

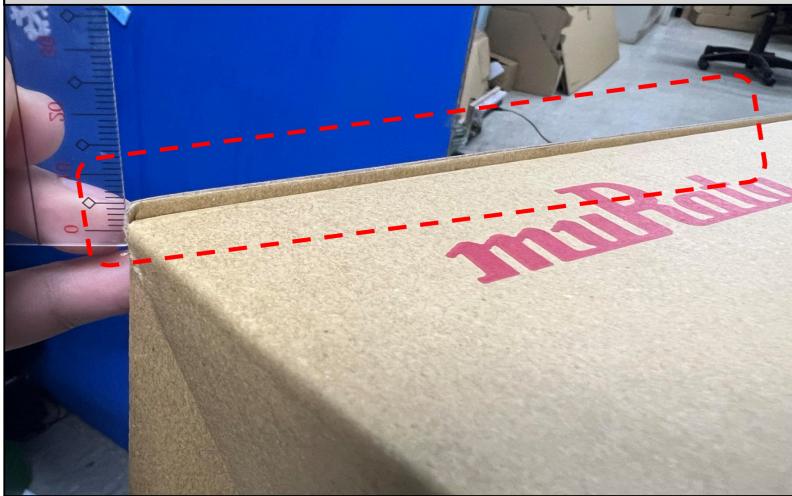
**KANE PACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISI 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
0039	241213

Customer	KOWA-EMORI PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	HP01D2200C-1	Department	PRODUCTION
Item Description	CARTON BOX W/ PRINT	Date of Detection	241210
Job Order Number	JO24-M-02017-45	Section Detected	QA SCREENING 4

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
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1360	48	3.53
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Nature of Defect:

OVER LAP

Requirement:

OVERLAP IS NOT ACCEPTABLE

Actual

OVERLAP UP TO 5MM

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> <u>Date.: 241210</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
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 Operator pre folding the item due to encounter close gap overlap. r nW2 The installed creasing matrix on the vertical creasing line move during Eterna process that caused of misalignment during folding in gluing process. r nW3 Weak adhesion of creasing matrix installed.



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: Re installation of Creasing Matrix.

Tooling // 2025-02-01

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	2025-03-01	Time	13:07
Title	N/A		
Attendees	n/a		
Prepared By:		Approved By:	
GERALD DE GUZMAN 250304		REXEL ALMARIO 250507	
		Department Head	

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INVESTIGATION REPORT FORM (IRF)**II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)**

Date Conducted: 2024-12-13	PIC: M.ASIS
Identified Rootcause Weak adhesion of creasing matrix installed	Recommendation Re-installation of creasing matrix

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	M.ASIS	2025-02-05	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO25-M-01915-5	250602	0	2000
2nd Verification of Action	M.ASIS	2025-06-02	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO25-M-01915-6	250609	0	2000
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO25-M-01915-67	250611	12	2000
Effectiveness of Action	M.ASIS	2025-06-18	<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO25-M-01915-8	250614	0	2000
Remarks:				5th	JO25-M-01915-10	250618	0	2000

IV. CLOSURE

Status	Remarks		
Closed IRF	5 consecutive lots running with only 12 pcs reject detected over the total output of 10,000 pcs.		
Approved by:	Process Owner Acknowledgment: (Receiving Section)		
MICHAEL CASILLANO 250702 04:10 QA Head	RHODORA MIRANDA 250703 07:58 Top Management	GERALD DE GUZMAN 250704 11:41 Line Leader	REXEL ALMARIO 251017 09:41 Department Head
Date: 25252525-07-02	Date: 25252525-07-03	Date: 25252525-07-04	Date: 25252525-10-17