

**KANE PACKAGE 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	Attention To	REXEL ALMARIO
Item Code	L00078649	Department	PRODUCTION
Item Description	VR-B CARTON	Date of Detection	250131
Job Order Number	JO25-M-00328-9	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
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1420	21	1.48
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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
<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>250131</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<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 in the item. r nW2 There is blockage/clogging of anilox. r nW3 Foreign materials stick in the anilox and flexo plate.



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		
FG	n/a	0	0	0	Rework PPM (Good)	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			<input type="checkbox"/> Yes <input type="checkbox"/> No	1st				
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd				
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd				
Effectiveness of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	4th				
Remarks:				5th				

IV. CLOSURE

Status	Remarks		
Closed IRF	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	REXEL ALMARIO 251017 09:37 Department Head
Date: 25252525-05-28	Date: 25252525-05-29	Date: 25252525-06-03	Date: 25252525-10-17