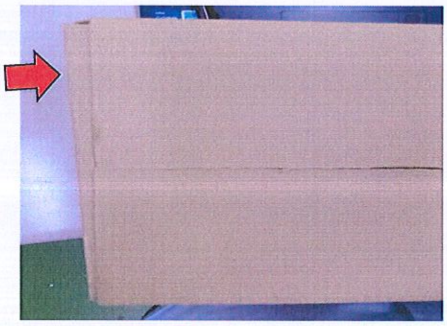
KANEPACKAGE PHILIPPINE INC.	ABNORMALITY REPORT	Control No. AR2024-12-070

I. Item Information

Item Code	TR1236-008	Customer	EMD TECH
Item Description	RELAY BOX	Delivery Date	241216
Inspection Date	241216	Inspection Time	3:30AM
Lot Quantity	800 PCS	Job Order Number	JO24-M-01822-2
Affected Quantity	94 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	11.75% 117,500 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 3
Problem Description	MISALIGN GLUE	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO MISALIGN GLUE	

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

Related Doc. Info.	Control Number
☑ Procedure Manual :	PM-QA-018
☑ Technical Drawing :	EMD-0002-01
☑ Work Instruction :	WI-QA-001-010
☑ Job Order :	JO24-R-00412-2
☑ Reports :	AR2024-12-070
☑ Defect Limit :	GENERAL DEFECT LIMIT

Requirement:	MISALIGN GLUE NOT ACCEPTABLE
Actual:	WITH MISALIGN GLUE
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
D. PEDRIGAL	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 ☐ >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.

1388

Kanepackage Philippine Inc.

PR-001-F12-REV.00

MEMO: - None -

JOB ORDER

Dela Cerna, Jessa Mae
SO # : SO24-M-01822 REV01

Customer : EMD Technologies Philippines Inc.	JOB ORDER:
ITEM CODE: **TR-1236-008** Netsuite Itemcode : TR-1236-008	JO24-M-01822-2
Item Description : Relay Box	

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
800	2024-12-12	Tuiza, Jecille Maduro	2024-12-06

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
302X1608 CF TX200-C	800	20	302X1588+20 CF	812	348902	SP

Tooling Reference # B-75 Control/Batch #: RM Issued By: 12/10

PROCESS / MACHINE	DATE	IN-CHARGE Operator	ME/QA	GOOD QTY	TRIAL RUN	REJECTED QTY INHOUSE	SUPPLIER	REMARKS
1. EQOS	12/10	MMJE	FRANCIS 12/10	812	3 G R			S - 9:45 E - 9:50
2. GLUING CONVEYOR 2	12/14	NC		800	12 G R			
3. LOT NUMBERING	12/16		JMena	800	G R			
4. SCREENING	12/16		DAR	650	G R	150		
5.					G R			
6.					G R			
7.					G R			
8.								
9.								
10.								

REJECTION HISTORY

Customer Claim:

Notes:

KANEPACKAGE PHILIPPINE, INC. REV.00
CUSTOMER : EMD TECHNOLOGIES PHILIPPINES INC.
ITEM CODE : TR-1236-008 RoHS OK
ITEM DESCRIPTION : RELAY BOX
ITEM SIZE :
LOT NUMBER : 24121..-JO24-M-01822-2 QA-CG633
QUANTITY : 10 pcs. MP QA PASSED

REMARKS Bal. 8 pcs. 12/18

PROD PLAN: ADD #0 PLAN 2024-347

PRODUCTION DATE: ARLENE PALLERMO Job Controller NETSUITE 12/16

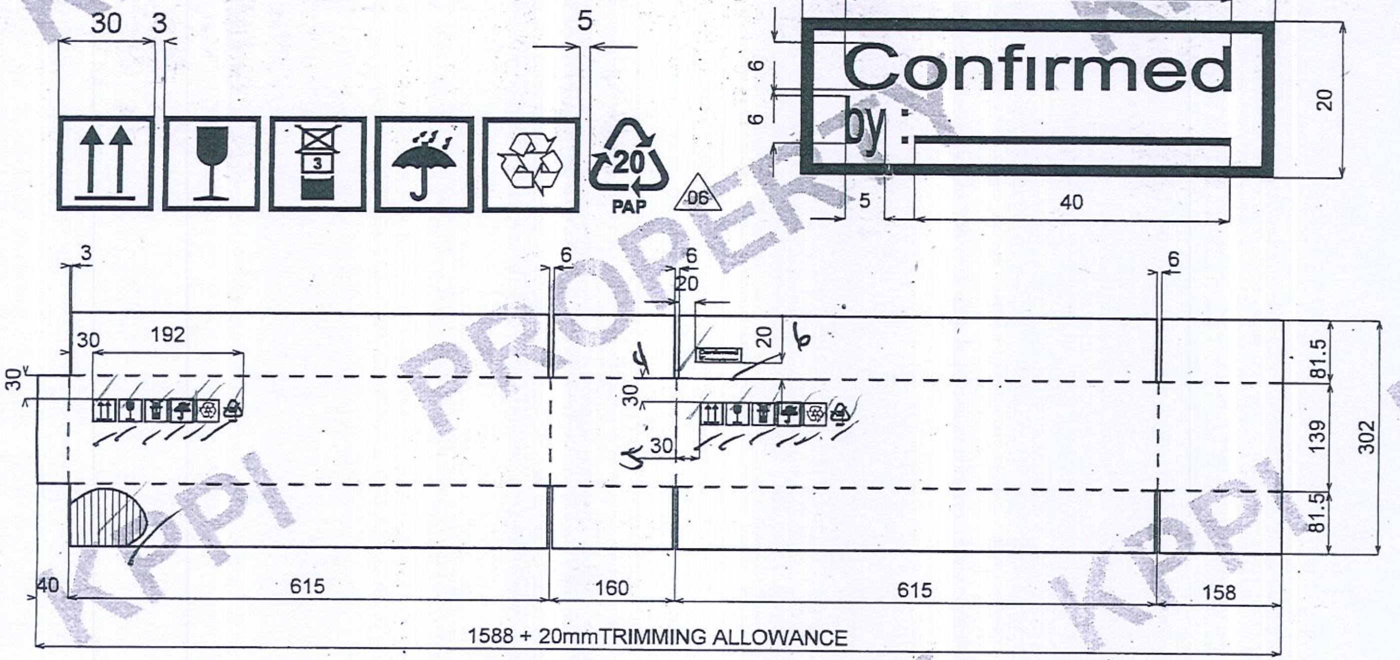
USE OUT 12/18 DATE:

*** UNCONTROLLED COPY FOR JOB ORDER ***

2024-12-06 Issued by:

RoHS

WITH SUTEBAN



BOX SPECIFICATION			
Inner Dimension	610 X 155 X 130mm		
Outer Dimension	618 X 163 X 146mm		
Joint Flap	GLUING INSIDE		
Illustration	SMOOTH SURFACE		
Bursting Strength	N/A		
BCT	N/A		
ECT	N/A		
PRINT COLOR	1	2	3
Flexo	EQ-01 BLACK		
Digital Print	N/A		
Offset	N/A		
Varnish Coating	N/A		

BLADE REQUIREMENTS

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

NOTES:

FLEXO PLATE : HARD CYREL
: 230 mm X 80 mm , 9 in X 4 in

F. ALCURAN Jr.
12/10

CUSTOMER : EMD TECHNOLOGIES PHILIPPINES INC.

ITEM DESCRIPTION/PART CODE:

TR-1236-008
RELAY BOX
SPACER / PARTITION

CUSTOMERS SUPPLIED REFERENCE NO.: N/A

ITEM KEY : EMD-0002-01AB-06

PAGE: 1/1

TOLERANCE	
DIMENSION:	+/- 3
<=50	+/- 1
51-200	+/- 2
201-400	+/- 3
401-700	+/- 4
701-1000	+/- 5
1000<	+/- 8
PRINT:	+/- 5

MATERIAL: C FLUTE (TX200/CM125TX200)

LEGEND: UNITS: mm N. T. S.

- CUTTING
- CREASING
- HALF-CUT
- PERFORATION
- HOLE

PROCESS					
1	SLITTER BIG	7	OQA	13	
2	SLITTER SMALL	8		14	
3	EQOS	9		15	
4	GLUING	10		16	
5	LOT NUMBERING	11		17	
6	QA SCREENING	12		18	

PACKING INSTRUCTION :
10 PCS. / BUNDLE

REV. #	DATE	REASON	REQUESTED BY:
06	240830	CHANGE PRINT LAYOUT (ADDITIONAL CAREMARK PAP20 , PRINT ALL BLACK)	K.ALIMARIO

KANEPACKAGE PHIL. INC.
#5 Ring Rd. LISP 2 Brgy. Lamesa Calamba, Laguna
Tel. Nos. :(049)545-7168 to 69
Fax Nos. :(049)545-7170/(049)545-6302

DRAWN BY: A. DE ROXAS
CHECKED BY: M. ALONSAGAY
APPROVED BY: S. LUBAG

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. SQB-12-001388

I. Item Information

Customer	EMD Technologies Philippines Inc.	Inspection Date	241216 Shift: ☐ Day ☑ Night
		Delivery Date	241212
Location	LAGUNA	Job Order No.	JO24-M-01822-2
Item Code	TR-1236-008	Job Order Qty.	800
Item Description	RELAY BOX	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	348702
Drawing Revision No.	06	Gluing Process	☑ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800
External Provider	ST		

II. Dimensional Inspection

Time Conducted Sample #1: 10:00 | Time Conducted Sample #2: 12:00 | Time Conducted Sample #3: 3:00

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	610	±3	610	610	610	16					
2	155		155	155	155	17					
3	130		130	130	130	18					
4	30	±5	30	30	30	19	NA				
5	30		30	30	30	20					
6	20		20	20	20	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: 24-20076-225

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	8		8
Grain Direction			
Paper Shade (Off Color)			
Bubbles			
Blister			
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 : ink stain	3		3
Linemark			
Fish-eye			
Stain : Oil stain	3		3
Excess Glue			
Gluing Defect : Misalign Glue	94		94
Worn-out	4		4
Dent	1		1
Punctured	2		2
Tear-off	7		7
Peel-off	2		2
Damages :			
Others : Poor slot	26		26

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)			

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

IV. Destructive Test *(Based on Customer Requirement)*

Requirement	Actual	Good	No Good

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

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

VI. Inspection Result

Total Qty Inspected	800
Total Qty Good	650
Total Qty NG	150
Defect Rate in %	18.75%
Defect Rate in PPM	187,500 %

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	
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.: Annvey-12-0370/023

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
D. Pedrigal	[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:
Total			

Verified by (Signature over Printed Name)
R&R Staff
Received by (Signature over Printed Name)
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