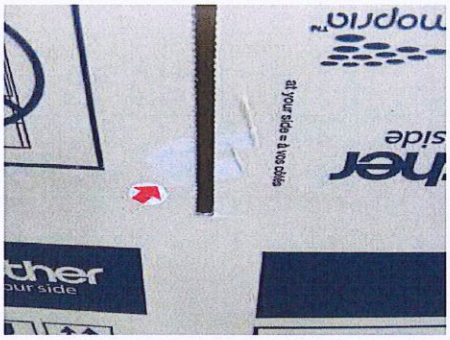
KANEPACKAGE PHILIPPINE INC.	ABNORMALITY REPORT	Control No. AR2025-08-025

I. Item Information

Item Code	D037M5001	Customer	BROTHER
Item Description	CARTON	Delivery Date	250812
Inspection Date	250811	Inspection Time	11AM
Lot Quantity	600 PCS	Job Order Number	JO25-M-02513-12A
Affected Quantity	27 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	4.50% 45,000 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
☑ Technical Drawing :	BIP-0816-01
☑ Work Instruction :	WI-QA-001-010
☑ Job Order :	JO25-M-02513-12A
☑ Reports :	AR2025-08-025
☑ Defect Limit :	BIPH DEFECT LIMIT

Requirement:	PEEL OFF NOT ACCEPTABLE	
Actual:	WITH PEEL OFF UP TO 15MM	
Conclusion or Recommendation:	REJECT	☑ Applicable ☐ Not Applicable

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. ABOC	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.

⑥ Annual 08-025

822

Kanepackage Philippine Inc.

PR-001-F12-REV.00

MEMO: - None -

JOB ORDER

Manaig Rea, Villanueva
SO # : SO25-M-02513

Customer : BROTHER INDUSTRIES (PHILS.), INC.

ITEM CODE: **D037M5001.C1**

Netsuite Itemcode : D037M5001.C1

JOB ORDER: JO25-M-02513-12A

Item Description : CARTON DCP-J131DW EU-C; A

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
600	2025-08-12	Pallermo, Arlene Gonzales	2025-08-05

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
712X1424 CF NPK280	600		N/A	600	208572	PW

E-4-25-323

Alita

Tooling Ref# - B-S8B R2-P120

Ctrl/Batch #:

RM Issued By: Elmer 8/8

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. EQOS	8/8	PENN	8/8	600	2 G R			
2. DIECUT S1700	8/9	IWJC	(1) cuen 8/9	600	G R			
3. GLUING LAMINATION	8/09	CARS		450 + 150 = 600	G R			
4. GLUING CONVEYOR 3	8/11	~~ERFEL~~ JEFFICK		600	G R			
5. SCREENING	8/11		JOMS	548	G R	48	4	P
6. TRANSFER TO BOX STICKER					G R			
7.								
8.								
9.								

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

REMARKS

PROD PLAN: ADD #0 PLAN 2025-224

WHOUSE OUT

NAME: Gp DATE: 8/8

*** UNCONTROLLED COPY FOR JOB ORDER ***

2025-08-05 ~~Issued by~~

GOOD AND NG REFERENCE OF USING GUIDEMARK FOR STICKER

GOOD

GOOD

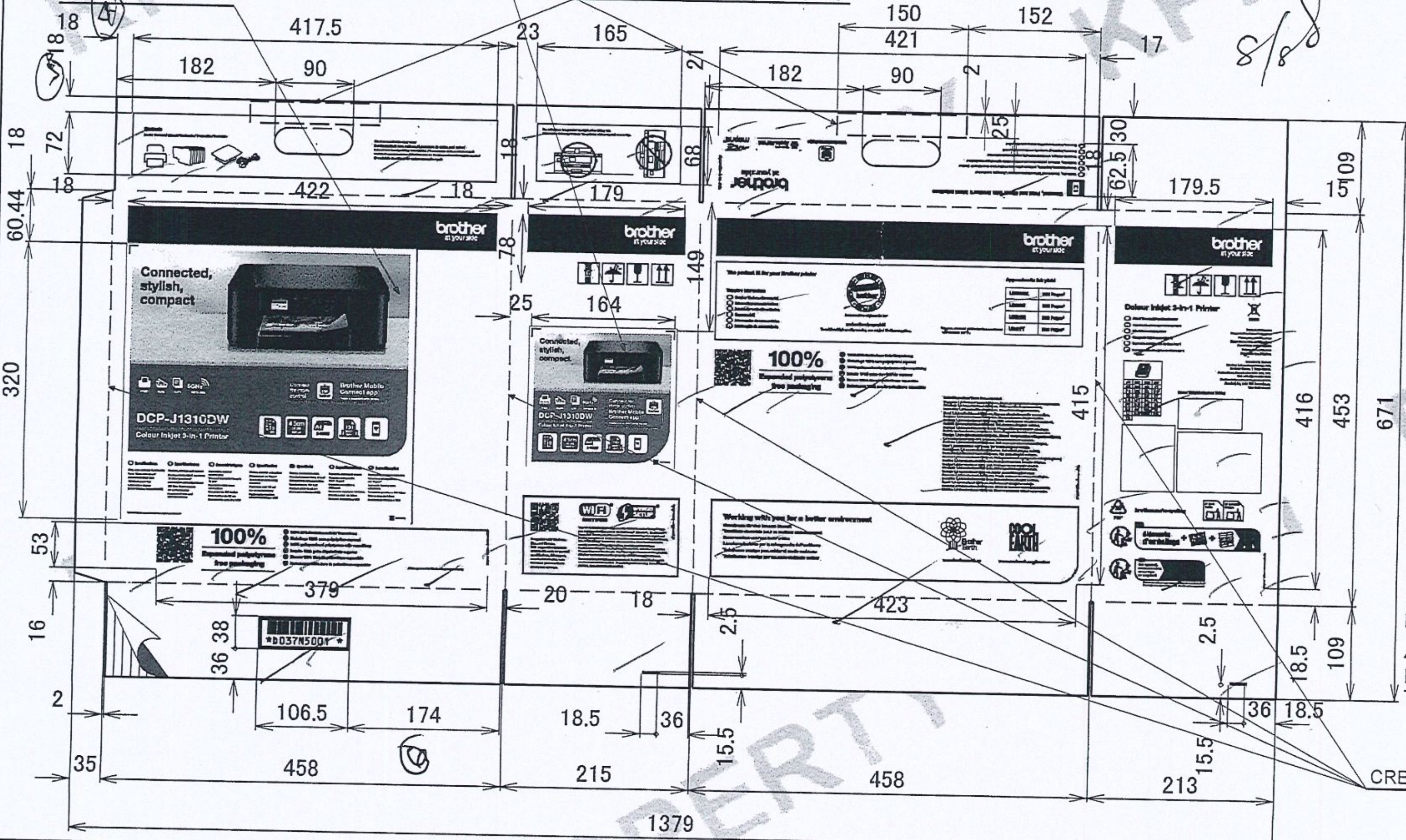
NOT GOOD (REJECT)

THIS REVERSE IS STICK CORRUGATED FIBERBOARD (EBF)

ATTACHED LABEL D037M7001

ATTACHED LABEL D037M8001

8/8



BOX SPECIFICATION		
Inner Dimension	453 X 210 X 445	
Outer Dimension	461 X 218 X 461	
Joint Flap	GLUING INSIDE	
Illustration	SMOOTH SURFACE	
Bursting Strength	1274 kPa (13 kgf/cm2)	
BCT	3162 N (322.65kgf)	
ECT	N/A	
PRINT COLOR	1	2
Flexo	EQ-01 BLACK	N/A
Digital Print	N/A	
Offset	N/A	
Varnish Coating	N/A	

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

RoHS

NOTES:

1. BLADE SHOULD BE WAVED (2P-3P)
2. BLADE COMMON TO D02XFU001 (CARTON NO BRAND CH-A 1VBLF)
3. FOR THE STICK CORRUGATED FIBERBOARD, USED DIEBLADE OF EBF CORRUGATED FIBERBOARD
   ITEM KEY : BIP-0438-01AD-01
4. EBF CORRUGATED FIBERBOARD IS GLUED ON THE ROUGH SURFACE

CUSTOMER : BROTHER

ITEM DESCRIPTION/PART CODE:

D037M5001
CARTON DCP-J131DW EU-C

CUSTOMERS SUPPLIED REFERENCE NO:

ITEM KEY :
BIP-0816-01AB-03

1−1
PAGE :

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

MATERIAL:
CF (NPK280/CM150/NPK280) /
CF (OJI280/CM150/OJI280)

LEGEND: UNITS: mm N.T.S.
- -CUTTING
- -CREASING
- -HALF-CUT
- -PERFORATION
- -HOLE

PROCESS					
1	EQOS	7	STICKER ATTACHMENT	13	
2	DIE-CUT ETERNA/S1700	8	SCREENING	14	
3	DETACHING	9	LOT NUMBERING	15	
4	GLUING (C1/C2/SD1800/SA2600/MANUAL)	10	OQA	16	
5	SCREENING	11		17	
6	REINFORCEMENT ATTACHMENT	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:
3	250225	REMOVE THE PAPER COMBINATIO OF EBF CORRUGATED FIBERBOARD	K.IIJIMA

DRAWN BY:	CHECKED BY:	APPROVED BY:
A. DE ROXAS	M. ALONSAGAY	S. LUBAG

DT-002-F01 REV.03

PROPERTY KPPI PROP

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. **SQB-08-000822**

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	250811 Shift: ☑ Day ☐ Night
		Delivery Date	250812
Location	BATANGAS	Job Order No.	JO25-M-02513-12A
Item Code	D037M5001.C1	Job Order Qty.	600
Item Description	CARTON DCP-J131DW EU-C;A	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	208572
Drawing Revision No.	03	Gluing Process	☑ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800
External Provider	PW		

II. Dimensional Inspection

Time Conducted Sample #1: 0620 Time Conducted Sample #2: 0747 Time Conducted Sample #3: 0915

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	453	±3	453	453	454	16	N/A				
2	210		210	211	210	17					
3	445		445	443	446	18					
4	18	±5	19	19	20	19					
5	18		20	19	20	20					
6	174		175	173	174	21					
7						22					
8						23					
9						24					
10						25					
11						26					
12						27					
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: 25-023-086-013

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)*

N/D

A. CORRUGATED ITEM / BOX / DANPLA	In-house	External Provider	Total Quantity
Scoring			
Grain Direction			
Paper Shade (Off Color)			
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 : poor	9		9
Linemark			
Fish-eye			1
Stain : Bird stain	1		
Excess Glue			
Gluing Defect : stain	5		5
Worn-out			
Dent	6	4	10
Punctured			
Tear-off			
Peel-off	27		27
Damages :			
Others :			

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

T2

Gluing

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Joint Flap			Judgement	
Requirement		Actual	Good	No Good
GLUED (Inside or Outside)	Inside	Inside	—	
STITCHED (Inside or Outside)	N	/	A	

Type of Material			Judgement	
	Requirement	Actual	Good	No Good
Corrugated	NPK280	NPK280	—	
Flute	CF	CF	—	
Others	XC	—	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	600	
Total Qty Good	548	
Total Qty NG	52	
Defect Rate in % / in PPM	8.66% / 86,66 PPM	

Defect Rate Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$

PPM Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 1{,}000{,}000$

VII. Sampling Inspection Result

Total Sampling Qty Inspected	N/A
Total Sampling Qty Good	
Total Sampling Qty NG	
Defect Rate in % / in PPM	

VIII. Disposition

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

Abnormality Report Control No.: ARNOS-08-0[illegible]

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
JDM S	[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:
Total			

Verified by (Signature over Printed Name)

R&R Staff

Received by (Signature over Printed Name)

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
250811	1	600	0620	0915	~~1hrs 40mins~~ 1 15mins	1hrs 40mins	Breaktime