

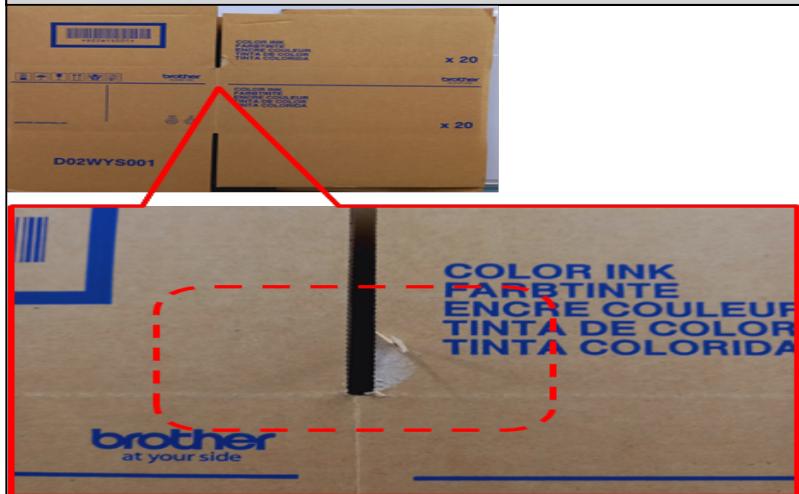
**KANE PACKAGE PHILIPPINE INC.**

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
0057	250218

Customer	BROTHER INDUSTRIES PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	D02WYS001	Department	PRODUCTION
Item Description	CARTON BK BTL21 (X20) PH	Date of Detection	250213
Job Order Number	JO25-M-00197-29	Section Detected	QA SCREENING

**ILLUSTRATION OF THE PROBLEM**

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
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500	20	4.00
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Nature of Defect:

PEEL OFF

Requirement:

NO PEEL OFF

Actual

WITH PEEL OFF UP TO 30MM

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"/> EQOS	<input type="checkbox"/> Dimension
Date.: <u>250213</u>	<input type="checkbox"/> For Rework	<input checked="" type="checkbox"/> Diecut	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
MA. ERIKA MAE ASIS   250218	CHARLENE JAN MARIE FLORES   250219	MICHAEL CASILLANO   250220	GERALD DE GUZMAN   250410

**I. INVESTIGATION / ANALYSIS****DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)****System / Training****Design / Toolings****Process / Material**

WHY 1 : Affected portion was peeled off during stripping.

WHY 2 : There is an uncut portion that wasn't fully cut during die cutting process.

WHY 3 : Cutting blade did not fully penetrate the affected area.

WHY 4 : Uneven die pressure due to inconsistent usage of backing tape and sponge ejector



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

System / Training

Design / Toolings

Process / Material

WHY 1 : NA

## FINAL CONCLUSION

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

WHO / WHEN

Process / Material

WHY 1: Back to zero layout

Tooling Custodian // 2025-04-15

WHY 2: STANDARDIZATION OF USING EJECTOR SPONGE AND BACKING TAPE

ME and Production IE // 2025-05-31

## 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	0
RM	na	0	0	0	Total Good	0
WIP	na	0	0	0		
FG	na	0	0	0	Rework PPM (Good)	0

B. Orientation

Date	2025-05-07	Time	09:29
Title	na		
Attendees	na		
Prepared By:			Approved By:
GERALD DE GUZMAN   250507			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:	PIC:
Identified Rootcause	Recommendation

**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			<input type="checkbox"/> Yes <input type="checkbox"/> No	1st				
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd				
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd				
Effectiveness of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	4th				
Remarks:				5th				

**IV. CLOSURE**

Status	Remarks			
Still Open	Attached the WI-PR-003-004 Guidelines in using Die cut Blade Ejector. No running of items for the past six months.			
Approved by:		Process Owner Acknowledgment: (Receiving Section)		
MICHAEL CASILLANO   260112 12:24 QA Head	N/A Top Management	N/A Line Leader	N/A Department Head	
Date: 26262626-01-12	Date: -	Date: -	Date: -	