

**KANEPACKAGE 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)

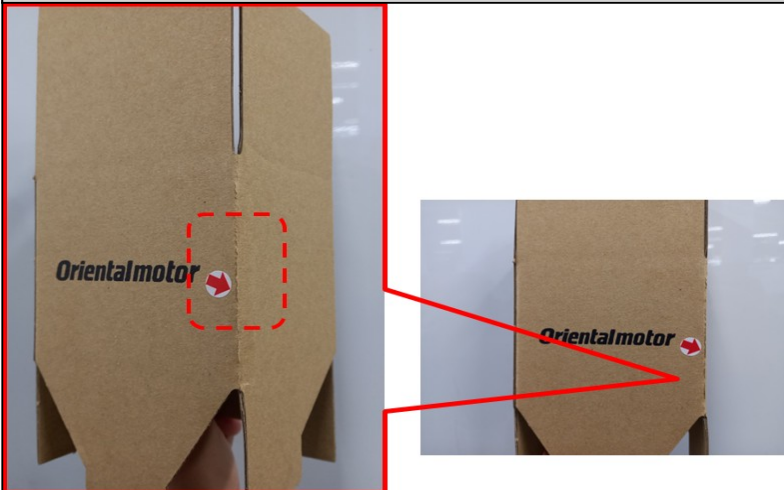
Control No.:

Date Issued

0113

251007

Customer	SUPERFLEX LOGISTICS, INC	Attention To	REXEL ALMARIO
Item Code	PKC404B-B	Department	PRODUCTION
Item Description	MOTOR INNER BOX	Date of Detection	251003
Job Order Number	JO25-M-03123-5	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1800	40	2.22
Nature of Defect:		
BURSTING		
Requirement:		
NO BURSTING		
Actual		
WITH BURSTING UP TO 65MM		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>251003</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 checked="" type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
MA. ERIKA MAE ASIS 251007	CHARLENE JAN MARIE FLORES 251007	MICHAEL CASILLANO 251013	GERALD DE GUZMAN 251013

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

WHY 1 : Uneven ejector pressure during the die cutting process

WHY 2 : Different hardness levels of ejector sponges were used in the same dieblade setup.

WHY 3 : The standard usage of the ejector sponge has not yet been implemented for this item due to r nthe old die blade. In addition old blade was not updated or relayouted during improvement r nactivity.

Design / Toolings**Process / Material**

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INVESTIGATION REPORT FORM (IRF)**INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)****System / Training**

WHY 1 : na

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

WHY 1: Replacement of ejector sponge from multiple type of r nejector to one type

Tooling // 2025-10-15

WHY 2: Horizontal implementation on proper usage of ejector r nsponge. Ongoing relayouting of dieblade with old and r nmultiple sponge. Started last Oct. 6 2025.

Tooling // 2025-11-30

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	Rework PPM (Good)	NA
FG	na	0	0	0		

B. Orientation

Date	2025-11-03	Time	14:52
Title	na		
Attendees	na		

Prepared By:**Approved By:**

GERALD DE GUZMAN | 251103

REXEL ALMARIO | 260427

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			[] Yes [] No	1st				
2nd Verification of Action			[] Yes [] No	2nd				
3rd Verification of Action			[] Yes [] No	3rd				
Effectiveness of Action			[] Yes [] No	4th				
Remarks:				5th				

IV. CLOSURE

Status	Remarks
Still Open	

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
N/A	N/A	N/A	N/A
QA Head	Top Management	Line Leader	Department Head
Date: -	Date: -	Date: -	Date: -