KANEPACKAGE PHILIPPINE INC.	# ABNORMALITY REPORT	Control No. AR2024-10-064

I. Item Information

Item Code	HP01D2000-3	Customer	KOWA EMORI
Item Description	CARTON BOX	Delivery Date	241009
Inspection Date	241008	Inspection Time	9PM
Lot Quantity	9,0000 PCS	Job Order Number	JO240M-01612-15
Affected Quantity	150 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	1.67% 16,667 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 4
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	Requirement:	BURSTING NOT ACCEPTABLE (CLASS A)
☑ Technical Drawing :	EMO-0100-01		
☑ Work Instruction :	WI-QA-001-010	Actual:	WITH BURSTING UP TO 10MM
☑ Job Order :	JO240M-01612-15		
☑ Reports :	AR2024-10-064	Conclusion or Recommendation:	REJECT ☑ Applicable ☐ Not Applicable
☑ Defect Limit :	EMORI DEFECT LIMIT		

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

☐ Good	☐ Conditional (Please indicate details)	☑ Rejected	☐ Conditional (Please indicate details)
☐ Rejected		☐ Backload	If item is for sorting, for backload, or for rework, fill-out below,
☐ Backload		☐ Good	Person In Charge / Target Date / Signature
		☐ For Sorting	
		☐ For Rework	

Remarks:

JUDGEMENT
(If subject is for issuance of IRF / CAR)
☐ FOR 5 WHY ISSUANCE
☑ FOR CAR ISSUANCE
☐ FOR IRF ISSUANCE

Detected by	Checked by	Initial Approved by (If Needed)	Approved by	Received By
M. GARCIA/C. MONTANO	A. FILIPINAS		M. CASILLANO	
QA Inspector	QA Line Leader	ME Head	QA Head	QA Staff

	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

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.

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Kanepackage Philippine Inc.

MEMO: - None -

PR-001-F12-REV.00

JOB ORDER

Labay, Menchie
SO # : SO24-M-01612

Customer : KOWA-EMORI PHILIPPINES, INC.	JOB ORDER:
ITEM CODE: **HP01D2000-3** Netsuite Itemcode : HP01D2000-3	JO24-M-01612-15
Item Description : CARTON BOX	

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
9000	2024-10-07	Villanueva, Nene Adeva	2024-10-01

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
779X701 BF TX200	4500	10	-NONE-	4510	0195511	P-1

Tooling Reference # S 95 / 35 / 98-0-0220 Control/Batch #: RM Issued By: Jhoan 10/5

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN	TRIAL RUN G	TRIAL RUN R	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. EQOS	10/5	PMEV	LEWAND 10/5	4510	2	G	R			S 0017 E 0021
2. DIECUT ETERNA	10/07	JAR JBG	Gino 10/07	40 4385	10	G	R 75	10T		
3. GLUING SD 1800	10/07	Greg Jeff Kurnh	Axie Ohio Cess	4,232 4387		G	R 21 81			
4. GLUING CONVEYOR 1			Gino 10/08	-1600 =4590		G	R			
5. LOT NUMBERING	10/08		Jheena Jay	3000 1500		G	R			
6. SCREENING	10/08		KEMMN	1500		G	R			
7.	10/08		Macliw Cesar	3000		G	R	150		
8.										
9.										
10.										

REJECTION HISTORY

Customer Claim:

Notes: IN-HOUSE REJECTION HISTORY: peel off, faded print, cannot fit lock, glue stain, excess glue, inverted p

KOWA-EMORI PHILIPPINES INC.

Item Code	Quantity
HP01D2000-3	10 pcs.
Item Description	**Supplier's QC**
CARTON BOX	PASSED INSPECTION RoHS OK QA-KP1618 MP
Lot No. / Ref. NO.	
241008-01612-15	

K KANEPACKAGE PHILIPPINE INC.

REMARKS

PROD PLAN: ADD #0 PLAN 2024-281

4490 to QA Rene 10/4 - LAMSEN

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. **SQA-10-000684**

I. Item Information

Customer	KOWA-EMORI PHILIPPINES, INC.	Inspection Date	241008 Shift: ☐ Day ☑ Night
		Delivery Date	241007
Location	Laguna	Job Order No.	JO24-M-01612-15
Item Code	HP01D2000-3	Job Order Qty.	9,000
Item Description	CARTON BOX	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	019554
Drawing Revision No.	06	Gluing Process	☑ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800
External Provider	PW		

II. Dimensional Inspection

Time Conducted Sample #1: 1820 | Time Conducted Sample #2: 1850 | Time Conducted Sample #3: 1930

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	183	+	184	184	184	16					
2	135	/ 2	135	136	135	17					
3	180	-	180	180	181	18					
4	19	+ /	19	19	19	19					
5	19	/ 5	19	19	21	20					
6	19	/	19	21	19	21					
7	19	-	21	19	19	22					
8						23					
9						24					
10						25					
11						26					
12						27					
13						28					
14						29					
15						30					

Measuring Tool Used: ☑ Meter Tape ☐ Thickness Gauge ☐ Moisture Content Tester ☐ Weighing Scale ☐ Zahn Cup ☐ Steel Ruler ☐ Stopwatch ☐ Caliper

Control Number of Measuring Tool Used: 24-16001-042

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			
Uneven Kraft liner			
Warpage			
Cracking on edge			
Bursting / Bursting on Edge (Crowfeet)	150		150
Wrong die-cut orientation			
Inverted die-cut			
Close Gap/ Wide Gap			
Print Color : ______			
Missing Print/ Character			
Blotted Print			
Smeared Print			
Other Print Defect : ______			
Linemark			
Fish-eye			
Stain : ______			
Excess Glue			
Gluing Defect : ______			
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

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)	l - ¼ JJ2O	✓		Corrugated	2 PPL	✓	
STITCHED (Inside or Outside)	—	NA		Flute	BF	✓	
				Others	—	NA	

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

VI. Inspection Result			VII. Sampling Inspection Result	
Total Qty Inspected	3150	Defect Rate Formula: Total Quantity NG / Total Qty. Inspected x100	Total Sampling Qty Inspected	—
Total Qty Good	3000		Total Sampling Qty Good	
Total Qty NG	150		Total Sampling Qty NG	NA
Defect Rate in % / in PPM	4.76% - 47619 PPM	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.: ARA024-10-064	

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
m. Garcia C. Montano	[signature]		[signature]
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	Cause of Downtime