

**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

0045

250107

Customer SANYO DENKI PHILS INC.

Attention To REXEL ALMARIO

Item Code 00912906-01

Department PRODUCTION

Item Description PACKAGE

Date of Detection 250103

Job Order Number JO24-M-02341-12

Section Detected QA SCREENING

ILLUSTRATION OF THE PROBLEM

ACTUAL: With
smeared print
REQUIREMENT:
No smeared print

Lot Quantity (pcs)

Reject Qty (pcs)

Reject %

800

40

5.00

Nature of Defect:

SMEARED PRINT

Requirement:

No smeared print

Actual

With smeared print

NO. OF OCCURENCE**DISPOSITION****AREA OF OCCURENCE / ORIGIN****CONTENT**

☒ First
☐ Recurrence No.: 1
Date.: 250103

☐ Hold
☐ Special Acceptance
☐ For Rework
☒ Reject / Disposal

☐ Slotter
☒ EQOS
☐ Diecut
☐ Detaching
☐ Gluing
☐ Vertical
☐ Others

☐ Material
☐ Dimension
☐ Appearance
☒ Process / Method

Issued by

Checked by

Approved by

Received by (Receiving Section)

LESTER JOHN DIOSO | 250107

CHARLENE JAN MARIE FLORES | 250111

MICHAEL CASILLANO | 250113

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 INK SPREAD FURTHER ON THE PRINTED AREA r nW2 ACCUMULATION OF INK ON THE EDGES OF FLEXO PLATE r nW3 DUE TO OVER PRINT IMPRESSION (ADJUSTMENT UPON TRIAL RUN)



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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 : N/A

FINAL CONCLUSION

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

WHO / WHEN

Process / Material

WHY 1: CLEANING OF CYREL UPON DETECTION OF SMEARED PRINT.

EQOS OPERATOR // 2024-12-28

WHY 2: TRANSFER SOLID PRINT FROM UNIT 1 TO UNIT 2 AFTER THE INSTALLATION OF NEW UPGRADED ANILOX ROLLER.

PRODUCTION LEADERS // 2025-04-01

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	Rework PPM (Good)	0
FG	n/a	0	0	0		

B. Orientation

Date	2025-04-01	Time	12:50
Title	n/a		
Attendees	n/a		

Prepared By:

Approved By:

GERALD DE GUZMAN | 250410

REXEL ALMARIO | 250507

Department Head



II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 2025-03-12	PIC: M.ASIS
Identified Rootcause Due to over pressure during print impression	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	2025-04-01	[<input type="checkbox"/>] Yes [<input type="checkbox"/>] No	1st	O25-M-01572-8	260901	0	500
2nd Verification of Action	M.ASIS	2025-05-03	[<input type="checkbox"/>] Yes [<input type="checkbox"/>] No	2nd	JO25-M-01572-27	270831	0	500
3rd Verification of Action	M.ASIS	2025-05-21	[<input type="checkbox"/>] Yes [<input type="checkbox"/>] No	3rd	JO25-M-01572-59	250515	0	300
Effectiveness of Action	M.ASIS	2025-06-04	[<input type="checkbox"/>] Yes [<input type="checkbox"/>] No	4th	JO25-M-01572-107	250521	0	300
Remarks: Change the corrective action to use Rubber Dust Remover for all single-color item with single mylar in Printing Unit 2 instead of transferring the solid print to unit 1 to unit 2.				5th	JO25-M-01977-23	250604	0	450

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: -