

**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

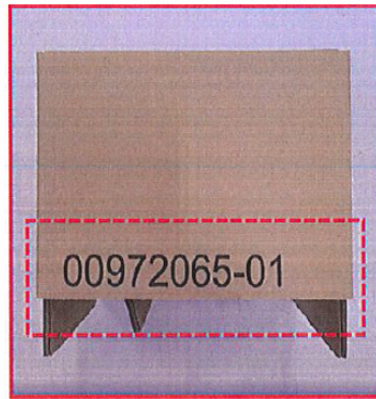
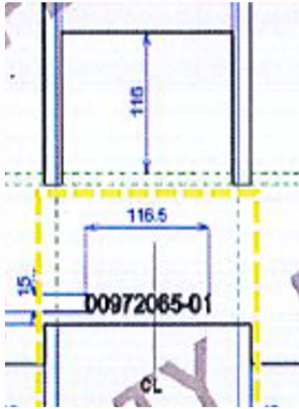
Department PRODUCTION

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

AREA OF OCCURENCE / ORIGIN

CONTENT

☒ First
☐ Recurrence No.: 1
Date.: 241125

☐ Hold
☐ Special Acceptance
☐ For Rework
☒ Reject / Disposal

☐ Slotter
☒ EQOS
☐ Diecut
☐ Detaching

☐ Gluing
☐ Vertical
☐ Others

☐ Material
☐ Dimension
☐ Appearance
☒ 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**



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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
Still Open	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	N/A Department Head
Date: 25252525-04-25	Date: 25252525-05-23	Date: 25252525-06-03	Date: -