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
0102	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: Heavy scoring end to end on class A surface
REQUIREMENT: Acceptable 1 pc light scoring regardless of size (no whitening; no damaged text & images)

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2700	67	2.48

Nature of Defect:

SCORING

Requirement:

Acceptable 1 pc light scoring regardless of size (no whitening; no damaged text & images)

Actual

Heavy scoring end to end on class A surface

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	HANDLING	☐ Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
| 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

Design / Toolings

Process / Material

WHY 1 :   Scoring occurred during stacking/palletizing of item.

WHY 2 :   Glue tab leaves pressure marks on the surface of the item.

WHY 3 :   Glue tab pressed against the product.

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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: Horizontal implementation of glue tab to glue tab r nstacking/palletizing of Brother Items.	Production // 2025-11-29
WHY 2: Provision of guidelines of glue tab to glue tab palletizing.	Production // 2025-11-29

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	2025-11-22	Time	13:46
Title	na		
Attendees	na		

Prepared By:	Approved By:
GERALD DE GUZMAN	251122	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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