



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

0052

250205

Customer NIDEC SUBIC PHILIPPINES CORPORATION

Item Code L00078649

Item Description VR-B CARTON

Job Order Number JO25-M-00328-9

Attention To REXEL ALMARIO

Department PRODUCTION

Date of Detection 250131

Section Detected QA SCREENING

ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)

1420

Reject Qty (pcs)

21

Reject %

1.48

Nature of Defect:

POOR PRINT

Requirement:

Poor print on class A is not acceptable

Actual

With poor print

NO. OF OCCURENCE

DISPOSITION

AREA OF OCCURENCE / ORIGIN

CONTENT

☒ First
☐ Recurrence No.: 1
Date.: 250131

☐ 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 | 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 in the item. r nW2 There is blockage/clogging of anilox. r nW3 Foreign materials stick in the anilox and flexo plate.

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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: Application of rubber dust remover in Printing Unit 1

Production Leaders Eqos
Operator // 2025-03-19

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	16:55
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:	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	High rejection rate detected. Details: JO25-M-01757-1 155 NG / 2,000 pcs @ 250513. Attached the CAR Request form 2425-PR-291

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 250528 09:38 QA Head	KOHEI ISHII 250529 03:55 Top Management	GERALD DE GUZMAN 250603 08:40 Line Leader	N/A Department Head
Date: 25252525-05-28	Date: 25252525-05-29	Date: 25252525-06-03	Date: -