

**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)

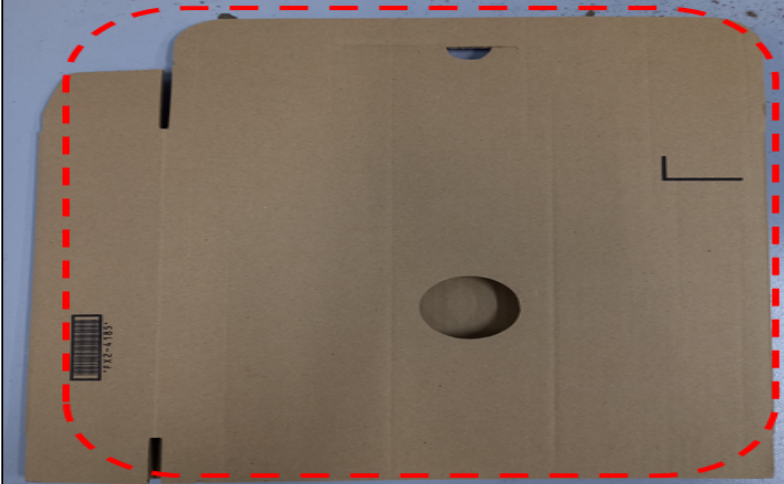
Control No.:

Date Issued

0053

250205

| | | | |
|------------------|-------------------------------|-------------------|---------------|
| Customer | CANON BUSINESS MACHINE PHILS. | Attention To | REXEL ALMARIO |
| Item Code | FX2-4185-000-RMFG | Department | PRODUCTION |
| Item Description | Z10_BOX-ACC-555 | Date of Detection | 250131 |
| Job Order Number | JO-F-25-72-1 | Section Detected | QA SCREENING |

ILLUSTRATION OF THE PROBLEM

| | | |
|--------------------|------------------|----------|
| Lot Quantity (pcs) | Reject Qty (pcs) | Reject % |
| 1996 | 56 | 2.81 |

Nature of Defect:

SCORING

Requirement:

Light scoring is acceptable

Actual

Heavy scoring end to end

| NO. OF OCCURENCE | DISPOSITION | AREA OF OCCURENCE / ORIGIN | CONTENT |
|--|--|---|--|
| <input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250131</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 type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input checked="" type="checkbox"/> Others <u>HANDLING</u> | <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 250205 | 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 Deep impression on the item surface resulted to Scoring. r nW2 Due to mounting of Eperan cushion all over the die blade.

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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 back to zero re layout of die blade.

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 | 2025-04-01 | Time | 03:59 |
| 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: 2025-02-05 | PIC: M.ASIS |
| Identified Rootcause Due to mounting of Eperan cushion all over the die-blade. | Recommendation Revision of WI-PR-003-004 Guidelines in using Diecut Blade Ejector |

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-25-509-2 | 250503 | 0 | 2000 |
| 2nd Verification of Action | M. ASIS | 2025-05-03 | [/] Yes [] No | 2nd | JO-F-25-562-3 | 250508 | 0 | 2000 |
| 3rd Verification of Action | M. ASIS | 2025-05-28 | [/] Yes [] No | 3rd | JO-F-25-591-14 | 250517 | 0 | 2000 |
| Effectiveness of Action | M. ASIS | 2025-05-28 | [/] Yes [] No | 4th | JO-F-25-615-5 | 250524 | 0 | 2000 |
| Remarks: Attached the revised WI-PR-003-004 (Guidelines in using diecut blade ejector) - work instruction based on CITO and trials conducted by ME | | | | 5th | JO-F-25-661-12 | 250528 | 0 | 2000 |

IV. CLOSURE

| Status | Remarks |
|------------|--|
| Still Open | 5 consecutive lots running with no detected defects. Corrective actions were effective |

| Approved by: | | Process Owner Acknowledgment: (Receiving Section) | |
|--|---|---|------------------------|
| RHODORA MIRANDA 250618 07:41 QA Head | RHODORA MIRANDA 250626 07:59 Top Management | GERALD DE GUZMAN 250626 02:04 Line Leader | N/A Department Head |
| Date: 25252525-06-18 | Date: 25252525-06-26 | Date: 25252525-06-26 | Date: - |