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
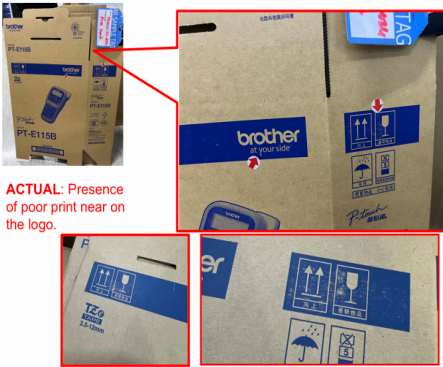
INVESTIGATION REPORT FORM (IRF)

Control No.:	Date Issued
0093	250623

Customer	BROTHER INDUSTRIES PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	D02Y4T001	Department	PRODUCTION
Item Description	PRINTED CARTON E115B CHN	Date of Detection	250610
Job Order Number	JO25-M-01987-58	Section Detected	QA SCREENING 2

ILLUSTRATION OF THE PROBLEM

QUALITY CONCERN – POOR PRINT

Customer	BROTHER		NO GOOD
Item Description	D02Y4T001 PRINTED CARTON		
Job Order Number	JO25-M-01987-58		
Lot Quantity	2,100 pcs.		
Rejected Quantity	65 pcs.		
Rejection Rate / PPM	3.1% / 30,952 PPM		
Detection date	250610		
Occurrence No.	2nd (250413)		
Detected by	QA SCREENING 2		
Status	REJECT (IRF ISSUANCE)		
Rejection Cost	-		

ACTUAL: Presence of poor print near on the logo.

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2100	65	3.10

Nature of Defect:

POOR PRINT

Requirement:

Poor print is not acceptable on the logo

Actual

Presence of poor print near on the logo.

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN		CONTENT
☐ First	☐ Hold	☐ Slotter	☐ Gluing	☐ Material
☒ Recurrence No.: 2	☐ Special Acceptance	☒ EQOS	☐ Vertical	☐ Dimension
	☐ For Rework	☐ Diecut	☐ Others	☐ Appearance
Date.: 250413	☒ Reject / Disposal	☐ Detaching	_____	☒ 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 occurence, 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 flexo plate

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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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		
FG	na	0	0	0	Rework PPM (Good)	na

B. Orientation				
Date	2025-09-09		Time	12:13
Title	na			
Attendees	NA			

Prepared By:	Approved By:
GERALD DE GUZMAN	250909	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: -