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
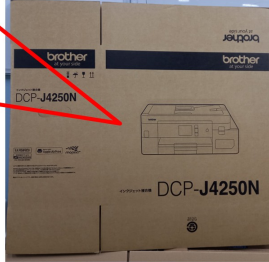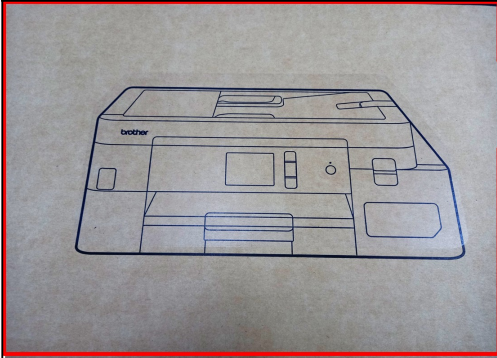
INVESTIGATION REPORT FORM (IRF)

Control No.:	Date Issued
0101	250717

Customer	BROTHER INDUSTRIES PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	D037LJ001	Department	PRODUCTION
Item Description	CARTON DCP-J4250N JPN	Date of Detection	250710
Job Order Number	JO-25-IPD-00814-3	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

ACTUAL: Misalign varnish
REQUIREMENT: Acceptable as long as image is still inside the varnish area.

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2200	89	4.05

Nature of Defect:

MISALIGN VARNISH

Requirement:

Acceptable as long as image is still inside the varnish area.

Actual

Misalign varnish

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.: __250710__	■ Reject / Disposal	☐ Detaching	_____	☐ Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO | 250717	CHARLENE JAN MARIE FLORES | 250723	MICHAEL CASILLANO | 250723	GERALD DE GUZMAN | 250731

I. INVESTIGATION / ANALYSIS

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

System / Training

WHY 1 :   Delay timing of board during varnish process in EQOS.

WHY 2 :   Loose rollers pull nip during varnish process.

WHY 3 :   The roller pull nip during 1st pass was tighter than the 2nd pass (varnish). The 2nd pass should be r ntighter than the 1st pass as the board is already compressed during 1st pass.

Design / Toolings

Process / Material

QA-027-F01 REV.01

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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:	Inclusion in Eqos printing standard machine setting that if r nthe item is 2pass the pull nip setup of the 1st pass should r nbe higher than the 2nd pass. This is due to the materials is r nalready pressed during the 1st pass.	Production IE // 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	16:06
Title	na		
Attendees	na		

Prepared By:	Approved By:
GERALD DE GUZMAN | 250807	N/A
	Department Head

QA-027-F01 REV.01

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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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