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
0090	250510

Customer	KOWA-EMORI PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	HP33D1057-1	Department	PRODUCTION
Item Description	CARTON BOX	Date of Detection	250507
Job Order Number	JO25-M-01645-28	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

ACTUAL: Print overlaps on the creasing line
REQUIREMENT: No misalign print

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2000	97	4.85

Nature of Defect:

MISALIGN PRINT

Requirement:

+- 5 mm printing tolerance

Actual

Print overlaps on the creasing line

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.: __250507__	☒ Reject / Disposal	☐ Detaching	_____	☐ Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO | 250510	CHARLENE JAN MARIE FLORES | 250519	MICHAEL CASILLANO | 250519	GERALD DE GUZMAN | 250614

I. INVESTIGATION / ANALYSIS

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

System / Training

Design / Toolings

WHY 1 :   With almost 2mm slanted mounting of cyrel on the affected portion.

WHY 2 :   Cyrel adhesive (double sided tape) got weak.

WHY 3 :   Accumulation of water during cyrel cleaning.

Process / Material

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INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)

System / Training

Design / Toolings

WHY 1 :   na

Process / Material

FINAL CONCLUSION	
CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)	**WHO / WHEN**

Design / Toolings

	WHO / WHEN
WHY 1: Conducted investigation by checking of actual non detach r ndie cutted items to find the cause.	Production // 2025-06-24
WHY 2: Align the slanted portion of cyrel then apply sealant.	Production // 2025-06-27
WHY 3: Revision of WI PR 001 031 Guidelines for Cyrel Layouting r nregarding inclusion of applying sealant to prevent r naccumulation of water in adhesive during cyrel cleaning.	Production // 2025-07-01

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	2025-07-15	Time	09:49
Title	na		
Attendees	na		

Prepared By:	Approved By:
GERALD DE GUZMAN | 250715	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: -

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