

**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)

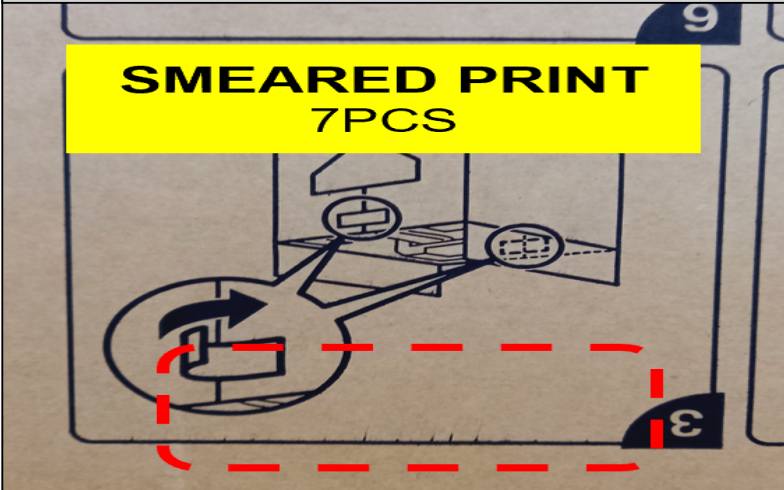
Control No.:

Date Issued

0067

250226

Customer	CANON BUSINESS MACHINE PHILS.	Attention To	REXEL ALMARIO
Item Code	FX2-5097-000	Department	PRODUCTION
Item Description	Z10 OUTER BOX	Date of Detection	250222
Job Order Number	JO-F-25-179-4	Section Detected	QA SCREENING 3

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
600	7	1.17
Nature of Defect:		
SMEARED PRINT		
Requirement:		
NO SMEARED PRINT		
Actual		
WITH SMEARED PRINT		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250222</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)
MA. ERIKA MAE ASIS 250226	CHARLENE JAN MARIE FLORES 250226	MICHAEL CASILLANO 250303	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 : INK SPREAD FURTHER ON THE PRINTED AREA

WHY 2 : ACCUMULATION OF INK ON THE EDGES OF FLEXO PLATE

WHY 3 : DUE TO OVER PRINT IMPRESSION (ADJUSTMENT UPON TRIAL RUN)

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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 : na

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 reject separator (have list of rejects)

ME // 2025-06-30

WHY 2: Revised Work Instruction regarding the reject process.

Production IE // 2025-06-30

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

B. Orientation

Date	2025-06-10	Time	08:33
Title	na		
Attendees	na		

Prepared By:

Approved By:

GERALD DE GUZMAN | 250610

REXEL ALMARIO | 251017

Department Head

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

Date Conducted: 2025-02-26	PIC: M.ASIS
Identified Rootcause due to over print impression	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	2025-04-14	[/] Yes [] No	1st	JO-F-25-502-5	260901	0	600
2nd Verification of Action			[] Yes [] No	2nd	JO-F-25-502-6	270831	0	600
3rd Verification of Action			[] Yes [] No	3rd	JO-F-25-502-7	250507	0	600
Effectiveness of Action	M.ASIS	2025-05-15	[/] Yes [] No	4th	JO-F-25-564-1	250510	0	600
Remarks: Did not agree on the corrective actions involving the reject separator and revision the reject process. Horizontal to IRF 0045 Change the corrective action to Use Rubber Dust Remover for all single-color item with single mylar in Printing Unit 2.				5th	JO-F-25-564-2	250515	0	600

IV. CLOSURE

Status	Remarks
Still Open	Five consecutive running with no smeared print issue

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
MICHAEL CASILLANO 260213 12:04 QA Head	N/A Top Management	N/A Line Leader	N/A Department Head
Date: 26262626-02-13	Date: -	Date: -	Date: -