

**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
0056	250205

Customer	DENSO PHILIPPINES CORPORATION	Attention To	REXEL ALMARIO
Item Code	PH989702-0721	Department	PRODUCTION
Item Description	BOX	Date of Detection	250131
Job Order Number	JO25-M-00326-12	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
700	20	2.86

Nature of Defect:

WORN OUT

Requirement:

Worn out with maximum of 30mm is acceptable in Class B while 50mm is the maximum worn out in Class C

Actual

Worn out up to 130mm. Damaged liner.

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 The edges of the board hits the feeder gate of Eqos that caused Worn Out Peel Off. r nW2 The edges of the board are delaminated up to 3 5mm.



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: Eqos feeder conduct pre folding upon detection. (This action is temporarily since its effect on the productivity) PRODUCTION // 2025-03-31

WHY 2: Coordinate the issue to Supplier SunPack (C/O QA) QA //

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	2025-04-08	Time	05:11
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: 2025-02-27	PIC: M.ASIS
Identified Rootcause The edges of the board were delaminated up to 3-5mm.	Recommendation Coordinate the root cause to Supplier

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	2025-05-07	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO25-M-01490-58	250507	0	200
2nd Verification of Action	M.ASIS	2025-07-09	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO25-M-01671-38	250509	0	600
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO25-M-01711-13	250515	0	1200
Effectiveness of Action	M.ASIS	2025-05-19	<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO25-M-01826-1	250516	0	260
Remarks: Attached the Why-Why analysis of Supplier. 4M Change of ME, and Job Orders with raw materials from new supplier (no related defect).				5th	JO25-M-01818-7	250519	0	500

IV. CLOSURE

Status	Remarks
Closed IRF	5 consecutive lots running with no defects. Implemented corrective action is 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