



KANE PACKAGE PHILIPPINE INC.

ABNORMALITY REPORT

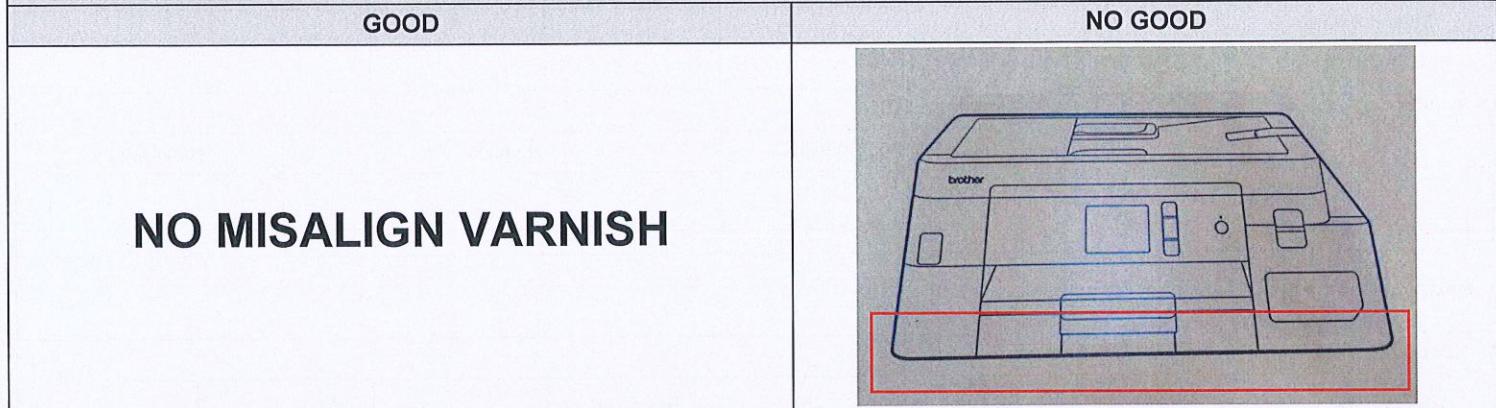
Control No.

AR2025-07-040

I. Item Information

Item Code	D037LJ001		Customer	BROTHER INDUSTRIES	
Item Description	CARTON DCP-J4250N JPN		Delivery Date	250710	
Inspection Date	250710		Inspection Time	7:00 AM	
Lot Quantity	2,166 PCS		Job Order Number	JO-25-IPD-00814-3	
Affected Quantity	89 PCS		Origin	<input checked="" type="checkbox"/> IN-HOUSE	<input type="checkbox"/> SUPPLIER:
Rejection Rate and PPM	4.10%	41,089 PPM	Date Received	N/A	
Sampling Quantity (IQA)	N/A		Detection (Section / Area)	SCREENING 3	
Problem Description	MISALIGNED VARNISH		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 VARNISH		
<input checked="" type="checkbox"/> Procedure Manual :	PM-QA-018				
<input checked="" type="checkbox"/> Technical Drawing :	BIP-0869-01AB-01	Actual:	WITH MISALIGNED VARNISH		
<input checked="" type="checkbox"/> Work Instruction :	WI-QA-001-010				
<input checked="" type="checkbox"/> Job Order :	JO-25-IPD-00814-3	Conclusion or Recommendation:	REJECT		
<input checked="" type="checkbox"/> Reports :	AR2025-07-040				<input checked="" type="checkbox"/> Applicable
<input checked="" type="checkbox"/> Defect Limit :	BROTHER DEFECT LIMIT				<input type="checkbox"/> Not Applicable

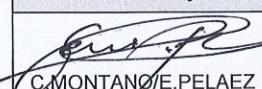
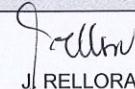
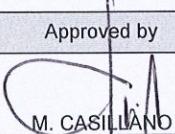
IV. Initial Disposition (To be filled out by ME Department If Needed)

<input type="checkbox"/> Good	<input type="checkbox"/> Conditional (Please indicate details)	<input 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
		<input type="checkbox"/> For Sorting	Target Date
		<input type="checkbox"/> For Rework	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
 C. MONTANO/E. PELAEZ	 J. RELLORA		 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.

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

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				

XI. Reworking 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.



Kanepackage Philippine Inc.

JOB ORDER

749

PR-001-F12-REV.00

MEMO: WITH VARNISH 1JOINT

Mary Grace Ubay

SO #: SO-25-IPD-00814



Customer : BROTHER INDUSTRIES (PHILS.), INC.

ITEM CODE: D037LJ001 VARNISH 1JOINT

Netsuite Itemcode : D037LJ001 VARNISH 1JOINT

JOB ORDER:
JO-25-IPD-00814-3

Item Description : CARTON DCP-J4250N JPN

QTY: 2200

DELIVERY DATE:

2025-07-10

CREATED BY:

Mendonez, Jhee Ann Manalo

DATE RELEASED:

2025-07-05

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
753X1576 EBF NPK210	2200	20	N/A	2220	251585	T. P. C

Tooling Ref# - A-2-183

Ctrl/Batch #:

RM Issued By:

2-9-24

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN	REJECTED QTY		REMARKS
		Operator	ME/QA			INHOUSE	SUPPLIER	
1. EQOS	7/9	MMJC	ME 7/9	2210	6 10 G R			
2. DIECUT S1700	7/9	DR	JOMIS 07/09	2200	1 10 G R			
3. GLUING CONVEYOR 3	7/9	EU	ME 7/9 07/09	500+910 200 RTG	1 34 G R			
4. LOT NUMBERING	7/9 7/10		Jb Diane	1200 500+300	G R			
5. SCREENING	7-9		CEZAK	10918 100	G R	118	PRODUCTION	
6.	7-10		EFFREN	1,025	G R	139	BY: DATE: 7-10-24 ARLENE PALLERMO Job Controller NET/WHITE HV	
7.								
8.								
9.								

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

Part Part Code	D037LJ001	QR Code
Part Part Name	CARTON DCP-J4250N JPN	
Prod Production Date	260710	STAMP
Lot Lot Number	JO-25-IPD-00814-3	7/10
Qty Quantity	10 pcs.	
P.C.P.O.	N/A	
Mol Mold No./Cavity	N/A	STAMP
Opt Operator	QA-CG2371	
Ren Remarks	IPD	

REMARKS

PROD PLAN: ADD #3 PLAN 2025-191

500 to QA- Sha 7/9
 910 to QA- Sha 7/9
 20 to QA- Arlene 7/10



KANE PACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT
(CORRUGATED AND MOULDED ITEMS)

Control No.

SQB-07-000749

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.			Inspection Date	20/07/09	Shift: <input type="checkbox"/> Day <input checked="" type="checkbox"/> Night
Location	BATANGAS			Delivery Date	25/07/10	
Item Code	D037LJ001 VARNISH 1JOINT			Job Order No.	JO-25-IPD-00814-3	
Item Description	CARTON DCP-J4250N JPN			Job Order Qty.	2,200	
Model	N/A			Inspection Method	<input checked="" type="checkbox"/> 100% <input type="checkbox"/> Sampling	
Drawing Revision No.	01			Delivery Receipt No.	20/07/09	
External Provider	TPC			Gluing Process	<input type="checkbox"/> Manual Gluing <input type="checkbox"/> Semi-Auto Gluing <input type="checkbox"/> SD1800	

II. Dimensional Inspection

Time Conducted Sample #1: 10:30				Time Conducted Sample #2: 20:00			Time Conducted Sample #3: 21:30				
Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	198		198	197	198	16					
2	212		214	213	212	17					
3	144	±5	147	147	148	18					
4	15.77		15.77	15.77	15.77	19					
5	15.04		15.04	15.04	15.04	20					
6	13		13	13	13	21					
7						22					
8						23					
9						24					
10						25					
11						26					
12						27					
13						28					
14						29					
15						30					

Measuring Tool Used:	<input checked="" type="checkbox"/> Meter Tape	<input type="checkbox"/> Moisture Content Tester	<input type="checkbox"/> Zahn Cup	<input type="checkbox"/> Stopwatch	Control Number of Measuring Tool Used:
	<input type="checkbox"/> Thickness Gauge	<input type="checkbox"/> Weighing Scale	<input type="checkbox"/> Steel Ruler	<input type="checkbox"/> Caliper	25-2308T-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	22	22	22	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	1		1	C. CORRUGATED PALLET		In-house	External Provider	Total Quantity
Uneven Kraft liner								
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 / Inverted print	1		1	Rusty Wire	N/A	N/A	N/A	
Close Gap/ Wide Gap				Wrong Orientation	N/A	N/A	N/A	
Print Color: POOR print	14		16	Damages: _____	N/A	N/A	N/A	
Missing Print/ Character				Others : _____	N/A	N/A	N/A	
Blotted Print				D. MOULDED ITEMS		In-house	External Provider	Total Quantity
Smeared Print								
Other Print Defect: Broken Text	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 : _____	5		5	Crack	N/A	N/A	N/A	
Excess Glue				Broken	N/A	N/A	N/A	
Gluing Defect: JDOT	3		3	Scratches	N/A	N/A	N/A	
Worn-out	5		5	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				Stain : _____	N/A	N/A	N/A	
Peel-off	2		2	Discoloration	N/A	N/A	N/A	
Damages : _____	4		4	Excess Flashes	N/A	N/A	N/A	
Others: Misaligned VARNISH	46		44	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)	✓	IDE	✓	Corrugated	UPK 210	UPK 210	✓
STITCHED (Inside or Outside)	✓	✓	✓	Flute	EBF	GBF	✓

IV. Destructive Test (Based on Customer Requirement)

Requirement	VI. Inspection Result (Based on Customer Requirement)				V. Barcode Print (If Only with Printed Barcode on Item)			
	Actual	Good	No Good	Scan 1	Scan 2	Good	No Good	
	✓	✓		✓	✓	✓	✓	
BQICS Compliance (For Epson items only)							Good	No Good

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

VI. Inspection Result		Compliance (For Epson Items Only)	Good	No Good
Total Qty Inspected	918	Defect Rate Formula:	Total Sampling Qty Inspected	VII. Sampling Inspection Result
Total Qty Good	820	Total Quantity NG Total Qty. Inspected x100	Total Sampling Qty Good	/
Total Qty NG	118		Total Sampling Qty NG	/
Defect Rate in %	12.45%	PPM Formula:	—	R

VI. Inspection Result

Total Qty Inspected	918	Defect Rate Formula: Total Quantity NG Total Qty. Inspected x 100	VII. Sampling Inspection Result
Total Qty Good	820		
Total Qty NG	118		
Defect Rate in %	12.578 / 12.578 %	PPM Formula:	

VII. Sampling Inspection Result

Defect Rate in PPM	12.50 / 128,540 ppm	PPM Formula: Total Quantity NG Total Qty. Inspected x 1,000,000	Defect Rate in % in PPM
VIII. Disposition			IX. Remarks

VIII. Disposition

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

IX. Remarks

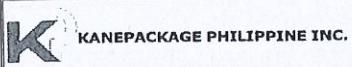
<input type="checkbox"/> For Rework	Abnormality Report Control No.: <u>PR2025-09-039</u> <u>D40</u> <u>01</u> <u>D42</u>		
Inspected by <i>C. montano</i>	Checked by <i>rellin</i>	Approved by (If there are major concerns)	Verified by (If there are major concerns)
QA Screening Inspector	QA Line Leader	QA Supervisor / QA Asst. Supervisor	QA Head

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



SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No.

SQA-07-000749

I. Item Information

Customer	BROTHER INDUSTRIES (PHLIS.), INC.	Inspection Date	20210	Shift: <input checked="" type="checkbox"/> Day <input type="checkbox"/> Night
Location	Laguna	Delivery Date	250710	
Item Code	D037LJ001 VARNISH 1JOINT	Job Order No.	JO-25-IPD-00814-3	
Item Description	CARTON DCP-J4250N JPN	Job Order Qty.	2,200	
Model	N/A	Inspection Method	<input checked="" type="checkbox"/> 100% <input type="checkbox"/> Sampling	
Drawing Revision No.	01	Delivery Receipt No.	251525	
External Provider	T-P-C	Gluing Process	<input checked="" type="checkbox"/> Manual Gluing <input type="checkbox"/> Semi-Auto Gluing <input type="checkbox"/> SD1800	

II. Dimensional Inspection

Time Conducted Sample #1: 6:30				Time Conducted Sample #2: 9:00				Time Conducted Sample #3: 11:40			
Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	498	1	499	499	498	16					
2	243	1	243	243	244	17					
3	446	+/-	446	446	445	18					
4	15.22	5	15	15	15	19					
5	15.04	1	15	15	15	20					
6	13	1	14	13	13	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: 25-22122-09
 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
				Condition of Wood			
Scoring	45		45	Rusty Nail	N/A	N/A	N/A
Grain Direction				Warping	N/A	N/A	N/A
Paper Shade (Off Color)				Fumigation Stamp	N/A	N/A	N/A
Bubbles				Crack / Damages	N/A	N/A	N/A
Blister	11			Others	N/A	N/A	N/A
Wrinkle				C. CORRUGATED PALLET			
Delamination				Color of Carton (Discoloration)	N/A	N/A	N/A
Uneven Kraft liner				Flute of Material	N/A	N/A	N/A
Warpage				Type of Adhesion	N/A	N/A	N/A
Cracking on edge				Adhesion of Runner	N/A	N/A	N/A
Bursting / Bursting on Edge (Crowfeet)				Rusty Wire	N/A	N/A	N/A
Wrong die-cut orientation				Wrong Orientation	N/A	N/A	N/A
Inverted die-cut				Damages: _____	N/A	N/A	N/A
Close Gap/Wide Gap				Others: _____	N/A	N/A	N/A
Print Color: poor print	0	0	0	D. MOULDED ITEMS			
Missing Print/Character				Poor Fusion	N/A	N/A	N/A
Blotted Print	12	12	12	Chip Off	N/A	N/A	N/A
Smeared Print				Warp / Deform	N/A	N/A	N/A
Other Print Defect: miss align print	27	27	27	Crack	N/A	N/A	N/A
Linemark				Broken	N/A	N/A	N/A
Fish-eye				Scratches	N/A	N/A	N/A
Stain: color stain	2	2	2	Foreign Materials	N/A	N/A	N/A
Excess Glue	5	5	5	Wet / Moist	N/A	N/A	N/A
Gluing Defect: _____				Dirt	N/A	N/A	N/A
Worn-out				Stain: _____	N/A	N/A	N/A
Dent	5	20	25	Discoloration	N/A	N/A	N/A
Punctured	4	0	0	Excess Flashes	N/A	N/A	N/A
Tear-off				Others: _____	N/A	N/A	N/A
Peel-off	2	2	2				
Damages: _____							
Others: miss align varnish	40	40	40				

173



KANEPACKAGE PHILIPPINE INC.

**SCREENING INSPECTION REPORT
(CORRUGATED AND MOULDED ITEMS)**