



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.:

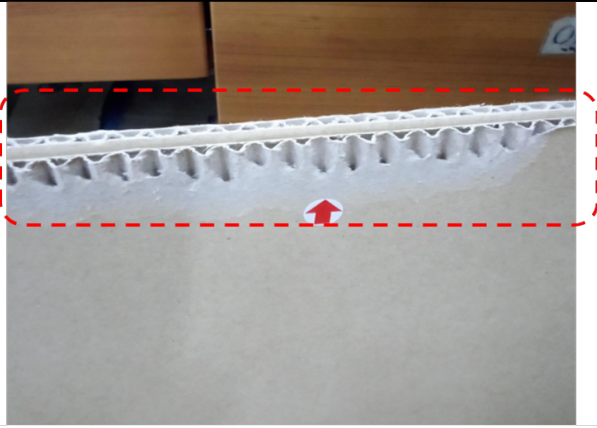
Date Issued

0071

250312

Customer	EPSON PRECISION PHILS. INC.- ASP/EPLB	Attention To	REXEL ALMARIO
Item Code	511594700-EQOS	Department	PRODUCTION
Item Description	BOX	Date of Detection	250228
Job Order Number	JO25-M-00574-4	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM



ACTUAL: PEEL OFF UP TO 120MM.

REQUIREMENT: ACCEPTABLE UP TO 25MM.

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1500	62	4.13

Nature of Defect:

PEEL OFF

Requirement:

ACCEPTABLE UP TO 25MM

Actual

PEEL OFF UP TO 120MM

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250328</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 250312	CHARLENE JAN MARIE FLORES 250312	MICHAEL CASILLANO 250312	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 : The liner get caught at the Eqos feed gate during running.

WHY 2 : Materials encountered warpage.

WHY 3 : 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 additional weight jig to prevent warping of materials. Paper weight jig already disposed as per advised of top management.

ME // 2025-06-30

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	08:26
Title	na		
Attendees	na		

Prepared By:**Approved By:**

GERALD DE GUZMAN | 250618

REXEL ALMARIO | 251017

Department Head



II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 2025-06-13	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-02372-8	250709	0	800
2nd Verification of Action			[] Yes [] No	2nd	JO25-M-02701-5	250816	0	700
3rd Verification of Action			[] Yes [] No	3rd	JO25-M-02949-3	250912	0	100
Effectiveness of Action	M.ASIS	2025-10-13	[/] Yes [] No	4th	JO25-M-03101-5	251003	0	400
Remarks:				5th	JO25-M-03101-6	251013	0	300

IV. CLOSURE

Status	Remarks
Still Open	Five consecutive running with no peel off 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: -