

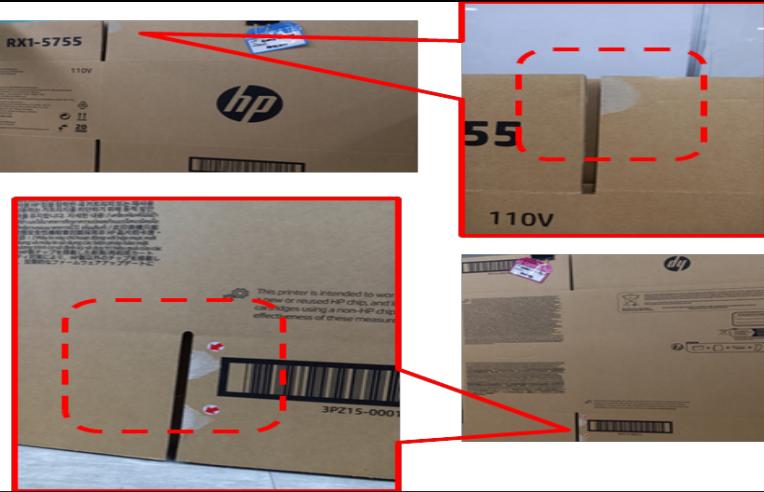
**KANE PACKAGE PHILIPPINE INC.**

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
0048	250124

Customer	CANON BUSINESS MACHINE PHILS.	Attention To	REXEL ALMARIO
Item Code	RX1-5781-000, RX1-5755-000	Department	PRODUCTION
Item Description		Date of Detection	250120
Job Order Number	JO-TO-IPD-25-00015-1, JO-F-24-1258-1	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2400	50	2.08

Nature of Defect:

PEEL OFF

Requirement:

PEEL OFF UP TO 10 MM IS ACCEPTABLE (CLASS B)

Actual

PEEL OFF UP TO 20 MM

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence No.: <u>1</u>	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
Date.: <u>240120</u>	<input type="checkbox"/> For Rework	<input checked="" type="checkbox"/> Diecut	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
MA. ERIKA MAE ASIS 250124	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 Not fully cut liner result to Peel Off during auto stripping in Diecut S1700. r nW2 Insufficient pressure on the slot portion. r nW3 Over application of Ejector Sponge.



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: Request for die blade re layout using Mizzoko white ejector sponge inside the slot and green ejector sponge with spacing outside the slot.	Production Leaders // 2025-03-19
WHY 2: TRAINING ON PROPER USAGE OF EJECTOR SPONGE (CITO) FOR THE STANDARDIZATION.	CITO // 2025-03-19

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	2025-03-19	Time	10:31
Title	CITO TRAINING		
Attendees	PRODUCTION QA ME DESIGN		
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: 2025-01-24	PIC: M.ASIS
Identified Rootcause Over application of Ejector Sponge.	Recommendation Request for die-blade re-layout

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	2025-03-18	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO-F-25-377-9	250403	1	600
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO-F-25-424-4	250412	14	1000
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO-F-25-462-2	250421	0	1000
Effectiveness of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO-F-25-558-2	250502	0	1000
Remarks:				5th	JO-F-25-462-5	250503	0	1500

IV. CLOSURE

Status	Remarks		
Closed IRF	5 lots consecutive running with minimal defects. Implemented corrective action is effective		
Approved by:	Process Owner Acknowledgment: (Receiving Section)		
MICHAEL CASILLANO 250613 07:47 QA Head	RHODORA MIRANDA 250626 07:58 Top Management	GERALD DE GUZMAN 250626 02:04 Line Leader	REXEL ALMARIO 251017 09:38 Department Head
Date: 25252525-06-13	Date: 25252525-06-26	Date: 25252525-06-26	Date: 25252525-10-17