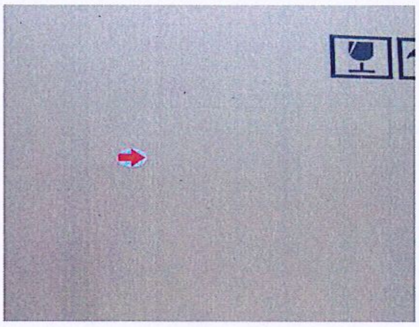
KANEPACKAGE PHILIPPINE INC.	# ABNORMALITY REPORT	Control No.
		AR2025-03-141

I. Item Information

Item Code	HP01D5601	Customer	KOWA EMORI
Item Description	CARTON BOX	Delivery Date	250326
Inspection Date	250326	Inspection Time	8:30AM
Lot Quantity	400 PCS	Job Order Number	JO25-M-00986-2
Affected Quantity	17 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	4.24% 42,500 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 5
Problem Description	HEAVY SCORING	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO HEAVY SCORING	

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

Related Doc. Info.	Control Number		
☑ Procedure Manual :	PM-QA-018	Requirement:	SCORING END TO END ALLOWED BUT SHOULD NOT GET THROUGH MURATA LOGO
☑ Technical Drawing :	EMO-0089-01		
☑ Work Instruction :	WI-QA-001-010	Actual:	WITH HEAVY SCORING END TO END
☑ Job Order :	JO25-M-00986-2		
☑ Reports :	AR2025-03-141	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
J. TAMPOC	A. FILIPINAS		M. CASILLANO	
QA Inspector	QA Line Leader	ME Head	QA Head	QA Staff

Important: Backloading Policy (External Provider Rejects)	Evaluation	Approved by	Final Disposition
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.

② 2639

Kanepackage Philippine Inc.

MEMO: - None -

JOB ORDER

Dela Ce
SO #

Customer : KOWA-EMORI PHILIPPINES, INC.	JOB ORDE
ITEM CODE: **HP01D5601** Netsuite Itemcode : HP01D5601	JO25-M-00986-2
Item Description : CARTON BOX	

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
400	2025-03-26	Tuiza, Jecille Maduro	2025-03-19

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
364X741 BF TX200-C	400	20	N/A	394	020574	PW

Tooling Reference # F-37 Control/Batch #: RM Issued By: [illegible] 3/25

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	3/25	PMEV	[illegible] 3/25	394	1				S-2026 E-2028
2. GLUING SA 2600	3/26	AN		387	1	7			
3. LOT NUMBERING	3/26		JAM	400					
4. SCREENING	3/26		J/R	370			17		BAL.
5.									
6.									
7.									
8.									
9.									

REJECTION/ ABNORMALITY HI

Customer Claim:

Notes:

KOWA-EMORI PHILIPPINES INC.

Item Code	Quantity
HP01D5601	10 pcs.
Item Description	Supplier's QC
CARTON BOX	PASSED INSPECTION RoHS OK QA-KP040 MP
Lot No. / Ref. NO.	
250326-00986-2	

KANEPACKAGE PHILIPPINE INC.

REMARKS
PROD PLAN: ADD #0 PLAN 2025-085

PRODUCTION OUT
BY:
DATE: 3/26
NETSUITE

NAME: DATE: 3/25

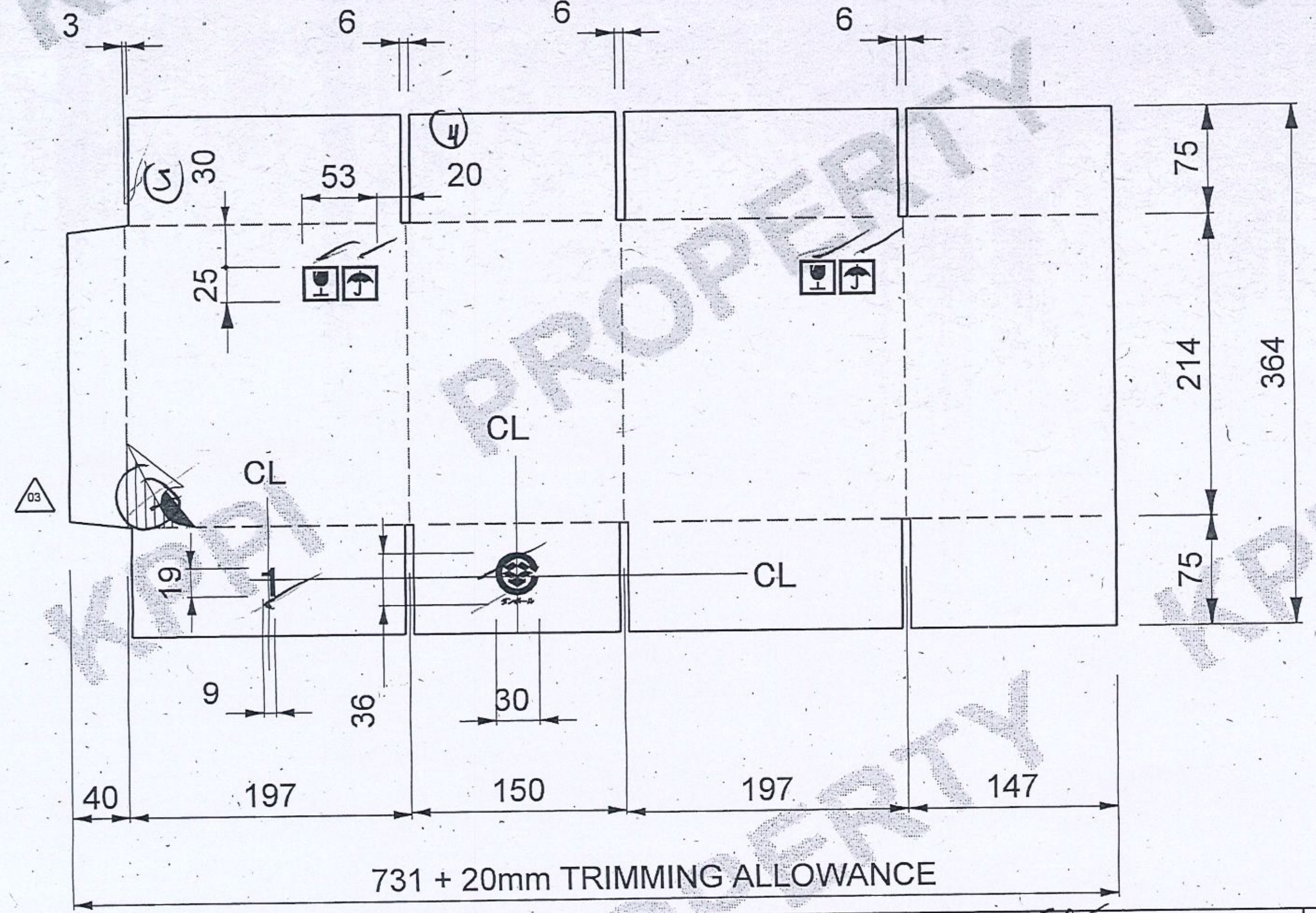
*** UNCONTROLLED COPY FOR JOB ORDER ***

2025-03-19 Issued by:

WITH SUTEBAN

ダンボール

1



BOX SPECIFICATION		
Inner Dimension	194 X 147 X 208mm	
Outer Dimension	200 X 153 X 420mm	
Joint Flap	GLUING INSIDE	
Illustration	Shows Smooth Surface (Outer Side)	
Bursting Strength	NA	
BCT	NA	
ECT	NA	
PRINT COLOR	1	2
Flexo	EQ-01 (BLACK)	NA
Digital Print	NA	
Offset	NA	
Varnish Coating	NA	

BLADE REQUIREMENT				
WOOD	Size:		Thickness:	
Type	Height	Thickness	Pitch	Length
Cutting Blade				
Waved Blade				
Perforation				
Half-Cut				
Creasing Line				

RoHS

NOTES:

1.) USE EXACT SHEET WITH CREASING SIZE: 364 X 751mm

250325
R. Pansingo

CUSTOMER :	KOWA EMORI
ITEM DESCRIPTION/PART CODE:	HP01D5601 CARTON BOX
CUSTOMERS SUPPLIED REFERENCE NO:	N/A
ITEM KEY :	EMO-0089-01AB-03
PAGE :	1 / 1

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

MATERIAL: B FLUTE (TX200/CM125/TX200)

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

PROCESS					
1	EQOS	7		13	
2	GLUING-C1/C2/SA/SD/MANUAL	8		14	
3	LOT NUMBERING	9		15	
4	QA SCREENING	10		16	
5	OQA	11		17	
6		12		18	

REV. #	DATE	REASON	REQUESTED BY:
03	241203	ADDITIONAL GRAIN DIRECTION. ADDITIONAL ITEM DESCRIPTION "CARTON BOX"	

PACKING INSTRUCTION: 10 PCS./BUNDLE (COLLAPSED)

DRAWN BY:	CHECKED BY:	APPROVED BY:
R. PAGKATOTOHAN	M. ALONSAGAY	S.LUBAG

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

DT-002-F01 REV.03

KPPI PROPERTY

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. SQB-03-002639

I. Item Information

Customer	KOWA-EMORI PHILIPPINES, INC.	Inspection Date	250326	Shift: ☑ Day ☐ Night
Location	BATANGAS	Delivery Date	250326	
Item Code	HP01D5601	Job Order No.	JO25-M-00986-2	
Item Description	CARTON BOX	Job Order Qty.	400	
Model	N/A	Inspection Method	☑ 100%	☐ Sampling
Drawing Revision No.	03	Delivery Receipt No.	0202574	
External Provider	P.W	Gluing Process	☐ Manual Gluing ☐ SD1800	☐ Semi-Auto Gluing

II. Dimensional Inspection

Time Conducted Sample #1: 6:50 | Time Conducted Sample #2: 7:10 | Time Conducted Sample #3: 7:30

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	194	+/-3	194	195	194	16					
2	147	+/-3	147	148	147	17					
3	208	+/-3	208	209	208	18					
4	20	+/-5	20	21	20	19					
5	30	+/-5	31	30	31	20	N				
6						21					
7						22					
8						23					
9						24					
10						25					
11						26					
12						27					
13						28			A		
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: 24-18045-156

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	17		17
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			
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 :			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		Type of Material			Judgement	
Requirement		Actual	Good	No Good	Requirement		Actual	Good	No Good
GLUED (Inside or Outside)	INSIDE	INSIDE	✓		Corrugated	UPPC	UPPC	✓	
					Flute	BF	BF	✓	
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	☐Good	☐ No Good
Scan 2	A	☐Good	☐ No Good
BQICS Compliance (For Epson items only)		☐Good	☐ No Good

VI. Inspection Result		
Total Qty Inspected	387	**Defect Rate Formula:** $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$
Total Qty Good	370	
Total Qty NG	17	**PPM Formula:** $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 1{,}000{,}000$
Defect Rate in %	4.39%	
Defect Rate in PPM	43,927 ppm	

VII. Sampling Inspection Result	
Total Sampling Qty Inspected	N
Total Sampling Qty Good	
Total Sampling Qty NG	A
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.: Anwre-03-141

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
JEX	[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		