

**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

0087

250711

Customer: EPSON PRECISION PHILIPPINES INCORPORATED - IJP

Attention To: WEENA APALLA

Item Code: 516555500

Department: KP LIMA PRODUCTION

Item Description: LIONEL MGY ICB FOR ASIA;C

Date of Detection: 250707

Job Order Number: JO-0011022

Section Detected: INLINE QA M3

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
930	39	4.19

Nature of Defect:

MISALIGNED CUT

Requirement:

ITEM SHOULD BE IN GOOD CONDITION NO OCCURENCE OF MISALIGN CUT

Actual

MISALIGN CUT OCCUR ON UPPER FLAP OF PANEL B



GOOD

NO GOOD

NO. OF OCCURENCE

DISPOSITION

AREA OF OCCURENCE / ORIGIN

CONTENT

First
 Recurrence No.: 1
 Date.: 250707

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)

JAM NIKKA MACARAIG | 250711

GLENN MAGSINO | 250801

RODERICK RAMOS | 250801

NOEMI CEPEDA | 250903

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

WHY 1 : The operator failed to follow the standard that has 3 layers of backing tape only.

Design / Toolings**Process / Material**

WHY 1 : peel off occurred during manual process

WHY 2 : During the processing of the item on the die cut an uncut was encountered leading to peeling off.

WHY 3 : The uncut surface on the item was due to the unbalanced distribution of pressure during the cutting process

WHY 4 : since there was an unbalanced distribution of pressure due to the unbalance quantity of backing tape in the pattern sheet

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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****System / Training**

WHY 1: re orientation regarding the standard of three backing tape. if the issue was persists the operator mas be back to zero set up

Production leader // 2025-07-17

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	0
RM	0	0	0	0	Total Good	0
WIP	0	0	0	0	Rework PPM (Good)	0
FG	0	0	0	0		

B. Orientation

Date	2025-07-17	Time	08:00
Title	the standard application of backing tape on pattern sheet		
Attendees	operator on diecut		

Prepared By:

Approved By:

GLEN MAGSINO | 260226

WEENA APALLA | 260226

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	JAM NIKKA MACARAIG	2026-03-04	[/] Yes [] No	1st	JOL-0014180	260901	0	350
2nd Verification of Action	JAM NIKKA MACARAIG		[] Yes [] No	2nd	JOL-0015428	270831	0	300
3rd Verification of Action			[] Yes [] No	3rd	JOL-0029178	260304	0	700
Effectiveness of Action			[] Yes [] No	4th			0	
Remarks:				5th			0	

IV. CLOSURE

Status	Remarks
Still Open	04-mar-26

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: -