

**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	
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 CREASING LINE			
NO. OF OCCURENCE		DISPOSITION	
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>241125</u>		<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	
AREA OF OCCURENCE / ORIGIN		CONTENT	
<input type="checkbox"/> Slotter <input checked="" type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching		<input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others <input checked="" type="checkbox"/> Process / Method	
Issued by		Checked by	
ERIKA ASIS 241128		CHARLENE JAN MARIE FLORES 241129	
Approved by		Received by (Receiving Section)	
MICHAEL CASILLANO 241202		GERALD DE GUZMAN 241206	
I. INVESTIGATION / ANALYSIS			
DIRECT CAUSE: (Analyze the reason of occurence, 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	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	



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

Date Conducted: 2025-02-06	PIC: L. Dioso
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. Dioso	2025-02-06	[/] Yes [] No	1st	JO25-M-00254-174	250206	0	500
2nd Verification of Action			[] Yes [] No	2nd	JO25-M-00254-176	250211	0	1080
3rd Verification of Action			[] Yes [] No	3rd	JO25-M-00254-178	250221	0	200
Effectiveness of Action			[] Yes [] 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	KOHEI ISHII 250523 02:41 Top Management	GERALD DE GUZMAN 250603 08:41 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