KANEPACKAGE PHILIPPINE INC.

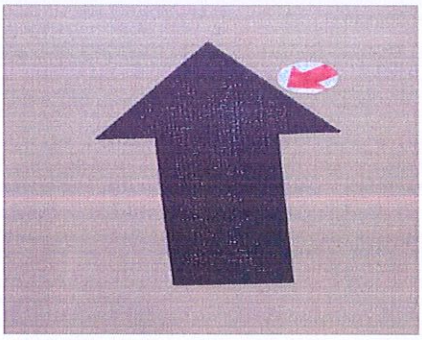
ABNORMALITY REPORT

Control No. **AR2025-02-085**

I. Item Information

Item Code	D080005130-00	Customer	HIBLOW
Item Description	XP BOX AND INSERT PAD	Delivery Date	250214
Inspection Date	250214	Inspection Time	1PM
Lot Quantity	5,000 PCS	Job Order Number	JO25-M-00047-10
Affected Quantity	38 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	0.76% 7,600 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 2
Problem Description	POOR PRIINT	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO POOR PRINT	

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

Related Doc. Info.	Control Number		
☑ Procedure Manual :	PM-QA-018	Requirement:	POOR PRINT NOT ACCEPTABLE
☑ Technical Drawing :	HPI-0128-01		
☑ Work Instruction :	WI-QA-001-010	Actual:	WITH POOR PRINT
☑ Job Order :	JO25-M-00047-10		
☑ Reports :	AR2025-02-085	Conclusion or Recommendation:	REJECT ☑ Applicable ☐ Not Applicable
☑ Defect Limit :	GENERAL DEFECT LIMIT		

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
C. MONTANO	A. PILIPINAS		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: Start	Sorting Time: End	No. of Man-power	Lot Number	Sorted Quantity	Reject Quantity	Defect Name	Sorted by

	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: Start	Reworking Time: End	# of Man-power	Lot Number	Reworked Quantity	Good Quantity	Reject Quantity	Rejection Rate (%)

Reworked by / Department	Endorsed to / Department

XII. Reinspection Result

Reinspection Date	Reworking Time: Start	Reworking Time: End	# of Man-power	Lot Number	Reinspected Quantity	Good Quantity	Reject Quantity	Rejection Rate (%)

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.

Annex-02-085

700 . 2091

Kanepackage Philippine Inc.

REPRINT
PR-001-F12-REV.00

MEMO: - None -

JOB ORDER

Mark Jefferson II Jorvina Pacia
SO # : SO25-M-00047

Customer : HIBLOW PHILIPPINES INC

ITEM CODE: DB08005130-00

Netsuite Itemcode : DB08005130-00

JOB ORDER: JO25-M-00047-10

Item Description : XP BOX PROTOTYPE OUTER BOX AND INSERT PAD

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
5000	2025-01-21	Mendonez, Jhee Ann Manalo	2025-01-14

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
615X1025 CF TX200	5000		N/A			

Tooling Reference # A94B / 141 / 18-29 Control/Batch #: RM Issued By:

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. EQOS								
2. DIECUT ETERNA					G R			
3. DETACHING 1	1-27 1-28	DJ DJ		~~2800~~ 2280 ~~380~~ 880	G R			
4. GLUING CONVEYOR 1	1/27 2/5	KHAUD ARIES	yan mak 610	+ 636 +73 +140 +370 +175 +200 940 460 +1280	G R			
5. LOT NUMBERING	1/27 1-28 2/4 02/05 02/03		JHEENA DIANE CLARISSA	250 500 650 1000 1000 400	G R			
6. SCREENING	1/27		JUNS	500	G R	84	2	
7.	1/28		J.LAVADO Lee Jay	880	G R	39	1	Actual count
8.	02-03		IAN	~~250~~ 310		12		
9.	02/04 02/05		MOCHA Jorel EFREN	1030 400		25 31	21	15
10.	02/05 02/07 02-14		J.LAVADO EFREN CEZAR	520 160 650				

Customer Claim:

ARLENE PALLERMO
Job Controller

Notes: IN-HOUSE REJECTION: 240819 Overcut 4,749 pcs. NG

175 - QA . Jul 2/7 - Aries
200 QA - Jna 2/10 Larry

REMARKS

PROD PLAN: ADD #0 PLAN 2025-021

636 to QA Hene 1/27 - Aries
940 to QA Jue 1/28 - Larry
1280 QA - Jna 2/3 Calvin
73 to QA Hene 2/4 - Aries
370 to QA Hene 2/5 - Aries

HIBLOW PHILIPPINES INC.
Item Code: DB08005130-00
Quantity: 10 pcs.
Item Description: XP BOX - PROTO TYPE OUTER BOX AND INSERT PAD
Supplier's QC: PASSED INSPECTION RoHS OK QA-CG234
Lot No. / Ref. NO.: 250214-00047-10
MADE IN THE PHILIPPINES
KANEPACKAGE PHILIPPINE INC.

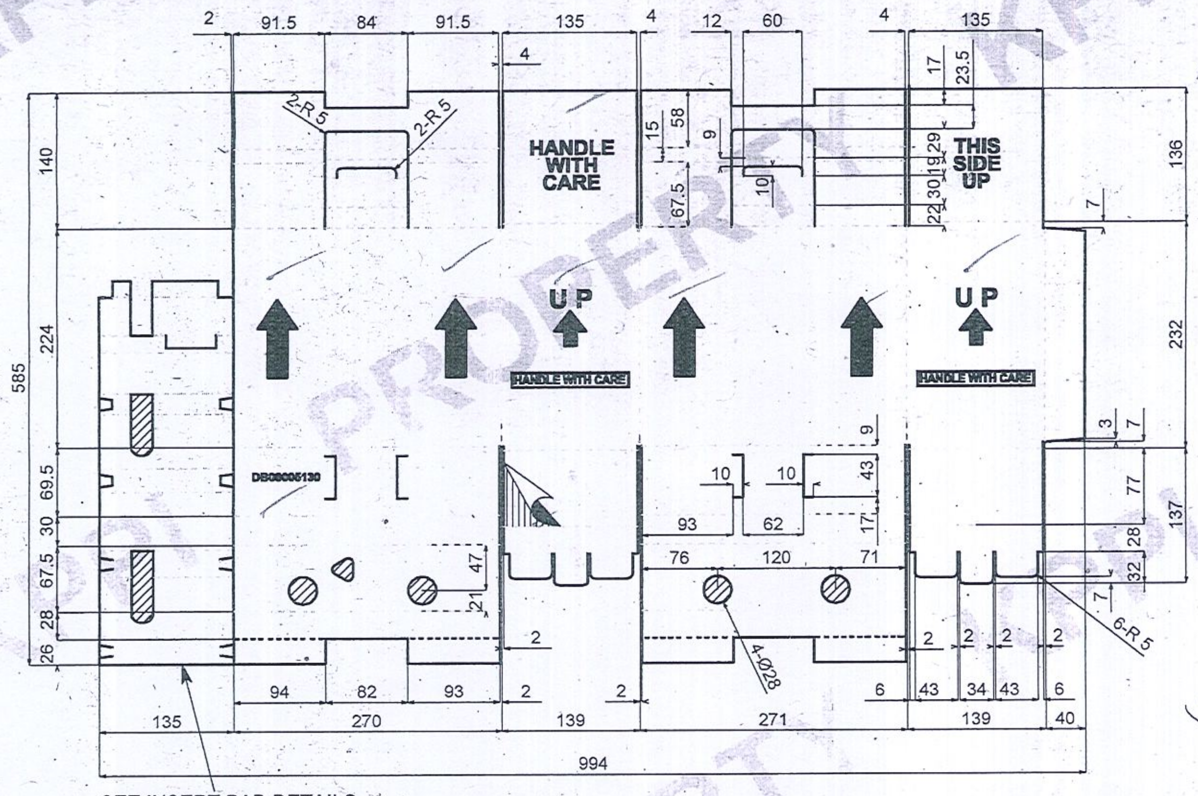
HIBLOW PHILIPPINES IN
Item Code: DB08005130-00
Item Description: XP BOX - PROTO TYPE OUTER BOX AND
Lot No. / Ref. NO.: 250205-00047-10
MADE IN THE PHILIP
KANEPACKAGE
Item Description: XP BOX - PROTO TYPE OUTER BOX AND I
Lot No. / Ref. NO.: 250205-00047-10
MADE IN THE PHILIPPINES
KANEPACKAGE PHILIPPINE INC.

Item Description: XP BOX - PROTO TYPE OUTER BOX AND INSERT PAD
Supplier's QC: PASSED INSPECTION RoHS OK QA-CG801
Lot No. / Ref. NO.: 250210-00047-10
MADE IN THE PHILIPPINES
KANEPACKAGE PHILIPPINE INC.
QA-CG2371
Quantity 10 pcs.
Supplier's QC PASSED INSPECTION RoHS OK QA-CG893
-00047-10
THE PHILIPPINES

*** UNCONTROLLED COPY FOR JOB ORDER ***

2025-01-14 Issued by:

WITH SUTEBAN



SEE INSERT PAD DETAILS

LEGEND:
- -CUTTING LINE
- -CREASING LINE
- -PERFORATION

DO NOT DETACHED INSERT PAD FROM THE OUTER BOX

BOX SPECIFICATION				
Inner Dimension	265 X 134 X 200mm			
Outer Dimension	N/A			
Joint Flap	GLUING INSIDE			
Illustration	SMOOTH SURFACE			
Bursting Strength	N/A			
BCT	N/A			
ECT	N/A			
PRINT COLOR	1			
Flexo	EQ-01 (BLACK)			
	N/A			
Offset	N/A			
Varnish Coating	N/A			
BLADE REQUIREMENTS				
WOOD	N/A			
Type	Height	Thickness	Pitch	Length
Cutting Blade				
Waved Blade				
Perforation				
Half-Cut				
Creasing Line				

NOTE:

1. USE BLADE OF DB08005110-01A OUTER BOX

258121
J. Rellora

△6 [A-2023-41480] PH-1-2013-363
PATENT NUMBER

CUSTOMER : HIBLOW

ITEM DESCRIPTION/PART CODE:
DB08005130-00
...P BOX - PROTO TYPE
...BOX AND INSERT PAD

CUSTOMERS SUPPLIED REFERENCE NO : N/A

ITEM KEY : HPI-0128-01AB-05

1/3 PAGE:

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

MATERIAL: C FLUTE
TX200/CM125/TX200

LEGEND: UNITS mm N. T. S.
- CUTTING
- CREASING
- HALF-CUT
- PERFORATION
- HOLE

PROCESS					
1	EQOS	7	OQA	13	
2	DIE CUT S1700	8		14	
3	DETACHING	9		15	
4	GLUING	10		16	
5	LOT. NUMBERING	11		17	
6	QA SCREENING	12		18	

...KAGE PHIL. INC.
...mesa Calamba, Laguna

REV. #	DATE	REASON	REQUESTED BY:
△5	24/02/09	ADDITIONAL PATENT NUMBER	F.YSMAEL

PACKING INSTRUCTION :
10 PCS. / BUNDLE

DRAWN BY:	CHECKED BY:	APPROVED BY:
L. AVILES	M. ALONSAGAY	S. LUBAG

DT-002-F01 REV.04

KANEPACKAGE PHILIPPINE INC.	SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)	Control No. SQA-01-002091

I. Item Information

Customer	HIBLOW PHILIPPINES INC	Inspection Date	250214 — Shift: ☑ Day ☐ Night
		Delivery Date	250121
Location	FCIE	Job Order No.	JO25-M-00047-10
Item Code	DB08005130-00	Job Order Qty.	5,000
Item Description	XP BOX PROTOTYPE OUTER BOX AND INSERT PAD	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	699914
Drawing Revision No.	05	Gluing Process	☑ Manual Gluing ☐ Semi-Auto Gluing
External Provider			☐ SD1800

II. Dimensional Inspection

Time Conducted Sample #1: 10:00 | Time Conducted Sample #2: 11:00 | Time Conducted Sample #3: 12:00

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	265		265	265	265	16					
2	134	+3	134	134	134	17					
3	200	-3	200	200	200	18					
4	72		72	72	72	19					
5	32	±5	32	32	32	20	N				
6	43		43	43	43	21				N	
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: 23-17013-022

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			
Grain Direction			
Paper Shade (Off Color)	N		
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			0
Print Color :			
Missing Print/ Character			
Blotted Print			
Smeared Print			
Other Print Defect : POOR PRINT	38		38
Linemark			
Fish-eye			
Stain :			
Excess Glue	N		
Gluing Defect :			
Worn-out			
Dent			
Punctured			
Tear-off			
Peel-off		0	
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)	INSIDE			Corrugated	TX200	TX200		
				Flute	CF	CF		
STITCHED (Inside or Outside)	N ——— A			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	688	**Defect Rate Formula:** $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$
Total Qty Good	650	
Total Qty NG	38	
Defect Rate in % / in PPM	5.52 % / 55,232.56 ppm	**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 % / in PPM	

VIII. Disposition

- ☑ Good
- ☐ Backload
- ☐ For Sorting
- ☐ For Rework
- ☐ For Special Acceptance
- ☐ Conditional (Please indicate details)

Abnormality Report Control No.: AR0024-02-085

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
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: 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	Cause of Downtime
	N		———	———	A		