



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.:

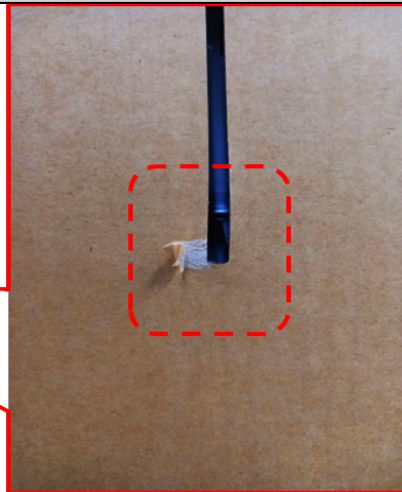
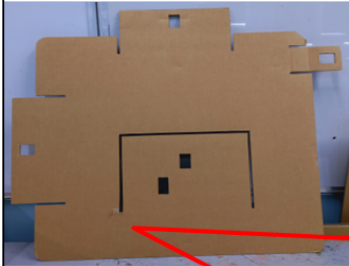
Date Issued

0055

250205

Customer	CANON BUSINESS MACHINE PHILS.	Attention To	REXEL ALMARIO
Item Code	RX1-6892-000	Department	PRODUCTION
Item Description	Z10_PARTITION_550FDR	Date of Detection	250201
Job Order Number	JO-F-25-30-2	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
400	10	2.50
Nature of Defect:		
PEEL OFF		
Requirement:		
Class A Maximum of 5mm diameter outside printer image and logo		
Actual		
Peel off on the slot area		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250201</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)
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 Uncut liner on the corner side of slot resulted to Peel Off. r nW2 Gap in the joint blade at the corner side. r nW3 There are trimmings get stuck in the die blade joint at the corner side.

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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 re layout of die blade to move the cutting blade joint from the corner side to the straight portion of slot to avoid stuck of trimmings.

Production Leaders Tooling //
2025-03-19

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)**A. Sorting Result**

	Location	Total Stock	NG	Total Good
RM	n/a	0	0	0
WIP	n/a	0	0	0
FG	n/a	0	0	0

C. Reworking

Rework Quantity	n/a
Total Good	0
Rework PPM (Good)	0

B. Orientation

Date	2025-04-10	Time	18:07
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: 2025-02-21	PIC: M.ASIS
Identified Rootcause Trimmings get stuck in the die-blade joint	Recommendation Re-layout of die blade

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-25-513-10	250502	0	580
2nd Verification of Action	M.ASIS	2025-05-02	[/] Yes [] No	2nd	JO-F-25-592-8	250522	0	400
3rd Verification of Action	M.ASIS	2025-06-11	[/] Yes [] No	3rd	JO-F-25-615-11	250523	0	400
Effectiveness of Action	M.ASIS	2025-06-27	[/] Yes [] No	4th	JO-F-25-663-2	250611	0	400
Remarks:				5th	JO-F-25-788-1	250627	0	950

IV. CLOSURE

Status	Remarks
Closed IRF	Five consecutive lots running with no related defect, corrective action was effective

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250718 03:49 QA Head	RHODORA MIRANDA 250730 08:17 Top Management	GERALD DE GUZMAN 250730 08:35 Line Leader	REXEL ALMARIO 251017 09:37 Department Head
Date: 25252525-07-18	Date: 25252525-07-30	Date: 25252525-07-30	Date: 25252525-10-17