**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 |
|---|---|
| 0054 | 250205 |

| | | | |
|---|---|---|---|
| Customer | SANYO DENKI PHILS INC. | Attention To | REXEL ALMARIO |
| Item Code | 01015138-01 | Department | PRODUCTION |
| Item Description | BOX PRINT SPECIFICATION | Date of Detection | 250201 |
| Job Order Number | JO25-M-00199-49 | Section Detected | QA SCREENING |

**ILLUSTRATION OF THE PROBLEM**


| Lot Quantity (pcs) | Reject Qty (pcs) | Reject % |
|---|---|---|
| 150 | 50 | 33.33 |

Nature of Defect:

EXCESS PRINT

Requirement:

There should be no excess print

Actual

Excess print on the glue tab area

| NO. OF OCCURENCE | DISPOSITION | AREA OF OCCURENCE / ORIGIN | CONTENT |
|---|---|---|---|
| ■ First | ☐ Hold | ☐ Slotter ☐ Gluing | ☐ Material |
| ☐ Recurrence No.: 1 | ☐ Special Acceptance | ■ EQOS ☐ Vertical | ☐ Dimension |
| Date.: 250201 | ☐ For Rework | ☐ Diecut ☐ Others | ☐ Appearance |
| | ■ 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 Suteban mark hit during Diecut process. r nW2 Instillation of suteban near on the box dimension (within print tolerance). r nW3 No standard distance for the instillation of suteban in Eqos.

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# INVESTIGATION REPORT FORM (IRF)

**INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)**

**System / Training**

**Design / Toolings**

**Process / Material**

**FINAL CONCLUSION**

| **CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)** | **WHO / WHEN** |
|---|---|
| **Process / Material** | |
| WHY 1: Conduct awareness orientation during Production Assembly | Production Leader // 2025-02-06 |
| WHY 2: Establish Guidelines for the Standard Distance of Suteban Installation | Production Leader // 2025-03-14 |

**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 | n/a |
| Rework PPM (Good) | n/a |

B. Orientation

| | | | |
|---|---|---|---|
| Date | 2025-02-06 | Time | 08:14 |
| Title | Production Weekly Assembly Meeting | | |
| Attendees | All Production | | |

| Prepared By: | Approved By: |
|---|---|
| GERALD DE GUZMAN \| 250304 | 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<br>QA Head | N/A<br>Top Management | N/A<br>Line Leader | N/A<br>Department Head |
| Date: - | Date: - | Date: - | Date: - |