

**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

0051

250205

Customer	CANON BUSINESS MACHINE PHILS.	Attention To	REXEL ALMARIO
Item Code	RX1-5755-000	Department	PRODUCTION
Item Description	Z10 CARTON	Date of Detection	250130
Job Order Number	JO-F-25-75-5	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
650	22	3.38

Nature of Defect:

POOR PRINT

Requirement:

Poor print on HP Logo is not acceptable

Actual

Poor print on HP Logo

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250130</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 250205	CHARLENE JAN MARIE FLORES 250205	MICHAEL CASILLANO 250210	GERALD DE GUZMAN 250210

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. r nW2 Ink didn t penetrate well in the item.

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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: Temporary increasing of Ink Viscosity from 9 seconds standard to 10 seconds.

Production Leaders Eqos
Operator // 2025-03-10

WHY 2: Replacement of upgraded anilox roller for better print resolution from 9 to 12.

UMETANI // 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	2025-04-10	Time	15:48
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: 2025-03-28	PIC: M.ASIS
Identified Rootcause Ink didn't penetrate well in the item.	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	2025-04-10	[/] Yes [] No	1st	JO-F-25-552-2	250430	0	100
2nd Verification of Action			[] Yes [] No	2nd	JO-F-25-552-3	240513	0	900
3rd Verification of Action			[] Yes [] No	3rd	JO-F-25-554	250517	0	300
Effectiveness of Action	M.ASIS	2025-06-17	[/] Yes [] No	4th	JO-F-25-722-1	250614	0	850
Remarks: No form submitted in replacing the anilox, the available evidence is the picture of UEDA replacing the anilox.				5th	JO-F-25-722-2	250617	0	900

IV. CLOSURE

Status	Remarks
Closed IRF	Five consecutive lots running with no related defect, corrective action was effective

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250718 03:49 QA Head	RHODORA MIRANDA 250730 08:16 Top Management	GERALD DE GUZMAN 250730 08:35 Line Leader	REXEL ALMARIO 251017 09:37 Department Head
Date: 25252525-07-18	Date: 25252525-07-30	Date: 25252525-07-30	Date: 25252525-10-17