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
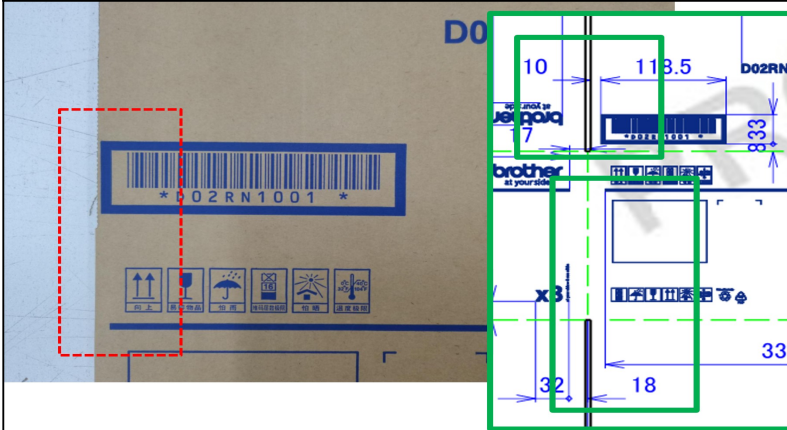
INVESTIGATION REPORT FORM (IRF)

Control No.:	Date Issued
0097	250709

Customer	BROTHER INDUSTRIES PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	D02RN1001	Department	PRODUCTION
Item Description	CARTON DEV UNIT ELLE (X3)	Date of Detection	250703
Job Order Number	JO25-M-02256-32	Section Detected	QA SCREENING 5

ILLUSTRATION OF THE PROBLEM

ACTUAL: Print already overlaps on the creasing line.
REQUIREMENT: ±5 Printing tolerance

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1000	40	4.00

Nature of Defect:

MISALIGN PRINT

Requirement:

±5 Printing tolerance

Actual

Print is 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.: __250703__	■ Reject / Disposal	☐ Detaching	_____	■ Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO | 250709	CHARLENE JAN MARIE FLORES | 250710	MICHAEL CASILLANO | 250710	GERALD DE GUZMAN | 250716

I. INVESTIGATION / ANALYSIS

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

System / Training

WHY 1 :   Misalign deiecut occurred during diecut process at Eterna machine r n

WHY 2 :   The sheet was not aligned to the dieblade setup due to lateral movement of the sheets.

WHY 3 :   Failure to use the feeder jogger that aligns the sheets going to the diechase.

Design / Toolings

Process / Material

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

System / Training

WHY 1 :   NA

Design / Toolings

Process / Material

FINAL CONCLUSION

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)	WHO / WHEN
System / Training	
WHY 1: Posting of reminder to Strictly use the feeder jogger to r nprevent misalign diecut	Production Leader // 2025-08-07

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	2025-07-31	Time	16:04
Title	na		
Attendees	na		

Prepared By:	Approved By:
GERALD DE GUZMAN | 250807	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: -

QA-027-F01 REV.01