



Kanepackage Philippine Inc.

PR-001-F12-REV.00

MEMO: - None -

Mark Jefferson II Jorvina Pacia
SO #: SO24-R-00075 REV2

JOB ORDER

Customer: LINE SEIKI PHILS. INC.

ITEM CODE: RM-ZRY002C

Netsuite Itemcode: RM-ZRY002C

JOB ORDER:



JO24-R-00075-2

Item Description: STANDARD BOX

QTY: 2000

DELIVERY DATE:
2024-04-26CREATED BY:
Javier, Charlotte NicoleDATE RELEASED:
2024-04-24

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
RM-ZRY002C.c1	2000		None			
RM-ZRY002C.c2	2000		None			
	0					
	0					

Tooling Reference # _____ Control/Batch #: _____ RM Issued By: _____

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN		REJECTED QTY		REMARKS
		Operator	ME/QA		G	R	INHOUSE	SUPPLIER	
1. GLUING SD 1800	24/04/30	Chell mao Either		1,620 375	G	R			
2. LOT NUMBERING	5h		Good	2,000	G	R			
3. SCREENING	8/2		Enlightenment John	1,260	G	R	735		
4.	05/03		JIM	340	G	R			NOTE: SAME FROM DEWONK WEDIC GLUE
5.					G	R			
6.					G	R			
7.					G	R			
8.	QA INPUT DATE 24/05/02 TIME 10:50 QTY 1,995								
9.	QA INPUT DATE 24/05/02 TIME 10:50 QTY 1,260								
10.	WIP REJECT DATE 24/05/02 TIME 10:50 QTY 735								

REJECTION HISTORY

Customer Claim: [2023 08 31] MAJOR CLAIM: Misalign Glue (3pcs. NG / 1,794pcs.)

Notes: NOTE: Sort the items after EQOS process. Separate the boards with 3mm-print movement so that the Diecut process will be able to easily adjust its setup/parameters.

REMARKS

PROD PLAN: ADD #8 PLAN 2024-117
IN-HOUSE REJECTION HISTORY: misalign print

KANEPACKAGE PHILIPPINE, INC. REV.00	
CUSTOMER	LINE SEIKI PHILS. INC.
ITEM CODE	RM-ZRY002C
ITEM DESCRIPTION	STANDARD BOX
LOT NUMBER	240504-JO24-R-00075-2
QUANTITY	20 pcs.
QUANTITY	20 pcs.
BoHS OK	
QA: KP052	
MP QA PASSED	
MP QA PASSED	

1620 to QA. Anten 4/30 Atmick

Set # 8 Plan 2024-117
*** UNCONTROLLED COPY FOR JOB ORDER ***

6

5

4

Issued by: 24-04-23

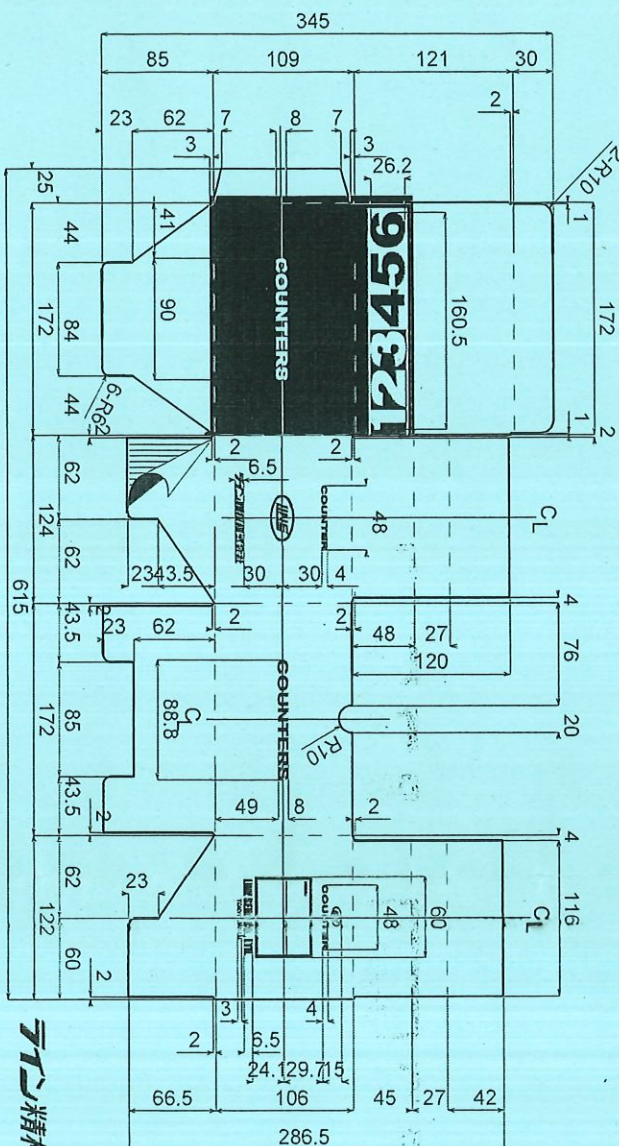
2

1

BOX SPECIFICATION				
Inner Dimension	169 X 121 X 100mm			
Outer Dimension				
Joint Flap	GLUING INSIDE			
Illustration	SMOOTH SURFACE			
Bursting Strength	N/A			
BCT	N/A			
ECT	N/A			
PRINT COLOR	1	2	3	
Flexo	EQ-10 BROWN			
Digital print	N/A			
Offset	N/A			
Varnish Coating	N/A			
BLADE REQUIREMENTS				
WOOD				
Type	Height	Thickness	Pitch	Length
Cutting Blade				
Waved Blade				
Perforation				
Half-Cut				
Creasing Line				

NOTES:

DO NOT DISPOSE THE PAD, USE
BLADE OF STANDARD BOX



LINE
COUNTER
MODEL
LINE SEIKI CO., LTD.
TOKYO JAPAN

ライン精機株式会社

CUSTOMER: LINE SEIKI
ITEM DESCRIPTION/PART CODE: CUSTOMERS SUPPLIED REFERENCE NO:

TOLERANCE
DIMENSION: +/- 3mm
MATERIAL: B FLUTE
(TX200/CM125/TX200)

STANDARD BOX

ITEM KEY

1/4

PRINT:

1/3

LEGEND:

UNIT: mm

PRINTING

CREASING

HALF-CUT

PERFORATION

PACKING INSTRUCTION:

20 PCS./BUNDLE

KANEPACKAGE PHIL. INC.
45 Ring Rd, LSP 2 Bldg, Linares Calamba, Laguna
Tel. Nos.: (039) 45-7185 to 89
Fax Nos.: (039) 45-7170 to (039) 45-6002

REV. # 231201

DATE

REASON

ADDITIONAL NOTE ON
BLADE DRAWING AND PAD

F.Y.S.M.A.E.L.
REQUESTED
BY:

REASON

DATE

REASON

DATE

REASON

DATE

REASON

DATE

4YRS 7moths
NEED INSPECTING DATA

OK

*



Kanepackage Philippine Inc.

MEMO: - None -

PR-001- V.00

JOB ORDER

Mark Jefferson II Jorvina Pacia
SO #: SO24-R-00075 REV2

Customer : LINE SEIKI PHILS. INC.		JOB ORDER:	
ITEM CODE: RM-ZRY002C.c1		JO24-R-00075-2A	
Netsuite Itemcode : RM-ZRY002C.c1			
Item Description : STANDARD BOX; A			
QTY: 2000	DELIVERY DATE: 2024-04-26	CREATED BY: Javier, Charlotte Nicole	DATE RELEASED: 2024-04-24

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
475X635 BF TX200	2000	20	475X635 BF	2020	225743	N

Tooling Reference # 5-18 C-112 410 Control/Batch #: _____ RM Issued By: Bur 4/25

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN		REJECTED QTY		REMARKS
		Operator	ME/QA		G	R	INHOUSE	SUPPLIER	
1. EQOS	4/25	CCMED	JHANK	2020	1				MUSING PRINT TEMPORARY APPROVED
2. DIECUT S1700	4/29	NJ/RJ	240429 JHANK	71301	6	1			FOR REPLACEMENT OF AFFECTED CYREL
3. DETACHING 1	4/30	DS		2014	G	R			
4. TRANSFER TO GLUING SD 1800		Ched Mac Epheer		1,620 375	G	R			
5. LOT NUMBERING					G	R			
6. SCREENING	5/2		5/2/2024 Joseph	11260	G	R	735		
7.					G	R			
8.									
9.									
10.									

REJECTION HISTORY
Customer Claim:
Notes:

REMARKS
PROD PLAN: ADD #8 PLAN 2024-117

WHOUSE OUT	
NAME: <u>Joe</u>	DATE: <u>4/25</u>

2024-117
*** UNCONTROLLED COPY FOR JOB ORDER ***

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NOTES:

**DO NOT DISPOSE THE PAD, USE
BLADE OF STANDARD BOX**



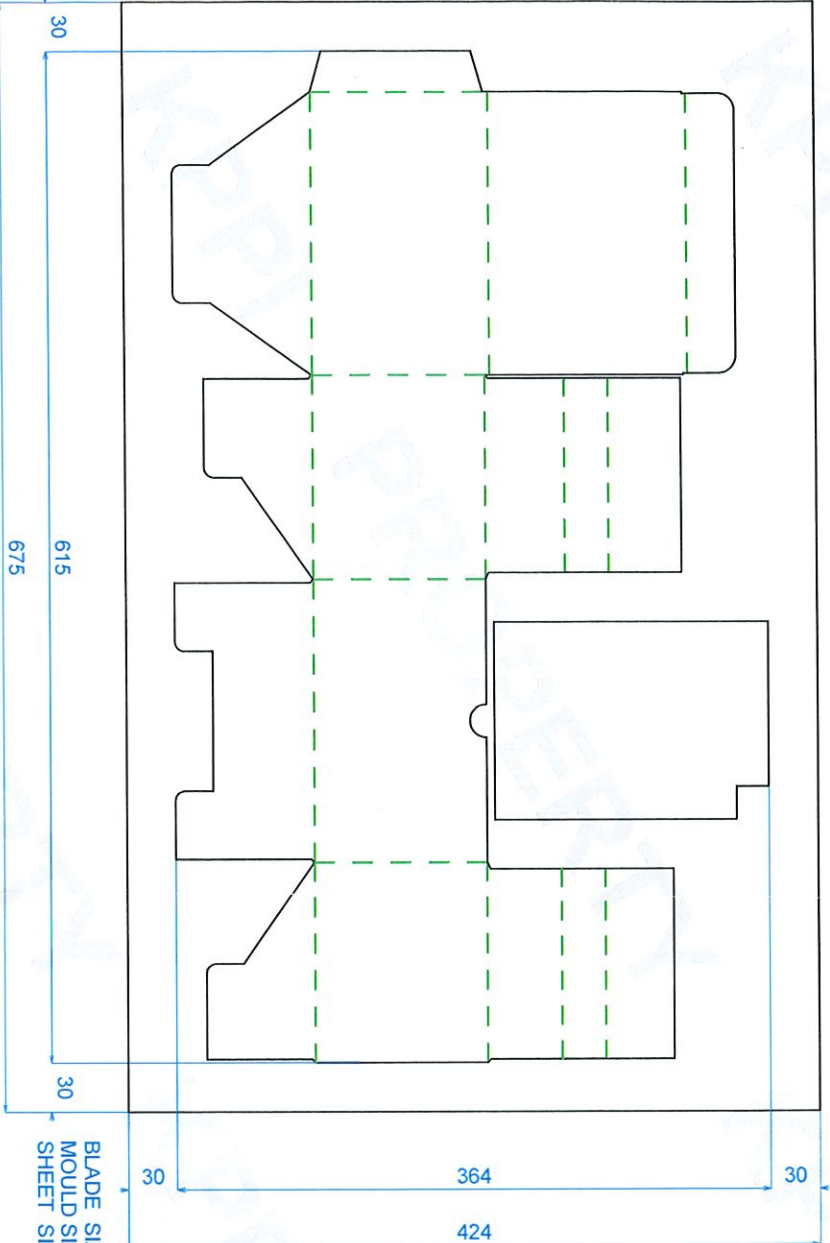
ライオン精機株式会社

246425
J. Reilborn

[illegible]

BOX SPECIFICATION			
Inner Dimension	169 X 121 X 100mm		
Outer Dimension			
Joint Flap	GLUING INSIDE		
Illustration	SMOOTH SURFACE		
Bursting Strength	N/A		
BCT	N/A		
ECT	N/A		
PRINT COLOR	1	2	3
Flexo	EQ-10 BROWN		
Digital print	N/A		
Offset	N/A		
Varnish Coating	N/A		
BLADE REQUIREMENTS			
WOOD	424 X 675	T = 15 mm	
Type	Height	Thickness	Pitch Length
Cutting Blade	23.8	2 PTS	3292
Waved Blade			
Perforation			
Half-Cut			
Creasing Line	22.75	2 PTS	2070

NOTES:
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 DO NOT DISPOSE THE PAD, USE
 BLADE OF STANDARD BOX



BLADE SIZE : 364 X 615
 MOULD SIZE : 424 X 675
 SHEET SIZE : 475 X 635

CUSTOMER : LINE SEIKI		TOLERANCE		MATERIAL: B FLUTE		PACKING INSTRUCTION : 20 PCS./BUNDLE		A. DE ROYAS		M. ALONSA GAY		S. LUBAG	
ITEM DESCRIPTION/PART CODE: RM-ZRY002C STANDARD BOX AND BOTTOM PAD		CUSTOMERS SUPPLIED REFERENCE NO: N/A		DIMENSION: +/- 3mm		(TX200/CM125/TX200)		P 1		7		13	
ITEM KEY: LSP-0005-01AB-08		DATE: 231201		REASON: ADDITIONAL NOTE ON BLADE DRAWING AND PAD		F. YSMARCEL REQUESTED BY:		R 2		8		14	
REV. # 8		DATE: 231201		REASON: ADDITIONAL NOTE ON BLADE DRAWING AND PAD		F. YSMARCEL REQUESTED BY:		O 3		9		15	
REV. # 5		DATE: 231201		REASON: ADDITIONAL NOTE ON BLADE DRAWING AND PAD		F. YSMARCEL REQUESTED BY:		C 4		10		16	
REV. # 4		DATE: 231201		REASON: ADDITIONAL NOTE ON BLADE DRAWING AND PAD		F. YSMARCEL REQUESTED BY:		E 5		11		17	
REV. # 3		DATE: 231201		REASON: ADDITIONAL NOTE ON BLADE DRAWING AND PAD		F. YSMARCEL REQUESTED BY:		S 6		12		18	
REV. # 2		DATE: 231201		REASON: ADDITIONAL NOTE ON BLADE DRAWING AND PAD		F. YSMARCEL REQUESTED BY:		S 6		12		18	
REV. # 1		DATE: 231201		REASON: ADDITIONAL NOTE ON BLADE DRAWING AND PAD		F. YSMARCEL REQUESTED BY:		S 6		12		18	



KANEPACKAGE PHILIPPINE INC.		SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)		Control No. SQA-05-000028	
I. Item Information					
Customer	LINE SEIKI PHILS. INC.		Inspection Date	24/05/02	Shift: ☐ Day ☒ Night
Location	Rosario		Delivery Date	240426	
Item Code	RM-ZRY002C		Job Order No.	JO24-R-00075-2	
Item Description	STANDARD BOX		Job Order Qty.	2,000	
Model	N/A		Inspection Method	☒ 100% ☐ Sampling	
Drawing Revision No.	08		Delivery Receipt No.	225743	
External Provider	75		Gluing Process	☐ Manual Gluing ☐ Semi-Auto Gluing	
				☒ SD1800	
II. Dimensional Inspection					
Time Conducted Sample #1: 6:00			Time Conducted Sample #2: 8:20		Time Conducted Sample #3: 10:20
Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	169	+1 -3	169	168	168
2	121		122	121	121
3	100		107	107	100
4	90		91	90	90
5	81		80	80	80
6	44		44	44	43
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					
23					
24					
25					
26					
27					
28					
29					
30					
Measuring Tools ☒ Meter Tape ☐ Thickness Gauge ☐ Weighing Scale ☐ Steel Ruler ☐ Caliper ☐ Zahn Cup ☐ Stopwatch ☐ Moisture Content Tester					
III. Visual Inspection (Leave cell blank if no detection on Applicable Criteria. Ensure to put actual quantity of defect based on classification or "N/A" if Not Applicable)					
A. CORRUGATED ITEM / BOX / DANPLA			In-house	External Provider	Total Quantity
Scoring			5		5
Grain Direction					
Paper Shade (Off Color)					
Bubbles					
Blister					
Wrinkle				1	1
Delamination					
Uneven Kraft liner			N		
Warpage					
Cracking on edge					
Bursting / Bursting on Edge (Crowfeet)					
Wrong die-cut orientation					
Inverted die-cut					
Close Gap/ Wide Gap					
Print Color :					
Missing Print/ Character					
Blotted Print					
Smeared Print					
Other Print Defect : Poor/misalign			87		87
Linemark					
Fish-eye					
Stain : stain			3		3
Excess Glue					
Gluing Defect : Weak Glue			417		417
Worn-out					
Dent					
Punctured					
Tear-off					
Peel-off					
Damages :					
Others : Scum / Extra Fold			224		224
			221/3		
B. PALLET			In-house	External Provider	Total Quantity
Condition of Wood			N/A	N/A	N/A
Rusty Nail			N/A	N/A	N/A
Warping			N/A	N/A	N/A
Fumigation Stamp			N/A	N/A	N/A
Crack/ Damages			N/A	N/A	N/A
Others			N/A	N/A	N/A
C. CORRUGATED PALLET			In-house	External Provider	Total Quantity
Color of Carton (Discoloration)			N/A	N/A	N/A
Flute of Material			N/A	N/A	N/A
Type of Adhesion			N/A	N/A	N/A
Adhesion of Runner			N/A	N/A	N/A
Rusty Wire			N/A	N/A	N/A
Wrong Orientation			N/A	N/A	N/A
Damages :			N/A	N/A	N/A
Others :			N/A	N/A	N/A
D. MOULDED ITEMS			In-house	External Provider	Total Quantity
Poor Fusion			N/A	N/A	N/A
Chip Off			N/A	N/A	N/A
Warp / Deform			N/A	N/A	N/A
Crack			N/A	N/A	N/A
Broken			N/A	N/A	N/A
Scratches			N/A	N/A	N/A
Foreign Materials			N/A	N/A	N/A
Wet / Moist			N/A	N/A	N/A
Dirt			N/A	N/A	N/A
Stain :			N/A	N/A	N/A
Discoloration			N/A	N/A	N/A
Excess Flashes			N/A	N/A	N/A
Others :			N/A	N/A	N/A

KANEPACKAGE PHILIPPINE INC.		SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)		Control No. SQA-05-000028	
I. Item Information					
Customer	LINE SEIKI PHILS. INC.		Inspection Date	240509	
Location	Rosario		Delivery Date	240426	
Item Code	RM-ZRY002C		Job Order No.	JO24-R-00075-2	
Item Description	STANDARD BOX		Job Order Qty.	2,000	
Model	N/A		Inspection Method	☒ 100% ☐ Sampling	
Drawing Revision No.	08		Delivery Receipt No.	225783	
External Provider	T-S		Gluing Process	☐ Manual Gluing ☐ Semi-Auto Gluing ☒ SD1800	
II. Dimensional Inspection					
Time Conducted Sample #1: 6:00			Time Conducted Sample #2: 6:15		Time Conducted Sample #3: 7:10
Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	169	+3mm	169	169	170
2	121		122	121	121
3	100		101	100	100
4	92		90	91	90
5	41		41	42	41
6	44		44	44	44
7					
8					
9					
10					
11					
12					
13					
14					
15					
Measuring Tools ☒ Meter Tape ☐ Thickness Gauge ☐ Weighing Scale ☐ Steel Ruler ☐ Caliper ☐ Zahn Cup ☐ Stopwatch ☐ Moisture Content Tester					
III. Visual Inspection (Leave cell blank if no detection on Applicable Criteria. Ensure to put actual quantity of defect based on classification or "N/A" if Not Applicable)					
A. CORRUGATED ITEM / BOX / DANPLA			In-house	External Provider	Total Quantity
Scoring			1		1
Grain Direction					
Paper Shade (Off Color)					
Bubbles					
Blister					
Wrinkle			2		2
Delamination			2		2
Uneven Kraft liner					
Warpage			1		1
Cracking on edge					
Bursting / Bursting on Edge (Crowfeet)			3		3
Wrong die-cut orientation					
Inverted die-cut					
Close Gap/ Wide Gap					
Print Color :					
Missing Print/ Character					
Blotted Print					
Smeared Print					
Other Print Defect: Misaligned print			4		4
Linemark					
Fish-eye				1	1
Stain: glue stain paper stain			20	1	20+1
Excess Glue			2		2
Gluing Defect: misaligned glue			1		1
Worn-out					
Dent			1		1
Punctured			1		1
Tear-off			3		3
Peel-off			15		15
Damages: EXTRA FOLD			4		4
Others: SCUM			15		15
B. PALLET			In-house	External Provider	Total Quantity
Condition of Wood			N/A	N/A	N/A
Rusty Nail			N/A	N/A	N/A
Warping			N/A	N/A	N/A
Fumigation Stamp			N/A	N/A	N/A
Crack/ Damages			N/A	N/A	N/A
Others			N/A	N/A	N/A
C. CORRUGATED PALLET			In-house	External Provider	Total Quantity
Color of Carton (Discoloration)			N/A	N/A	N/A
Flute of Material			N/A	N/A	N/A
Type of Adhesion			N/A	N/A	N/A
Adhesion of Runner			N/A	N/A	N/A
Rusty Wire			N/A	N/A	N/A
Wrong Orientation			N/A	N/A	N/A
Damages:			N/A	N/A	N/A
Others:			N/A	N/A	N/A
D. MOULDED ITEMS			In-house	External Provider	Total Quantity
Poor Fusion			N/A	N/A	N/A
Chip Off			N/A	N/A	N/A
Warp / Deform			N/A	N/A	N/A
Crack			N/A	N/A	N/A
Broken			N/A	N/A	N/A
Scratches			N/A	N/A	N/A
Foreign Materials			N/A	N/A	N/A
Wet / Moist			N/A	N/A	N/A
Dirt			N/A	N/A	N/A
Stain:			N/A	N/A	N/A
Discoloration			N/A	N/A	N/A
Excess Flashes			N/A	N/A	N/A
Others:			N/A	N/A	N/A

T= 77