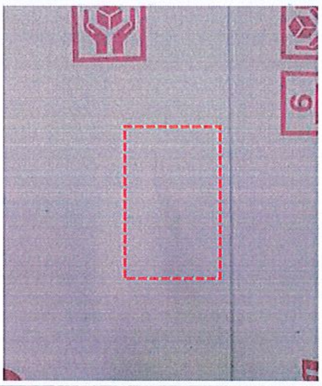
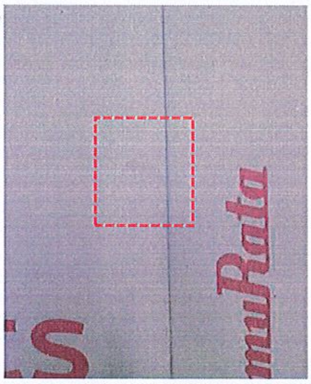
KANEPACKAGE PHILIPPINE INC.	# ABNORMALITY REPORT	Control No. AR2024-05-107

Item Code	HP01D2200C-1	Customer	KOWA-EMORI
Item Description	CARTON BOX	Delivery Date	240524
Inspection Date	240527	Inspection Time	07:00 PM
Lot Quantity	1430 pcs.	Job Order Number	1. JO24-M-00602-59 2.
Affected Quantity	49 pcs.	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	3.42% / 34,265 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 4
Problem Description	GLUE STAIN	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO GLUE STAIN	 

III. Documented Information Review (To be filled out by QA Line leader)

Related Doc. Info.	Control Number		
☐ Procedure Manual :	PM-QA-018	Requirement:	NO GLUE STAIN
☐ Technical Drawing :	EMO-0111-01AB-04	Actual:	WITH GLUE STAIN
☐ Work Instruction :	WI-QA-001-010		
☐ Job Order :	JO24-M-00602-59	Conclusion or Recommendation:	REJECT ☐ Applicable ☐ Not Applicable
☐ Reports :	AR2024-05-107		
☐ Defect Limit :	GENERAL DEFECT LIMIT		

IV. Initial Disposition (To be filled out by ME Department If Needed)

☐ Good ☐ Conditional (Please indicate details)
☐ Rejected
☐ Backload

V. Final Disposition

☑ Rejected ☐ Conditional (Please indicate details)
☐ Backload
☐ Good
☐ For Sorting
☐ For Rework

If item is for sorting, for backload, or for rework, fill-out below,

Person In Charge	Target Date	Signature

Remarks:

JUDGEMENT
(If subject is for issuance of IRF / CAR)
☐ FOR CAR ISSUANCE
☑ FOR IRF ISSUANCE

Detected by	Checked by	Initial Approved by (If Needed)	Approved by
J. REYES	J. RELLORA		240528 R. RAMOS
QA Inspector	QA Line Leader	ME Supervisor	QA Head

	Evaluation	Approved by	Final Disposition
Important: Backloading Policy (External Provider Rejects) *Rejection rate that is more than 80% of the total quantity shall be approved by Top Management before backloading.*	☐ <80% No Need ☐ >80% Need	Top Management	☐ Backload ☐ Accept ☐ Other ______

Note: All details must be filled out completely.
Submit this form to Line Leader immediately after accomplishment.

KANEPACKAGE PHILIPPINE INC.

ABNORMALITY REPORT

VI. Item Information			
Item Code		Customer	
Item Description		Delivery Date	
Inspection Date		Inspection Time	
Lot Quantity		Job Order Number	1. 2.
Affected Quantity		Origin	☐IN-HOUSE ☐SUPPLIER: ______
Rejection Rate and PPM		Date Received	
Sampling Quantity (IQA)		Detection (Section / Area)	
Problem Description		Delivery Receipt Number	

VII. Sorting Instructions	

VIII. Sorting Details

Sorting Date	Sorting Time		No. of Man-power	Lot Number	Sorted Quantity	Reject Quantity	Defect Name	Sorted by
	Start	End						

	Total Sorting Hours	Total No. of Manpower	Total Sorted Quantity	Total Reject Quantity	Total Good Quantity	Rejection Rate (%)
Sorting Result						
R&R Verification						

IX. Warehouse Details (To be filled out by QA Line Leader If needed)

	Reason	Total Quantity	Remarks	Received by
☐ Pull-Out				
☐ For Transfer				

X. Reworking Instructions	

XI. Reworking Result

Reworking Date	Reworking Time		# of Man-power	Lot Number	Reworked Quantity	Good Quantity	Reject Quantity	Rejection Rate (%)
	Start	End						

Reworked by / Department	Endorsed to / Department

XII. Reinspection Result

Reinspection Date	Reworking Time		# of Man-power	Lot Number	Reinspected Quantity	Good Quantity	Reject Quantity	Rejection Rate (%)
	Start	End						

Inspected by	Verified by	Approved by
QA Inspector	QA Line Leader/Sub-Leader	QA Head

Note: All details must be filled out completely.
Submit this form to Line Leader immediately after accomplishment.

131

5971

PR-001-F12-REV.

Kanepackage Philippine Inc.

1500

MEMO: - None -

JOB ORDER

Santiago, Jhanine
SO # : SO24-M-00602 REV03

Customer : KOWA-EMORI PHILIPPINES, INC.	JOB ORDER:
ITEM CODE: **HP01D2200C-1** Netsuite Itemcode : HP01D2200C-1	JO24-M-00602-59
Item Description : CARTON BOX	

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
6000	2024-05-24	Villanueva, Nene Adeva	2024-05-17

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
728X1025 BF TX200	6000	20	-NONE-	6020	0189879	[illegible]

B1-10-190 SH1

Tooling Reference # 590-27 Control/Batch #: RM Issued By: [illegible] 5/23

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN		REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
					G	R			
1. EQOS	5/23	RVEM	JEX	6019	2	1			
2. DIECUT ETERNA	5/24 5/23	BABG JJG	JEX	5055 964	6				
3. GLUING SD 1800	5/23	MAE, DJ VEPT		5997		20			
4. GLUING CONVEYOR 1	5/24	[illegible]		2160 737 1200 1874		26			
5. LOT NUMBERING	05-24 5/25		BUEN QM	1500+1500 1500					
6. SCREENING	05-24		CEZAR	1000					
7.	05-24		Mac [illegible]	1150			10		
8.	5-27		[illegible] [illegible]	850 1500			31		
9.	05/27		VIM	1500+1500 3240			98 89	1	
10.				5840					

QA INPUT DATE 240527
TIME 10:25 QTY 5971
QA OUTPUT DATE 240527
TIME 10:28 QTY 5840
PRODUCTION OUT
TIME 10:28 QTY 131

5/29

REJECTION HISTORY

Customer Claim:

Notes: NOTE: Put nickmark on the gluetab of the item for reference. The gluing operator should always check
HISTORY: overcut, bursting, misalign glue, extra fold, visible poka yoke

IN-HOUSE REJECTION

KOWA-EMORI PHILIPPINES INC.

Item Code	Quantity
HP01D2200C-1	10 pcs.
Item Description	**Supplier's QC**
CARTON BOX W/ PRINT	PASSED INSPECTION RoHS OK QA-KP052
Lot No. / Ref. NO.	
240527-00602-59	MP

KANEPACKAGE PHILIPPINE INC.

240527-00602-59 MP

KANEPACKAGE PHILIPPINE INC.

REMARKS
PROD PLAN: ADD #0 PLAN 2024-145

2160 to QA - [illegible] 5/24
1200 to QA - Arlen 5/25 [illegible]
737 to QA - Arlen 5/21 [illegible]

[illegible] 5/23

KANEPACKAGE PHILIPPINE INC.	SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)	Control No. SQA-05-001832

I. Item Information

Customer	KOWA-EMORI PHILIPPINES, INC.	Inspection Date	240527 — Shift: ☐ Day ☑ Night
		Delivery Date	240524
Location	Laguna	Job Order No.	JO24-M-00602-59
Item Code	HP01D2200C-1	Job Order Qty.	6,000
Item Description	CARTON BOX	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	0189879
Drawing Revision No.	03	Gluing Process	☐ Manual Gluing ☐ Semi-Auto Gluing
External Provider	Package World		☑ SD1800

II. Dimensional Inspection

Time Conducted Sample #1: 6:30 | Time Conducted Sample #2: 7:30 | Time Conducted Sample #3: 9:44 PM

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	273		273	273	273	16					
2	344	±2mm	346	346	344	17					
3	698		698	698	698	18					
4	149		149	149	149	19					
5	337		337	337	337	20					
6	334	±5mm	334	334	334	21					
7	995		995	995	995	22					
8						23					
9						24					
10						25					
11						26					
12						27					
13						28					
14						29					
15						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	2		2
Grain Direction			
Paper Shade (Off Color)			
Bubbles			
Blister			
Wrinkle	4		4
Delamination			
Uneven Kraft liner			
Warpage			
Cracking on edge			
Bursting / Bursting on Edge (Crowfeet)	1		1
Wrong die-cut orientation			
Inverted die-cut			
Close Gap/ Wide Gap			
Print Color: Poor print	2		2
Missing Print/ Character			
Blotted Print			
Smeared Print			
Other Print Defect :			
Linemark			
Fish-eye			
Stain : paper stain / glue stain	49	1	49+1
Excess Glue			
Gluing Defect : Misaligned glue	4		4
Worn-out			
Dent	9		9
Punctured	4		4
Tear-off	3		3
Peel-off	147		147
Damages :			
Others : extra fold	2		2

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 = 90

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Joint Flap		Judgement	
Requirement	Actual	Good	No Good
GLUED (Inside or Outside) INSIDE	INSIDE	✓	–
STITCHED (Inside or Outside) N/A	N/A	–	–

Type of Material			Judgement	
	Requirement	Actual	Good	No Good
Corrugated	UPPC	WPPC	✓	–
Flute	B-F	B-F	✓	–
Others	N/A	N/A	–	–

IV. Destructive Test (Based on Customer Requirement)

Requirement	Actual	Good	No Good
N/A	N/A	–	–

V. Barcode Print (If Only with Printed Barcode on Item)

Scan 1	N/A	☐ Good	☐ No Good
Scan 2		☐ Good	☐ No Good
BQICS Compliance (For Epson items only)		☐ Good	☐ No Good

VI. Inspection Result

Total Qty Inspected	1430
Total Qty Good	1340
Total Qty NG	90
Defect Rate in %	6.29%
Defect Rate in PPM	62,937.06 PPM

Defect Rate Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$

PPM Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 1{,}000{,}000$

VII. Sampling Inspection Result

Total Sampling Qty Inspected	N/A
Total Sampling Qty Good	
Total Sampling Qty NG	
Defect Rate in %	
Defect Rate in PPM	

VIII. Disposition

- ☑ Good
- ☐ Backload
- ☐ For Sorting
- ☐ For Rework
- ☐ For Special Acceptance
- ☐ Conditional (Please indicate details)

Abnormality Report Control No.: AR2024-05-107

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
C. REYES	[signature]		[signature] 240528
QA Screening Inspector	QA Line Leader	QA Supervisor / QA Asst. Supervisor	QA Head

X. Reject & Reworks Item Verification

Defect	Verification Quantity		Remarks:	Verified by (Signature over Printed Name)
	Good	No-Good		
				R&R Staff
				Received by (Signature over Printed Name)
Total				QA Inspector

XI. Overall Inspection Time

CORRUGATED AND MOULDED ITEMS

Date	No.of Manpower	Qty	Time Start	Time End	Downtime	Total hrs.	Cause of Downtime
240527	2	1430	6:30	9:45	N/A	3 hrs & 15 mins	N/A