

**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 the old die blade. In addition old blade was not updated or relayouted during improvement activity.

Design / Toolings**Process / Material**



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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		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			[] 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: -