



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.:

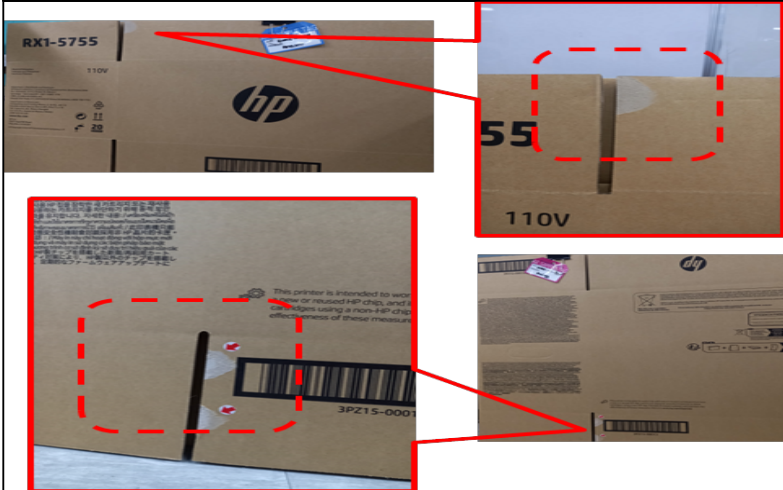
Date Issued

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"/> Recurrence No.: <u>1</u> Date.: <u>240120</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 checked="" type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input 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)
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.

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INVESTIGATION REPORT FORM (IRF)**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	Rework PPM (Good)	0
FG	n/a	0	0	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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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	[/] Yes [] No	1st	JO-F-25-377-9	250403	1	600
2nd Verification of Action			[] Yes [] No	2nd	JO-F-25-424-4	250412	14	1000
3rd Verification of Action			[] Yes [] No	3rd	JO-F-25-462-2	250421	0	1000
Effectiveness of Action			[] Yes [] 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