

 KANEPACKAGE PHILIPPINE INC.		ABNORMALITY REPORT		Control No.	
				AR2025-05-009	

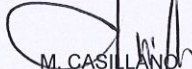
I. Item Information					
Item Code	DB08005130-00	Customer	HIBLOW		
Item Description	XP BOX WITH INSERT PAD	Delivery Date	250503		
Inspection Date	250503	Inspection Time	2PM		
Lot Quantity	5,000 PCS	Job Order Number	JO25-M-01315-1		
Affected Quantity	57 PCS	Origin	☒ IN-HOUSE ☐ SUPPLIER:		
Rejection Rate and PPM	1.14% 11,400 PPM	Date Received	N/A		
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 3		
Problem Description	PEEL OFF	Delivery Receipt Number	N/A		

II. Visual Reference (Defect Illustration)	
NO PEEL OFF	

III. Documented Information Review (To be filled out by Qa Line Leader)					
Related Doc. Info.	Control Number	Requirement:	ACCEPTABLE UP TO 25MM		
☒ Procedure Manual :	PM-QA-018	Actual:	WITH PEEL OFF UP TO 30MM		
☒ Technical Drawing :	HPI-0128-01				
☒ Work Instruction :	WI-QA-001-010				
☒ Job Order :	JO25-M-01315-1	Conclusion or Recommendation:	REJECT ☒ Applicable ☐ Not Applicable		
☒ Reports :	AR2025-05-009				
☒ Defect Limit :	GENERAL 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
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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) Rejection rate that is more than 80% of the total quantity shall be approved by Top Management before backloading.	Evaluation ☐ <80% No Need ☐ >80% Need	Approved by Top Management	Final Disposition ☐ Backload ☐ Accept ☐ Other _____
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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.

PR-001-F12-REV.00

MEMO: - None -

JOB ORDER

Francine Minaves

SO #: SO25-M-01315 REV3

Customer: HIBLOW PHILIPPINES INC

ITEM CODE: DB08005130-00

Netsuite Itemcode: DB08005130-00

JOB ORDER:

JO25-M-01315-1



Item Description: XP BOX PROTOTYPE OUTER BOX AND INSERT PAD

QTY: 5000

DELIVERY DATE:

2025-04-23

CREATED BY:

Pallermo, Arlene Gonzales

DATE RELEASED:

2025-04-16

Raw Material Code:

615X1025 CF TX200

Qty To
Be Used:

5000

Over
Run:

20

Cut
Size:

N/A

Actual
Issued:

4850

DR#:

66667

SUPPLIER:

8/8

Tooling Reference # A-94B - 141

Control/Batch #:

RM Issued By:

Cms 4/24

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN		REJECTED QTY		REMARKS
		Operator	ME/QA		G	R	INHOUSE	SUPPLIER	
1. EQOS	4/24	DEM	2nd 4/24	4850	2				E-0239 E-2239
2. DIECUT ETERNA	4/28	UPA	2nd 4/28	4,850	1		11		
3. DETACHING 1	4-28	DS		+1200 2,000 +1100	G	R			
4. GLUING CONVEYOR 1	4/28 5/02	Man with hand motion check	1,090	2243, 35 620	2				DESTRUCTIVE TEST APPROVED 20428
5. LOT NUMBERING	04-28 8/2	Diane Pachen		800 100 + 120 1500 + 170	G	R			
6. SCREENING	04-28	Ian		1500	G	R	23		
7.	4/29	Joy Jerich		708			12		
8.	05/02	J. Lina		655			77	3	
9.	05/03	JST		1010					

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes: IN-HOUSE REJECTION: 240819 Overcut - 4,749 pcs. NG / 5,000 pcs.

QA INPUT: DATE
TIME QTYQA OUTPUT: DATE
TIME QTYWP REJECT DATE 4/29
TIME 9:10 QTY 35

REMARKS

PROD PLAN: ADD #3 PLAN 2025-113

2243 to QA - Sna 4/28
620 QA - Jm 5/2
35 to QA - Sna 5/2
1000 to QA - k... 5/2

HIBLOW PHILIPPINES INC.

Item Code
DB08005130-00Quantity
10 pcs.Item Description
XP BOX - PROTOTYPE OUTER BOX AND INSERT PAD

Supplier's QC

PASSED

Lot No. / Ref. No.
250503-01315-1

INSPECTION

RoHS OK

QA: KP040

MADE IN THE PHILIPPINES

WP

WITH SUTEBAN

BOX SPECIFICATION				
Inner Dimension	285 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				
Flexo	EQ-01 (BLACK)			
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



JA-2023-414801 PH-1-2013-363
PATENT NUMBER

DO NOT DETACHED INSERT PAD
FROM THE OUTER BOX

SEE INSERT PAD DETAILS

LEGEND:
- CUTTING LINE
- CREASING LINE
- PERFORATION

CUSTOMER: HIBLOW		MATERIAL: C FLUTE TX200/CM125/TX200	
ITEM DESCRIPTION/PART CODE: DB08005130-001 XP BOX - PROTO TYPE OUTER BOX AND INSERT PAD		TOLERANCE: DIMENSION: +/- 3 51-200 +/- 1 201-400 +/- 3 401-700 +/- 5 701-1000 +/- 8 1000+ +/- 5 mm	
CUSTOMERS SUPPLIED REFERENCE NO: N/A		ITEM KEY: 1/3	
DATE: 24/02/09		ADDITIONAL PATENT NUMBER	
REV # 5		REASON	
KANEPACKAGE PHIL INC. #2 Ring Rd, USP 2 Bldg, Linares Calamba, Laguna Tel. No. (09)954-71610 to 59 Fax No. (09)954-7170 (09)954-6322		F.Y.S.M.A.E.L. REQUESTED BY:	
Packing Instruction: 10 PCS. / BUNDLE		CHECKED BY: M. ALONSA GAY APPROVED BY: S. LUBAG	
DT-002-FOT REV.04		1	

	SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)				Control No. SQA-04-002319		
I. Item Information							
Customer	HIBLOW PHILIPPINES INC			Inspection Date	250503		
Location	FCIE			Delivery Date	250423		
Item Code	DB08005130-00			Job Order No.	JO25-M-01315-1		
Item Description	XP BOX PROTOTYPE OUTER BOX AND INSERT PAD			Job Order Qty.	5,000		
Model	N/A			Inspection Method	☐ 100% ☐ Sampling		
Drawing Revision No.	05			Delivery Receipt No.	66667		
External Provider	8/8			Gluing Process	☒ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800		
II. Dimensional Inspection							
Time Conducted Sample #1: 9:00			Time Conducted Sample #2: 10:30			Time Conducted Sample #3: 1:30	
Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3		
1	265	} +1.3	266	265	266	16	
2	134		134	135	134	17	
3	200		201	200	201	18	
4	58	} +1.5	58	59	58	19	
5	67.5		68	67	68	20	
6						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: 24-18065-150	
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	5		5	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	N			C. CORRUGATED PALLET	In-house	External Provider	Total Quantity
Warping				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 : POOR PRINT	7		7	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 : OIL		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	1		1	Wet / Moist	N/A	N/A	N/A
Punctured				Dirt	N/A	N/A	N/A
Tear-off	2		2	Stain :	N/A	N/A	N/A
Peel-off 30mm	57		57	Discoloration	N/A	N/A	N/A
Damages : OVERLAP	1		1	Excess Flashes	N/A	N/A	N/A
Others : BIRD STAIN	4		4	Others :	N/A	N/A	N/A

