

**KANE PACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISI II, Brgy. La Mesa, Calamba City, Laguna
 Telephone No. (049) 5457-7166 to 69
 Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)

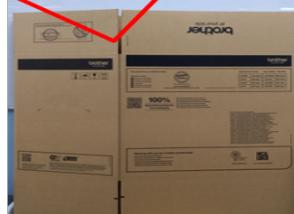
Control No.:	Date Issued
0068	250301

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

ACTUAL: With misalign print up to 15mm

REQUIREMENT: No misalign print



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

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence No.: <u>1</u>	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
Date.: <u>250225</u>	<input type="checkbox"/> For Rework	<input type="checkbox"/> Vertical	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Process / Method
		<input type="checkbox"/> Detaching	
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



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					C. Reworking	
	Location	Total Stock	NG	Total Good	Rework Quantity	na
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	2025-06-10		Time
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
Date: 25252525-10-20	Date: -
	Date: -
	Date: -