



# 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.:

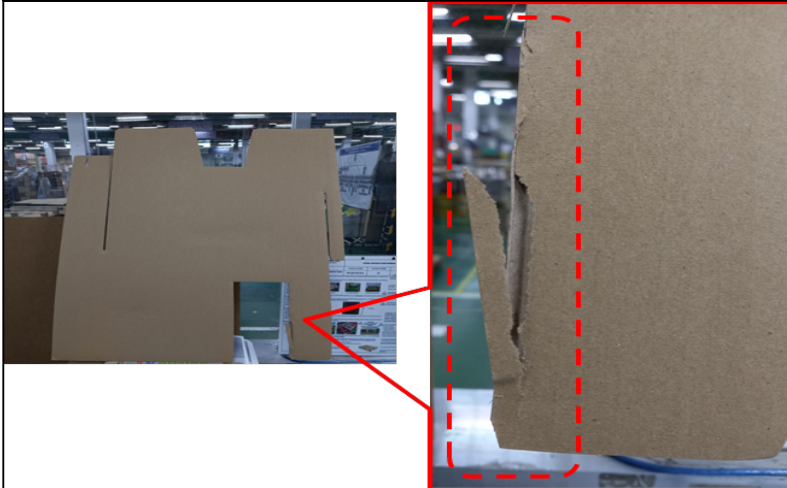
Date Issued

0050

250204

Customer	CANON BUSINESS MACHINE PHILS.	Attention To	REXEL ALMARIO
Item Code	3CB-0059-000	Department	PRODUCTION
Item Description	PARTITION	Date of Detection	250131
Job Order Number	JO-F-25-64-5	Section Detected	QA SCREENING

### ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
4000	174	4.35
Nature of Defect:		
BURSTING		
Requirement:		
Acceptable up to maximum 25mm length by 3mm width		
Actual		
With bursting up to 150 mm		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: 2 Date.: 241111	<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   250204	CHARLENE JAN MARIE FLORES   250205	MICHAEL CASILLANO   250210	GERALD DE GUZMAN   250210

### I. INVESTIGATION / ANALYSIS

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

#### System / Training

#### Design / Toolings

#### Process / Material

WHY 1 : W1 UNEVEN EJECTOR PRESSURE. r nW2 INCONSISTENT USAGE OF EJECTOR SPONGE r nW3 NO ESTABLISHED STANDARD SOLUTION TO AVOID BURSTING

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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: RELAYOUT OF THE BLADE

Production Leader Tooling //  
2025-03-31

WHY 2: ESTABLISH STANDARD USAGE OF EJECTOR SPONGE ACCORDING TO CITO S TRAINING

Production ME // 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	2025-04-10	Time	15:43
Title	n/a		
Attendees	n/a		

Prepared By:

Approved By:

GERALD DE GUZMAN | 250410

REXEL ALMARIO | 250507

Department Head



**II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)**

Date Conducted: 2025-04-01	PIC: L. Dioso
Identified Rootcause Unbalance ejector pressure due to inconsistent usage of ejector sponge and eperan.	Recommendation Re-layout blade and establish standard usage of ejector sponge.

**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	L. Dioso	2025-04-05	[ / ] Yes [ ] No	1st	JO-F-25-382-4	250405	15	2000
2nd Verification of Action	L. Dioso	2025-04-23	[ / ] Yes [ ] No	2nd	JO-F-25-442-7	250415	12	3000
3rd Verification of Action			[ / ] Yes [ ] No	3rd	JO-F-25-483-6	250423	21	3000
Effectiveness of Action	L. Dioso	2025-04-28	[ / ] Yes [ ] No	4th	JO-F-25-483-7	250504	17	3000
Remarks: Rejects for CBMP Partitions including 3CB-0059-000 drastically improve.				5th	JO-F-25-530-2	250514	8	2000

**IV. CLOSURE**

Status	Remarks
Still Open	Low rejection rate for item 3CB-0059-000

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO   250901 10:36 QA Head	N/A Top Management	N/A Line Leader	N/A Department Head
Date: 25252525-09-01	Date: -	Date: -	Date: -