

**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)

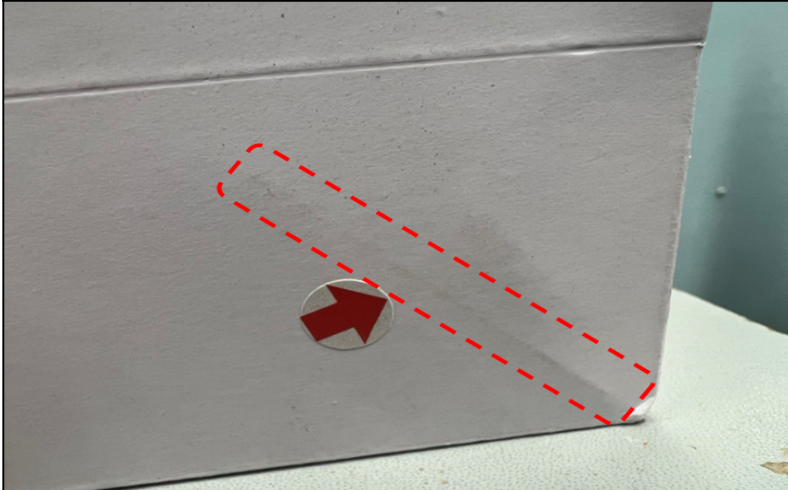
Control No.:

Date Issued

0038

241213

Customer	ARKRAY	Attention To	REXEL ALMARIO
Item Code	63-29360 BOX	Department	PRODUCTION
Item Description	(ACCESSORY CASE 90(W) X 155 (D) CLAYCOATED 400 DMS WHITE/GRAY BACK09		
Job Order Number	JO24-M-02227-2	Section Detected	PRODUCTION

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
42	11	26.19

Nature of Defect:

DENT

Requirement:

DENT IS NOT ACCEPTABLE

Actual

WITH DENT UP TO 55MM

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>241209</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)
ERIKA ASIS 241213	CHARLENE JAN MARIE FLORES 241217	MICHAEL CASILLANO 241217	GERALD DE GUZMAN 250113

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

WHY 1 : W1 The items are claycoated materials colliding with each other causing dent. r nW2 The items are process in conveyor an overlapping feeding causing them to press against one another. r n



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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

Process / Material

WHY 1: Conduct awareness orientation during Production Assembly

Production Leader // 2025-01-30

WHY 2: Inclusion of rejection history in the Job Order. r n No overlapping feeding in conveyor for this item

QA IE // 2025-02-07

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	2025-01-30	Time	08:15
Title	Awareness regarding Dent of Arkray 63 29360 Box Claycoated Accessory Case		
Attendees	All Production		

Prepared By:

Approved By:

GERALD DE GUZMAN | 250304

REXEL ALMARIO | 250507

Department Head



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

Date Conducted:	PIC:
Identified Rootcause	Recommendation

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
Still Open	No running of items for the past six months. Last running was on June 19, 2025, no defects found out of 500 pcs lot quantity.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 260112 12:24 QA Head	N/A Top Management	N/A Line Leader	N/A Department Head
Date: 26262626-01-12	Date: -	Date: -	Date: -