

**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

0088

250711

Customer: EPSON PRECISION PHILIPPINES INCORPORATED - IJP

Attention To: WEENA APALLA

Item Code: 516713800 PANEL A

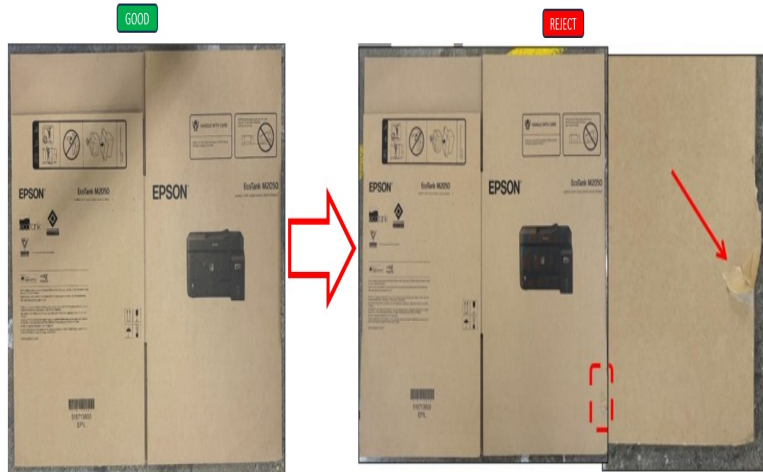
Department: KP LIMA PRODUCTION

Item Description: LUCIDA MGY ICB FOR INDIA

Date of Detection: 250710

Job Order Number: JO-0011144

Section Detected: SEMI AUTO M3

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)

Reject Qty (pcs)

Reject %

900

43

4.78

Nature of Defect:

PEEL OFF

Requirement:

ITEM SHOULD BE IN GOOD CONDITION NO OCCURRENCE OF PEEL OFF

Actual

PEEL OCCUR ON UPPER AND LOWER FLAP SIDE PORTION DUE TO UNCUT

NO. OF OCCURENCE

DISPOSITION

AREA OF OCCURENCE / ORIGIN

CONTENT

First
 Recurrence No.: 1
 Date.: 250710

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

Glen Magsino | 260224

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

WHY 1 : Misalign cut was due to the deformation of PS item

WHY 2 : The deformation of PS was due to applied covered stretch film thin PS prone to deformation during stocking process in the loading area that hit the feeder sensor

WHY 3 : A thin printed sheet hit the cover of upper feeder sensor during mass production

WHY 4 : when printed sheet hits the feeder sensor it will cause to failed to detect the passing of the printed sheet that cause misalign between printed sheet to single face

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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: Operator to pressed the 4 corner of the printed sheet to avoid touching the feeder sensor cover

Operator // 2025-07-28

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	2025-07-10	Time	20:24
Title	notify the concern of the operator about encountered problem		
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			[] 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	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: -