

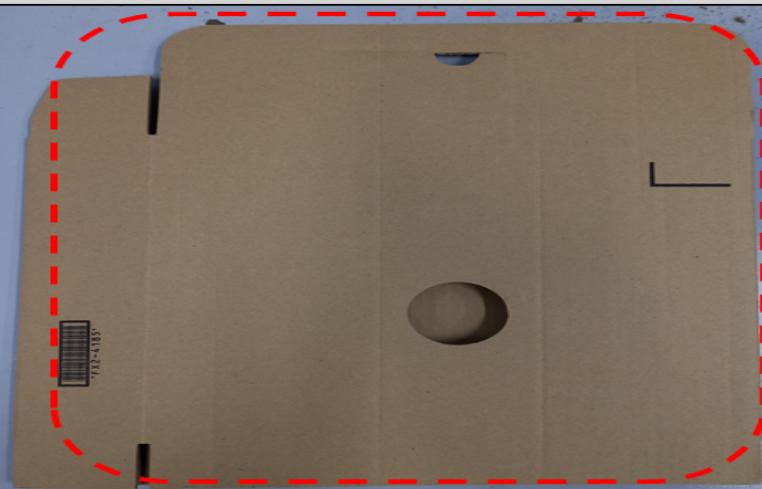
**KANE PACKAGE PHILIPPINE INC.**

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
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"/> 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"/> Gluing	<input type="checkbox"/> Dimension
Date.: <u>250131</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> EQOS	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Process / Method
		<input type="checkbox"/> Detaching	<u>HANDLING</u>
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.



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		
FG	n/a	0	0	0	Rework PPM (Good)	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

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INVESTIGATION REPORT FORM (IRF)**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	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO-F-25-509-2	250503	0	2000
2nd Verification of Action	M. ASIS	2025-05-03	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO-F-25-562-3	250508	0	2000
3rd Verification of Action	M. ASIS	2025-05-28	<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO-F-25-591-14	250517	0	2000
Effectiveness of Action	M. ASIS	2025-05-28	<input type="checkbox"/> Yes <input type="checkbox"/> 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
Closed IRF	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
Date: 25252525-06-18	Date: 25252525-06-26
GERALD DE GUZMAN 250626 02:04 Line Leader	REXEL ALMARIO 251017 09:37 Department Head
Date: 25252525-06-26	Date: 25252525-10-17