

**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

0097

260108

Customer	EPSON PRECISION PHILIPPINES INCORPORATED - IJP	Attention To	WEENA APALLA
Item Code	513671100	Department	KP LIMA PRODUCTION
Item Description	OUTER CARTON BOX	Date of Detection	260107
Job Order Number	JOL-00023241	Section Detected	SA-2600

ILLUSTRATION OF THE PROBLEM

Lot Quantity (pcs)	Reject Qty (pcs)	Reject %
2500	112	4.48
Nature of Defect:		
PEEL OFF		
Requirement:		
THE ITEM SHOULD BE IN GOOD CONDITION NO OCCURENCE OF PEEL OFF		
Actual		
THE PEEL OFF OCCUR ON LOWER PORTION B/C		

NO. OF OCCURENCE	DISPOSITION	AREA OF OCCURENCE / ORIGIN	CONTENT
<input type="checkbox"/> First <input checked="" type="checkbox"/> Recurrence No.: <u>0</u> Date.: <u>260107</u>	<input type="checkbox"/> Hold <input type="checkbox"/> Special Acceptance <input type="checkbox"/> For Rework <input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Slotter <input checked="" type="checkbox"/> EQOS <input type="checkbox"/> Diecut <input type="checkbox"/> Detaching <input type="checkbox"/> Gluing <input type="checkbox"/> Vertical <input type="checkbox"/> Others	<input type="checkbox"/> Material <input type="checkbox"/> Dimension <input type="checkbox"/> Appearance <input checked="" type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)
JAM NIKKA MACARAIG 260108	MELFORD ANONUEVO 260108	RODERICK RAMOS 260114	Glen Magsino 260120

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

WHY 1 : Peel off Encountered in EQOS Process mass Production r nEdge of the ICB hit the front guide of the feeder section r nEdge of the ICB hit the front guide of the feeder section

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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 : Peel off defect not detected due to occurrence is random and not capture during sampling inspection

FINAL CONCLUSION**CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)****WHO / WHEN****System / Training**

WHY 1: Conduct orientation to EQOS operator for the defect encountered and advised if the warpage is more than the allowed limit don't process the material and conduct repalletizing and reconditioning.

Prod Leader // 2026-01-21

Process / Material

WHY 1: Apply the principle of moving the feeder guide where the is no warpage same as the concept for VOION E FLUTE MATERIAL

Prod Leader // 2026-01-21

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	NA	0	-0	0	Total Good	0
WIP	NA	0	0	0	Rework PPM (Good)	0
FG	NA	0	0	0		

B. Orientation

Date	2026-01-21	Time	06:00
Title	Adjustment to avoid peel off defect specially for warp material		
Attendees	EQOS Operator and Leaders		

Prepared By:**Approved By:**

GLEN MAGSINO | 260206

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: 2026-02-05	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	2026-01-30	[/] Yes [] No	1st	JOL-0025006	260126	0	1100
2nd Verification of Action	JAM NIKKA MACARAIG	2026-02-05	[/] Yes [] No	2nd	JOL-0025106	251126	0	1000
3rd Verification of Action	JAM NIKKA MACARAIG	2026-02-05	[/] Yes [] No	3rd	JOL-25579	260130	5	2060
Effectiveness of Action	JAM NIKKA MACARAIG	2026-02-05	[/] Yes [] No	4th	JOL-26116	260205	0	550
Remarks:				5th	JOL-26039	260205	0	1550

IV. CLOSURE

Status	Remarks
Still Open	

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: -