14240618

Control No.

KANEPACKAGE PHILIPPINE INC.

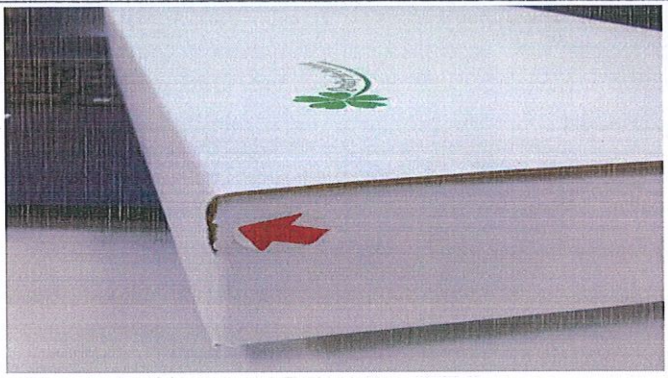
ABNORMALITY REPORT

AR2024-06-067

I. Item Information

Item Code	473 MB	Customer	MERASENKO
Item Description	OXYGEN TUBE 260X180X42.5	Delivery Date	240614
Inspection Date	240614	Inspection Time	9AM
Lot Quantity	969 PCS.	Job Order Number	JO24-C-00130-13A
Affected Quantity	29 PCS.	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	2.99% 29,928 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 2
Problem Description	BURSTING	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO BURSTING	

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

Related Doc. Info.	Control Number
☐ Procedure Manual :	PM-QA-018
☐ Technical Drawing :	MRC-0030-01
☐ Work Instruction :	WI-QA-001-010
☐ Job Order :	JO24-C-00130-13A
☐ Reports :	AR2024-06-067
☐ Defect Limit :	GENERAL DEFECT LIMIT

Requirement:	BURSTING UP TO 10MM ACCEPTABLE
Actual:	WITH BURSTING UP TO 15MM
Conclusion or Recommendation:	REJECT ☐ Applicable ☐ Not Applicable

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
R. MAGSINO	A. FILIPINAS		FOR 240614
QA Inspector	QA Line Leader	ME Supervisor	QA Head

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.

Evaluation	Approved by	Final Disposition
☐ <80% No Need		☐ Backload
☐ >80% Need		☐ Accept
	Top Management	☐ 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.

Annual -06-067

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. SQB-06-001079

I. Item Information

Customer	MERASENKO CORP.	Inspection Date	240614 Shift: ☑ Day ☐ Night
		Delivery Date	240613
Location	CEBU	Job Order No.	JO24-C-00130-13A
Item Code	473MB-RMFG	Job Order Qty.	1,000
Item Description	OXYGEN TUBE	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	196413
Drawing Revision No.	05	Gluing Process	☐ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800
External Provider	DW		

II. Dimensional Inspection

Time Conducted Sample #1: 01:20   Time Conducted Sample #2: 07:20   Time Conducted Sample #3: 07:20

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	260	+2 / −	260	260	260	16					
2	180		180	180	180	17					
3	42.5		42.5	42.5	42.5	18					
4						19					
5						20					
6						21					
7						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			
Grain Direction			
Paper Shade (Off Color)			
Bubbles			
Blister			
Wrinkle			
Delamination		N/A	
Uneven Kraft liner			
Warpage			
Cracking on edge			
Bursting / Bursting on Edge (Crowfeet)	[illegible]		[illegible]
Wrong die-cut orientation			
Inverted die-cut			
Close Gap/ Wide Gap			
Print Color :			
Missing Print/ Character			
Blotted Print			
Smeared Print			
Other Print Defect :			
Linemark		N/A	
Fish-eye			
Stain : paper stain	20		20
Excess Glue			
Gluing Defect : Dirt	10		10
Worn-out			
Dent			
Punctured			
Tear-off			
Peel-off			
Damages :			
Others :			

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

actual 15 mm

Defect limits 10 mm

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Joint Flap			Judgement		Type of Material		Judgement	
Requirement		Actual	Good	No Good	Requirement	Actual	Good	No Good
GLUED (Inside or Outside)		Inside	–		Corrugated	NA	NA	–
					Flute	CF	CF	–
STITCHED (Inside or Outside)	NA	NA			Others			

IV. Destructive Test (Based on Customer Requirement)				V. Barcode Print (If Only with Printed Barcode on item)			
Requirement	Actual	Good	No Good	Scan 1	NA	☐ Good	☐ No Good
NA	NA			Scan 2		☐ Good	☐ No Good
				BQICS Compliance (For Epson items only)		☐ Good	☐ No Good

VI. Inspection Result			VII. Sampling Inspection Result	
Total Qty Inspected	969	Defect Rate Formula: Total Quantity NG / Total Qty. Inspected x100	Total Sampling Qty Inspected	NA
Total Qty Good	910		Total Sampling Qty Good	
Total Qty NG	59		Total Sampling Qty NG	
Defect Rate in % / in PPM	6.08% – 60887	PPM Formula: Total Quantity NG / Total Qty. Inspected x1,000,000	Defect Rate in % / in PPM	

VIII. Disposition		IX. Remarks
☑ Good	☐ For Special Acceptance	
☐ Backload	☐ Conditional (Please indicate details)	
☐ For Sorting		
☐ For Rework	Abnormality Report Control No.: ARMOL-06-060	

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
R-NCGAN	[signature]	[signature] 240616	
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
				NA			

80X11 = 970 970
(30)

Kanepackage Philippine Inc.

MEMO: - None -

PR-001-F12-REV.00

JOB ORDER

Amores, Glezyl
SO # : SO24-C-00130

Customer : MERASENKO CORP.

ITEM CODE: 473MB-RMFG
Netsuite Itemcode : 473MB-RMFG

JOB ORDER: JO24-C-00130-13A

Item Description : OXYGEN TUBE 260X180X42.5; A

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
1000	2024-06-13	Pallermo, Arlene Gonzales	2024-06-06

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
475X935 EF WK140	1000	10	475X935 EF	1000	140413	pw

Tooling Reference # 12-28 Control/Batch #: RM Issued By: ELMER 6/8

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. DIECUT S1700	6/8	RJ	6/8	994	1 G R			
2. DETACHING 1	6/11	RJ		992	4 G R			
3. GLUING SD 1800	6/13	MAR HAPPY		969	23 G R			
4. LOT NUMBERING	6/14		JHEENA	1000	G R			
5. SCREENING	6/14			910	G R	59		
6.					G R			
7.					G R			
8.								
9.								
10.								

KANEPACKAGE PHILIPPINE, INC.
CUSTOMER : MERASENKO CORP.
ITEM CODE : 473MB
ITEM DESCRIPTION : NEW OXYGEN TUBE 260X180X42.5
LOT NUMBER : 240614-JO24-C-00130-13A
QUANTITY : 20 pcs.
QA-CG601 QA PASSED

REJECTION HISTORY

Customer Claim:

Notes:

5mm movement (3mm tolerance included) on diecut approved by QA: 240608

REMARKS 6/13

PROD PLAN: ADD #0 PLAN 2024-165

6/8

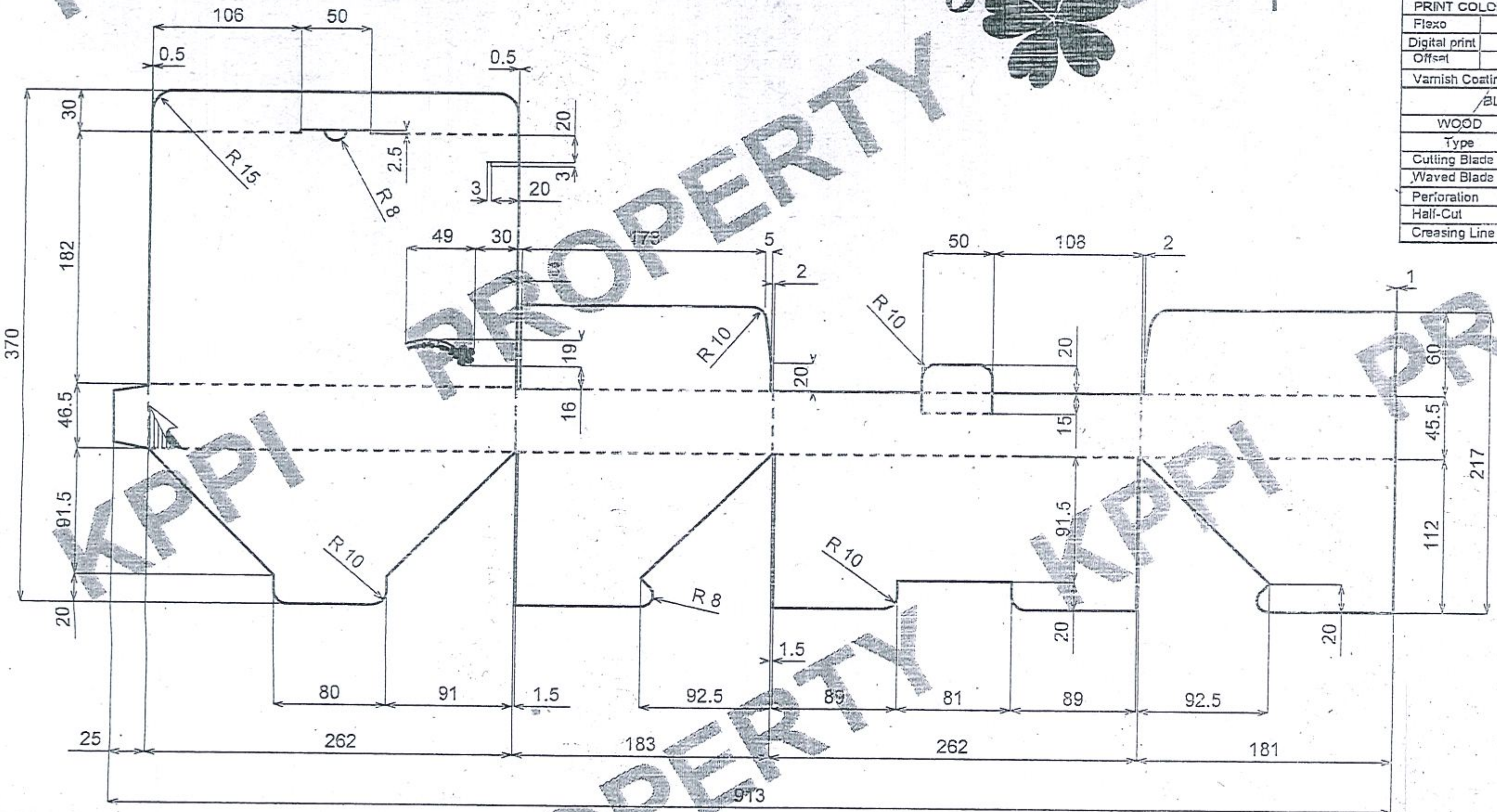
*** UNCONTROLLED COPY FOR JOB ORDER ***

2024-06-05 Issued by:

BOX SPECIFICATION	1 2 3	
Inner Dimension	260 X 180 X 42.5 mm	
Outer Dimension	264 X 184 X 50.5 mm	
Joint Flap	GLUING INSIDE	
Illustration	Shows Smooth Surface (Outer Side)	
Bursting Strength	N/A	
BCT	N/A	
ECT	N/A	
PRINT COLOR	1	2
Flexo	GREEN (PANTHONE 355EC)	
Digital print	N/A	
Offset	N/A	
Varnish Coating	N/A	

BLADE REQUIREMENTS

WOOD	Size:		Thickness :	
Type	Height	Thickness	Pitch	Length
Cutting Blade				
Waved Blade				
Perforation				
Half-Cut				
Creasing Line				



CUSTOMER : MERASENKO			TOLERANCE		MATERIAL:
ITEM DESCRIPTION/PART CODE:	CUSTOMERS SUPPLIED REFERENCE NO.:		DIMENSION: +/- 2MM		E FLUTE (WKL140/CM125/TX200)
473MB 5 NEW OXYGEN TUBE 260 X 180 X 42.5	N/A		<=50	+/- 1	
			51-200	+/- 2	
			201-400	+/- 3	
	ITEM KEY : MRC-0030-01AB-05	1 / 2 PAGE :	401-700	+/- 4	LEGEND: UNITS: mm N. T. S.
			701-1000	+/- 5	- CUTTING
			1000<	+/- 8	- CREASING
			PRINT: +/- 3MM		- HALF-CUT
					- PERFORATION

KANEPACKAGE PHIL. INC. #5 Ring Rd. LISP 2 Brgy. Lamesa Calamba, Laguna Tel. Nos. :(049)545-7166 to 69 Fax Nos. :(049)545-7170/(049)545-0302	REV. #	DATE	REASON	REQUESTED BY:
	05	23/08/24	ADDITIONAL ITEM CODE BASE ON CUSTOMERS PO	D. LOQUITE

PROCESS					
1	SLITTER	7	QA BUNDLE	13	
2	EQOS-PRINT	8	LOT NUMBER ATTACHMENT	14	
3	DIE-CUT S1700	9	OQA	15	
4	DETACHING	10		16	
5	GLUING	11		17	
6	LOT NUMBER GENERATION	12		18	

PACKING INSTRUCTION :	DRAWN BY:	CHECKED BY:	APPROVED BY:
20 PCS /BUNDLE(COLLAPSED) COVERED WITH STRETCH FILM	S. NGUYEN	M. ALONSAGAY	S. LUDAG

DT-002-F01 REV.03