



KANEPACKAGE PHILIPPINE INC.

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT FORM (IRF)

☐ Inhouse Detection ☒ Customer Claim Date Issued: JUNE 14, 2022

Customer	EPSON VP	Attention To	GERALD DE GUZMAN
Item Code	5151421-00	Department	KPLAGUNA-PRODUCTION
Item Description	CARTON BOX (STD;B)	Date of Detection	JUNE 14, 2020
Job Order Number	JO-22-L-00135-1 (A) JO-22-L-00135-1 (B)	Section Detected	EPSON VP

ILLUSTRATION OF THE PROBLEM		Major	Minor
		☒	☐

Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
100	1	1.00%

Nature of Defect:

POOR PRINT

Requirement:

ITEM SHOULD BE IN GOOD CONDITION NO POOR PRINT

Actual:

NO. OF OCCURRENCE		DISPOSITION		AREA OF OCCURRENCE / ORIGIN		CONTENT
☒	First	☐	Hold	☐	Slotter	☐ Material
☐	Recurrence	☐	Special Acceptance	☒	EQOS	☐ Dimension
	No.:	☐	For Rework	☐	Diecut	☒ Appearance
	Date: _____	☒	Reject / Disposal	☐	Detaching	☐ Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
 m. Ayres QA-IE Staff	 QA Supervisor	QA Asst. Manager	Head/ Supervisor

I. INVESTIGATION / ANALYSIS

DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)	INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)
1. The company's internal control system is not strict enough, leading to the leakage of information. 2. The company's management is not strict enough, leading to the leakage of information. 3. The company's employees are not strict enough, leading to the leakage of information.	1. The company's internal control system is not strict enough, leading to the leakage of information. 2. The company's management is not strict enough, leading to the leakage of information. 3. The company's employees are not strict enough, leading to the leakage of information.

System / Training		Why 1:	Why 2:	Why 3:	Why 4:	Why 5:

Design / Toolings	
Why 1:	
Why 2:	
Why 3:	
Why 4:	
Why 5:	

Process / Material	Why 1:	Why 2:	Why 3:	Why 4:	Why 5:

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INVESTIGATION REPORT FORM (IRF)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE****OUTFLOW ROOTCAUSE**

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)									
CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)									
A. Sorting Result									
Actions to be done to eliminate recurrence									
Who / When									
RM									
WIP									
FG									
System									
B. Orientation									
Design / Tools									
Process									
C. Reworking									
Rework Quantity									
Total Good									
Rework Percentage (Good)									
Date Conducted: _____ PIC: _____									
II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)									
Identified Rootcause									
Recommendation									
III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)									
Remarks									
Implemented?									
[] Yes [] No									
[] Yes [] No									
[] Yes [] No									
[] Yes [] No									
[] Yes [] No									
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improvement action.									
IV. CLOSURE									
Approved by:									
Process Owner Acknowledgment: (Receiving Section)									
Status:									
Closed									
Still Open									
Re-Issue IRF									
QA Supervisor									
QA Asst. Manager									
Line Leader									
Date:									
Date:									

99-1 pallet

13204, Told 05/18



Kanepackage Philippine Inc.

JOB ORDER

PR-001-F12-REV.00

MEMO: - None -

de Jesus, Melissa
SO #: TO22-L-00135

Customer : EPSON PRECISION PHILIPPINES INCORPORATED - VP

JOB ORDER:

ITEM CODE: 515142100 PANEL A



Netsuite Itemcode : 515142100 PANEL A

JO-22-L-00135-1

Item Description : CARTON BOX (STD; B)_PH (PART A)

QTY: 100

DELIVERY DATE:

2022-05-18

CREATED BY:

Dario, Engleberth Nunez

DATE RELEASED:

2022-05-11

Raw Material Code:

Qty To Be Used: 100

Cut Size: N/A

Actual Issued: 100

DR#: 067746-PA

SUPPLIER:

Tooling Reference # 0-117-224

Control/Batch #:

RM Issued By:

Bayer 5/10

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN	REJECTED QTY		REMARKS
		Operator	ME/QA			INHOUSE	SUPPLIER	
1. EQOS	5/18	HKMMC		99	1 G R			fighting on 4
2. PRODUCTION PACKING					G R			
3. FOR TRANSFER TO KP LIMA					G R			
4.					G R			
5.					G R			
6.					G R			
7.					G R			
8.					G R			
9.					G R			
10.					G R			

QUALITY ASSURANCE DEPARTMENT

ENCLOSURE

REJECTION HISTORY

Customer Claim:

Notes:

5/19 chelle

REMARKS

PROD PLAN: ADD #0 PLAN 2022-138

99 to 49 New 5/18/24

99-1p91k2



Kanepackage Philippine Inc.

JOB ORDER

PR-001-F12-REV.00

MEMO: - None -

de Jesus, Melissa
SO #: TO22-L-00135

Customer : EPSON, PRECISION PHILIPPINES INCORPORATED - VP		JOB ORDER:	
ITEM CODE: 515142100 PANEL B		JO-22-L-00135-2	
Netsuite Itemcode : 515142100 PANEL B			

Item Description : CARTON BOX (STD; B)_PH (PART B)		DATE RELEASED:	2022-05-11
QTY: 100	DELIVERY DATE: 2022-05-18	CREATED BY: Dario, Engleberth Nunez	

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
615X970 CBF NPK180	100		N/A	100		pu

Tooling Reference # 20-113-224 Control/Batch #: RM Issued By: Bay 5/19

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN	REJECTED QTY		REMARKS
		Operator	ME/QA			INHOUSE	SUPPLIER	
1. EQOS	5/18	HK MC	R 5/18 Rising	99	1 G R			pg tag 9/18
2. PRODUCTION PACKING					G R			
3. FOR TRANSFER TO KP LIMA					G R			
4.					G R			
5.					G R			
6.					G R			
7.					G R			
8.								
9.								
10.								

Customer Claim:	REJECTION HISTORY
Notes:	

5/19

chelle

WROUST OUT

NAME: Don DATE: 5/18

REMARKS
PROD PLAN: ADD #0 PLAN 2022-138

for 99 to pg none 5/18/24

**INVESTIGATION REPORT FOR POOR PRINT OF
EPPI VP 515142100 CZECH CARTON BOX**

DIRECT CAUSE PROCESS/MATERIAL	W1	The corrugated board issued to Eqos have submerged portion.
	W2	The Eqos cyrel cant penetrate in the submerged portion of corrugated board that caused poor print or broken image.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	Broken image cannot detected during sampling since the machine speed during mass production is 120bpm (Board Per Minute) and only 1pc is affected.
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PRODUCTION CORRECTIVE ACTION

If ok to QA to conduct 100% sorting of raw materials during in coming	
PIC:	QA

PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
ASST. MANAGER