

**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
0062	250222

Customer	EPSON PRECISION PHILS. INC.- ASP/EPLB	Attention To	REXEL ALMARIO
Item Code	511593800	Department	PRODUCTION
Item Description	OUTER CARTON BOX	Date of Detection	250218
Job Order Number	JO25-M-00652-4	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

ACTUAL: With torn up to 20mm-25mm
REQUIREMENT: Acceptable up to 5mm

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1200	20	1.67

Nature of Defect:

TORN

Requirement:

Acceptable up to 5mm

Actual

With torn up to 20mm-25mm

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250218</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 type="checkbox"/> Diecut <input type="checkbox"/> Detaching	<input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input checked="" type="checkbox"/> Others <u>HANDLING</u>
Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO 250222	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**

WHY 1 : DUE TO CROWDED AREA

WHY 2 : DURING TRANSPORTATION THE ITEM COLLIDED WITH AN OBJECT

WHY 3 : INSUFFICIENT PROTECTION ON THE EDGES OF THE ITEM

Design / Toolings**Process / Material**



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

System / Training

WHY 1 : n/a

Design / Toolings

Process / Material

FINAL CONCLUSION

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

WHO / WHEN

System / Training

WHY 1: PUTTING ADDITIONAL PROTECTION (SCRAP) FOR BIG SHEETS

Production Leaders // 2025-03-27

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	2025-03-27			Time	08:15			
Title	Production Assembly							
Attendees	production operators							
Prepared By:				Approved By:				
GERALD DE GUZMAN 250428				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			
Approved by:		Process Owner Acknowledgment: (Receiving Section)	
N/A QA Head	N/A Top Management	N/A Line Leader	N/A Department Head
Date: -	Date: -	Date: -	Date: -