

**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

0090

250716

Customer: EPSON PRECISION PHILIPPINES INCORPORATED - IJP

Attention To: WEENA APALLA

Item Code: 516713800 PANEL A

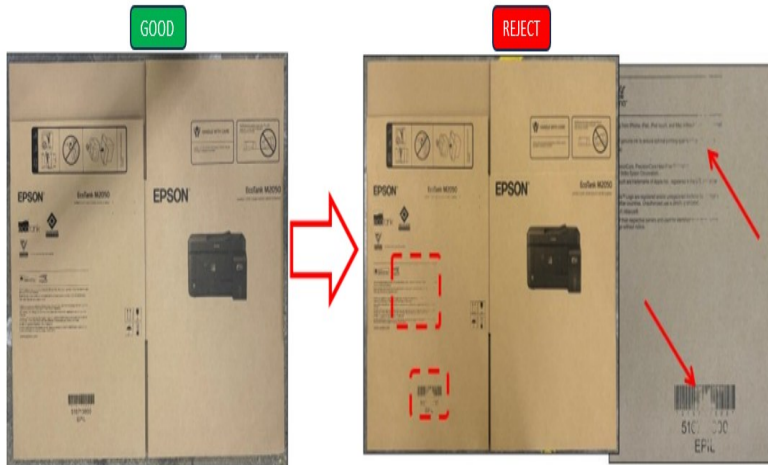
Department: KP LIMA PRODUCTION

Item Description: LUCIDA MGY ICB FOR INDIA

Date of Detection: 250710

Job Order Number: JO-0011144

Section Detected: SEMI AUTO GLUING

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)

Reject Qty (pcs)

Reject %

900

55

6.11

Nature of Defect:

POOR PRINT

Requirement:

THE ITEM SHOULD BE IN GOOD CONDITION OF POOR PRINT

Actual

POOR PRINT OCCUR ON CLASS A ON PRINTER IMAGE & PRINT TEXT

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 | 250716

GLENN MAGSINO | 250801

RODERICK RAMOS | 250801

Glen Magsino | 260225

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

WHY 1 : Poor Print was due to ink that was not properly distributed in the surface of RM

WHY 2 : Ink was not properly distributed due yo uneven surface of RM

WHY 3 : The uneven surface of RM was due to dent marks that contribute the problem of poor print

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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 of all the operators checking of 1 pcs per 20 pcs of output coming from the machine to help the detection of poor printing problems

Production Leader // 2025-07-20

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	2025-07-16	Time	09:38
Title	reminder to operator regarding the implementation of detection problem during Mass production		
Attendees	operator on EQOS		

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: 2025-10-27	PIC: JAM NIKKA AMACARAIG
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	2025-08-26	[/] Yes [] No	1st	JOL-0012904	250730	0	-40
2nd Verification of Action	JAM NIKKA MACARAIG	2025-09-03	[/] Yes [] No	2nd	JOL-0014027	250819	0	1000
3rd Verification of Action	JAM NIKKA MACARAIG	2025-10-27	[/] Yes [] No	3rd	JOL-0014373	250826	0	850
Effectiveness of Action	JAM NIKKA MACARAIG	2025-10-27	[/] Yes [] No	4th	JOL-0014703	250903	0	160
Remarks:				5th	JOL-0018399	251027	2	2800

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: -