



# 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

0068

250301

Customer	BROTHER INDUSTRIES PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	D037G1001	Department	PRODUCTION
Item Description	CARTON MFC-J4550DW EU-C	Date of Detection	250225
Job Order Number	JO-25-IPD-00279-1	Section Detected	QA SCREENING 3

### ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2100	37	1.76

Nature of Defect:

MISALIGN PRINT

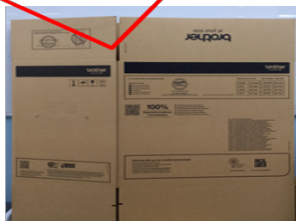
Requirement:

±5 print tolerance

Actual

Misalign print up to 15 mm from creasing line

**ACTUAL:** With misalign print up to 15mm  
**REQUIREMENT:** No misalign 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>250225</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   250301	CHARLENE JAN MARIE FLORES   250301	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 : Movement of print during process

WHY 2 : Delayed timing/feeding of boards

WHY 3 : Warp materials

WHY 4 : Lacking of weight jig

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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 new weight jig to prevent warping of materials. Paper weight jig already disposed as per advised of top management.

ME // 2025-06-16

**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	na
Total Good	0
Rework PPM (Good)	0

**B. Orientation**

Date	2025-06-10	Time	08:36
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: 2025-06-04	PIC: M.ASIS
Identified Rootcause Lacking quantity of weight jig	Recommendation Provision of weight jig

**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	2025-06-30	[ / ] Yes [ ] No	1st	JO25-M-02262-7	250710	0	450
2nd Verification of Action			[ ] Yes [ ] No	2nd	JO25-M-02262-8	250711	0	450
3rd Verification of Action			[ ] Yes [ ] No	3rd	JO25-M-02513-6	250802	0	400
Effectiveness of Action	M.ASIS	2025-09-03	[ / ] Yes [ ] No	4th	JO25-M-02513-7	250828	0	200
Remarks:				5th	JO25-M-02801-7	250903	0	220

**IV. CLOSURE**

Status	Remarks
Still Open	Five consecutive running with no misalign print issue detected. Corrective action is effective

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: -