KANEPACKAGE PHILIPPINE INC.

ABNORMALITY REPORT

Control No. **AR2025-06-060**

I. Item Information

Item Code	D028GY001	Customer	BROTHER
Item Description	CARTON	Delivery Date	250623
Inspection Date	250623	Inspection Time	3:30AM
Lot Quantity	1,450 PCS	Job Order Number	JO25-M-01987-133
Affected Quantity	25 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	1.72% 1,724 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)

GOOD	NO GOOD
NO PEEL OFF	

III. Documented Information Review (To be filled out by Qa Line Leader)

Related Doc. Info.	Control Number		
☑ Procedure Manual :	PM-QA-018	Requirement:	PEEL OFF NOT ACCEPTABLE
☑ Technical Drawing :	BIP-0646-01		
☑ Work Instruction :	WI-QA-001-010	Actual:	WITH PEEL OFF UP TO 100MM
☑ Job Order :	JO25-M-01987-133		
☑ Reports :	AR2025-06-060	Conclusion or Recommendation:	REJECT ☑ Applicable ☐ Not Applicable
☑ Defect Limit :	BIPH DEFECT LIMIT		

IV. Initial Disposition (To be filled out by ME Department If Needed)

☐ Good ☐ Conditional (Please indicate details)
☐ Rejected
☐ Backload

☑ 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
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	Approved by	Final Disposition
☐ <80% No Need		☐ Backload
☐ >80% Need		☐ Accept
	Top Management	☐ 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 1622

PR-001-F12-REV.00

Kanepackage Philippine Inc.

MEMO: - None -

JOB ORDER

Labay, Menchie
SO # : SO25-M-01987rev5

Customer : BROTHER INDUSTRIES (PHILS.), INC.

JOB ORDER: JO25-M-01987-133

ITEM CODE: **D028GY001**

Netsuite Itemcode : D028GY001

Item Description : CARTON TN FCL X4

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
1450	2025-06-23	Pallermo, Arlene Gonzales	2025-06-16

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
1186X929 CF NPK210	725	10	N/A	735		
1186X929 CF NPK210	725	10	N/A	735	2058?3	PW
	0					
	0					
	0				AKMF	
	0					
	0					
	0					
E2-76-340	0					
E40A-05	0					

Tooling Ref# ~~CYREL-E/ BLADE-E-2-CYREL-40A/ BLADE-16~~ Ctrl/Batch #: RM Issued By: cmy 6/20

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. EQOS	6/20	PMEE	6/20	1470	2 G R			E 1014 E 1004
2. DIECUT ETERNA	06/23	GVA	6/16	1470	G R			S-0631 E-0642
3. DETACHING 1	6/23	DJ		2940	G R			
4. GLUING CONVEYOR 2	6/23	EJ	DS	360	G R			
5. LOT NUMBERING	6/23		Jhena	700	G R			
6. SCREENING	6/23		JEX	720	G R	30		
7.								
8.								
9.								

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

KANEPACKAGE PHILIPPINES INC.		
Part Code	D028GY001	
Part Name	CARTON TN FCL X4	STAMP
Production Date	250623	
Lot Number	JO25-M-01987-133	
Quantity	10 pcs.	6/23
P.O.	N/A	
Mold No./Cavity	N/A	STAMP
Operator	QA-KP040	
Remarks	MP	

REMARKS:
PROD PLAN: ADD #0 PLAN 2025-174

360 - QA - 6/23

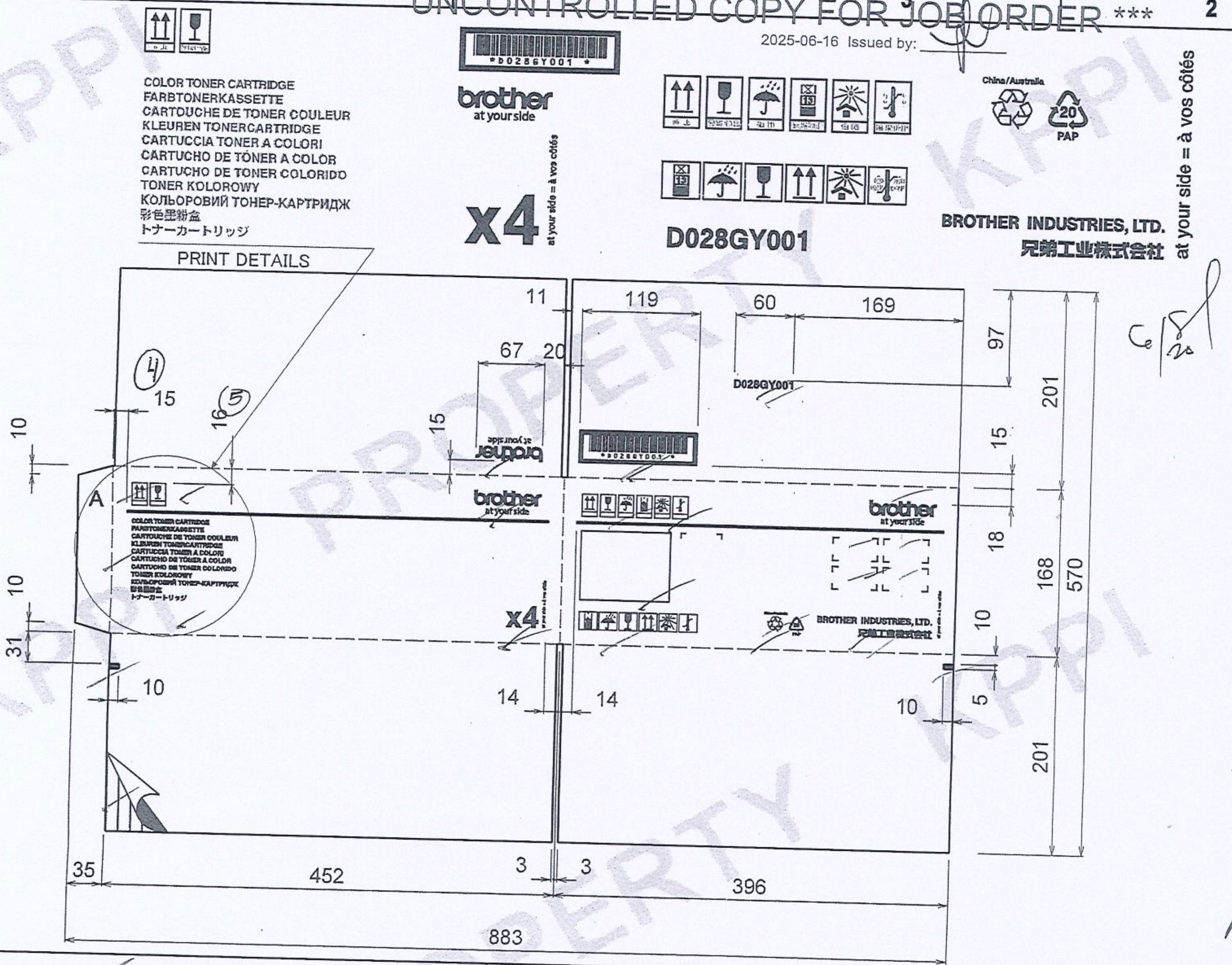
WHOUS

NAME: DATE: 6/23

*** ~~UNCONTROLLED COPY FOR JOB ORDER~~ ***

2025-06-16 Issued by:

01 (2) (3)



BOX SPECIFICATION		
Inner Dimension	447 X 393 X 159 mm	
Outer Dimension	455 X 401 X 175 mm	
Joint Flap	GLUING INSIDE (2 JOINTS)	
Illustration	SMOOTH SURFACE	
Bursting Strength	1090kPa (11.1 kgf/cm2) MIN	
BCT	2533N (258.3kgf) MIN	
ECT		
PRINT COLOR	1	2
Flexo	EQ-18 BRO. BLUE	
Digital Print		
Offset		
Varnish Coating		

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

RoHS

C6/8/25

NOTES:

1. CUTTING SHOULD BE WAVED (2-3P)

78

258

18

CUSTOMER: BROTHER

ITEM DESCRIPTION/PART CODE:

D028GY001
CARTON TN FCL X4
PART A

CUSTOMERS SUPPLIED REFERENCE NO:

ITEM KEY: BIP-0646-01AB-01

PAGE: 1–3

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

MATERIAL: C FLUTE
NPK210/CM125/NPK210

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	SCREENING	12		18	

PACKING INSTRUCTION:
10 PCS. / BUNDLE

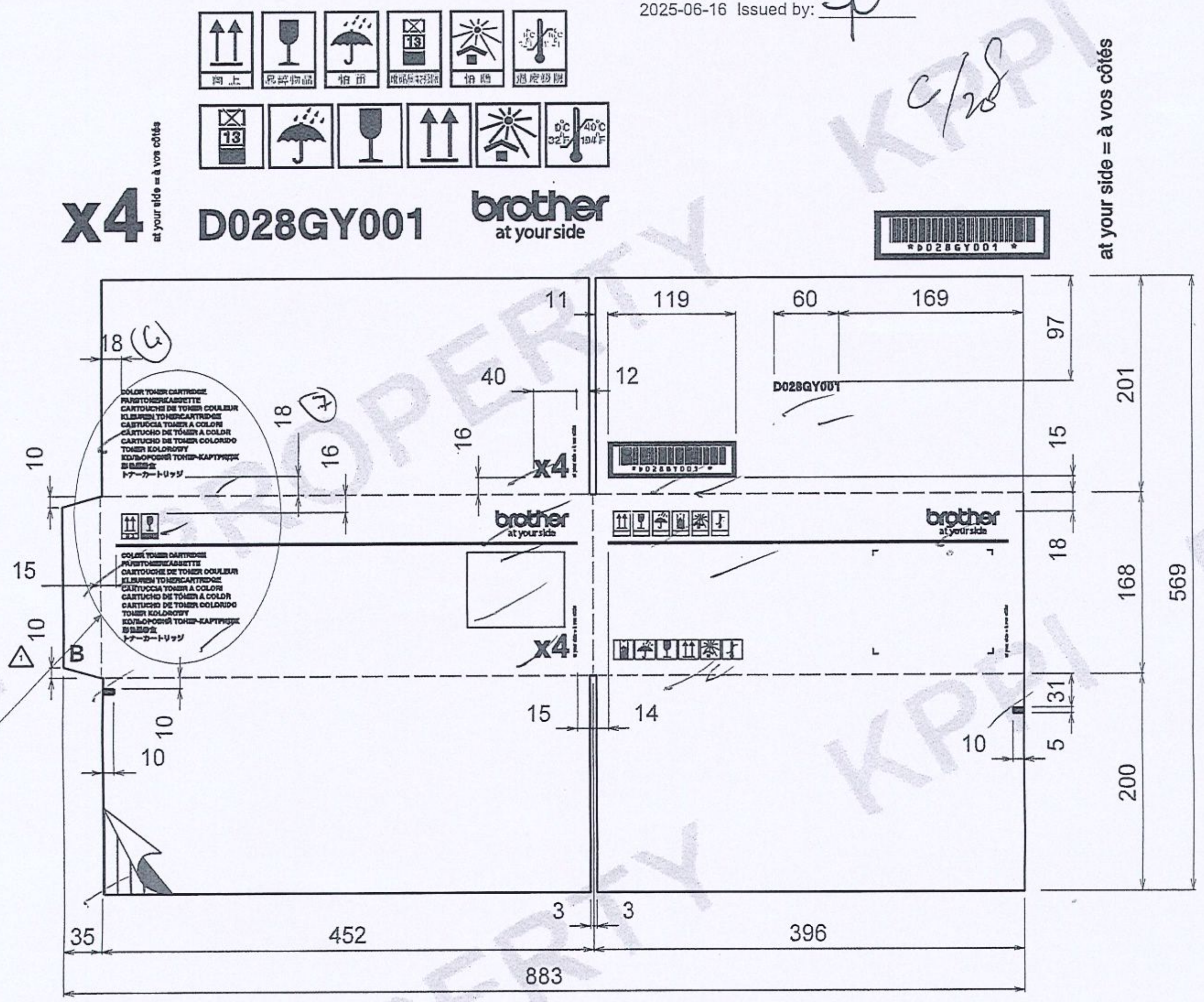
KANEPACKAGE PHILIPPINE INC.
#5 Ring Rd. LISP 2 Brgy. Lamesa Calamba, Laguna
Tel. Nos.:(049)545-7166 to 69
Fax Nos.:(049)545-7170/(049)545-6302

REV. #	DATE	REASON	REQUESTED BY:
1	250324	CHANGE POKAYOKE "B" POSITION FROM UPPER TO LOWER	K. IIJIMA

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

*** UNCONTROLLED COPY FOR JOB ORDER ***

2025-06-16 Issued by:



COLOR TONER CARTRIDGE
FARBTONERKASSETTE
CARTOUCHE DE TONER COULEUR
KLEUREN TONERCARTRIDGE
CARTUCCIA TONER A COLORI
CARTUCHO DE TÓNER A COLOR
CARTUCHO DE TONER COLORIDO
TONER KOLOROWY
КОЛЬОРОВИЙ ТОНЕР-КАРТРИДЖ
彩色墨粉盒
トナーカートリッジ

COLOR TONER CARTRIDGE
FARBTONERKASSETTE
CARTOUCHE DE TONER COULEUR
KLEUREN TONERCARTRIDGE
CARTUCCIA TONER A COLORI
CARTUCHO DE TÓNER A COLOR
CARTUCHO DE TONER COLORIDO
TONER KOLOROWY
КОЛЬОРОВИЙ ТОНЕР-КАРТРИДЖ
彩色墨粉盒
トナーカートリッジ

PRINT DETAILS

BOX SPECIFICATION

Inner Dimension	447 X 393 X 159 mm	
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Joint Flap	GLUING INSIDE (2 JOINTS)	
Illustration	SMOOTH SURFACE	
Bursting Strength	1090kPa (11.1 kgf/cm2) MIN	
BCT	2533N (258.3kgf) MIN	
ECT		
PRINT COLOR	1	2
Flexo	EQ-18 BRO. BLUE	
Digital Print		
Offset		
Varnish Coating		

BLADE REQUIREMENT

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

RoHS

NOTES:

1. CUTTING SHOULD BE WAVED (2-3P)

CUSTOMER :	BROTHER
ITEM DESCRIPTION/PART CODE:	CUSTOMERS SUPPLIED REFERENCE NO:
D028GY001 CARTON TN FCL X4 PART B	ITEM KEY : BIP-0646-01AB-01 / PAGE : 2–3

TOLERANCE

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

MATERIAL: C FLUTE
NPK210/CM125/NPK210

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-MANUAL	10		16	
5	LOT NUMBERING	11		17	
6	SCREENING	12		18	

PACKING INSTRUCTION:
10 PCS. / BUNDLE

REV. #	DATE	REASON	REQUESTED BY:
1	250324	CHANGE POKAYOKE "B" POSITION FROM UPPER TO LOWER	K. IIJIMA

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

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

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. **SQB-06-001622**

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	~~24~~ 250623 Shift: ☐ Day ☐ Night
		Delivery Date	250623
Location	BATANGAS	Job Order No.	JO25-M-01987-133
Item Code	D028GY001	Job Order Qty.	1,450
Item Description	CARTON TN FCL X4	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	205833
Drawing Revision No.	01	Gluing Process	☑ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800
External Provider	P.W		

II. Dimensional Inspection

Time Conducted Sample #1: 8:30 | Time Conducted Sample #2: 10:00 | Time Conducted Sample #3: 3:30

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	447	+/-3	447	448	447	16					
2	393		393	394	393	17					
3	159		159	160	159	18					
4	15	+/-5	15	16	16	19					
5	16		16	15	15	20	N				
6	18		19	18	16	21					
7	18		18	16	17	22					
8						23					
9						24					
10						25					
11						26					
12						27				A	
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: 24-1806S-150

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		+5
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 :			D
Linemark			
Fish-eye			
Stain :			
Excess Glue	1		1
Gluing Defect : GLUE STAIN	1		1
Worn-out			
Dent	1		1
Punctured	1		1
Tear-off			
Peel-off	25		25
Damages :			
Others : SCRATCH	1		1

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	AKITA	AKITA	✓	
STITCHED (Inside or Outside) N		A		Flute	CF	CF	✓	
				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	750	**Defect Rate Formula:** $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$
Total Qty Good	720	
Total Qty NG	30	
Defect Rate in %	4%	**PPM Formula:** $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 1{,}000{,}000$
Defect Rate in PPM	40,000 ppm	

VII. Sampling Inspection Result	
Total Sampling Qty Inspected	N / A
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.: AR2018-06-0[illegible]

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		