

**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: -