

**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)

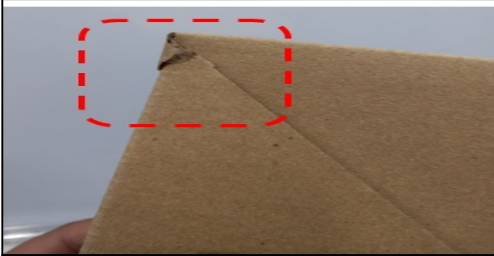
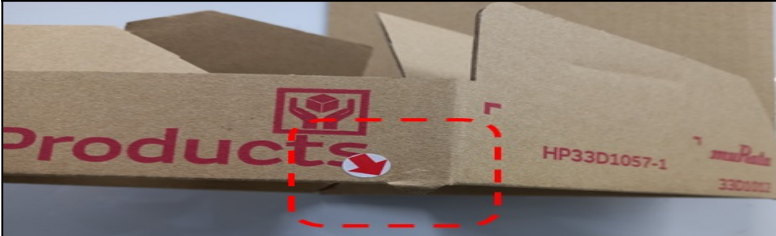
Control No.:

Date Issued

0114

251007

Customer	KOWA-EMORI PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	HP33D1057-1	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	251003
Job Order Number	JO25-M-03055-43	Section Detected	QA SCREENING 4

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2000	36	1.80

Nature of Defect:

TEAR OFF

Requirement:

ACCEPTABLE TEAR OFF UP TO 3MM. NO TORN LINER/CM

Actual

WITH TEAR OFF UP TO 10MM

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****Design / Toolings****Process / Material**

WHY 1 : Tear off occurred during folding of the item.

WHY 2 : The part with tear off has shallow creasing which exerted more pressure during folding.

WHY 3 : The creasing matrix installed was short.

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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 : Replacement of affected creasing matrix.

WHY 2 : Set standard that the dimension of creasing matrix to be r ninstalled will be equal to the dimension of creasing blade.

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

WHY 1: Replacement of affected creasing matrix.

Eterna Operator // 2025-10-10

WHY 2: Set standard that the dimension of creasing matrix to be r ninstalled will be equal to the dimension of creasing blade.

Prod. IE // 2025-11-15

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	14:56
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: -