



# 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.:

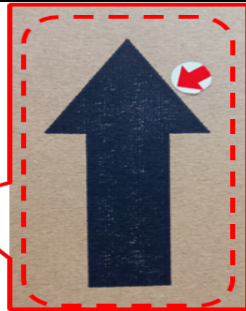
Date Issued

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 %
5000	38	0.76

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 checked="" type="checkbox"/> Recurrence No.: <u>2</u> Date.: <u>250127</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   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

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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: Conducted cleaning of cyrel and anilox upon r ndetection.

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. r n(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**

	Location	Total Stock	NG	Total Good
RM	na	0	0	0
WIP	na	0	0	0
FG	na	0	0	0

**C. Reworking**

Rework Quantity	0
Total Good	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 [ / ] No	1st				
2nd Verification of Action	M.ASIS	2025-02-28	[ <input type="checkbox"/> ] Yes [ / ] No	2nd				
3rd Verification of Action	M.ASIS	2025-04-14	[ / ] 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	N/A Line Leader	N/A Department Head
Date: 25252525-10-20	Date: -	Date: -	Date: -