

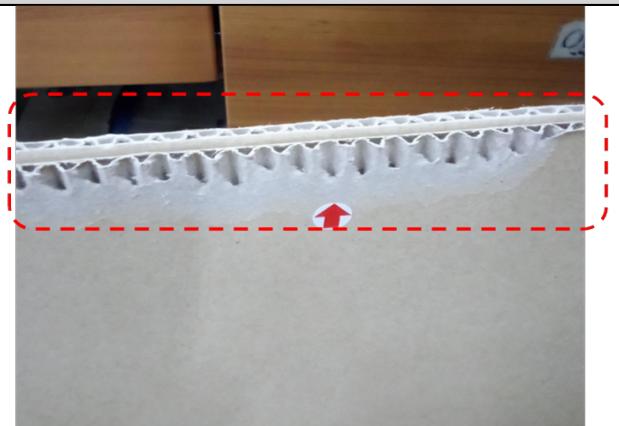
**KANE PACKAGE PHILIPPINE INC.**

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
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

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
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1500	62	4.13
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Nature of Defect:

PEEL OFF

Requirement:

ACCEPTABLE UP TO 25MM

Actual

PEEL OFF UP TO 120MM

ACTUAL: PEEL OFF UP TO 120MM.

REQUIREMENT: ACCEPTABLE UP TO 25MM.

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>250328</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 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



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					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	08:26
Title	na		
Attendees	na		

Prepared By:	Approved By:
GERALD DE GUZMAN 250618	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: 2025-06-13	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
Date: 25252525-10-20	Date: -
	Date: -
	Date: -