

**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
0094	250630

Customer	BROTHER INDUSTRIES PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	D028GY001	Department	PRODUCTION
Item Description	CARTON TN FCL X4	Date of Detection	250623
Job Order Number	JO25-M-01987-133	Section Detected	QA SCREENING 3

ILLUSTRATION OF THE PROBLEM

		Lot Quantity (pcs)	Reject Qty (pcs)	Reject %	
		1450	25	1.72	
Nature of Defect:		PEEL OFF			
Requirement:		PEEL OFF NOT ACCEPTABLE			
Actual		WITH PEEL OFF UP TO 100MM			

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>250623</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input checked="" type="checkbox"/> Detaching	<input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
MA. ERIKA MAE ASIS 250630	CHARLENE JAN MARIE FLORES 250701	MICHAEL CASILLANO 250702	GERALD DE GUZMAN 250709

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

WHY 1 : The liner peeled off during curing process at conveyor

WHY 2 : The liner stucked on the conveyor belt.

WHY 3 : Presence of excess glue on the glue tab

WHY 4 : Over application of glue.



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: Reorientation to operators on the proper application of glue and immediately wipe out excess glue using provided rags Production // 2025-07-17

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	0
WIP	NA	0	0	0		
FG	NA	0	0	0	Rework PPM (Good)	0

B. Orientation				
Date	2025-07-17		Time	17:01
Title	Reorientation to operators on the proper application of glue and immediately wipe out excess glue using provided rags.			
Attendees	Gluing operators			
Prepared By:			Approved By:	
GERALD DE GUZMAN 250717			N/A	
			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: -