

**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

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
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250103</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	<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)
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)

**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)**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

**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)**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	[] Yes [/] No	1st	O25-M-01572-8	260901	0	500
2nd Verification of Action	M.ASIS	2025-05-03	[/] Yes [] No	2nd	JO25-M-01572-27	270831	0	500
3rd Verification of Action	M.ASIS	2025-05-21	[/] Yes [] No	3rd	JO25-M-01572-59	250515	0	300
Effectiveness of Action	M.ASIS	2025-06-04	[/] Yes [] 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	Five consecutive running without smeared print issue.

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 260213 12:03 QA Head	N/A Top Management	N/A Line Leader	N/A Department Head
Date: 26262626-02-13	Date: -	Date: -	Date: -