



# 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

0092

250623

Customer HIBLOW PHILIPPINES INC.

Attention To REXEL ALMARIO

Item Code DB04020120-00

Department PRODUCTION

Item Description VP Individual Large Box

Date of Detection 250610

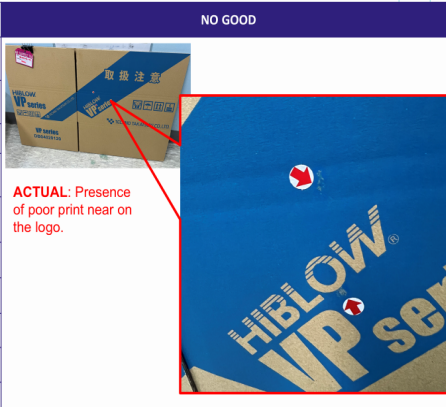
Job Order Number JO25-M-01680-11

Section Detected QA SCREENING 4

### ILLUSTRATION OF THE PROBLEM

#### QUALITY CONCERN – POOR PRINT

Customer	HIBLOW
Item Description	DB04020120-00 VP INDIVIDUAL BOX
Job Order Number	JO25-M-01680-11
Lot Quantity	160 pcs.
Rejected Quantity	35 pcs.
Rejection Rate / PPM	21.88% / 218,750 PPM
Detection date	250610
Occurrence No.	1 <sup>st</sup>
Detected by	QA SCREENING 4
Status	REJECT (IRF ISSUANCE)
Rejection Cost	-



Lot Quantity (pcs)

160

Reject Qty (pcs)

35

Reject %

21.88

Nature of Defect:

POOR PRINT

Requirement:

There should be no poor print on the logo

Actual

Presence of poor print near on the logo.

#### NO. OF OCCURENCE

#### DISPOSITION

#### AREA OF OCCURENCE / ORIGIN

#### CONTENT

☒ First  
☐ Recurrence No.: 1  
Date.: 250610

☐ Hold  
☐ Special Acceptance  
☐ For Rework  
☒ Reject / Disposal

☐ Slotter  
☒ EQOS  
☐ Diecut  
☐ Detaching  
☐ Gluing  
☐ Vertical  
☐ Others

☐ Material  
☐ Dimension  
☐ Appearance  
☒ Process / Method

Issued by

Checked by

Approved by

Received by (Receiving Section)

LESTER JOHN DIOSO | 250623

CHARLENE JAN MARIE FLORES | 250626

MICHAEL CASILLANO | 250626

GERALD DE GUZMAN | 250709

### I. INVESTIGATION / ANALYSIS

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

#### System / Training

#### Design / Toolings

#### Process / Material

WHY 1 : Uneven distribution of ink to the substrate.

WHY 2 : Foreign materials that were stuck in the flexoplate

WHY 3 : Dust remover cannot collect all the foreign materials on the boards due to over accumulation of dust.

WHY 4 : No set frequency on the cleaning of dust remover.

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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: Set frequency of dust remover every end of the shift.

Production // 2025-08-26

WHY 2: Inclusion to WI and Eqos Daily Maintenance Form.

Production IE // 2025-08-29

**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	na
WIP	na	0	0	0	Rework PPM (Good)	na
FG	na	0	0	0		

**B. Orientation**

Date	2025-09-09	Time	12:09
Title	na		
Attendees	NA		

**Prepared By:****Approved By:**

GERALD DE GUZMAN | 250909

N/A

Department Head

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**INVESTIGATION REPORT FORM (IRF)****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: -