

**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)**

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					
				Exceedson poor print level					
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 occurence, 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									

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**INVESTIGATION REPORT FORM (IRF)****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**

WHY 1: Conduct a sample trial to determine the appropriate machine speed in order to eliminate poor print. r n  
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**

	Location	Total Stock	NG	Total Good
RM	N/A	0	0	0
WIP	N/A	0	0	0
FG	N/A	0	0	0

**C. Reworking**

Rework Quantity	N/A
Total Good	N/A
Rework PPM (Good)	N/A

**B. Orientation**

Date	2026-01-23	Time	01:44
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			[ ] 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: -