

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		



Kanepackage Philippine Inc.

JOB ORDER

MEMO: - None -

Labay, Menchie

SO #: SO25-M-00781REV3.1

PR-001-F12-REV.00

Customer: BROTHER INDUSTRIES (PHILS.), INC.

ITEM CODE: D02Y4T001

Netsuite Itemcode: D02Y4T001

JOB ORDER:

JO25-M-00781-66



Item Description: PRINTED CARTON E115B CHN

QTY: 850

DELIVERY DATE:

2025-03-17

CREATED BY:

Tuiza, Jecille Maduro

DATE RELEASED:

2025-03-13

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
475X728 EF NPK170	850	20	475X728 EF	870	0200786	FW

Tooling Reference #

E5110-150

Control/Batch #:

RM Issued By:

3/17

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN		REJECTED QTY		REMARKS
		Operator	ME/QA		G	R	INHOUSE	SUPPLIER	
1. EQOS	3/17	PVERM	ENAND 2/17	870	2				
2. DIECUT S1700	3/17	WILUS JAMES	JAMES 1/17	880	14				
3. DETACHING 1	3/17	NIL		854					
4. GLUING SD 1800	3/18	RHEA MACHICA ARAB MANUEL		842	14				
5. LOT NUMBERING	03/19		JLana	840					
6. SCREENING	03-18		CEZAR	820			12		
7.									
8.									
9.									

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

REMARKS

PROD PLAN: ADD #11 PLAN 2025-076

KANEPACKAGE PHILIPPINES INC.

Part Code	D02Y4T001
Part Name	PRINTED CARTON E115B CHN
Production Date	260318
Lot Number	JO25-M-00781-66
Quantity	20 pcs.
P.O.	N/A
Mold No./Cavity	N/A
Operator	QA-CG234
Remarks	MP



STAMP

STAMP

2025-03-13 Issued by: *ff*

BOX SPECIFICATIONS	
Inner Dimension	234 X 94.5 X 254 mm
Outer Dimension	237 X 97.5 X 259 mm
Joint Flap	GLUING INSIDE
Illustration	SMOOTH SURFACE (OUTSIDE)
Bursting Strength	883 kPa (9kg/cm ²)
BCT	
ECT	
PRINT COLOR	1 2
Flexo	BROTHER BLUE BLUE 255
Digital Print	
Offset	
Varnish Coating	
BLADE REQUIREMENT	
WOOD	Size: Thickness: Pitch: Length:
Type	
Cutting Blade	
Waved Blade	
Perforation	
Half-Cut	
Creasing Line	

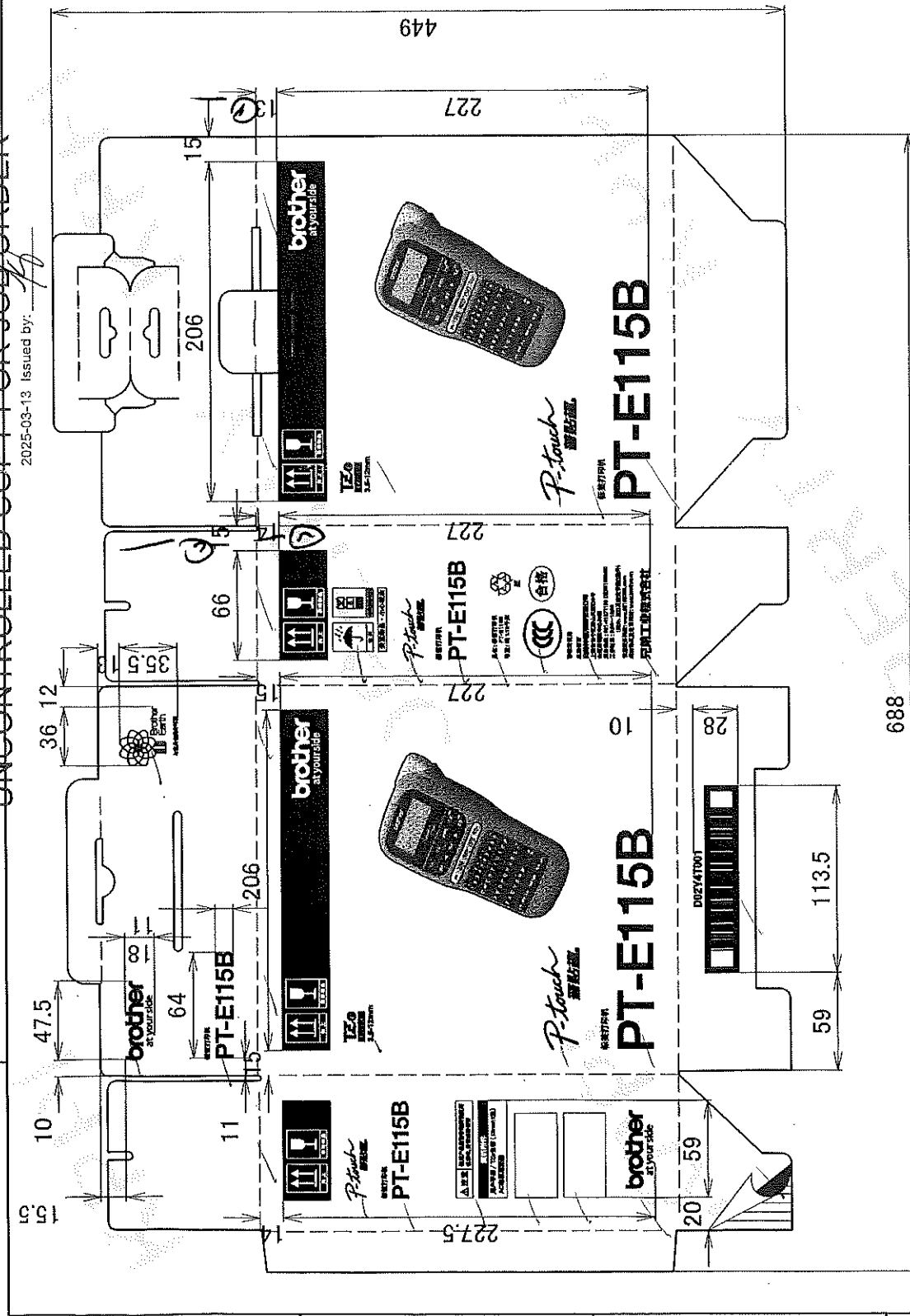
C



B

25037
J-Rellora

A



CUSTOMER: BROTHER		ITEM DESCRIPTION/PART CODE: D02Y4T001		PRINTED CARTON E115B CHN			
CUSTOMERS SUPPLIED REFERENCE NO:		ITEM KEY: BIP-0616-01AB-02		PAGE: 1-3			
CHANGE SHEET SIZE AS PER CORRECT DRAWING DETAILS FROM 475 X 762 TO 475 X 725		REV. # 02		DATE 241121			
KANEPACKAGE PHILIPPINE INC. 45 Ring Rd, LDP 2 Bldg, Larena Cebu, Laguna Tel. No. (049) 545-7709 / 49545-7302		K. IJIMA REQUESTED BY:		REASON			
TOLERANCE		DIMENSION		PRINT: +/- 5			
		TOLERANCE		PRINT: +/- 5			
		DIMENSION		PRINT: +/- 5			
		DIMENSION		MATERIAL: EF (NPK170/CM125/NPK170)	P R O C E S S		
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		DIMENSION					
		DIMENSION		LEGEND: Unit in mm	P A C K I N G I N S T R U C T I O N : 25 PCS. / BUNDLE		
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KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No.

SQB-03-001898

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	2503/8	Shift: ☐ Day ☒ Night
Location	BATANGAS	Delivery Date	250317	
Item Code	D02Y4T001	Job Order No.	JO25-M-00781-66	
Item Description	PRINTED CARTON E115B CHN	Job Order Qty.	850	
Model	N/A	Inspection Method	☒ 100% ☐ Sampling	
Drawing Revision No.	02	Delivery Receipt No.	020706	
External Provider	PCO	Gluing Process	☐ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800	

II. Dimensional Inspection

Time Conducted Sample #1: 9:10				Time Conducted Sample #2: 9:30				Time Conducted Sample #3: 10:20			
Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	234		234	234	234	16					
2	94.5	+3	94.5	94.5	94.5	17					
3	254	-	254	254	254	18					
4	13		13	13	13	19					
5	14	+5	14	14	14	20	N	←			22
6	15	-	15	15	15	21					
7						22					
8						23					
9						24					
10						25					
11						26					
12						27					
13						28					
14						29					
15						30					

Measuring ☒ Meter Tape ☐ Moisture Content Tester ☐ Zahn Cup ☐ Stopwatch
 Tool Used: ☐ Thickness Gauge ☐ Weighing Scale ☐ Steel Ruler ☐ Caliper
 Control Number of Measuring Tool Used: 25-23085-012

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

A. CORRUGATED ITEM / BOX / DANPLA	In-house	External Provider	Total Quantity	B. PALLET	In-house	External Provider	Total Quantity
Scoring	7		7	Condition of Wood	N/A	N/A	N/A
Grain Direction				Rusty Nail	N/A	N/A	N/A
Paper Shade (Off Color)				Warping	N/A	N/A	N/A
Bubbles				Fumigation Stamp	N/A	N/A	N/A
Blister				Crack/ Damages	N/A	N/A	N/A
Wrinkle	1		1	Others	N/A	N/A	N/A
Delamination							
Uneven Kraft liner				C. CORRUGATED PALLET	In-house	External Provider	Total Quantity
Warpage				Color of Carton (Discoloration)	N/A	N/A	N/A
Cracking on edge				Flute of Material	N/A	N/A	N/A
Bursting / Bursting on Edge (Crowfeet)				Type of Adhesion	N/A	N/A	N/A
Wrong die-cut orientation				Adhesion of Runner	N/A	N/A	N/A
Inverted die-cut				Rusty Wire	N/A	N/A	N/A
Close Gap/ Wide Gap				Wrong Orientation	N/A	N/A	N/A
Print Color: _____				Damages: _____	N/A	N/A	N/A
Missing Print/ Character				Others: _____	N/A	N/A	N/A
Blotted Print							
Smeared Print				D. MOULDED ITEMS	In-house	External Provider	Total Quantity
Other Print Defect: <u>Misaligned Print</u>	2		2	Poor Fusion	N/A	N/A	N/A
Linemark				Chip Off	N/A	N/A	N/A
Fish-eye				Warp / Deform	N/A	N/A	N/A
Stain: _____	2		2	Crack	N/A	N/A	N/A
Excess Glue				Broken	N/A	N/A	N/A
Gluing Defect: _____				Scratches	N/A	N/A	N/A
Worn-out				Foreign Materials	N/A	N/A	N/A
Dent				Wet / Moist	N/A	N/A	N/A
Punctured				Dirt	N/A	N/A	N/A
Tear-off	3		3	Stain: _____	N/A	N/A	N/A
Peel-off	1		1	Discoloration	N/A	N/A	N/A
Damages: _____	1		1	Excess Flashes	N/A	N/A	N/A
Others: <u>JPOT</u>	25		25	Others: _____	N/A	N/A	N/A

(42)



Joint Flap		Judgement		Type of Material			Judgement		
Requirement		Actual	Good	No Good	Requirement		Actual	Good	No Good
GLUED (Inside or Outside)	INSIDE	IDE	/		Corrugated	NPK 170	NPK 170	/	
					Flute	EF	EF	/	
STITCHED (Inside or Outside)	OUTSIDE		/		Others	OUTSIDE		/	

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

Requirement	Actual	Good	No Good	Scan 1	☐ Good ☐ No Good
5	4			Scan 2	☐ Good ☐ No Good
				BQICS Compliance (For Epson items only)	☐ Good ☐ No Good

VII. Sampling Inspection Result

Total Qty Inspected	842	Defect Rate Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$	Total Sampling Qty Inspected	
Total Qty Good	800		Total Sampling Qty Good	
Total Qty NG	42		Total Sampling Qty NG	✓ ———— ✗
Defect Rate in % in PPM	4.90% / 49,000.24 ppm	PPM Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 1,000,000$	Defect Rate in % in PPM	

IX. Remarks

☒ Good ☐ Backload ☐ For Sorting ☐ For Rework	☐ For Special Acceptance ☐ Conditional (Please indicate details) Abnormality Report Control No.: <u>AWR-03-099</u>	IX. Remarks
---	--	-------------

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
C. MONTANO			
QA Screening Inspector	QA Line Leader	QA Supervisor / QA Asst. Supervisor	QA Head

Defect	Verification Quantity		Remarks:	Verified by (Signature over Printed Name)
	Good	No-Good		
Total				QA Inspector

CORRUGATED AND MOULDED ITEMS

[illegible]

Annex - 05-100 delam

1899



Kanepackage Philippine Inc.

PR-001-F12-REV.00

MEMO: - None -

Talatala, Mirasol
SO #: TO-F-25-285

JOB ORDER

Customer : CANON BUSINESS MACHINE PHILS.		JOB ORDER:	
ITEM CODE: FX2-5097-000-RMFG		JO-F-25-285-4	
Netsuite Itemcode : FX2-5097-000-RMFG			
Item Description : Z10 BOX OUTER			
QTY: 600	DELIVERY DATE: 2025-03-15	CREATED BY: Mendonez, Jhee Ann Manalo	DATE RELEASED: 2025-03-08

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
875X1200 CBF NPK280	600	15	NA	615	202246	pw
875X1200 CBF NPK280	600	15	NA	615	202293	
	0					
	0					

Tooling Reference # **E-58-246** Control/Batch #: **10** RM Issued By: **Elmer 3/17**

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN		REJECTED QTY		REMARKS
		Operator	ME/QA		G	R	INHOUSE	SUPPLIER	
1. EQOS	03/17	JMA	2/17/17	A. G15 B. G15	2				AC-20H E-20H PS-20H E-20H
2. DIECUT S1700	3/8	Tm12	P. 2018/18	A. G18 B. G14	4	1			A- S-4.18 E-4.18 P-4.18 E-4.18
3. GLUING CONVEYOR 2					G	R			
4. LOT NUMBERING					G	R			
5. SCREENING	3/8		JOM S	2	G	R		23	
6. BARCODE SCANNING					G	R			
7.					G	R			
8.									
9.									
10.									

KANEPACKAGE PHILIPPINE, INC. REV.00
CUSTOMER : CANON BUSINESS MACHINE PHILS. INC.
ITEM CODE : FX2-5097-000
ITEM DESCRIPTION : Z10 BOX OUTER 555
ITEM SIZE :
LOT NUMBER : 250313-25-285-4
QUANTITY : 2 pcs.
MP CA PASSED

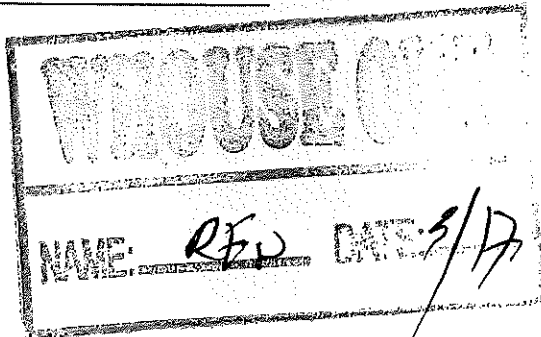
REJECTION HISTORY

Customer Claim:

Notes: IN-HOUSE REJECTION HISTORY: peel off

REMARKS

PROD PLAN: ADD #0 PLAN 2025-074





BOX CERTIFICATE

PAPER MATERIAL	NPCK280/CMT175X3/NPK280
BURSTING TEST	1714 kPa
BOX MAKER	KANEPACKAGE PHILIPPINE INC.

2025-03-08 Issued by: *[Signature]*

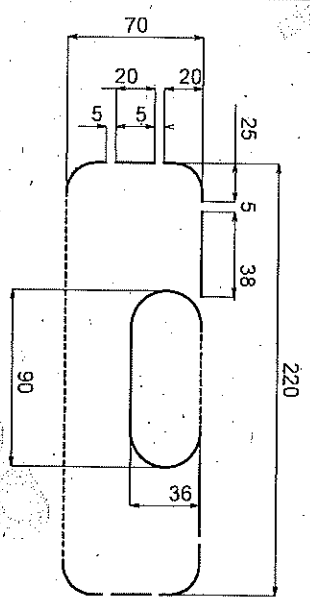
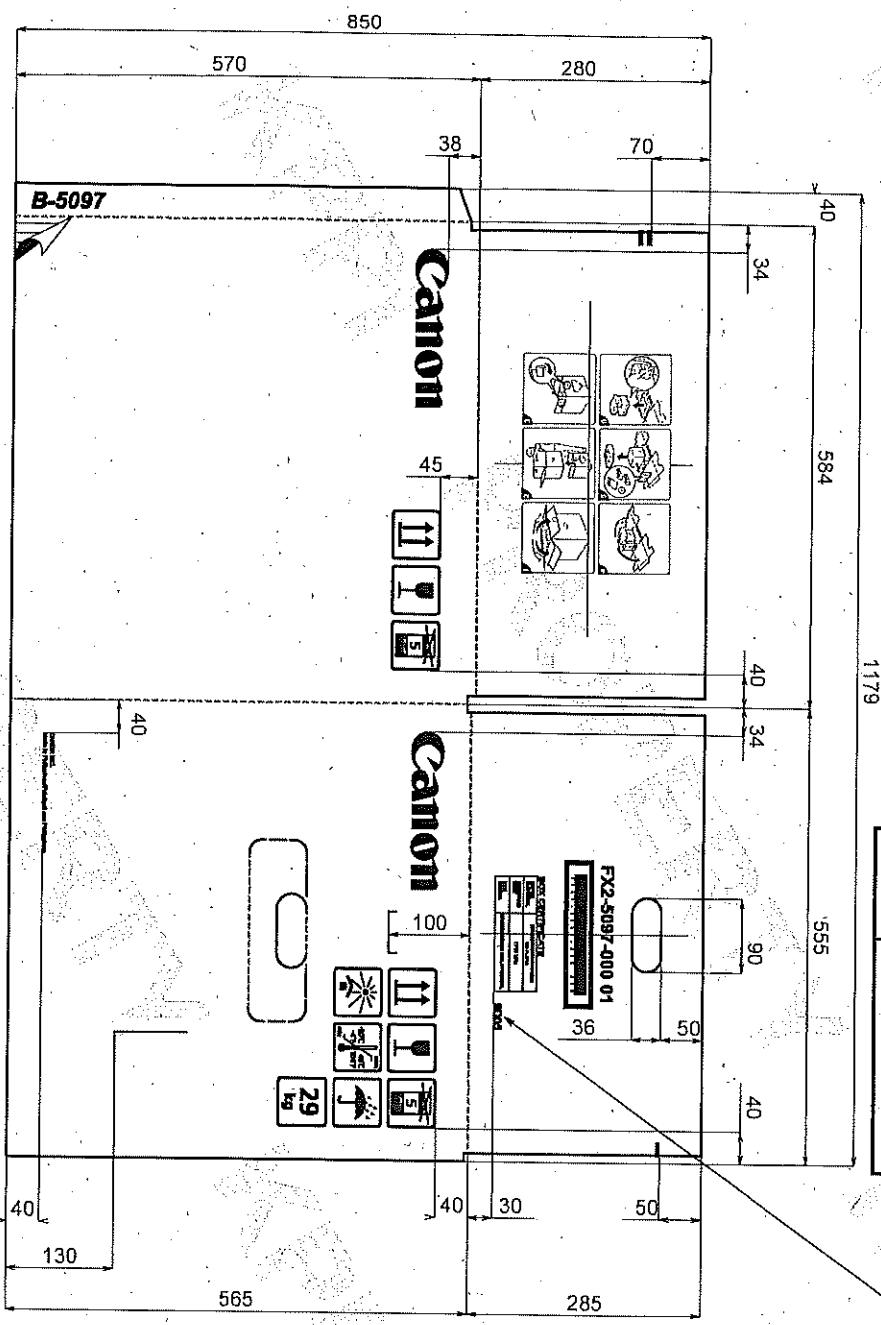
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INDICATION OF DATE OF MANUFACTURE

9 - LAST DIGIT OF THE YEAR
D - MONTH OF THE YEAR (A - L)
05 - DAY

NOTES:

1. INNER DIMENSION : 576 X 549 X 557mm
2. JOINT FLAP : GLUING INSIDE (2 JOINTS)
3. WITH PRINT : EQ-01 BLACK
4. BCT : 587 kgf
5. CUTTING LINE SHALL BE WAVED (2 PITCH)
6. USE BLADE OF FX2-4183-000 Z10 OUTER BOX_555



WITH SUTEBAN

CUSTOMER : CBMP

ITEM DESCRIPTION/PART CODE : CUSTOMERS SUPPLIED REFERENCE NO :

FX2-5097-000
Z10_BOX OUTER_555
PART B

ECN NO. - JUN16197
ITEM KEY : CBM-0402-01AB-06
PAGE : 2/2
PRINT : +/5

TOLERANCE

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

MATERIAL:

CB FLUTE
(NPK280/CMT175X3/NPK280)

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

P	1	EGOS	7	BARCODE SCANNING	13
O	2	DIECUT S1700/S1400	8	OCA	14
C	3	DETACHING	9		15
S	4	GLUING	10		16
S	5	LOT NUMBERING	11		17
S	6	QA SCREENING	12		18

PACKING INSTRUCTION :
PALLETIZED

Drawn by: J.M. SULANSON
Checked by: M. ALAREZ
Approved by: S. LUBAG

6

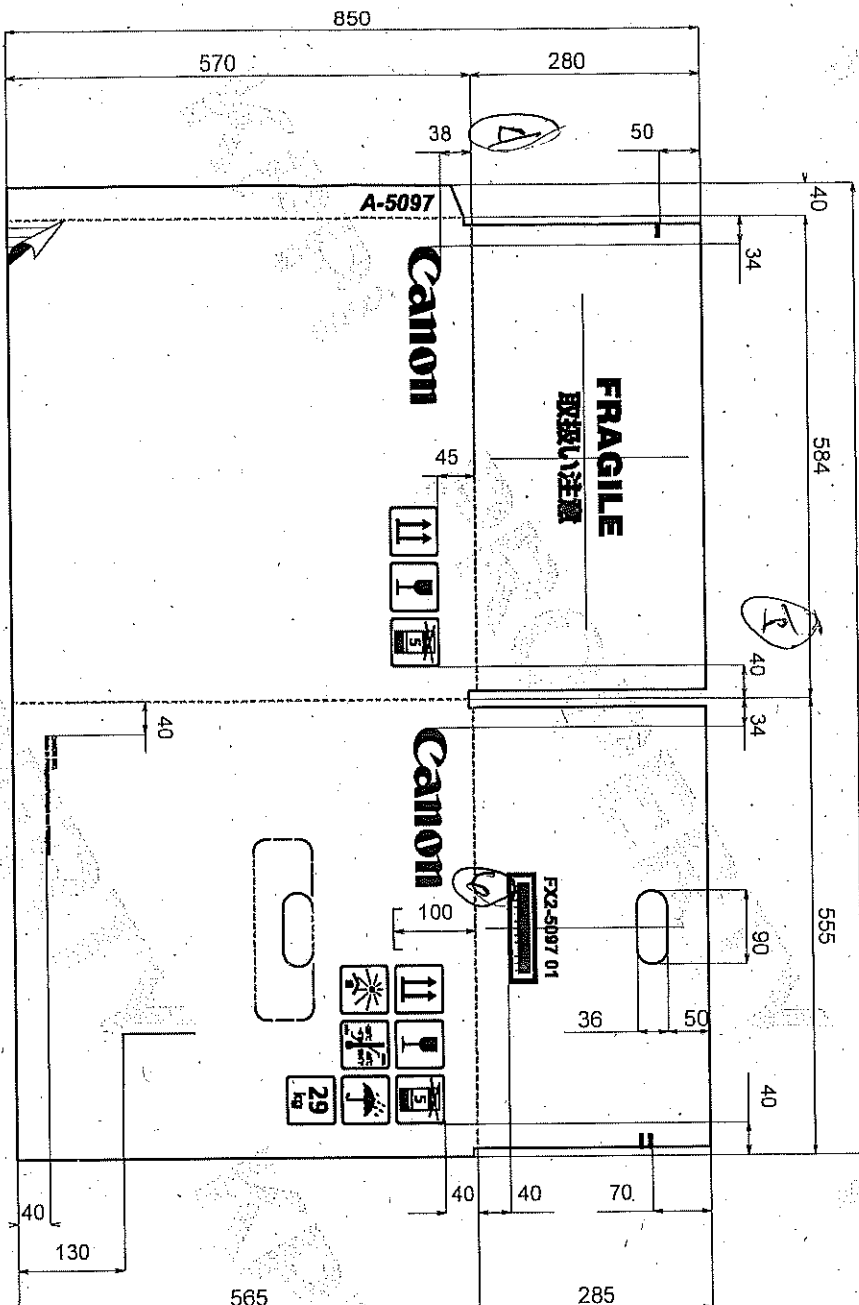
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*** UNCONTROLLED COPY FOR 3108/ORDER *** 2

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2025-03-08 Issued by: 14

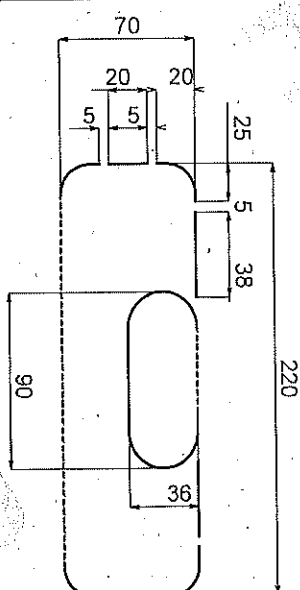
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NOTES:

1. INNER DIMENSION : 576 X 549 X 557mm
2. JOINT FLAP : GLUING INSIDE (2 JOINTS)
3. WITH PRINT : EQ-01 BLACK
4. BCT : 587 kgf
5. CUTTING LINE SHALL BE WAVED (2 PITCH)
6. USE BLADE OF FX2-4183-000 Z10 OUTER BOX_565

WITH SUTEBAN



CUSTOMER: CBMP

ITEM DESCRIPTION/PART CODE: CUSTOMERS SUPPLIED REFERENCE NO.:

ECN No. - JUN16197

FX2-5097-000
Z10_BOX_OUTER_565
PART A

ITEM KEY:

CBM-0402-01AB-06

PAGE: 1/2

PRINT: +/5

TOLERANCE

DIMENSION: +S/-2mm

51-200 +/1

201-400 +/2

401-700 +/3

701-1000 +/4

1000+ +/5

MATERIAL:

CB FLUTE (NPK280/CM175X3/NPK280)

LEGEND: UNITS: mm

- CUTTING

- CREAMING

- HALF-CUT

- PERFORATION

P. 1

R. 2

O. 3

C. 4

E. 5

S. 6

EQOS

DIECUT S1700/S1400

DETACHING

GLUING

LOT NUMBERING

QA SCREENING

BARCODE SCANNING

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KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT
(CORRUGATED AND MOULDED ITEMS)

Control No.

SQB-03-001899

I. Item Information

Customer	CANON BUSINESS MACHINE PHILS.	Inspection Date	2504/8	Shift: ☐ Day ☒ Night
Location	BATANGAS	Delivery Date	250315	
Item Code	FX2-5087-000-RMFG	Job Order No.	JO-F-25-285-4	
Item Description	Z10 BOX OUTER	Job Order Qty.	600	
Model	N/A	Inspection Method	☒ 100% ☐ Sampling	
Drawing Revision No.	06	Delivery Receipt No.	202209	
External Provider	PLW	Gluing Process	☒ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800	

II. Dimensional Inspection

Time Conducted Sample #1: 2041			Time Conducted Sample #2: 2051			Time Conducted Sample #3: 2059					
Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	576	±5	576	577	577	16					
2	549		549	550	551	17					
3	557		557	557	557	18					
4	58	±5	58	59	59	19					
5	40		40	41	42	20					
6	100		100	102	101	21					
7						22					
8						23					
9						24					
10						25					
11						26					
12						27					
13						28					
14						29					
15						30					

Measuring Tool Used: ☒ Meter Tape ☐ Moisture Content Tester ☐ Zahn Cup ☐ Stopwatch ☐ Control Number of Measuring Tool Used: 250225/6819
☐ Thickness Gauge ☐ Weighing Scale ☐ Steel Ruler ☐ Caliper

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

A. CORRUGATED ITEM / BOX / DANPLA			In-house	External Provider	Total Quantity	B. PALLET			In-house	External Provider	Total Quantity
Scoring						Condition of Wood			N/A	N/A	N/A
Grain Direction						Rusty Nail			N/A	N/A	N/A
Paper Shade (Off Color)						Warping			N/A	N/A	N/A
Bubbles						Fumigation Stamp			N/A	N/A	N/A
Blister						Crack/ Damages			N/A	N/A	N/A
Wrinkle						Others			N/A	N/A	N/A
Delamination				23	23	C. CORRUGATED PALLET			In-house	External Provider	Total Quantity
Uneven Kraft liner						Color of Carton (Discoloration)			N/A	N/A	N/A
Warpage						Flute of Material			N/A	N/A	N/A
Cracking on edge						Type of Adhesion			N/A	N/A	N/A
Bursting / Bursting on Edge (Crowfeet)						Adhesion of Runner			N/A	N/A	N/A
Wrong die-cut orientation						Rusty Wire			N/A	N/A	N/A
Inverted die-cut						Wrong Orientation			N/A	N/A	N/A
Close Gap/ Wide Gap						Damages:			N/A	N/A	N/A
Print Color:						Others:			N/A	N/A	N/A
Missing Print/ Character						D. MOULDED ITEMS			In-house	External Provider	Total Quantity
Blotted Print						Poor Fusion			N/A	N/A	N/A
Smeared Print						Chip Off			N/A	N/A	N/A
Other Print Defect:						Warp / Deform			N/A	N/A	N/A
Linemark						Crack			N/A	N/A	N/A
Fish-eye						Broken			N/A	N/A	N/A
Stain:						Scratches			N/A	N/A	N/A
Excess Glue						Foreign Materials			N/A	N/A	N/A
Gluing Defect:						Wet / Moist			N/A	N/A	N/A
Worn-out						Dirt			N/A	N/A	N/A
Dent						Stain:			N/A	N/A	N/A
Punctured						Discoloration			N/A	N/A	N/A
Tear-off						Excess Flashes			N/A	N/A	N/A
Peel-off						Others:			N/A	N/A	N/A
Damages:											
Others:											

		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	x/pe 210	✓					
STITCHED (Inside or Outside)	pe		✓		Flute	C/T	✓					
					Others	N	✓					
IV. Destructive Test (Based on Customer Requirement)				V. Barcode Print (If Only with Printed Barcode on Item)								
Requirement	Actual	Good	No Good	Scan 1		☐ Good	☐ No Good					
70%	95%	✓		Scan 2	x/pe 210	☐ Good	☐ No Good					
				BQICS Compliance (For Epson items only)		☐ Good	☐ No Good					
VI. Inspection Result				VII. Sampling Inspection Result								
Total Qty Inspected	25	Defect Rate Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$ PPM Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 1,000,000$		Total Sampling Qty Inspected	x/pe 210							
Total Qty Good	2			Total Sampling Qty Good								
Total Qty NG	23			Total Sampling Qty NG								
Defect Rate	92% / 920,000 PPM			Defect Rate	in %							
					in PPM							
VIII. Disposition				IX. Remarks								
☒ Good ☐ For Special Acceptance ☐ Backload ☐ Conditional (Please indicate details) ☐ For Sorting ☐ For Rework Abnormality Report Control No.: <u>Amort 13-100</u>												
Inspected by		Checked by							Approved by (If there are major concerns)		Verified by (If there are major concerns)	
Jous		mg									QA Head	
QA Screening Inspector		QA Line Leader		QA Supervisor / QA Asst. Supervisor								
X. Reject & Reworks Item Verification												
Defect	Verification Quantity		Remarks:	Verified by (Signature over Printed Name)								
	Good	No-Good										
Total				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					