

**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

0123

251105

Customer	NIDEC SUBIC PHILIPPINES CORPORATION	Attention To	REXEL ALMARIO
Item Code	L00086480	Department	PRODUCTION
Item Description	FLEXWAVE BOX D	Date of Detection	251027
Job Order Number	JO25-M-03358-1	Section Detected	QA SCREENING 2

**ILLUSTRATION OF THE PROBLEM**

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2200	41	1.86

Nature of Defect:

MISALIGN GLUE

Requirement:

Cannot fit lock not acceptable

Actual

Cannot fit lock

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First <input type="checkbox"/> Recurrence No.: <u>1</u> Date.: <u>251027</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 type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input checked="" 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****Design / Toolings**

WHY 1 : W1 The misalign glue (cannot fit lock) issue reoccurs repeatedly. r nW2 The first gluing area is misaligned. r nW3 The folding of the panel is inconsistent. r nW4 The crease is forming in different directions instead of folding in one line only. r nW5 Since the die blade came from repair and was changed from triple crease to single crease the cut creasing blades on both sides were still hitting the items causing the crease to form in different directions.

**Process / Material**

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**INVESTIGATION REPORT FORM (IRF)****INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)****System / Training****Design / Toolings**

WHY 1 : N/A

**Process / Material****FINAL CONCLUSION****CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)****WHO / WHEN****Design / Toolings**

WHY 1: PR for a replacement die blade with a single creasing blade.

Production // 2026-03-13

**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	0	0	0	0	Total Good	N/A
WIP	0	0	0	0	Rework PPM (Good)	N/A
FG	00	0	0	0		

## B. Orientation

Date	2026-03-05	Time	15:55
Title	N/A		
Attendees	N/A		

## Prepared By:

## Approved By:

GERALD DE GUZMAN | 260305

REXEL ALMARIO | 260427

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: -