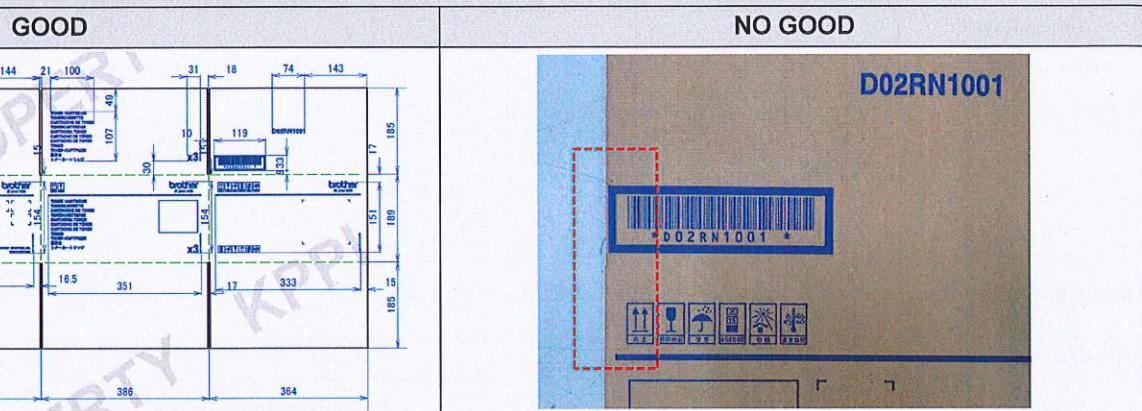


I. Item Information

Item Code	D02RN1001	Customer	BROTHER INDUSTRIES
Item Description	CARTON DEV UNIT ELLE X3	Delivery Date	250704
Inspection Date	250703	Inspection Time	12:30 AM
Lot Quantity	1,000 PCS	Job Order Number	JO25-M-02256-32
Affected Quantity	40 PCS	Origin	<input checked="" type="checkbox"/> IN-HOUSE <input type="checkbox"/> SUPPLIER:
Rejection Rate and PPM	4.00% 40,000 PPPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 5
Problem Description	MISALIGNED PRINT	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)



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

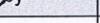
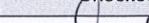
Related Doc. Info.		Control Number	Requirement:	NO MISALIGN PRINT
<input checked="" type="checkbox"/>	Procedure Manual :	PM-QA-018		
<input checked="" type="checkbox"/>	Technical Drawing :	BIP-0645-01AB	Actual:	WITH MISALIGNED PRINT
<input checked="" type="checkbox"/>	Work Instruction :	WI-QA-001-010		
<input checked="" type="checkbox"/>	Job Order :	JO25-M-02256-32		
<input checked="" type="checkbox"/>	Reports :	AR2025-07-013	Conclusion or Recommendation:	REJECT
<input checked="" type="checkbox"/>	Defect Limit :	BROTHER DEFECT LIMIT		<input checked="" type="checkbox"/> Applicable <input type="checkbox"/> Not Applicable

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

<input type="checkbox"/> Good	<input type="checkbox"/> Conditional (Please indicate details)	<input checked="" type="checkbox"/> Rejected	<input type="checkbox"/> Conditional (Please indicate details)		
<input type="checkbox"/> Rejected		<input type="checkbox"/> Backload	If item is for sorting, for backload, or for rework, fill-out below,		
<input type="checkbox"/> Backload		<input type="checkbox"/> Good	Person In Charge	Target Date	Signature
		<input type="checkbox"/> For Sorting			
		<input type="checkbox"/> 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
 K. MARAVILLA	 J. RELLORA		 M. CASILLANO	
QA Inspector	QA Line Leader	ME Head	QA Head	QA Staff
Important: Backlogging Policy (External Provider Rejects) Rejection rate that is more than 80% of the total quantity shall be approved by Top Management before backlogging.		Evaluation	Approved by	Final Disposition
		<input type="checkbox"/> <80% No Need <input type="checkbox"/> >80% Need		<input type="checkbox"/> Backload <input type="checkbox"/> Accept <input type="checkbox"/> Other _____
		Top Management		

*Note: All details must be filled out completely.
Submit this form to Line Leader immediately after accomplishment.*

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
<input type="checkbox"/> Pull-Out				
<input type="checkbox"/> 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: JULY 2025 PLAN

Labay, Menchie
SO #: SO25-M-02256

JOB ORDER

(1) 278

Customer: BROTHER INDUSTRIES (PHILS.), INC.

ITEM CODE: D02RN1001

Netsuite Itemcode: D02RN1001

JOB ORDER:

JO25-M-02256-32



Item Description: CARTON DEV UNIT ELLE X3

QTY: 1000

DELIVERY DATE:

2025-07-04

CREATED BY:

JECEL BALINGBING BUCE

DATE RELEASED:

2025-06-27

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
1160X1581 CF NPK180	500	10	N/A	AKTA 570	0206590	PCW

Tooling Ref# CYREL-G/ BLADE-E-2-CYREL-60B/ BLADE-43 Ctrl/Batch #: _____ RM Issued By: *un 7/2*

PROCESS / MACHINE	DATE	IN-CHARGE Operator	GOOD QTY	TRIAL RUN		REJECTED QTY INHOUSE	REMARKS
				G	R		
1. EQOS	07/02	JAMIN	516				
2. DIECUT ETERNA	07/03	BBE	510	2			
3. DETACHING 1	7/3	HC	1020	G	R		
4. GLUING SA 2600	7/3	HJ	1000	1	20		
5. LOT NUMBERING	07-03		1000	G	R		
6. SCREENING	07/03	FCN	960	G	R	40	
7.							
8.							
9.							

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

WITH OCCURRENCE OF POOR PRINT DURING RUNNING IN PREVIOUS
REMARKS DUE TO GLUE ATTACHED ON CYREL IMAGE. IN USED "TUNER".

PROD PLAN: ADD #0 PLAN 2025-185 - P.Renkomo 2025-02

PRODUCTION OUT

BY:

DATE:

KANEPACKAGE PHILIPPINES INC.

Part Code	D02RN1001	STAMP
Part Name	CARTON DEV UNIT ELLE (X3)	
Production Date	260703	
Lot Number	JO25-M-02256-32	
Quantity	10 pcs.	
P.O.	N/A	
Mold No./Cavity	N/A	
Operator	QA-KP892	
Remarks	MP	



KANE PACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT
(CORRUGATED AND MOULDED ITEMS)

Control No.

SQB-07-000278

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	25/07/03	Shift: <input type="checkbox"/> Day <input checked="" type="checkbox"/> Night
Delivery Date			25/07/03	
Job Order No.			JO25-M-02256-32	
Job Order Qty.			1,000	
Inspection Method		<input checked="" type="checkbox"/> 100% <input type="checkbox"/> Sampling		
Delivery Receipt No.			C20GJ96	
Gluing Process		<input type="checkbox"/> Manual Gluing <input checked="" type="checkbox"/> Semi-Auto Gluing		
			SD1800	

II. Dimensional Inspection

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	350	J+5	355	355	355	16					
2	350	J+5	355	355	355	17					
3	180	J-0	185	185	185	18					
4	10	J+5	10	10	10	19					
5	25	J+5	25	25	25	20					
6						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: 250 25-003 F00

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				C. CORRUGATED PALLET	In-house	External Provider	Total Quantity
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				D. MOULDED ITEMS	In-house	External Provider	Total Quantity
Smeared Print							
Other Print Defect: <u>misaligned</u>	90		90				
Linemark							
Fish-eye							
Stain : _____							
Excess Glue							
Gluing Defect : _____							
Worn-out							
Dent							
Punctured							
Tear-off							
Peel-off							
Damages : _____							
Others : _____							



KANE PACKAGE 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)	X inside X inside	/		Corrugated	X 180/180	X 180/180	/
STITCHED (Inside or Outside)	X		/	Flute	OF	OF	/
				Others	X		/

IV. Destructive Test (Based on Customer Requirement)

V. Barcode Print (If Only with Printed Barcode on Item)	
<input checked="" type="checkbox"/>	Good
<input type="checkbox"/>	No Good
<input checked="" type="checkbox"/>	Good
<input type="checkbox"/>	No Good
<input checked="" type="checkbox"/>	Good
<input type="checkbox"/>	No Good

Inspected 1988 Defects

VII. Sampling Inspection Result

VI. Inspection Result

VII. Sampling Inspection Result

VII. Sampling Inspection Result

Quantity Inspected

VI. Inspection Result	
Total Qty Inspected	1000
Total Qty Good	960
Total Qty NG	40
Defect Rate	in % 4.00% / 400 ppm
	in PPM
Defect Rate Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$	
PPM Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 1,000,000$	

VIII. Disposition

Good For Special Acceptance
 Backload Conditional (Please indicate details)
 For Sorting
 For Reward

Abnormality Report Control No.: ARND25-07-613

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
<i>K. Morawilla</i>	<i>J. M. Hsu</i>		<i>C. Lin</i>
QA Screening Inspector	QA Line Leader	QA Supervisor / QA Asst. Supervisor	QA Head

X. Reject & Reworks Item Verification

XI. Overall Inspection Time

Since 25
3
1,800⁰⁰
QA