KANEPACKAGE PHILIPPINE INC.

ABNORMALITY REPORT

Control No. **AR2024-10-065**

I. Item Information

Item Code	511659400	Customer	EPSON ASP/EPLB
Item Description	OUTER CARTON BOX	Delivery Date	241009
Inspection Date	241008	Inspection Time	2AM
Lot Quantity	910 PCS	Job Order Number	JO240M-01690-3.1
Affected Quantity	20 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	2.20% 21,978 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 5
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 :	EPL-0513-01
☑ Work Instruction :	WI-QA-001-010
☑ Job Order :	JO240M-01690-3.1
☑ Reports :	AR2024-10-065
☑ Defect Limit :	GENERAL DEFECT LIMIT

Requirement:	BURSTING NOT ACCEPTABLE
Actual:	WITH BURSTING UP TO 30MM
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 5 WHY ISSUANCE
☑ FOR CAR ISSUANCE
☐ FOR IRF ISSUANCE

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

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

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.

(5) AN2024-10-0?? 697

Kanepackage Philippine Inc.

PR-001-F12-REV.00

MEMO: FOR COMMON USE

JOB ORDER

Francine Minaves
SO # : SO24-M-01690-B

Customer : EPSON PRECISION PHILS. INC.- ASP/EPLB

ITEM CODE: **511659400**

Netsuite Itemcode : 511659400

JOB ORDER: JO24-M-01690-3.1

Item Description : OUTER CARTON BOX

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
910	2024-10-08	Pallermo, Arlene Gonzales	2024-10-07

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
620X2045 CBF TX175-C	910	15	N/A	855	345337	SP

Tooling Reference # D-1   Control/Batch #: ________   RM Issued By: ___ 10/8

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. EQOS	10/8	PMEV	10/8	855	2 G R			S-1048 F-1010 bal. 70
2. GLUING SA 2600	10/8	DN		855	G R			
3. LOT NUMBERING	10/08		Jheena	910	G R			
4. SCREENING	10/08		JEREMY JEX	825	G R	7	23	BAL.
5.					G R			
6.					G R			
7.					G R			
8.								
9.								
10.								

REJECTION HISTORY

Customer Claim:

Notes:

KANEPACKAGE PHILIPPINE, INC.
ITEM CODE : 511659400 241008 RoHS OK
ITEM DESCRIPTION : OUTER CARTON BOX
ITEM SIZE :
LOT NUMBER : 241008-JO24-M-01690-3.1 QA-KP040
QUANTITY : 10 pcs. MP QA PASSED

REMARKS Bal 70 10/8

PROD PLAN: ADD #9 PLAN 2024-282

PRODUCTION OUT
BY: 10/8
DATE:
NETSUITE

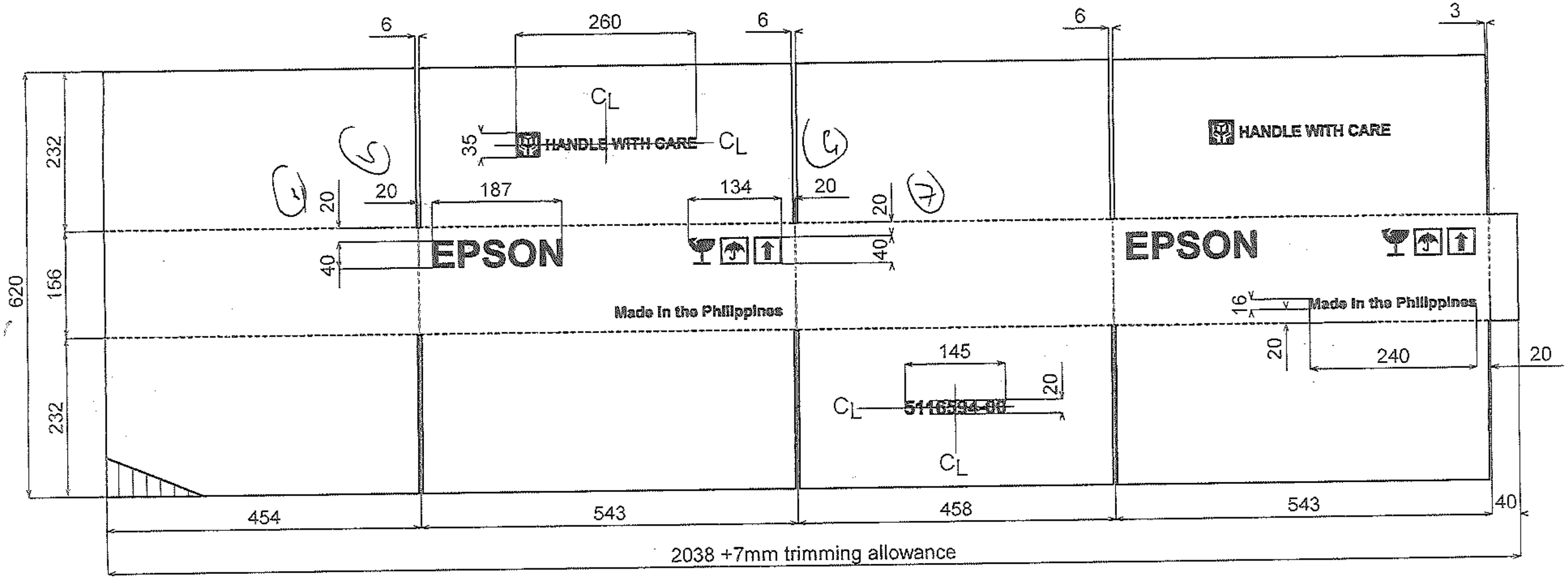
Ada #9. plan 2024-282

*** UNCONTROLLED COPY FOR JOB ORDER ***

2024-10-07 Issued by:

RoHS

NOTE :
1. INNER DIMENSION : 535 X 450 X 140
2. JOINT FLAP : GLUING INSIDE
3. PRINTING COLOR : BLUE (EQ-02)



15

CUSTOMER : EPSON		TOLERANCE		MATERIAL: CB FLUTE TX175/CM125X3/TX175
ITEM DESCRIPTION/PART CODE:	CUSTOMERS SUPPLIED REFERENCE NO :	DIMENSION: +/-3mm		
511659400 OUTER CARTON BOX		<=50	+/- 1	LEGEND: UNITS: mm N.T.S.
		51~200	+/- 2	- CUTTING
	ITEM KEY : EPL-0513-01AB-06	201-400	+/- 3	- CREASING
	PAGE : 1 / 1	401-700	+/- 4	- HALF-CUT
		701-1000	+/- 5	- PERFORATION
		1000<	+/- 8	
		PRINT:	+/- 5	

REV. #	DATE	REASON	REQUESTED BY:
6	21/09/18	CHANGE OF MATERIAL	S. ORTILLA

KANEPACKAGE PHIL. INC.
#5 Ring Rd. LISP 2 Brgy. Lameda Calamba, Laguna
Tel. Nos. :(049)545-7166 to 69
Fax Nos. :(049)545-7170/(049)545-6302

PROCESS	SFLI PROCESS		KPPI PROCESS	
1	SLOTTER BIG	7	OVERHANG	13
2	SLOTTER SMALL	8	GLUING-SEMI AUTO	14
3	LONGWAY PRINTING	9	LOT NUMBERING	15
4	LOT NUMBERING	10	QA SCREENING	16
5	OQA	11	OQA	17
6		12		18

PACKING INSTRUCTION :
10 PCS./BUNDLE

DRAWN BY:	CHECKED BY:	APPROVED BY:
R. ROBRIGADO	D. TAPAY	S. LUBAG

DT-002-F01 REV.03

(E)

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. SQB-10-000697

I. Item Information

Customer	EPSON PRECISION PHILS. INC.- ASP/EPLB	Inspection Date	241008 Shift: ☐ Day ☑ Night
		Delivery Date	241008
Location	BATANGAS	Job Order No.	JO24-M-01690-3.1
Item Code	511659400	Job Order Qty.	910
Item Description	OUTER CARTON BOX	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	345337
Drawing Revision No.	06	Gluing Process	☐ Manual Gluing ☑ Semi-Auto Gluing ☐ SD1800
External Provider	SIP		

II. Dimensional Inspection

Time Conducted Sample #1: 10:50 Time Conducted Sample #2: 11:30 Time Conducted Sample #3: 1:00

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	535	+/-3	535	536	535	16					
2	450	+/-3	451	450	451	17					
3	140	+/-3	141	140	141	18					
4	20	+/-5	21	20	21	19					
5	20	+/-5	19	21	19	20					
6	20	+/-5	20	21	19	21					
7	20	+/-5	20	21	20	22	N				
8						23					
9						24					
10						25					
11						26			A		
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: 24-18068-180

III. Visual Inspection (Leave cell blank if no detection on Applicable Criteria. Ensure to put actual quantity of defect based on clasification or "N/A" if Not Applicable)

A. CORRUGATED ITEM / BOX / DANPLA	In-house	External Provider	Total Quantity
Scoring		1	1
Grain Direction	N		
Paper Shade (Off Color)			
Bubbles			
Blister			
Wrinkle			
Delamination			
Uneven Kraft liner			D
Warpage			
Cracking on edge			
Bursting / Bursting on Edge (Crowfeet)		20	20
Wrong die-cut orientation			
Inverted die-cut	N		
Close Gap/ Wide Gap			
Print Color :			
Missing Print/ Character			
Blotted Print			
Smeared Print			
Other Print Defect :			
Linemark			D
Fish-eye			
Stain : PAPER		2	2
Excess Glue			
Gluing Defect :			
Worn-out	1		1
Dent			
Punctured	3		3
Tear-off			
Peel-off	2		2
Damages :			
Others : DIRT	1		1

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	
Requirement	Actual	Good	No Good
GLUED (Inside or Outside) INSIDE	INSIDE	✓	
STITCHED (Inside or Outside) N	A		

Type of Material			Judgement	
	Requirement	Actual	Good	No Good
Corrugated	UPPC	UPPC	✓	
Flute	CBF	CBF	✓	
Others	N	A		

IV. Destructive Test (Based on Customer Requirement)

Requirement	Actual	Good	No Good
N	A		

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

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

VI. Inspection Result

Total Qty Inspected	855	
Total Qty Good	825	
Total Qty NG	30	
Defect Rate in %	3.50%	
Defect Rate in PPM	35 087 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.: AR0004-10-0...

IX. Remarks

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

X. Reject & Reworks Item Verification

Defect	Verification Quantity Good	Verification Quantity No-Good	Remarks:	
				Verified by (Signature over Printed Name)
				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
		N/A					