



# 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	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 %
1420	21	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
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250131</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 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**

	Location	Total Stock	NG	Total Good
RM	n/a	0	0	0
WIP	n/a	0	0	0
FG	n/a	0	0	0

**C. Reworking**

Rework Quantity	n/a
Total Good	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			[ ] 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
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