

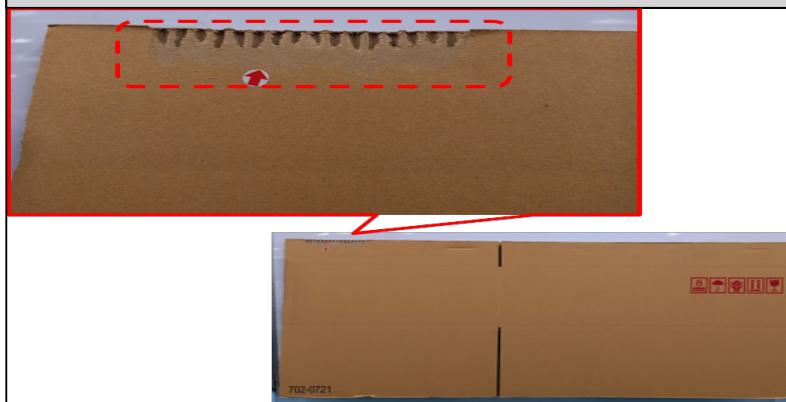
**KANE PACKAGE PHILIPPINE INC.**

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
0059	250220

Customer	DENSO PHILIPPINES CORPORATION	Attention To	REXEL ALMARIO
Item Code	PH989702-0721	Department	PRODUCTION
Item Description	BOX	Date of Detection	250213
Job Order Number	JO25-M-00433-59	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

Peel off up to 225mm by 30mm

ACTUAL: Peel off up to 225mm by 30mm
REQUIREMENT: No peel off

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)
LESTER JOHN DIOSO 250220	CHARLENE JAN MARIE FLORES 250225	MICHAEL CASILLANO 250226	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 : The liner surface of the board was hit on the feed gate of Eqos.

WHY 2 : Presence of excess liner and delamination in the edge of the boards.

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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 : na

FINAL CONCLUSION**CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)****WHO / WHEN****Process / Material**

Assign specific Supplier for this item (Packageworld). Based on checking and trial run using two
 WHY 1: different supplier (Packageworld and Sunpack) for this item it was found out that materials from
 Packageworld was no occurrence of peel off was observed.

MPD and Purchasing // 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	na
RM	na	0	0	0	Total Good	na
WIP	na	0	0	0		
FG	na	0	0	0	Rework PPM (Good)	na

B. Orientation			
Date	2025-05-19	Time	14:40
Title	na		
Attendees	na		

Prepared By:	Approved By:
GERALD DE GUZMAN 250519	REXEL ALMARIO 251017
	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 are delaminated up to 3-5mm	Recommendation N/A

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	2025-04-23	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO25-M-02120-23	250618	0	600
2nd Verification of Action	M.ASIS	2025-04-29	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO25-M-02120-24	250627	0	600
3rd Verification of Action	M.ASIS	2025-06-16	<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO25-M-02323-34	250701	0	370
Effectiveness of Action	M.ASIS	2025-06-17	<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO25-M-02323-35	250705	0	1000

Remarks: This issue was common to CAR-264 PEEL OFF. The corrective action according to production was to change the supplier.

The trial run conducted last May 2025 and implemented in June 2025.

Attached the CAR-264 PEEL OFF, LA-0169 Why-Why_Report - SUNPACK, ME-4M-25-0032 (SDP AND EPSON) CHANGE SUPPLIER FROM SUNPACK TO PW, PH98-0721_JO_PACKAGEWORLD.

IV. CLOSURE

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