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
■ First	☐ Hold	☐ Slotter	☐ Gluing	☐ Material
☐ Recurrence No.: 1	☐ Special Acceptance	■ EQOS	☐ Vertical	☐ Dimension
	☐ For Rework	☐ Diecut	☐ Others	☐ Appearance
Date.: 250130	■ Reject / Disposal	☐ Detaching	_____	■ 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 occurence, 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.

QA-027-F01 REV.01

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

Date Conducted:	PIC:
Identified Rootcause	Recommendation

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			[ ] Yes [ ] No	1st				
2nd Verification of Action			[ ] Yes [ ] No	2nd				
3rd Verification of Action			[ ] Yes [ ] No	3rd				
Effectiveness of Action			[ ] Yes [ ] No	4th				
Remarks:				5th				

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: -