



# 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.:

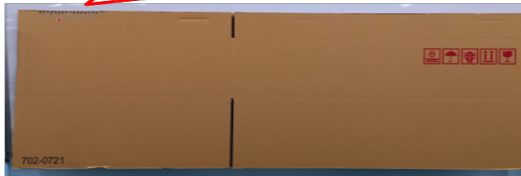
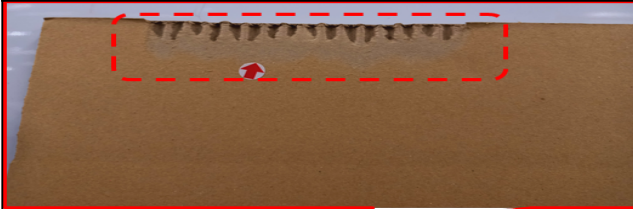
Date Issued

0059

250220

Customer	DENSO PHILIPPINES CORPORATION	Attention To	REXEL ALMARIO
Item Code	PH989702-0721	Department	PRODUCTION
Item Description	BOX	Date of Detection	250213
Job Order Number	JO25-M-00433-59	Section Detected	QA SCREENING

### ILLUSTRATION OF THE PROBLEM



**ACTUAL:** Peel off up to 225mm by 30mm  
**REQUIREMENT:** No peel off

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
500	20	4.00

Nature of Defect:

PEEL OFF

Requirement:

No peel off

Actual

Peel off up to 225mm by 30mm

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250213</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 type="checkbox"/> EQOS <input checked="" 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   250220	CHARLENE JAN MARIE FLORES   250225	MICHAEL CASILLANO   250226	GERALD DE GUZMAN   250410

### I. INVESTIGATION / ANALYSIS

**DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)**

**System / Training**

**Design / Toolings**

**Process / Material**

WHY 1 : The liner surface of the board was hit on the feed gate of Eqos.

WHY 2 : Presence of excess liner and delamination in the edge of the boards.

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

System / Training

Design / Toolings

Process / Material

WHY 1 : na

**FINAL CONCLUSION**

**CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)**

**WHO / WHEN**

Process / Material

WHY 1: Assign specific Supplier for this item (Packageworld). Based on checking and trial run using two different supplier (Packageworld and Sunpack) for this item it was found out that materials from Packageworld was no occurrence of peel off was observed.

MPD and Purchasing // 2025-05-31

**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	na
RM	na	0	0	0	Total Good	na
WIP	na	0	0	0	Rework PPM (Good)	na
FG	na	0	0	0		

B. Orientation

Date	2025-05-19	Time	14:40
Title	na		
Attendees	na		

Prepared By:

Approved By:

GERALD DE GUZMAN | 250519

REXEL ALMARIO | 251017

Department Head

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

Date Conducted: 2025-02-27	PIC: M.ASIS
Identified Rootcause The edges of the board are delaminated up to 3-5mm	Recommendation N/A

**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	M.ASIS	2025-04-23	[ <input type="checkbox"/> ] Yes [ <input type="checkbox"/> ] No	1st	JO25-M-02120-23	250618	0	600
2nd Verification of Action	M.ASIS	2025-04-29	[ <input type="checkbox"/> ] Yes [ <input type="checkbox"/> ] No	2nd	JO25-M-02120-24	250627	0	600
3rd Verification of Action	M.ASIS	2025-06-16	[ <input type="checkbox"/> ] Yes [ <input type="checkbox"/> ] No	3rd	JO25-M-02323-34	250701	0	370
Effectiveness of Action	M.ASIS	2025-06-17	[ <input type="checkbox"/> ] Yes [ <input type="checkbox"/> ] No	4th	JO25-M-02323-35	250705	0	1000
Remarks: This issue was common to CAR-264 PEEL OFF. The corrective action according to production was to change the supplier. The trial run conducted last May 2025 and implemented in June 2025. Attached the CAR-264 PEEL OFF, LA-0169 Why-Why_Report - SUNPACK, ME-4M-25-0032 (SDP AND EPSON) CHANGE SUPPLIER FROM SUNPACK TO PW, PH98-0721_JO_PACKAGEWORLD.				5th	JO25-M-02415-12	250716	0	1500

**IV. CLOSURE**

Status	Remarks
Still Open	Five consecutive running with no peel off issue detected. Corrective action is effective

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO   251020 10:56 QA Head	N/A Top Management	N/A Line Leader	N/A Department Head
Date: 25252525-10-20	Date: -	Date: -	Date: -