

**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
0043	250104

Customer	KOYAMA TRADING PHIL., INC.	Attention To	REXEL ALMARIO
Item Code	PKC505B-B	Department	PRODUCTION
Item Description	INNER BOX	Date of Detection	241221
Job Order Number	JO24-M-02398-8	Section Detected	QA SCREENING 2

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2000	100	5.00

Nature of Defect:

POOR PRINT

Requirement:

NO POOR PRINT

Actual

WITH POOR PRINT

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> <u>Date.: 241221</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 checked="" type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching	<input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others
Issued by	Checked by	Approved by	Received by (Receiving Section)
ERIKA ASIS 250104	CHARLENE JAN MARIE FLORES 250106	MICHAEL CASILLANO 250106	GERALD DE GUZMAN 250113

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

WHY 1 : W1 Uneven distribution of ink in the item r nW2 There is blockage/clogging of anilox r nW3 Foreign materials stick in the anilox and flexo plate.



INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)

System / Training

Design / Toolings

Process / Material

FINAL CONCLUSION

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

WHO / WHEN

Process / Material

WHY 1: Conducted cleaning of cyrel and anilox upon detection.

Eqos Operator // 2024-12-20

WHY 2: Provision of rubber dust remover.

Production Leader // 2025-02-21

WHY 3: Set cleaning frequency using the rubber dust remover. (after the trial of effectiveness)

Production IE // 2025-02-28

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	n/a
RM	n/a	0	0	0	Total Good	0
WIP	n/a	0	0	0		
FG	n/a	0	00	0	Rework PPM (Good)	0

B. Orientation

Date 2025-02-28 Time 13:37

Title n/a

Attendees n/a

Prepared By:

Approved By:

GERALD DE GUZMAN | 250304

REXEL ALMARIO | 250507

Department Head

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INVESTIGATION REPORT FORM (IRF)**II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)**

Date Conducted: 2025-01-04	PIC: M.ASIS
Identified Rootcause Foreign materials stick in the anilox and flexo plate.	Recommendation N/A

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	M.ASIS	2025-02-28	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO25-M-01530-8	250428	1700	0
2nd Verification of Action	M.ASIS	2025-04-14	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO25-M-01787-4	250521	1500	0
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO25-M-01928-4	250524	1200	0
Effectiveness of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	4th	JO25-M-02047-6	250603	1000	0
Remarks: Trial resulted in using all single-color item with single mylar in printing unit 2 and rubber dust remover should place in printing unit 1. No cleaning frequency established.				5th	JO25-M-02199-7	250620	500	0

IV. CLOSURE

Status	Remarks
Closed IRF	5 consecutive lots running with no defects. Implemented corrective action is effective
Approved by:	Process Owner Acknowledgment: (Receiving Section)
MICHAEL CASILLANO 250702 04:11 QA Head	RHODORA MIRANDA 250703 08:00 Top Management
Date: 25252525-07-02	Date: 25252525-07-03
GERALD DE GUZMAN 250704 11:41 Line Leader	REXEL ALMARIO 251017 09:41 Department Head
Date: 25252525-07-04	Date: 25252525-10-17