

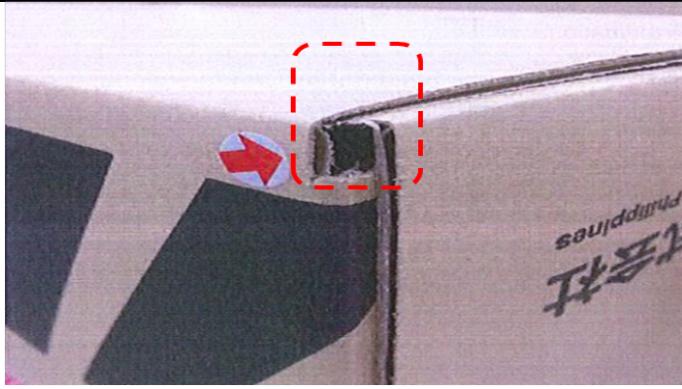
**KANE PACKAGE PHILIPPINE INC.**

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
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"/> Hold	<input type="checkbox"/> Slotter	<input checked="" type="checkbox"/> Gluing
<input type="checkbox"/> Recurrence No.: <u>1</u>	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Vertical
Date.: <u>250113</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Others
<input type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching		<input checked="" 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.



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

CONDUCT STUDY FOR THE NEW STACKING HEIGHT LIMIT IN EQOS FEEDER SINCE THE EXISTING

WHY 2: 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		
FG	n/a	0	0	0	Rework PPM (Good)	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

**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)**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	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO25-M-001186-87	250423	0	1050
2nd Verification of Action	M.ASIS	2025-04-23	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO25-M-001186-97	250430	0	1000
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO25-M-01572-53	250510	0	1040
Effectiveness of Action	M.ASIS	2025-07-09	<input type="checkbox"/> Yes <input type="checkbox"/> 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 QA Head	N/A Top Management
Date: 25252525-10-20	Date: -
	N/A Line Leader
	N/A Department Head
	Date: -