

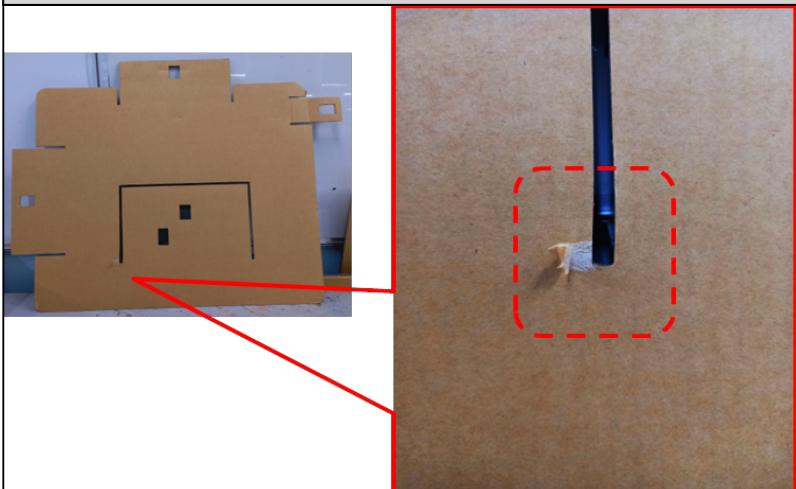
**KANE PACKAGE PHILIPPINE INC.**

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
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 %
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400	10	2.50
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## 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"/> Gluing <input type="checkbox"/> EQOS <input type="checkbox"/> Vertical <input checked="" type="checkbox"/> Diecut <input type="checkbox"/> Others <input type="checkbox"/> Detaching	<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.



## 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					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	2025-04-10
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: 2025-02-21	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	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO-F-25-513-10	250502	0	580
2nd Verification of Action	M.ASIS	2025-05-02	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO-F-25-592-8	250522	0	400
3rd Verification of Action	M.ASIS	2025-06-11	<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO-F-25-615-11	250523	0	400
Effectiveness of Action	M.ASIS	2025-06-27	<input type="checkbox"/> Yes <input type="checkbox"/> 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
Date: 25252525-07-18	Date: 25252525-07-30
GERALD DE GUZMAN   250730 08:35 Line Leader	REXEL ALMARIO   251017 09:37 Department Head
Date: 25252525-07-30	Date: 25252525-10-17