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
0078	250329

Customer	BROTHER INDUSTRIES PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	D02Y4T001	Department	PRODUCTION
Item Description	PRINTED CARTON E115B CHN	Date of Detection	250318
Job Order Number	JO25-M-00781-66	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM	
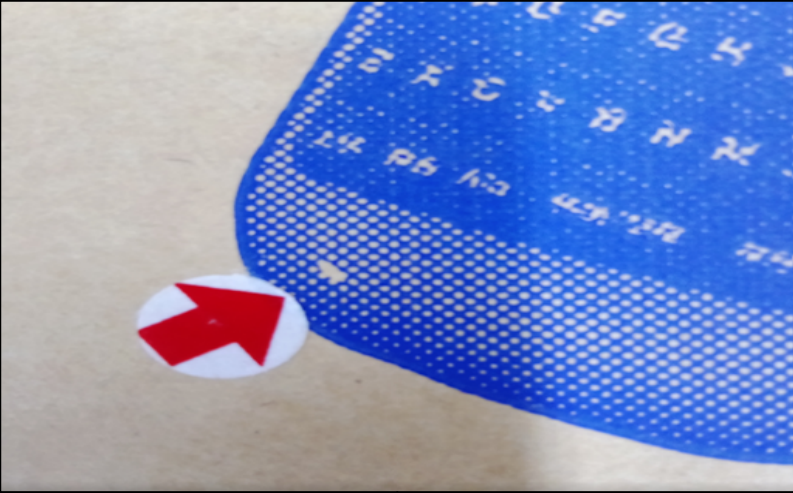
Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
850	25	2.94

Nature of Defect:

SPOT(S)

Requirement:

Spot is not acceptable

Actual

Spot on printer image

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN		CONTENT
■ First	☐ Hold	☐ Slotter	☐ Gluing	☐ Material
☐ Recurrence No.: _1_	☐ Special Acceptance	■ EQOS	☐ Vertical	☐ Dimension
	☐ For Rework	☐ Diecut	☐ Others	☐ Appearance
Date.: _250318_	■ Reject / Disposal	☐ Detaching	_____	■ Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO | 250329	CHARLENE JAN MARIE FLORES | 250421	MICHAEL CASILLANO | 250422	GERALD DE GUZMAN | 250506

I. INVESTIGATION / ANALYSIS

DIRECT CAUSE: (Analyze the reason of occurence, why it happened?)

System / Training

Design / Toolings

Process / Material

WHY 1 :   Uneven distribution of ink to the substrate.

WHY 2 :   There is blockage of anilox.

WHY 3 :   Foreign materials stick in the flexo plate.

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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: Inclusion of Rubber Dust Remover usage in Eqos daily Parameter sheet to monitor if the operator use it for the items with single mylar in printing unit 2.	Production IE // 2025-06-14

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	08:59
Title	na		
Attendees	na		

Prepared By:	Approved By:
GERALD DE GUZMAN | 250618	N/A
	Department Head

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

Date Conducted:	PIC:
Identified Rootcause	Recommendation

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			[ ] Yes [ ] No	1st				
2nd Verification of Action			[ ] Yes [ ] No	2nd				
3rd Verification of Action			[ ] Yes [ ] No	3rd				
Effectiveness of Action			[ ] Yes [ ] No	4th				
Remarks:				5th				

IV. CLOSURE

Status	Remarks
Still Open	

Approved by:		Process Owner Acknowledgment: (Receiving Section)	
N/A	N/A	N/A	N/A
QA Head	Top Management	Line Leader	Department Head
Date: -	Date: -	Date: -	Date: -