		GE PHILIPPINE INC. La Mesa, Calamba City, Laguna	I	NVESTIGA ⁻	TION R	EPORT	FORM (IRF)
Te	elephone No. (049) 545-7166 t			Inhouse Detection		Custor	mer Claim
Fa	x No. (049) 545-6302		Conf	rol No.: 606		Date Issued:	22 07 28
Customer		SUPERFLEX	Atter	ntion To	Gei	ald De Guzman	& Roderick Ramos
Item Code		LOKD92001-2146	Depa	artment		PRODUCT	TION & QA
Item Description		LOWER F PART 8	Date	of Detection		22 0	7 27
Job Order Number	•	JO22-M-1624-9	Sect	ion Detected		CUST	OMER
	ILLUSTRATION O	F THE PROBLEM		Major		Minor	
				Lot Quantity (pcs.)	Reject Qu	antity (pcs.)	Reject Percentage
			Carrie	1,100	1	100	100.00%
			Natu	re of Defect:		\$\$417 T.	41516167 N 1933
	a judan ibahaha	3 4 5			OFF S	SPECS	
2	3 4 5 6 7	8 9 10 11 2	Req	uirement:			
					115mm x 40	0mm x 40mm	
			Actu	al:			Andreas services
					105mm x 40	0mm x 40mm	
NO, OF	OCCURRENCE	DISPOSITION	919	AREA OF OCCU	RRENCE / OR	IGIN	CONTENT
First		Hold		Slotter	Gluing	9	Material
Recurrenc	e	Special Acceptance		EQOS	Vertic	al	Dimension
No.:		For Rework		Diecut	Other	s:	Appearance
Date:		Reject / Disposal		Detaching			Process / Method
ls	ssued by	Checked by		Approved by			Received by (Receiving Section)
	le/E rangelista	Roderick Ramos QA Sr. Supervisor	\$.	Rexel Almario QA Asst. Manag			erald De Guzman lead/ Supervisor
		I. INVESTIGAT	ION //	ANALYSIS			
DIRECT C	AUSE: (Analyze the reaso	on of occurrence, why it happened?)			(Analyze the re	eason of occurr	ence, why it leaked?)
Why 1:			Why	1:			
System / Training Myh 4:	See attacl	red	Why :				
E Why 4:			Why 4				
Why 5:			Why				
Why 1:			Why				
			Why :				
SB Why 2: Why 3: Why 4:	See attac	cheed	Why:				
UBI SE Why 4:	301 3011010	<i>3.</i> 144	Why				
Why 5:			Why s				
Why 1:			Why				
Why 2:	See attach		Why 2				
Why 2: Why 3: Why 4:	our whach	ea	Why:				
CONTROL CONTRO			Why 4	4:			
Why 5:			Why !	5:			

KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna

÷ * ', '

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)

			The second secon	400000000000000000000000000000000000000		
			FINAL CON	ICLUSION		
C	OCCURRENCE ROOTCAUSE	E			OUTFLOW ROOTCAUSE	
IMAGES ATE A STICLE				COPPECTIVE AC	OTION: (Astionale to don't	on will not be a section
	ction to be done to contain/ tempore	ary correct the probl	em tound)		CTION: (Actions to be done to ensure that the proble	Who / When
A. Sorting Result	ation Total Stock	NG	Total Good	Action	is to be done to eliminate recurrence	Willo / Wileit
RM	ation Total Stock	110	Total Good			
WIP				System		
FG						
B. Orientation						
Date	Time			Design /		
Title				Tools		
Attendees						
C. Reworking						
Rework Quantity				Dragon		
Total Good				Process		
Rework Percentage (Good)						
II. QA ROOTCAUSE \	VERIFICATION (To be filled	out by QA In-cl	harge)	Date Conducted:	PIC:	
	Identified Rootcause				Recommendation	
DIFFE ATOR 1010	NOT FOLLOW H	le VRacou	W.	Vie-040VI	1770V OF WI	
	11 (0(0):1:1:1					14 419 2 3 5 H 5 8
				ON (To be filled out	A CONTRACTOR OF THE PROPERTY OF THE PARTY OF	
	Checked by	Date		ON (To be filled out	Remarks	
1st Verification of Action					A CONTRACTOR OF THE PROPERTY OF THE PARTY OF	
1st Verification of Action	Checked by	Date	Implen	nented?	Remarks	
1st Verification of Action 2nd Verification of Action	Checked by	Date	Implen	nented?	Remarks	
	Checked by	Date	Implem	nented?	Remarks	
	Checked by	Date	Implem	nented?	Remarks	
2nd Verification of Action	Checked by	Date	Implem [] Yes	[] No	Remarks	
2nd Verification of Action	Checked by	Date	Implem [] Yes	[] No	Remarks	
2nd Verification of Action 3rd Verification of Action Effectiveness of Action	Checked by K. PURMINIP	Date ALOPO 6	Implem [] Yes [] Yes [] Yes	[] No [] No [] No	Remarks	within 5 consecutive
2nd Verification of Action 3rd Verification of Action Effectiveness of Action Note: If no same defects /	Checked by K. PURMISSIP	Date ADOOU	Implem [] Yes [] Yes [] Yes [] Yes	[] No [] No [] No [] No	Remarks	within 5 consecutive vement action.
2nd Verification of Action 3rd Verification of Action Effectiveness of Action Note: If no same defects /	Checked by K. PURMISSIP	Date ADOOU	Implem [] Yes [] Yes [] Yes [] Yes	[] No tion is considered efferable be re-issued to the	Remarks W/A ective / closed. If the same problem occurs of	within 5 consecutive vement action.
2nd Verification of Action 3rd Verification of Action Effectiveness of Action Note: If no same defects /	Checked by K. PURMISSIP	Date ADOOU	Implem [] Yes [] Yes [] Yes [] Yes corrective acation Report st	[] No tion is considered efferable be re-issued to the	Remarks W/A ective / closed. If the same problem occurs of	vement action.
2nd Verification of Action 3rd Verification of Action Effectiveness of Action Note: If no same defects / deliveries or 3rd verification	Checked by K. PARM BASTP problems occurs for 5 consecution of action still not yet implem SURANCE DEPAR	Date ADOOU	Implem [] Yes [] Orrective acception Report sites approached by the content of the con	[] No tion is considered efferable re-issued to the possible seed by:	Remarks W/A ective / closed. If the same problem occurs to affected department to provide new impro	vement action.
2nd Verification of Action 3rd Verification of Action Effectiveness of Action Note: If no same defects / deliveries or 3rd verificatio QUALITY AS Statements	Checked by V. QUANTESSIP problems occurs for 5 consecution of action still not yet implem SURANCE DEPAR Remarks	Date ADOOU	Implem [] Yes IV. GLO Appro	[] No tion is considered efferable re-issued to the possible seed by:	Remarks W/A ective / closed. If the same problem occurs of the eaffected department to provide new impro	vement action.
2nd Verification of Action 3rd Verification of Action Effectiveness of Action Note: If no same defects / deliveries or 3rd verificatio QUALITY AS Statements	Checked by K. PANISAM problems occurs for 5 consects of action still not yet implem SURANCE DEPAR Remarks	Date ADOPO 6 Cutive deliveries, nented, Investige	Implem [] Yes IV. GLO Appro	[] No tion is considered efferable be re-issued to the posure ved by:	Remarks W/A ective / closed. If the same problem occurs of the eaffected department to provide new impro	nt: (Receiving Section) Department Head

1100



QTY:

Kanepackage Philippine Inc.

DELIVERY DATE:

2022-07-29

MEMO: - None -

PR-001-F12-REV.00

JOB ORDER

CREATED BY:

Dario, Engleberth Nunez

Chavez, Michelle Realeza SO #: SO22-M-01624

DATE RELEASED:

2022-07-26

Customer: SUPERFLEX LOGISTICS, INC..

ITEM CODE: LOKD92001-2146-8

Netsuite Itemcode: LOKD92001-2146-8

Item Description: CUSHION LOWER F PART 8

Q 10 7/2

Tooling Reference #		Cont	rol/Batch #:			_	RM Issued B	1: Orman	
DD00500/11/01/11/5		IN-CH	ARGE	GOOD	TRI	AL	REJECT	ED QTY	
PROCESS / MACHINE	DATE	Operator	ME/QA	QTY	RL	IN	INHOUSE	SUPPLIER	REMARKS
1. SLICING	7/28	850		5	G	R			
2. VERTICAL	7/29	SHE		1190	G	R			Λ
3. LOT NUMBERING	7.29		100	mo	G.	R			
4. PRODUCTION PACKING	+20	Chall		1100	G	R			
5.	07-29		DACILLO	1160	G	R		_	CLOSE
6.					G	R			
7.					G	R			
8.									
9.									
10.									

Customer Claim:

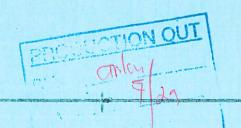
CUSTOMER
ITEM CODE
ITEM DESCRIPTION: CUSHION LOWER F PART 8
Lot NO.

QUANTITY

CUSTOMER
ITEM CODE
ILOK D92001-2146
RoHS OK
RO

REMARKS

PROD PLAN: ADD #4 PLAN 2022-210





INVESTIGATION REPORT FOR OFF SPECS OF SUPERFLEX LOKD92001-2146 LOWER F PART 8

DIRECT CAUSE	W1	The operator overlooked the measurement and dimensions required during setup.
PROCESS/MATERIAL	W2	Upon checking of the attached measurement guide in vertical machine, it was found out that the guide markings are already faded.



The markings on the installed measurement guide was already faded or pale.

INDIRECT
CAUSE
(OUTFLOW)
PROCESS/MATERIAL

\A/1

Operator did not conduct double checking using the issued meter tape during trial run and in-between mass production.

PRODUCTION CORRECTIVE ACTION

1. Alert th	e vertical operators regarding this	issue.	
2. Replace	ement of the measurement guide.		
PIC:	PRODUCTION	TARGET DATE:	220806
PIC:	PRODUCTION	TANGET DATE.	22000

PREPARED BY:

MEL ABE

PROD. IE STAFF

APPROVED BY:

YERWALV APALLA ASST. MANAGER

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	H
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Month and Year

Machine

ME INC.			DAILY MACHINE CHECKLIST (DMC)		Σ	AC	天	Z	O	岦	2	로	2		2	0													
																DAY													
to Check	1	2	2 3 4 5	4		9	7 8	80	6	10	=	12	5	#	15	31	12	18	13	20 2	21 22	2 23	24	25	26	27	28	23	30
iring Visual																	\dashv		\dashv	\dashv	-	-							
J Sioble Glace																		_		_							_		

DAY	\$ 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30														
SULPHINE STATES									_	-	7				_
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	14												1		
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	+														
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Hanny Chark	nos to casta	Hearing Visual	Visual / Sight Glass	Visual	Wisual	Visual	Hearing Visual	Functional Test	Visual	Visual	Use Calibrated Meter Tape	Visual	Visual	Hearing Wisual	Visual
The same of the same	יים כווהכא מיים ביותר היים ביותר	Sound & Wibration	Level	Tension Wear & Tear	Free from oil, stain and dirt	Sharpness Wear & Tear	Leak Wear & Tear	Operation	Damaged Insulation	Mounting Fixation	Slitter Big: 69mm Slitter Small: 36mm	Sticker Control	Dust, Dirt, Unnecessary items	Sound & Vibration	Appearance
	Palameter	Į.	ar Oil / Hydraulio	ler Chain & V.	٠	de & Holder	re & Connector	sh Button & Foot	d Cable / Wire	ety Cover &	e Guide Actual asurement	chine Speed (0RPM)	ohine Cleaning	ve Gear of Glue Micator	asurement Scale

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ual Time Checked																											
nature												STATE OF TAXABLE PARTY.															_
ervisor / Line Leader																								-			
ual Time Checked																											-
nature								1															\dashv			\dashv	
Legend: ✓ = Operational I Inspected OK	nspe	scted	¥		= ×	X = Not Operational / Defective	berat	ional	l Def	ectiv	g)		NA	= Pa	гате	ter is	s not	NA = Parameter is not applicable	cabl	a)		Z	= ≥	NW = No Work	/ork		

te: Production speal obsidition of the machine and update the Daily Machine Checklist if proposity performed by operator. Checklist she done at ROBin the modning.
Pagesusor, Assat, Supervisor and/or Line Leader Shall Neophine Shall be recorded by operator. Checklist if proposity performed by operator. Checklist shall be machine until it has been repoired and corrected by the machine shall be recorded on Machine.
Parameterist found describe and one proposition and/or to the Line Leader. Do not operate the machine until it has been repoired by the Engineering maintenance. Peparis done on the machine shall be recorded on Machine.

No Te		SE PHILIPPINE INC. a Mesa, Calamba City, Laguna o 69	INVESTIGATION Inhouse Detection	TION RE	-	FORM (IRF)			
. 10	x No. (013) 313 0302		Control No.: 606	I	Date Issued:	22 07 28			
Customer		SUPERFLEX	Attention To	Gera	ld De Guzman	& Roderick Ramos			
Item Code		LOKD92001-2146	Department		PRODUCT	ION & QA			
Item Description		LOWER F PART 8	Date of Detection		22 0	7 27			
Job Order Number		JO22-M-1624-9	Section Detected		CUST	OMER			
	ILLUSTRATION O	F THE PROBLEM	Major		Minor				
			Lot Quantity (pcs.) 1,100 Nature of Defect:	Reject Qua		Reject Percentage 100.00%			
	3 4 5 6 7	8 9 101 2	Requirement:	OFF SI	PECS				
			requirement.	115mm x 40r	mm x 40mm				
The second second			Actual:	105mm x 40i	mm x 40mm				
NO. OF	OCCURRENCE	DISPOSITION	AREA OF OCCU	RRENCE / ORIG	GIN	CONTENT			
First		Hold	Slotter	Gluing		Material			
Recurrence	e	Special Acceptance	EQOS	Vertica	ıl	Dimension			
No.:		For Rework	Diecut	Others	6	Appearance			
Date:		Reject / Disposal	Detaching			Process / Method			
	ssued by	Checked by	Approved by	1		Received by (Receiving Section)			
	lld Evangelista A-II Staff	Roderick Ramos QA Sr. Supervisor	Rexel Almari QA Asst. Mana			erald De Guzman Head/ Supervisor			
		I. INVESTIGA	TION / ANALYSIS						
DIRECT C	CAUSE: (Analyze the reason	on of occurrence, why it happened?)	INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)						
Why 1:			Why 1: QA Inspector overlooked the OFF specs,						
System / Training Myh 3: Why 4:			Why 1: QA Inspector oterlooked the OFF specs, Why 2: QA Inspector microad the measurement on the Why 3: meter tape.						
Why 3:			Why 3:						
Why 4:			Why 4:						
Why 5:			Why 5:						
Why 1:			Why 1:						
) <u>드</u> Why 2:			Why 2:						
SD UIIOO Why 2: Why 3: Why 4:			Why 3:						
UB Why 4:			Why 4:						
Why 5:			Why 5:						
Why 1:			Why 1:						
			Why 2:						
My 2:									
Why 2: Why 3: Why 4:			Why 3:						
ပို့ Why 4:			Why 4:						

No. 5 F Teleph

Effectiveness of Action

KANEPACKAGE PHILIPPINE INC.

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)

			FINAL CON	CLUSION						
oc	CURRENCE ROOTCAUSE				OUTFLOW ROOTCAUSE					
					respector did not follow the standard					
All controls of the second	ion to be done to contain/ temporar	y correct the prob	lem found)	CORRECT	TVE ACTION: (Actions to be done to ensure that the problem will not he	Who / When				
A. Sorting Result		No.	T-1-1 C		Actions to be done to eliminate recurrence	vviio / vviien				
Locat	ion Total Stock	NG	Total Good							
RM				System						
WIP										
FG										
B. Orientation										
Date	Time									
Title										
Attendees	Hestoria de Maria do Arias	ALCOHOLD STATE								
C. Reworking				Process	1. Issuance of NTE 2. generation of Quality Mest to be DA/ discuss on the daily Quality 220802					
Rework Quantity										
Total Good					meeting	330,805				
Rework Percentage (Good)		out by OA In a	(harra)	Date Conduc	201 202 201 15					
II. QA ROOTCAUSE V	ERIFICATION (To be filled of light l	out by WA III-c	marge)	Date Conduc	Recommendation					
QA Inspector	did not follow occubre.	he			the - orientation of stendard proudle	re.				
standara f.										
	III. CORRE	ECTIVE ACTIO	N VERIFICAT	ION (To be fil	led out by QA In-charge)					
	Checked by	Date	Implen	nented?	Remarks					
1st Verification of Action	DA 15	27 1803	[/] Yes	[] No	N/A					
2nd Verification of Action			[]Yes	[] No						
3rd Verification of Action			[] Yes	[] No						

Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improvement action.

[] No

[]Yes

SOUNITY	ACCUDAN	OF DEDAR	CASCAST	IV. CLC	OSURE				
Tatus:	NOOD KAN IN	WE DEPAR	INFINI	Appro	ved by:	Process Owner Acknowledgment: (Receiving Section)			
till Ope	O C	SE	Date:	\ Supervisor	QA Asst. Manager Date:	Line Leader Date:	Department Head Date:		
AND	and the	<u> </u>							



Kanepackage Philippine Inc.

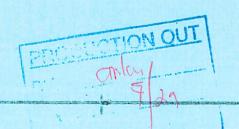
MEMO: - None -

PR-001-F12-REV.00

Chavez, Michelle Realeza

N		SO # : SO22-M-01624											
Customer: SUPERFLEX LOGISTICS, INC JOB ORDER:													
ITEM CODE: LOKE	92001	-2146-8	3				JO22-M	-016	24.0	回源的			
Netsuite Itemcode : LOKD92001-2: Item Description : CUSH		RFPART	8				JUZZ-IVI	-010	24-5				
OTY:		VERY DAT		CREATE	DBY:			DA.	TE RELEAS	ED:			
1100		2022-07-2	9	Dario, Engl	eberth N	unez			2022-07-2	26			
	Chu To Over Cut												
Raw Material Code:	Q Be	ty To Ove Used: Run				ctual sued		DR#:	SUPI	PLIER:			
PP45 6 40X115X40MM 5 2038 64													
Tooling Reference #		Con	trol/Batch #:				DM loss	and D	. Donard	7/2			
rooming reference #													
PROCESS / MACHINE	DATE	Operator	ME/QA	GOOD	TRIA		REJECTED QTY INHOUSE SUPPLIE			REMARKS			
	71	Operator	III III III III III III III III III II	Q11	Itor	•	INHOUSE SUPPLIER		OOI I LILK				
1. SLICING	7/28	850		5	G	R							
2. VERTICAL	7/29	SHE		1100	G	R			_	^			
3. LOT NUMBERING	7.29		100	MO	G.	R							
4. PRODUCTION PACKING	+20	Mayo		1100	G	R							
5.	07-29		DACILLO	1160	G	R			_	CLOSE			
6.					G	R							
7.					G	R							
8.													
9.													
10.													
				CANED	ACK	16	F PH	11.15	PPINE, I	NC			
Customer Claim:		CUSTO		. /			GISTIC			140.			
Notace		ITEM (CODE	:-LØK	D9200	1-2	21/46 POHS OK						
Notes:			DESCRIPT							' L			
		Lot NO		11	729-JC pcs.)22	-M-016	24-	9	QA-CG884 MP			
REMARKS			A ===										

PROD PLAN: ADD #4 PLAN 2022-210





\(\frac{1}{2} \)	"		()			DATE	5000		202	6,0	228	Les	v 8	20802	10	7.0.5	700	20.	8	6 RFV 01
Received by	1					/O	28-28-10-10-10-10-10-10-10-10-10-10-10-10-10-	100000	720837	720802	22082	220802	20802	220	ROCE	7.0807.7	100000	208021	200 002 200 002	OA-007-F16 REV.01
Approved by	Man 22080	Koderick Kamus		Y 1,100 pcs.	RY OFF SPECS	SIGNATURE				A TOP OF THE PARTY		1		- The state of the	0					,
Checked by		Nico Orlanda/ Pamela Filipinas	AFFECTED GOAN	DEFECT QUANTITY	DEFECT CATEGORY	EMPLOYEE NAME		Marin Par	HIStory Blan	Z	-	MATTHEN	7 - 12 P	Marie for mosp			20	THOU SOUTH	ASS	
Prepared by		Roche/fe/Eyangelista	20	JO22-M-01624-9	OMER			N N		1 1 2	-7	MARK	Mark	W	4		1			A
Date Prepared	22 08 02		ED 22 08 02		CUSTOMER															
	j <mark> </mark>		DATE ENCOUNTERED	AFFECTED LOT NO.	DETECTED BY	NO	A September	101 2			1		EEE						m x 40mm	
	OUALITY ALERT		SUPERFLEX	LOKD92001-2146	LOWER F PART 8	NO GOOD ILLUSTRATION	Indestrate and Company of the Compan	2 3 4 6 6 7 8 9					Actual: 105mm x 40mm x 40mm	GOOD ILLUSTRATION		(115)			Requirement: 115mm x 40mm x 40mm	
	10	5	CUSTOMER	PART NO.	PART NAME			-												



KANEPACKAGE PHILIPPINE INC.

		M	INUTES OF T		TING							
Date:	220810	, Time Start:	10:15Am	Time Finished: _	10:22	Am	Venue:	PRODUCTION 200 From				
ATTENDEES:												
Name		Dept.	Sign	Nam	ie	De	ot.	Sign				
SHERWIN MU	Na Banan	PROP.	Av					•				
KOSEMMUE	buncamiu	pol	J=-			,						
	Mabalot	pnd.	ort.			,		5				
	Doodlesp	Pivel	21									
Josephing	Murtillan		Cui									
SECUNDO BU	7.11	Phop	Jan									
				No.								

AGENDA:		ORTENT	ATION REGARI	ING OF	F SPECS	S OF S	SUPER	FLEX				
		Olfgela.	LOKD92001-2									
MINUTES:								page _ l _ of _ l _				
DIRECT CAUSED:	The operator of measurement	verlooked the guide in verti	e measurement and dim cal machine, it was four	ensions requ nd out that th	ired during e guide ma	setup. U rkings ar	pon check e already	ring of the attached faded.				
			5									
INDIRECT CAUSE:	Operator did n production.	ot conduct do	puble checking using the	e issued mete	r tape durir	ıg trial ru	ın and in-	between mass				
	1. Replacemen	t of the mea	surement guide. (TD: Do	one)								
CORRECTIVE ACTION:	2. Inclusion of measurement guide checking to DMC. (TD: 220817)											
ACIZONI	3. Orientation/	reminder of t	the correct/proper proce	dure.								
0	> Trial	run & sampli	ng must be double chec	k using the is	sued meter	tape.		10				
	> Must	be conduct s	ampling checking on fire	st, middle & l	ast of mass	product	ion.					
		during packi sued meter t	ng & bundling the assigi ape.	n operator m	ust be cond	uct samp	oling chec	king of dimension				
		,										
FOLLOW UP N	TEETING:											
(date & time)												
for KPPI fill up o	only						**************************************					
Prepared by:			Reviewed by:		Λ	oted by:		*				
Genses DE	602man				THE STREET STREET	THE ACTION AND THE	ning of the Street					