

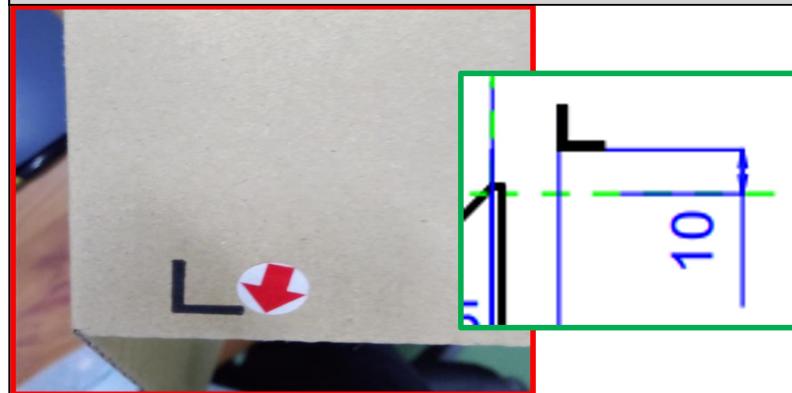
**KANE PACKAGE PHILIPPINE INC.**

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
0111	250908

Customer	SANYO DENKI PHILS INC.	Attention To	REXEL ALMARIO
Item Code	00949344-01	Department	PRODUCTION
Item Description	PRINT SPECIFICATION	Date of Detection	250903
Job Order Number	JO25-M-02713-74	Section Detected	QA SCREENING

ILLUSTRATION OF THE PROBLEM

Requirement: 10mm (± 3 mm printing tolerance)
Actual: 6mm

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1900	69	3.63

Nature of Defect:

MISALIGN PRINT

Requirement:10mm (± 3 mm printing tolerance)**Actual**

6mm

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence No.: 1	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
Date.: 250903	<input type="checkbox"/> For Rework	<input type="checkbox"/> Vertical	<input type="checkbox"/> Appearance
	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Diecut	<input checked="" type="checkbox"/> Process / Method
		<input type="checkbox"/> Detaching	
Issued by	Checked by	Approved by	Received by (Receiving Section)
LESTER JOHN DIOSO 250908	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 : Misaligned diecut at Eterna.

WHY 2 : Random delayed feeding of materials.

WHY 3 : *rn* Stucked up bearing at feeder roller (findings during Eterna machine maintenance c/o Supplier) *r* and worn out engineering plastic in the gripper bar causing misalign gripped.



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: Replacement of worn out machine part.

Production // 2025-11-15

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	2025-11-03	Time	14:48
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			<input type="checkbox"/> Yes <input type="checkbox"/> No	1st				
2nd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	2nd				
3rd Verification of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	3rd				
Effectiveness of Action			<input type="checkbox"/> Yes <input type="checkbox"/> No	4th				
Remarks:				5th				

IV. CLOSURE

Status	Remarks		
Still Open			
Approved by:		Process Owner Acknowledgment: (Receiving Section)	
N/A QA Head	N/A Top Management	N/A Line Leader	N/A Department Head
Date: -	Date: -	Date: -	Date: -