

**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

0095

251007

Customer: EPSON PRECISION PHILIPPINES INCORPORATED - IJP

Attention To: WEENA APALLA

Item Code: 5150864-01

Department: KP LIMA PRODUCTION

Item Description:

Date of Detection: 251003

Job Order Number: JOL-0016953

Section Detected: SD1800/SHIFT B

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)

Reject Qty (pcs)

Reject %

2900

71

2.45

Nature of Defect:

PEEL OFF

Requirement:

ITEM SHOULD BE IN GOOD CONDITION NO OCCURRENCE OF PEEL OFF

Actual

PEEL OFF OCCUR ON THE UPPER FLAP CLASS B

NO. OF OCCURENCE

DISPOSITION

AREA OF OCCURENCE / ORIGIN

CONTENT

First
 Recurrence No.: 1
 Date.: 251003

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 | 251007

MELFORD ANONUEVO | 251009

RODERICK RAMOS | 251010

Glen Magsino | 260226

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

WHY 1 : Peel off occur during stripping process on diecut

WHY 2 : During the stripping process the nick mark was not fully cut resulting to peel off

WHY 3 : Numerous nick mark was observed on the cutting mark

WHY 4 : Numerous nick was made to avoid loose board

WHY 5 :

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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: standardize the position of the nick mark on the gripper side and put marking on the pattern sheet of the location of the nick mark to avoid patching on the said area

production tooling // 2025-09-01

Process / Material

WHY 1: strengthen the control on the changes of the blade layout by implementing on the request for tooling relay out from approval

production leader // 2025-09-01

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	2026-02-26	Time	04:47
Title	N/A		
Attendees	N/A		

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		2026-02-07	[/] 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: -