



KANE PACKAGE PHILIPPINE INC.

ABNORMALITY REPORT

Control No.

AR2025-07-021

I. Item Information

Item Code	D037LJ001		Customer	BROTHER INDUSTRIES	
Item Description	CARTON DCP-J4250N JPN		Delivery Date	250707	
Inspection Date	250707		Inspection Time	7:00 AM	
Lot Quantity	1,505 PCS.		Job Order Number	JO-25-IPD-00814-2	
Affected Quantity	38 PCS.		Origin	<input checked="" type="checkbox"/> IN-HOUSE	<input type="checkbox"/> SUPPLIER:
Rejection Rate and PPM	2.52%	25,249 PPM	Date Received	N/A	
Sampling Quantity (IQA)	N/A		Detection (Section / Area)	SCREENING 3	
Problem Description	POOR PRINT		Delivery Receipt Number	N/A	

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO POOR PRINT	

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

Related Doc. Info.	Control Number	Requirement:		
<input checked="" type="checkbox"/> Procedure Manual :	PM-QA-018			
<input checked="" type="checkbox"/> Technical Drawing :	BIP-0869-01AB-01			
<input checked="" type="checkbox"/> Work Instruction :	WI-QA-001-010	Actual:	WITH POOR PRINT	
<input checked="" type="checkbox"/> Job Order :	JO-25-IPD-00814-2			
<input checked="" type="checkbox"/> Reports :	AR2025-07-021			
<input checked="" type="checkbox"/> Defect Limit :	BROTHER DEFECT LIMIT	Conclusion or Recommendation:	REJECT	<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

Remarks: SAME ISSUANCE WITH PREVIOUS OCCURRENCE.

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
E. PELAEZ QA Inspector	J. RELLORA 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
	<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.

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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

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.

E3-11

PR-001-F12-REV.00

MEMO: WITH VARNISH 1JOINT

Mary Grace Ubay
SO #: SO-25-IPD-00814

JOB ORDER

Customer: BROTHER INDUSTRIES (PHILS.), INC.

ITEM CODE: D037LJ001 VARNISH 1JOINT

NetSuite Itemcode: D037LJ001 VARNISH 1JOINT

JOB ORDER:

JO-25-IPD-00814-2



Item Description: CARTON DCP-J4250N JPN

QTY: 1500

DELIVERY DATE:

2025-07-07

CREATED BY:

Tuiza, Jecille Maduro

DATE RELEASED:

2025-07-05

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
753X1576 EBF NPK210	1500	20	N/A	1500	127398	5

Tooling Ref# -

H2A/B-100

Ctrl/Batch #:

RM Issued By:

CML 7/3

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN	REJECTED QTY		REMARKS
		Operator	ME/QA			INHOUSE	SUPPLIER	
1. EQOS	07/05	Jamm	Re 7/5	1520	G R			
2. DIECUT ST100	07/05	WMS domes	MIRE 0705	700	G R			
3. GLUING CONVEYOR 3	7/7	A.J. K	Med 9/7	500	1 15			
4. LOT NUMBERING	7/7		JW	1500	G R			
5. SCREENING	7/7		EPPER	1407	G R	98		
6.					G R	QA INPUT DATE 250707	TIME 4:17	QTY 1500
7.						QA OUTPUT DATE 250707		
8.						TIME 4:17	QTY 1402	
9.						TIME 4:17	REJECT QTY 98	

REJECTION/ ABNORMALITY HISTORY

Customer Claim: * DIMENSION OF PRINT APPROVED MADE PRO WITHIN THE TOL: ± 15
- DUE TO DIFFERENT DIMENSION OF PRINT EACH CHARACTERNotes: * WITH OCCURRENCE OF LIGHT SCORING DURING PRO.
ADJUSTMENT - RELAY BUT THE EJECTORS OF BLADE TO LBLCN
* LIGHT SCORING APPROVED BY QA PATROL

PRODUCTION QU

REMARKS

PROD PLAN: ADD #13 PLAN 2025-188

500- QA- JWL 7/7

NETSUITE

Part Code	D037LJ001
Part Name	CARTON DCP-J4250N JPN
Production Date	250707
Lot Number	JO-25-IPD-00814-2
Quantity	10 pcs.
P.O.	N/A
Mold No./Cavity	N/A
Operator	QA-CG2371
Remarks	IPD



KANE PACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT
(CORRUGATED AND MOULDED ITEMS)

Control No.

SQB-07-000461

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	202707	Shift: <input checked="" type="checkbox"/> Day <input type="checkbox"/> Night
Delivery Date			250707	
Location	BATANGAS	Job Order No.	JO-25-IPD-00814-2	
Item Code	D037LJ001 VARNISH 1 JOINT	Job Order Qty.	1,500	
Item Description	CARTON DCP-J4250N JPN	Inspection Method	<input checked="" type="checkbox"/> 100% <input type="checkbox"/> Sampling	
Model	N/A	Delivery Receipt No.	20270708	
Drawing Revision No.	01	Gluing Process	<input checked="" type="checkbox"/> Manual Gluing <input type="checkbox"/> Semi-Auto Gluing	
External Provider	TS		<input type="checkbox"/> SD1800	

II. Dimensional Inspection

Time Conducted Sample #1: 6:30				Time Conducted Sample #2: 10:00			Time Conducted Sample #3: 1:40				
Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	498		499	498	498	16					
2	747		743	742	744	17					
3	446	+ -	445	444	446	18					
4	25.71	5	26	25	25	19					
5	44.05		44	45	44	20					
6	17		17	17	17	21					
7	15.04		15	15	15	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:
 Thickness Gauge Weighing Scale Steel Ruler Caliper 25-231227-0101

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)	N			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	6		6	Others	N/A	N/A	N/A
Delamination				C. CORRUGATED PALLET		External Provider	Total Quantity
Uneven Kraft liner							
Warpage				Color of Carton (Discoloration)	N/A	N/A	N/A
Cracking on edge	N			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: misalignment	1		1	Damages: _____	N/A	N/A	N/A
Missing Print/ Character				Others: _____	N/A	N/A	N/A
Blotted Print				D. MOULDED ITEMS		External Provider	Total Quantity
Smeared Print							
Other Print Defect: poor print	38		38	Poor Fusion	N/A	N/A	N/A
Linemark	2		2	Chip Off	N/A	N/A	N/A
Fish-eye	3		3	Warp / Deform	N/A	N/A	N/A
Stain: bird stain	1		1	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	5		5	Foreign Materials	N/A	N/A	N/A
Dent	5		5	Wet / Moist	N/A	N/A	N/A
Punctured	7		7	Dirt	N/A	N/A	N/A
Tear-off	6		6	Stain: _____	N/A	N/A	N/A
Peel-off	9		9	Discoloration	N/A	N/A	N/A
Damages: _____				Excess Flashes	N/A	N/A	N/A
Others: poor varnish b	5		5	Others: _____	N/A	N/A	N/A



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)	INSIDE	INSIDE	X	Corrugated	NPIC210	NPIC210	
STITCHED (Inside or Outside)	M		X	Flute	PE	PE	
				Others	u	2	

IV. Destructive Test (Based on Customer Requirement)

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

VI. Inspection Result

VII. Sampling Inspection Result					
Total Qty Inspected	1,503	Defect Rate Formula: Total Quantity NG Total Qty. Inspected x100	Total Sampling Qty Inspected		
Total Qty Good	1402		Total Sampling Qty Good		
Total Qty NG	98		Total Sampling Qty NG	9	
Defect Rate in % in PPM	0.59% (or) 116 PPM	PPM Formula: Total Quantity NG Total Qty. Inspected x 1,000,000	Defect Rate in % in PPM		

VIII. Disposition

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

VII. Sampling Inspection Result

VII. Sampling Inspection Result	
Total Sampling Qty Inspected	.
Total Sampling Qty Good	
Total Sampling Qty NG	9
Defect Rate in %	✓
in PPM	✓

Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
E. PEREZ	J. Villan		J. M. H.

X. Reject & Reworks Item Verification

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

XI. Overall Inspection Time

CORRUGATED AND MOULDED ITEMS