

**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 |
| 0061         | 250220      |

|                  |                        |                   |               |
|------------------|------------------------|-------------------|---------------|
| Customer         | SANYO DENKI PHILS INC. | Attention To      | REXEL ALMARIO |
| Item Code        | 00902010-01            | Department        | PRODUCTION    |
| Item Description | PRINT SPECIFICATION    | Date of Detection | 250214        |
| Job Order Number | JO25-M-00254-9         | Section Detected  | QA SCREENING  |

**ILLUSTRATION OF THE PROBLEM****ACTUAL:** With poor print**REQUIREMENT:** No poor print

| Lot Quantity (pcs) | Reject Qty (pcs) | Reject % |
|--------------------|------------------|----------|
| 2500               | 16               | 0.64     |

Nature of Defect:

POOR PRINT

Requirement:

There should be no poor print

Actual

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>240801</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 : Foreign materials stick in the flexo plate and 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: Provision of rubber dust remover Production IE and Leaders // 2025-02-21

## 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                      | 2025-04-30 |  |  | Time                   | 09:08 |  |  |  |
| Title                     | na         |  |  |                        |       |  |  |  |
| Attendees                 | na         |  |  |                        |       |  |  |  |
| Prepared By:              |            |  |  | Approved By:           |       |  |  |  |
| GERALD DE GUZMAN   250430 |            |  |  | 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 |             |      | <input type="checkbox"/> Yes <input type="checkbox"/> No | 1st     |           |      |        |         |
| 2nd Verification of Action |             |      | <input type="checkbox"/> Yes <input type="checkbox"/> No | 2nd     |           |      |        |         |
| 3rd Verification of Action |             |      | <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  |   |   |  |
|--|--|---|---|--|
| Closed IRF                                     | Poor print occurred again in items of Sanyo Denki with 8% rejection rate, already issued CAR 2425-PR-256. The corrective actions will be monitoring in CAR system and there will be horizontal implementation in common items. Attached the Abnormality Report and CAR Form. |   |   |  |
| Approved by:                                   |  | Process Owner Acknowledgment: (Receiving Section) |   |  |
| MICHAEL CASILLANO   250626<br>12:25<br>QA Head | RHODORA MIRANDA   250703<br>08:00<br>Top Management  | GERALD DE GUZMAN   250704<br>11:25<br>Line Leader | REXEL ALMARIO   251017 09:37<br>Department Head |  |
| Date: 25252525-06-26                           | Date: 25252525-07-03   | Date: 25252525-07-04                              | Date: 25252525-10-17                            |  |