



KANEPACKAGE PHILIPPINE INC.

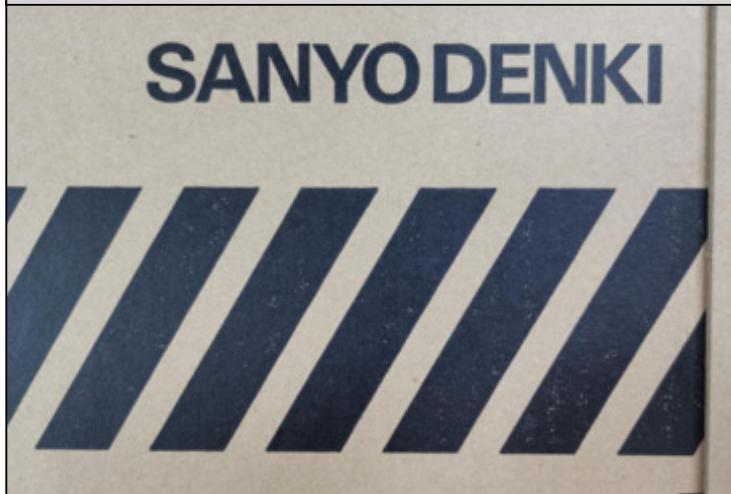
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 5457-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)

Control No.:	Date Issued
0122	251105

Customer	SANYO DENKI PHILS INC.	Attention To	REXEL ALMARIO
Item Code	00939007-01	Department	PRODUCTION
Item Description	Corrugated Carton	Date of Detection	251025
Job Order Number	JO25-M-03289-13	Section Detected	QA SCREENING 5

ILLUSTRATION OF THE PROBLEM



Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
1470	55	3.74

Nature of Defect:

POOR PRINT

Requirement:

Poor print up to level 15

Actual

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN		CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>251023</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 251105	CHARLENE JAN MARIE FLORES 251108	MICHAEL CASILLANO 251111	GERALD DE GUZMAN 251111	

I. INVESTIGATION / ANALYSIS

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

System / Training

WHY 1 : W1 Inconsistent application of ink to the board. r nW2 There are no controlled machine speed settings in the EQOS. r nW3 There is no established machine speed standard in the EQOS.

Design / Toolings

Process / Material



INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)

System / Training

WHY 1 : N/A

Design / Toolings

Process / Material

FINAL CONCLUSION

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

WHO / WHEN

System / Training

Conduct a sample trial to determine the appropriate machine speed in order to eliminate poor print. r n
 WHY 1: r nStandardize the appropriate machine speed to Minimum of 120 BPM and Maximum of 200 BPM according to the result of the conducted study by incorporating them into the Eqos Work Instruction.

Production IE // 2026-01-16

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	N/A
RM	N/A	0	0	0	Total Good	N/A
WIP	N/A	0	0	0		
FG	N/A	0	0	0	Rework PPM (Good)	N/A

B. Orientation	
Date	2026-01-23
Title	Orientation of Eqos WI rev.17
Attendees	All Eqos Operator

Prepared By:	Approved By:
GERALD DE GUZMAN 260120	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: -