

**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
0054	250205

Customer	SANYO DENKI PHILS INC.	Attention To	REXEL ALMARIO
Item Code	01015138-01	Department	PRODUCTION
Item Description	BOX PRINT SPECIFICATION	Date of Detection	250201
Job Order Number	JO25-M-00199-49	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
150	50	33.33

Nature of Defect:

EXCESS PRINT

Requirement:

There should be no excess print

Actual

Excess print on the glue tab area

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 checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
Date.: <u>250201</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Vertical	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Process / Method
		<input type="checkbox"/> Detaching	
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 Suteban mark hit during Diecut process. r nW2 Instillation of suteban near on the box dimension (within print tolerance). r nW3 No standard distance for the instillation of suteban in Eqos.



INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)

System / Training

Design / Toolings

Process / Material

FINAL CONCLUSION

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

WHO / WHEN

Process / Material

WHY 1: Conduct awareness orientation during Production Assembly

Production Leader // 2025-02-06

WHY 2: Establish Guidelines for the Standard Distance of Suteban Installation

Production Leader // 2025-03-14

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

B. Orientation

Date 2025-02-06 Time 08:14

Title Production Weekly Assembly Meeting

Attendees All Production

Prepared By:

Approved By:

GERALD DE GUZMAN | 250304

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: 2025-02-21	PIC: M.ASIS
Identified Rootcause No standard distance for the installation of suteban in EQOS.	Recommendation Establish Guidelines for the Standard Distance of Suteban Installation

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	2025-02-28	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO25-M-02456-33	250801	0	500
2nd Verification of Action	M.ASIS	2025-03-14	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO25-M-02696-42	250821	0	200
3rd Verification of Action	M.ASIS	2025-03-24	<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO25-M-02696-43	250901	0	350
Effectiveness of Action	M.ASIS	2025-03-24	<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO25-M-02921-34	251007	0	700
Remarks: The Option 1, inclusion of Suteban location to Mylar was not applicable according to sign.				5th	JO25-M-02921-41	251009	0	200

IV. CLOSURE

Status	Remarks
Still Open	Five consecutive running with no excess print issue detected. The corrective action is effective.
Approved by:	Process Owner Acknowledgment: (Receiving Section)
MICHAEL CASILLANO 251020 10:56 QA Head	N/A Top Management
Date: 25252525-10-20	Date: -
	N/A Line Leader
	N/A Department Head
	Date: -