



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

0111

250908

Customer SANYO DENKI PHILS INC.

Attention To REXEL ALMARIO

Item Code 00949344-01

Department PRODUCTION

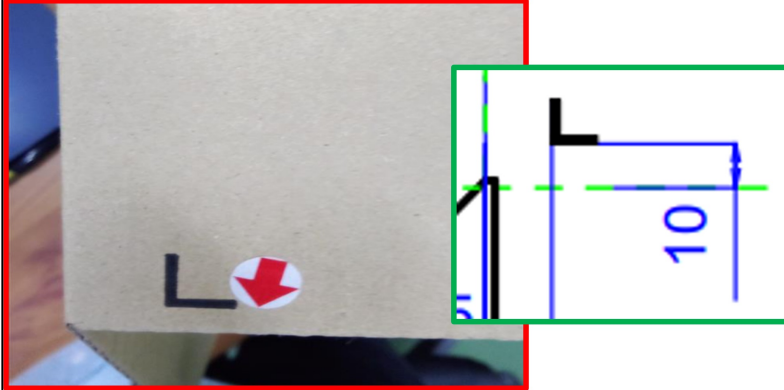
Item Description PRINT SPECIFICATION

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

☒ First
☐ Recurrence No.: 1
Date.: 250903

☐ Hold
☐ Special Acceptance
☐ For Rework
☒ Reject / Disposal

☐ Slotter
☒ EQOS
☐ Diecut
☐ Detaching
☐ Gluing
☐ Vertical
☐ Others

☐ Material
☐ Dimension
☐ Appearance
☒ Process / Method

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

**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)**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**

	Location	Total Stock	NG	Total Good
RM	na	0	0	0
WIP	na	0	0	0
FG	na	0	0	0

C. Reworking

Rework Quantity	NA
Total Good	NA
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

**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)**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: -