

**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
0060	250220

Customer	HIBLOW PHILIPPINES INC.	Attention To	REXEL ALMARIO
Item Code	DB08005130-00	Department	PRODUCTION
Item Description	XP BOX PROTOTYPE OUTER BOX AND INSERT PAD	Date of Detection	250214
Job Order Number	JO25-M-00047-10	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

ACTUAL: With poor print
REQUIREMENT: No poor print

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
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5000	38	0.76
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Nature of Defect:

POOR PRINT

Requirement:

There should be no poor print

Actual

With poor print

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input checked="" type="checkbox"/> Recurrence No.: <u>2</u>	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
Date.: <u>250127</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 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 : Uneven distribution of ink in the item

WHY 2 : There is blockage/clogging of anilox



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: Conducted cleaning of cyrel and anilox upon detection.

Eqos operators // 2025-01-21

WHY 2: Provision of rubber dust remover

Production // 2025-02-21

WHY 3: Set cleaning frequency using the rubber dust remover. (after the trial of effectiveness)

production // 2025-02-28

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

B. Orientation			
Date	2025-04-24	Time	08:47
Title	na		
Attendees	na		

Prepared By:	Approved By:
GERALD DE GUZMAN 250424	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: 2025-04-24	PIC: M.ASIS
Identified Rootcause Foreign materials stick in the anilox and flexo plate	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	2025-02-21	<input type="checkbox"/> Yes <input type="checkbox"/> No	1st				
2nd Verification of Action	M.ASIS	2025-02-28	<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd				
3rd Verification of Action	M.ASIS	2025-04-14	<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
Still Open	No running of items for the last six consecutive months. Corrective Action was implemented last April 14, 2025.
Approved by:	Process Owner Acknowledgment: (Receiving Section)
MICHAEL CASILLANO 251020 10:57 QA Head	N/A Top Management
Date: 25252525-10-20	Date: -
	N/A Line Leader
	N/A Department Head
	Date: -