



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:	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	N/A	N/A	N/A
QA Head	Top Management	Line Leader	Department Head
Date: -	Date: -	Date: -	Date: -