

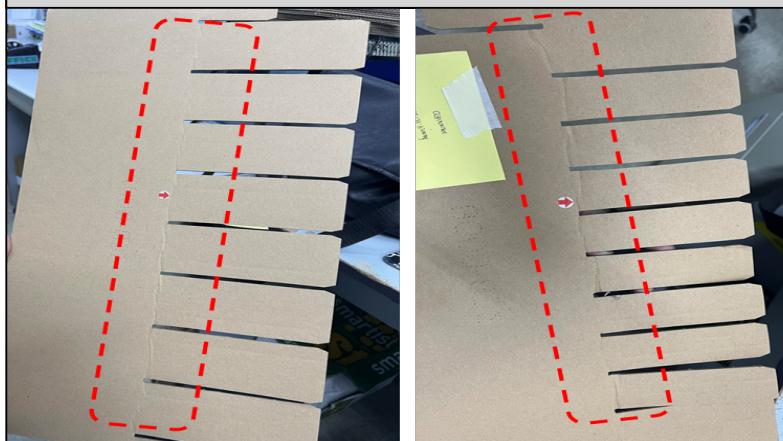
**KANE PACKAGE PHILIPPINE INC.**

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
0040	241226

Customer	CANON BUSINESS MACHINE PHILS.	Attention To	REXEL ALMARIO
Item Code	3CB-0007-000/3CB-0008-000	Department	PRODUCTION
Item Description		Date of Detection	241216
Job Order Number	JO-F-24-1149-2, JO-F-24-1149-3	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
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1000	222	22.20
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Nature of Defect:

SCORING

Requirement:

NO SCORING

Actual

WITH SCORING

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT	
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>241216</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 type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input checked="" type="checkbox"/> Others <u>DETACHING</u>	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)	
ERIKA ASIS 241226	CHARLENE JAN MARIE FLORES 241226	MICHAEL CASILLANO 241227	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 PULLING FORCE WAS APPLIED ON ITEM DURING DETACHING PROCESS. r nW2 WORK INSTRUCTION FOR THE REMOVAL OF TRIMMINGS OF DIECUTTED BOARD WAS GENERAL TO ALL ITEMS (NEED EXTRA CAREFUL TO DETACH THIS ITEM SINCE THE SCORING ACCEPTABLE ON OTHER ITEMS IS REJECTED IN CBMP 3CB).



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 REGARDING THE ISSUE DURING PRODUCTION ASSEMBLY

Production Leader // 2025-01-16

WHY 2: GUIDELINES FOR PROPER DETACHING OF ITEMS

Production Leader // 2025-01-31

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 2025-01-16 Time 08:15

Title Production Weekly Assembly Meeting

Attendees All Production

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: 2025-05-02	PIC: M.ASIS
Identified Rootcause No proper detaching method for 3CB partitions	Recommendation Revision of detaching work instruction

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	2025-01-31	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO-F-25-693-2	250617	0	1000
2nd Verification of Action	M.ASIS	2025-03-13	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO-F-25-872-2	250731	0	1000
3rd Verification of Action	M.ASIS	2025-03-24	<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO-F-25-923-1	250809	0	1000
Effectiveness of Action	M.ASIS	2025-09-22	<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO-F-25-994-2	250821	0	1000
Remarks: The revised work instruction in detaching was horizontal to all CBMP items					5th	JO-F-25-1111-52	250922	0
IV. CLOSURE								

Status	Remarks			
Still Open	Five consecutive running with no scoring issue detected. Implemented corrective action is effective.			
Approved by:		Process Owner Acknowledgment: (Receiving Section)		
REXEL ALMARIO 251017 10:06 QA Head	N/A Top Management	N/A Line Leader	N/A Department Head	
Date: 25252525-10-17	Date: -	Date: -	Date: -	