

**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

0092

250731

Customer: EPSON PRECISION PHILIPPINES INCORPORATED - IJP

Attention To: WEENA APALLA

Item Code: 516700300

Department: KP LIMA PRODUCTION

Item Description: STRATOS SA ICB FOR AMERICA;D

Date of Detection: 250728

Job Order Number: JO-0012305

Section Detected: SD1800

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)

Reject Qty (pcs)

Reject %

1000

40

4.00

Nature of Defect:

PEEL OFF

Requirement:

THE ITEM BE IN GOOD CONDITION WITHOUT ANY OCCURENCE OF PEEL OFF

Actual

THE PEEL OFF OCCURED ON UPPER FLAP DUE TO UNCUT

NO. OF OCCURENCE

DISPOSITION

AREA OF OCCURENCE / ORIGIN

CONTENT

First
 Recurrence No.: 1
 Date.: 250728

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 | 250731

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 backing tape only

Design / Toolings**Process / Material**

WHY 1 : peel off occurred during on manual process

WHY 2 : During the process of the item on the die cut an uncut was encountered leading to peel off

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

WHY 4 : since there was an unbalanced distribution of the pressure due to the unbalanced 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 : na

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 tapes. If the issue persists the operator r nmas
 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	20:26
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: 2025-09-22	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	2025-09-05	[/] Yes [] No	1st	JOL-0013424	250811	0	1800
2nd Verification of Action	JAM NIKKA MACARAIG	2025-09-15	[/] Yes [] No	2nd	JOL-0014535	250827	0	1100
3rd Verification of Action	JAM NIKKA MACARAIG	2025-09-22	[/] Yes [] No	3rd	JOL-0015138	250905	0	1000
Effectiveness of Action	JAM NIKKA MACARAIG	2026-04-22	[/] Yes [] No	4th	JOL-0015870	250915	0	310
Remarks:				5th	JOL-0016125	250922	0	1000

IV. CLOSURE

Status	Remarks
Still Open	26-mar-04

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: -