

**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)

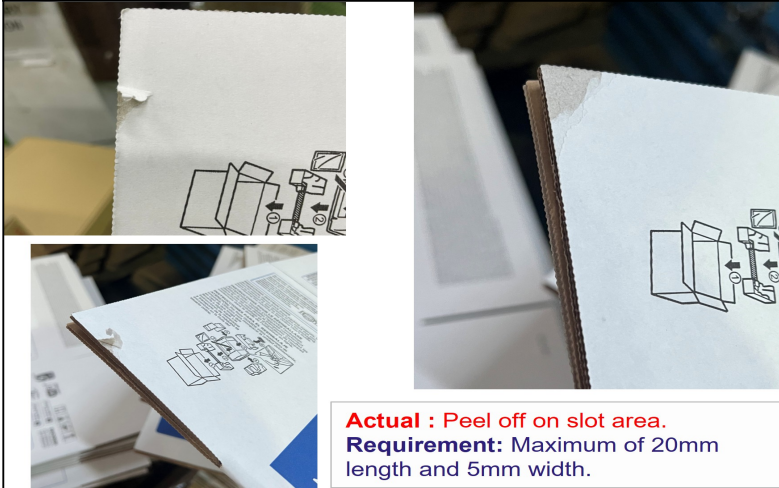
Control No.:

Date Issued

0108

250820

Customer	BROTHER INDUSTRIES PHILIPPINES, INC.	Attention To	REXEL ALMARIO
Item Code	D038PE001.C1	Department	PRODUCTION
Item Description	CARTON MFC-J1260W US/CAN-C; A	Date of Detection	250812
Job Order Number	JO25-M-02513-32A	Section Detected	QA SCREENING 3

ILLUSTRATION OF THE PROBLEM

Actual : Peel off on slot area.
Requirement: Maximum of 20mm length and 5mm width.

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1200	27	2.25

Nature of Defect:

PEEL OFF

Requirement:

Maximum of 20mm length and 5mm width.

Actual

Peel off on slot area.

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250812</u>	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input type="checkbox"/> EQOS <input checked="" type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO 250820	CHARLENE JAN MARIE FLORES 250828	MICHAEL CASILLANO 250901	GERALD DE GUZMAN 250901

I. INVESTIGATION / ANALYSIS**DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)****System / Training****Design / Toolings**

WHY 1 : Peel Off occurs during auto stripping in Diecut S1700

WHY 2 : Presence of uncut liner

WHY 3 : Backward movement of cutting blade

WHY 4 : Loosed blade on the slot portion

WHY 5 : Due to hard materials (NPK280) the 2 bridge on the slot portion got insufficient.

Process / Material

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INVESTIGATION REPORT FORM (IRF)**INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)****System / Training****Design / Toolings**

WHY 1 : na

Process / Material**FINAL CONCLUSION****CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)****WHO / WHEN****Design / Toolings**

WHY 1: Replacement of die blade (with attachment of special r ninstruction regarding additional bridge on the slot portion). Common to D02XFU001.

Tooling // 2025-08-18

WHY 2: Inclusion in Design Review Form the 3 bridge particular to Die cutted RSC Box using EB Flute NPK materials.

Design // 2025-08-01

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	2025-09-08	Time	16:30
Title	na		
Attendees	NA		

Prepared By:**Approved By:**

GERALD DE GUZMAN | 250908

REXEL ALMARIO | 251028

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: -