

**KANE PACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISI 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"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence No.: <u>1</u>	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
Date.: <u>250130</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Vertical	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Process / Method
		<input type="checkbox"/> Detaching	
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.



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

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INVESTIGATION REPORT FORM (IRF)**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	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st	JO-F-25-552-2	250430	0	100
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd	JO-F-25-552-3	240513	0	900
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd	JO-F-25-554	250517	0	300
Effectiveness of Action	M.ASIS	2025-06-17	<input type="checkbox"/> Yes <input type="checkbox"/> 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
Date: 25252525-07-18	Date: 25252525-07-30
GERALD DE GUZMAN 250730 08:35 Line Leader	REXEL ALMARIO 251017 09:37 Department Head
Date: 25252525-07-30	Date: 25252525-10-17