KANEPACKAGE PHILIPPINE INC.

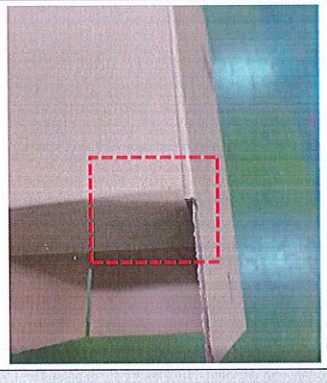
ABNORMALITY REPORT

Control No.
AR2024-11-063

I. Item Information

Item Code	HP01D5601	Customer	KOWA-EMORI
Item Description	CARTON BOX	Delivery Date	241114
Inspection Date	241113	Inspection Time	02:20 AM ~~pm~~
Lot Quantity	396 PCS.	Job Order Number	JO24-M-01800-47
Affected Quantity	35 PCS.	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	8.8% 88,383 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 5
Problem Description	BULGING	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
~~NO BULGING~~ MISALIGN SLOT (CLUMPING)	

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

Related Doc. Info.	Control Number
☑ Procedure Manual :	PM-QA-018
☑ Technical Drawing :	EMO-0089-01AB-02
☑ Work Instruction :	WI-QA-001-010
☑ Job Order :	JO24-M-01800-47
☑ Reports :	AR2024-11-063
☑ Defect Limit :	GENERAL DEFECT LIMIT

Requirement:	NO ~~BULGING~~ MISALIGN SLOT
Actual:	WITH ~~BULGING~~ MISALIGN SLOT
Conclusion or Recommendation:	REJECT ☑ Applicable ☐ Not Applicable

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

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

V. Final Disposition

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

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
R. RANSUYO	J. RELLORA		M. CASILLANO	241114
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 ☐ >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.

Kanepackage Philippine Inc.

1015

PR-001-F12-REV.00

MEMO: - None -

JOB ORDER

Dela Cerna, Jessa Mae
SO # : SO24-M-01800 REV07

Customer : KOWA-EMORI PHILIPPINES, INC.

JOB ORDER: JO24-M-01800-47

ITEM CODE: HP01D5601
Netsuite Itemcode : HP01D5601

Item Description : CARTON BOX

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
400	2024-11-14	Villanueva, Nene Adeva	2024-11-08

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
364X741 BF TX200-C	400	15	N/A	415	6196956	PPO

Tooling Reference # F-33 Control/Batch #: RM Issued By: 11/12

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN G	TRIAL RUN R	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. EQOS	11/12	MEMJ	LOUHILD 11/12	415	3				C 0112 E 0113
2. GLUING SA 2600	11	P-D		396	2	19			
3. LOT NUMBERING	11/13		JM	400					
4. SCREENING	11/13		RC	354			42		
5.									
6.									
7.									
8.									
9.									
10.									

REJECTION HISTORY

Customer Claim:

Notes:

KOWA-EMORI PHILIPPINES INC.

Item Code	Quantity
HP01D5601	10 pcs.
Item Description: CARTON BOX	Supplier's QC: PASSED INSPECTION RoHS OK QA-KP734
Lot No. / Ref. NO.: 241113-01800-47	MP

KANEPACKAGE PHILIPPINE INC.

REMARKS

PROD PLAN: ADD #3 PLAN 2024-319

PRODUCTION OUT
BY: 11/13
DATE:
NETSUITE

11/12

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. SQB-11-001015

I. Item Information

Customer	KOWA-EMORI PHILIPPINES, INC.	Inspection Date	24/11/13 Shift: ☐ Day ☑ Night
		Delivery Date	241114
Location	BATANGAS	Job Order No.	JO24-M-01800-47
Item Code	HP01D5601	Job Order Qty.	400
Item Description	CARTON BOX	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	096954
Drawing Revision No.	02	Gluing Process	☐ Manual Gluing ☑ Semi-Auto Gluing ☐ SD1800
External Provider	PW		

II. Dimensional Inspection

Time Conducted Sample #1: 0220 Time Conducted Sample #2: 0240 Time Conducted Sample #3: 0300

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	194	±3	195	195	194	16					
2	147		147	147	148	17					
3	208		208	208	208	18					
4	364		365	365	366	19					
5	20	±5	20	20	20	20					
6	30		30	30	31	21					
7						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: 24-21073 & 07

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	2		2
Grain Direction			
Paper Shade (Off Color)			
Bubbles			
Blister	NC		
Wrinkle			
Delamination			
Uneven Kraft liner			
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 :			
Linemark			
Fish-eye			
Stain :			
Excess Glue			
Gluing Defect			
Worn-out	3		3
Dent	2		2
Punctured			
Tear-off			
Peel-off			
Damages :			
Others : Buckling	35		35

D

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	CORRC	CORRC	✓	
Flute	BF	BF	✓	
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/A	☐ Good	☐ No Good
Scan 2		☐ Good	☐ No Good
BQICS Compliance (For Epson items only)		☐ Good	☐ No Good

VI. Inspection Result

Total Qty Inspected	396	Defect Rate Formula: Total Quantity NG / Total Qty. Inspected x100
Total Qty Good	354	
Total Qty NG	42	
Defect Rate in %	10.61%	PPM Formula: Total Quantity NG / Total Qty. Inspected x1,000,000
Defect Rate in PPM	106 061 PPM	

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.: AR2024-11-063

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
R. Ranseyo			
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
N/A				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
24/11/13	1	396	0220	0300	N/A	40 mins	N/A