

**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

0094

251003

Customer: EPSON PRECISION PHILIPPINES INCORPORATED - IJP

Attention To: WEENA APALLA

Item Code: 5163364-00

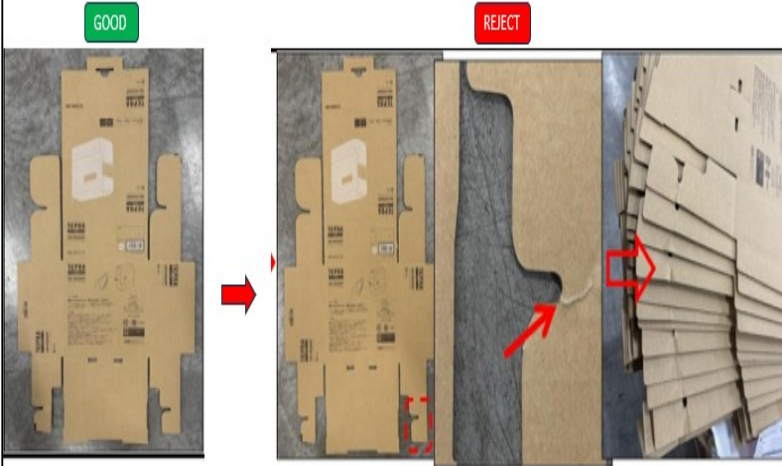
Department: KP LIMA PRODUCTION

Item Description: MUFFIN CARTON BOX ,CK81010

Date of Detection: 251002

Job Order Number: JOL-0016992

Section Detected: SCREENING QA

**ILLUSTRATION OF THE PROBLEM**

Lot Quantity (pcs)

Reject Qty (pcs)

Reject %

600

24

4.00

Nature of Defect:

DAMAGED

Requirement:

ITEM SHOULD BE IN GOOD CONDITION WITH NO OCCURANCE OF DAMAGED

Actual

THE ACTUAL DAMAGED OCCURED DURING MANUAL DETACHING

NO. OF OCCURENCE

DISPOSITION

AREA OF OCCURENCE / ORIGIN

CONTENT

First  
 Recurrence No.: 1  
 Date.: 251002

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 | 251003

MELFORD ANONUEVO | 251009

RODERICK RAMOS | 251009

Glen Magsino | 260225

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

WHY 1 : Damaged occur during the manual stripping process

WHY 2 : during the pulling of the scrap material the affected portion also pulled out causing to damaged

WHY 3 : The affected portion has no cutting blade

WHY 4 : The stripping process of the scrap is not considered during the design of the die cut blade

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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**

Design / Toolings

WHY 1: Attached a sutera blade to cut on the affected portion and separate it during pulling of the outer scrap

produciton tooling // 2025-10-06

**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	2025-10-06	Time	09:30
Title	Orientation on the operator regarding to proper manual detaching		
Attendees	detaching operator		

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	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: -