



**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	
0110		250904	
Customer	MITSUMI PHILIPPINES INC.	Attention To	REXEL ALMARIO
Item Code	19-Y926 A	Department	PRODUCTION
Item Description	19-Y926 A DRT-J583 CARTON BOX-R	Date of Detection	250829
Job Order Number	JO25-M-02706-2	Section Detected	QA SCREENING 2

**ILLUSTRATION OF THE PROBLEM**



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1000	35	3.50
Nature of Defect:		
POOR PRINT		
Requirement:		
There should be no poor print.		
Actual		
Poor print is not acceptable.		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>250829</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 checked="" type="checkbox"/> EQOS <input 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   250904	CHARLENE JAN MARIE FLORES   250908	MICHAEL CASILLANO   250909	GERALD DE GUZMAN   250909

**I. INVESTIGATION / ANALYSIS**

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

**System / Training**

**Design / Toolings**

**Process / Material**

- WHY 1 : Insufficient printing impression to transfer ink properly to substrate.
- WHY 2 : r n Set impression parameter range is already at its maximum adjustment but still cannot achieve r ngood print quality.
- WHY 3 : EQOS settings were not updated for the UPPC s material properties making the current EQOS r nstandard settings not capable for this type of material.

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**INVESTIGATION REPORT FORM (IRF)****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: Conduct study for applicable Eqos standard settings of r nprinting impression for UPPC materials.

M.E. // 2025-10-30

**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	2025-11-03	Time	14:43
Title	NA		
Attendees	NA		

Prepared By:

Approved By:

GERALD DE GUZMAN | 251103

N/A

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: -