



ABNORMALITY REPORT

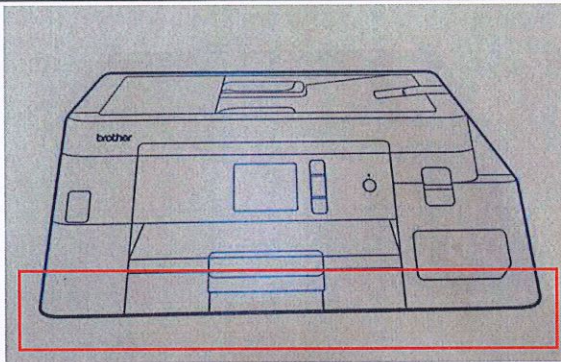
Control No.

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)

GOOD	NO GOOD
NO MISALIGN VARNISH	

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	Actual:	WITH MISALIGNED VARNISH
<input checked="" type="checkbox"/> Technical Drawing :	BIP-0869-01AB-01		
<input checked="" type="checkbox"/> Work Instruction :	WI-QA-001-010	Conclusion or Recommendation:	REJECT <input checked="" type="checkbox"/> Applicable <input type="checkbox"/> Not Applicable
<input checked="" type="checkbox"/> Job Order :	JO-25-IPD-00814-3		
<input checked="" type="checkbox"/> Reports :	AR2025-07-040		
<input checked="" type="checkbox"/> Defect Limit :	BROTHER DEFECT LIMIT		

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

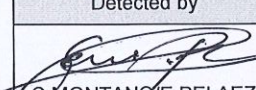
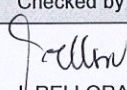
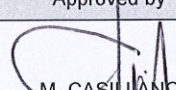
<input type="checkbox"/> Good	<input type="checkbox"/> Conditional (Please indicate details)	<input type="checkbox"/> Rejected	<input type="checkbox"/> Conditional (Please indicate details)
<input type="checkbox"/> Rejected		<input type="checkbox"/> Backload	If item is for sorting, for backload, or for rework, fill-out below,
<input type="checkbox"/> Backload		<input type="checkbox"/> Good	Person In Charge 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
 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.		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	



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
<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.

JOB ORDER

MEMO: WITH VARNISH 1JOINT

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

PR-001-F12-REV.00

Customer : BROTHER INDUSTRIES (PHILS.), INC.

ITEM CODE: **D037LJ001 VARNISH 1JOINT**

Netsuite Itemcode : D037LJ001 VARNISH 1JOINT

JOB ORDER:

JOMON4454
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
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Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
753X1576 EBF NPK210	2200	20	N/A	2200	251585	T. P. C

Tooling Ref# - **H-2-183**

Ctrl/Batch #:

RM Issued By:

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN		REJECTED QTY		REMARKS
		Operator	ME/QA		G	R	INHOUSE	SUPPLIER	
1. EQOS	7/9	MMJC	he 7/9	2210	6	10			
2. DIECUT S1700	7/9	OR	JOMI	2200	1	10			
3. GLUING CONVEYOR 3	7/9	EU	mfu 200909	500+910 200 RRP	1	34			
4. LOT-NUMBERING	7/9 7/10		Jb Diane	1200 500+500					
5. SCREENING	7-9		CEZAR	918 800			118		PRODUCTION
6.	7-10		EPREN	1,075			179		BY: ARLENE PALLERMO Job Controller NETSUITE
7.									
8.									
9.									

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

REMARKS

PROD PLAN: ADD #3 PLAN 2025-191

500 to QA - sha 7/9
910 to QA - sha 7/9
200 to QA - sha 7/10

KANEPACKAGE PHILIPPINES INC.

Part Part Code	D037LJ001
Part Part Name	CARTON DCP-J4250N JPN
Prod Production Date	250710
Lot Lot Number	JO-25-IPD-00814-3
Que Quantity	10 pcs.
P.C.P.O.	N/A
Mol Mold No./Cavity	N/A
Opt Operator	QA-CG2371
Ren Remarks	IPD



STAMP

STAMP



KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT
(CORRUGATED AND MOULDED ITEMS)

Control No.

SQB-07-000749

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	20709	Shift:	<input type="checkbox"/> Day <input checked="" type="checkbox"/> Night
Location	BATANGAS	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.	251575		
External Provider	T.P.C	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: 2:00			Time Conducted Sample #3: 5:30					
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	243		244	243	244	17					
3	146		147	147	147	18					
4	15.77	± 5	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: ☒ Meter Tape ☐ Moisture Content Tester ☐ Zahn Cup ☐ Stopwatch ☐ Thickness Gauge ☐ Weighing Scale ☐ Steel Ruler ☐ Caliper Control Number of Measuring Tool Used: 25-23085-012

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				Color of Carton (Discoloration)	N/A	N/A	N/A
Warpage				Flute of Material	N/A	N/A	N/A
Cracking on edge				Type of Adhesion	N/A	N/A	N/A
Bursting / Bursting on Edge (Crowfeet)				Adhesion of Runner	N/A	N/A	N/A
Wrong die-cut orientation				Rusty Wire	N/A	N/A	N/A
Inverted die-cut / Inverted print	1		1	Wrong Orientation	N/A	N/A	N/A
Close Gap/ Wide Gap				Damages:	N/A	N/A	N/A
Print Color: POOR print	14		14	Others:	N/A	N/A	N/A
Missing Print/ Character				D. MOULDED ITEMS	In-house	External Provider	Total Quantity
Blotted Print				Poor Fusion	N/A	N/A	N/A
Smeared Print				Chip Off	N/A	N/A	N/A
Other Print Defect: Broken Text	2		2	Warp / Deform	N/A	N/A	N/A
Linemark				Crack	N/A	N/A	N/A
Fish-eye				Broken	N/A	N/A	N/A
Stain:	5		5	Scratches	N/A	N/A	N/A
Excess Glue				Foreign Materials	N/A	N/A	N/A
Gluing Defect: JPO	3		3	Wet / Moist	N/A	N/A	N/A
Worn-out	5		5	Dirt	N/A	N/A	N/A
Dent		10	10	Stain:	N/A	N/A	N/A
Punctured				Discoloration	N/A	N/A	N/A
Tear-off	2		2	Excess Flashes	N/A	N/A	N/A
Damages:	4		4	Others:	N/A	N/A	N/A
Others: Misaligned VARNISH		46	46				



SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Joint Flap		Judgement		Type of Material			
Requirement	Actual	Good	No Good	Requirement	Actual	Good	No Good
GLUED (Inside or Outside)	125 IDE	✓		Corrugated	NPK 210	✓	
STITCHED (Inside or Outside)	2 / A			Flute	EBF	✓	
				Others	2	✓	
IV. Destructive Test (Based on Customer Requirement)				V. Barcode Print (If Only with Printed Barcode on Item)			
Requirement	Actual	Good	No Good	Scan 1	2 / A	<input type="checkbox"/> Good	<input type="checkbox"/> No Good
				Scan 2		<input type="checkbox"/> Good	<input type="checkbox"/> No Good
				BQICS Compliance (For Epson items only)			
				<input type="checkbox"/> Good <input type="checkbox"/> No Good			
VI. Inspection Result				VII. Sampling Inspection Result			
Total Qty Inspected	918	Defect Rate Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$		Total Sampling Qty Inspected	2 / A		
Total Qty Good	820						
Total Qty NG	118						
Defect Rate in % in PPM	12.85% / 128,540 ppm	PPM Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 1,000,000$		Defect Rate in % in PPM			
VIII. Disposition				IX. Remarks			
<input checked="" type="checkbox"/> Good <input type="checkbox"/> For Special Acceptance <input type="checkbox"/> Backload <input type="checkbox"/> Conditional (Please indicate details) <input type="checkbox"/> For Sorting <input type="checkbox"/> For Rework							
Abnormality Report Control No.: AR2015-07-039				040/041/042			
Inspected by	Checked by	Approved by (If there are major concerns)		Verified by (If there are major concerns)			
C. MONTANO	J. Kellin						
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					
Total							
				R&R Staff			
				Received by (Signature over Printed Name)			
				QA Inspector			

[illegible]

	SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)	Control No. SQA-07-000749									
	I. Item Information										
Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date: 250910 Shift: <input checked="" type="checkbox"/> Day <input type="checkbox"/> Night Delivery Date: 250710 Job Order No.: JO-25-IPD-00814-3 Job Order Qty.: 2,200 Inspection Method: <input checked="" type="checkbox"/> 100% <input type="checkbox"/> Sampling Delivery Receipt No.: 251525 Gluing Process: <input checked="" type="checkbox"/> Manual Gluing <input type="checkbox"/> Semi-Auto Gluing <input type="checkbox"/> SD1800									
Location	Laguna										
Item Code	D037LJ001 VARNISH 1JOINT										
Item Description	CARTON DCP-J4250N JPN										
Model	N/A										
Drawing Revision No.	01										
External Provider	T.P.C										
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		499	499	498	16					
2	243		243	243	244	17					
3	446		446	446	448	18					
4	10.38		15	15	15	19					
5	10.04		15	15	15	20					
6	10		14	15	15	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 <input type="checkbox"/> Thickness Gauge <input type="checkbox"/> Weighing Scale <input type="checkbox"/> Steel Ruler <input type="checkbox"/> Caliper			Control Number of Measuring Tool Used: 25-22128-019								
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			45		45	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			11			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						Color of Carton (Discoloration)			N/A	N/A	N/A
Warpage						Flute of Material			N/A	N/A	N/A
Cracking on edge						Type of Adhesion			N/A	N/A	N/A
Bursting / Bursting on Edge (Crowfeet)						Adhesion of Runner			N/A	N/A	N/A
Wrong die-cut orientation						Rusty Wire			N/A	N/A	N/A
Inverted die-cut						Wrong Orientation			N/A	N/A	N/A
Close Gap/ Wide Gap						Damages:			N/A	N/A	N/A
Print Color: poor print			6		6	Others:			N/A	N/A	N/A
Missing Print/ Character						D. MOULDED ITEMS			In-house	External Provider	Total Quantity
Blotted Print			12		12	Poor Fusion			N/A	N/A	N/A
Smearred Print						Chip Off			N/A	N/A	N/A
Other Print Defect: misalign print			27		27	Warp / Deform			N/A	N/A	N/A
Linemark						Crack			N/A	N/A	N/A
Fish-eye						Broken			N/A	N/A	N/A
Stain: glue stain			2		2	Scratches			N/A	N/A	N/A
Excess Glue			5		5	Foreign Materials			N/A	N/A	N/A
Gluing Defect:						Wet / Moist			N/A	N/A	N/A
Worn-out						Dirt			N/A	N/A	N/A
Dent			5	20	25	Stain:			N/A	N/A	N/A
Punctured			6	6	6	Discoloration			N/A	N/A	N/A
Tear-off						Excess Flashes			N/A	N/A	N/A
Peel-off			2		2	Others:			N/A	N/A	N/A
Damages:											
Others: mis align Varnish			40		40						

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