Date: 25252525-10-17