



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.:

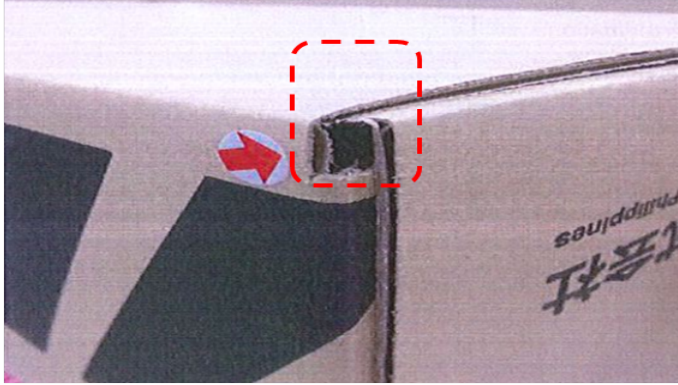
Date Issued

0047

250123

Customer	SANYO DENKI PHILS INC.	Attention To	REXEL ALMARIO
Item Code	00897168-01 PACKAGE	Department	PRODUCTION
Item Description	PACKAGE	Date of Detection	250113
Job Order Number	JO240-M-02341-30	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM



ACTUAL: With poor slot up to 12mm
REQUIREMENT: Poor slot not acceptable

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1600	26	1.63
Nature of Defect:		
POOR SLOT		
Requirement:		
Poor slot not acceptable		
Actual		
With poor slot up to 12mm		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250113</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 type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO 250123	CHARLENE JAN MARIE FLORES 250125	MICHAEL CASILLANO 250127	GERALD DE GUZMAN 250128

I. INVESTIGATION / ANALYSIS

DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)

System / Training

Design / Toolings

Process / Material

WHY 1 : W1 DELAY FEEDING OF MATERIAL IN EQOS. r nW2 OVERSTACKING ON FEEDING UNIT. r nW3 FAILED TO FOLLOW THE STACKING GUIDELINE FOR C FLUTE ITEMS.



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INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)

System / Training

Design / Toolings

Process / Material

WHY 1 : N/A

FINAL CONCLUSION

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

WHO / WHEN

Process / Material

WHY 1: AWARENESS ORIENTATION REGARDING THIS ISSUE DURING PRODUCTION ASSEMBLY MEETING.

Production Leader // 2025-03-27

WHY 2: CONDUCT STUDY FOR THE NEW STACKING HEIGHT LIMIT IN EQOS FEEDER SINCE THE EXISTING STACKING HEIGHT LIMIT WAS MADE DUE TO BLUNT RUBBER ROLLER BEFORE (RUBBER ROLLER WAS REPLACED LAST DECEMBER 16 2024).

Production Leader // 2025-04-15

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	2025-03-27	Time	08:03
Title	Production Weekly Assembly Meeting		
Attendees	All Production		

Prepared By:

Approved By:

GERALD DE GUZMAN | 250410

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: 2025-03-27	PIC: M.ASIS
Identified Rootcause Operator failed to follow the stacking height guideline for C-flute items	Recommendation Highlight the issue to EQOS operators

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	2025-04-15	[/] Yes [] No	1st	JO25-M-001186-87	250423	0	1050
2nd Verification of Action	M.ASIS	2025-04-23	[/] Yes [] No	2nd	JO25-M-001186-97	250430	0	1000
3rd Verification of Action			[/] Yes [] No	3rd	JO25-M-01572-53	250510	0	1040
Effectiveness of Action	M.ASIS	2025-07-09	[/] Yes [] No	4th	JO25-M-01572-135	250524	0	1250
Remarks: N/A				5th	JO25-M-02264-43	250709	0	1100

IV. CLOSURE

Status	Remarks
Still Open	Five consecutive running with no poor slot issue detected. Implemented corrective action is effective.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
251020 10:56	N/A	N/A	N/A
QA Head	Top Management	Line Leader	Department Head
Date: 25252525-10-20	Date: -	Date: -	Date: -