

**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

0125

251112

Customer: EPSON PRECISION PHILIPPINES INCORPORATED - IJP

Attention To: REXEL ALMARIO

Item Code: 516645900

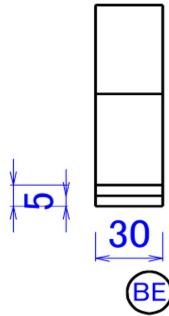
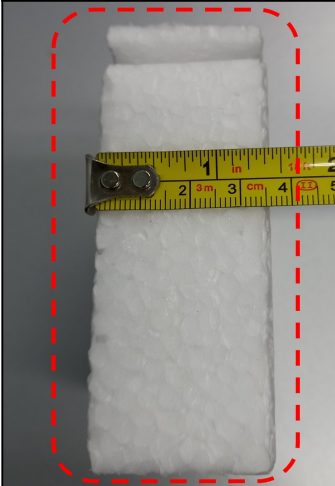
Department: PRODUCTION

Item Description: PAD,SCN,BOTTOM,LR,ASP

Date of Detection: 251105

Job Order Number: JO-25-L-0279-19

Section Detected: QA SCREENING 6

ILLUSTRATION OF THE PROBLEM

Requirement: 30mm thickness
 (Tolerance: +/-2mm)
Actual: 35 mm thickness

Lot Quantity (pcs)

Reject Qty (pcs)

Reject %

800

36

4.50

Nature of Defect:

OFF SPECS

Requirement:

30mm thickness (Tolerance: +/-2mm)

Actual

35 mm thickness

NO. OF OCCURENCE**DISPOSITION****AREA OF OCCURENCE / ORIGIN****CONTENT**

First
 Recurrence No.: 1
 Date.: 251105

Hold
 Special Acceptance
 For Rework
 Reject / Disposal

Slotter
 EQOS
 Diecut
 Detaching
 Gluing
 Vertical
 Others
PRESSING

Material
 Dimension
 Appearance
 Process / Method

Issued by

Checked by

Approved by

Received by (Receiving Section)

LESTER JOHN DIOSO | 251112

CHARLENE JAN MARIE FLORES | 251114

MICHAEL CASILLANO | 251117

GERALD DE GUZMAN | 251117

I. INVESTIGATION / ANALYSIS**DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)****System / Training****Design / Toolings****Process / Material**

WHY 1 : W1 The 30mm requirement had an additional 1 2mm due to increased compression from the pressing machine. r nW2 There was an unexpected increase in the required additional allowance of 1 2mm. r nW3 The operator observed uneven thickness in the planks.

**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 : N/A

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

WHY 1: Oriented the operator to separate planks with uneven thickness since it require different setups during the slicing process to get the 1 2mm additional thickness.

Production // 2026-02-05

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	Rework PPM (Good)	N/A
FG	N/A	0	0	0		

B. Orientation

Date	2026-02-05	Time	08:05
Title	Production Weekly Assembly Meeting (Advised the separation of uneven thickness of planks)		
Attendees	All Production		

Prepared By:**Approved By:**

GERALD DE GUZMAN | 260202

REXEL ALMARIO | 260427

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: -