KANEPACKAGE PHILIPPINE INC.

ABNORMALITY REPORT

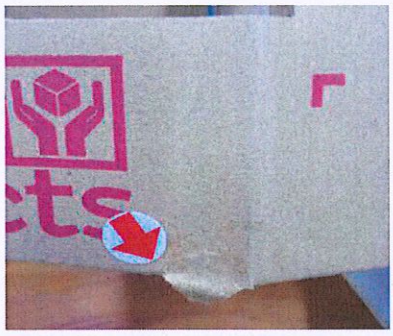
Control No.

AR2025-10-007

I. Item Information

Item Code	HP33D1057-1	Customer	KOWA EMORI
Item Description	CARTON BOX	Delivery Date	251003
Inspection Date	251003	Inspection Time	2AM
Lot Quantity	2,000 PCS	Job Order Number	JO25-M-03055-43
Affected Quantity	36 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	1.80% 18,000 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 4
Problem Description	TEAR OFF	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO TEAR 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 :	EMO-0098-01
☑ Work Instruction :	WI-QA-001-010
☑ Job Order :	JO25-M-03055-43
☑ Reports :	AR2025-10-007
☑ Defect Limit :	KOYAMA DEFECT LIMIT

Requirement:	ACCEPTABLE UP TO 3MM. NO TORN LINER/CM
Actual:	WITH TEAR OFF UP TO 10MM
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
R. ORAP	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.

(5) 2

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PR-001-F12-REV.00

Kanepackage Philippine Inc.

MEMO: - None -

JOB ORDER

Dela Cerna, Jessa Mae
SO # : SO25-M-03055

SNA

Customer : KOWA-EMORI PHILIPPINES, INC.

JOB ORDER: JO25-M-03055-43

ITEM CODE: HP33D1057-1
Netsuite Itemcode : HP33D1057-1

Item Description : CARTON BOX

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
2000	2025-10-03	Pallermo, Arlene Gonzales	2025-09-29

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
720X797 BF TX200	1000	10	N/A	1010	2100 13	PW

39-19-19
F-32B R1-P34 #39-2

Tooling Ref# CYREL F/ BLADE 39-CYREL 32B/ SLOT 19 Ctrl/Batch #: _____ RM Issued By: Elmer 10/1

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN G	TRIAL RUN R	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. EQOS	10/1	PMEW	10/01	1010	2				
2. DIECUT ETERNA	10/02	GBB	10/02	1,010					
3. GLUING CONVEYOR 1	10-03	M,JM,SJ,A A,C,E,M,E		1200 798	22				FIRST Glue - 2000
4. LOT NUMBERING	10/3		Diane	1200					
5. SCREENING	10/3		RICO	1950			48		
6.									
7.									
8.									
9.									

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes: IN-HOUSE REJECTION HISTORY: extra fold, misaligned print, Misaligned glue 75/2100 (230530);

PRODUCTION OUT BY: DATE: KP SYSTEM

KOWA-EMORI PHILIPPINES INC.

Item Code	Quantity
HP33D1057-1	10 pcs.
Item Description: CARTON BOX	Supplier's QC: PASSED INSPECTION RoHS OK QA-CG7331
Lot No. / Ref. NO.: 251003-03055-43	MP

KANEPACKAGE PHILIPPINE INC.

REMARKS

PROD PLAN: ADD #0 PLAN 2025-276

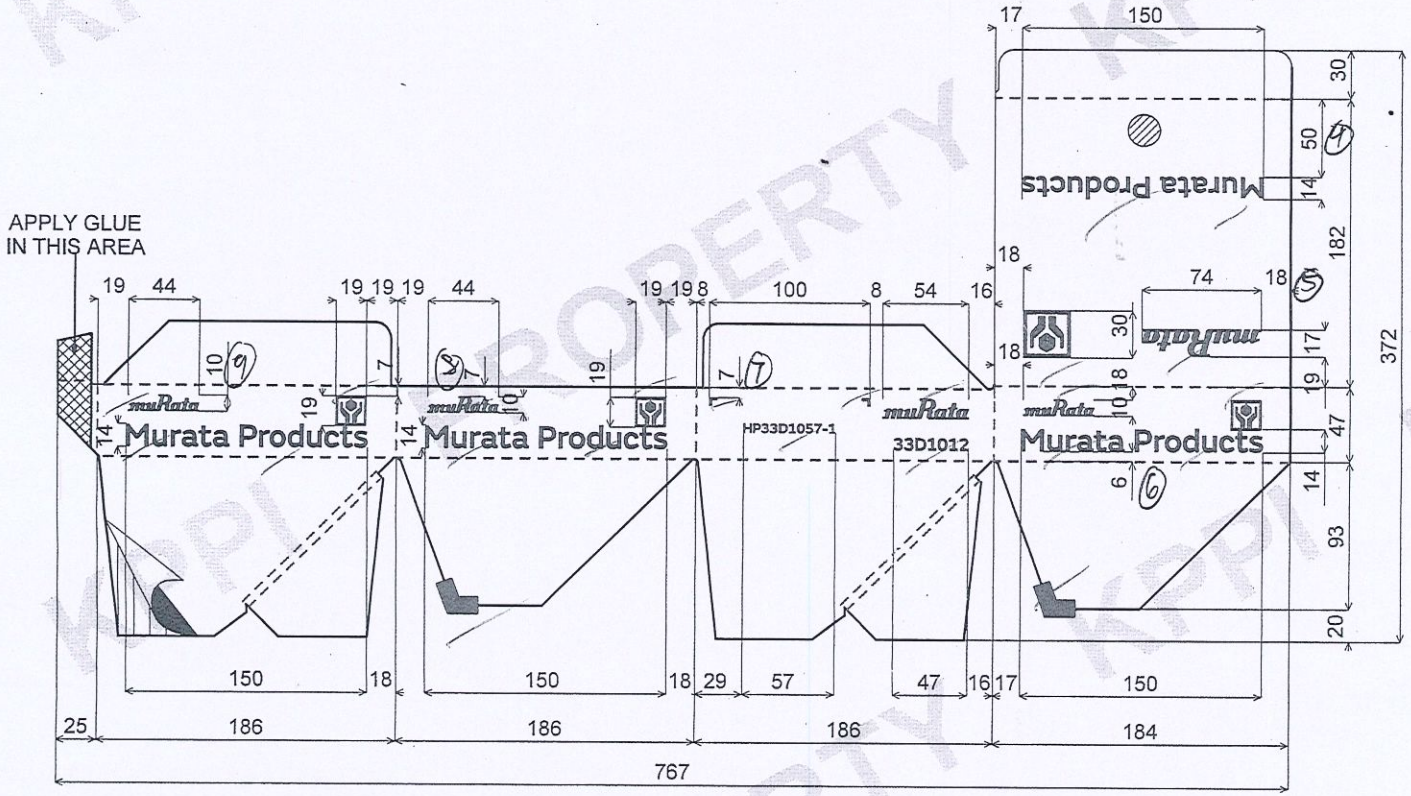
1200 - DA - JM 10/3

2025-09-29 Issued by: _____

RoHS

BOX SPECIFICATION			
Inner Dimension	183 X 183 X 41 mm		
Outer Dimension	N/A		
Joint Flap	GLUING INSIDE		
Illustration	SMOOTH SURFACE		
Bursting Strength	N/A		
BCT	N/A		
ECT	N/A		
PRINT COLOR	1	2	3
Flexo	EQ-04 RED		
Digital print	N/A		
Offset	N/A		
Varnish Coating	N/A		

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



NOTES :

1. BOTTOM FLAP : GLUINg
2. USE CREASING MATRIX 1 X 4

CUSTOMER :	KOWA EMORI	TOLERANCE		MATERIAL:	B FLUTE (TX200/CM125/TX200)
ITEM DESCRIPTION/PART CODE:	CUSTOMERS SUPPLIED REFERENCE NO:	DIMENSION:	+/- 2		
CARTON BOX HP33D1057-1	N/A	<=50	+/- 1		
		51~200	+/- 2		
		201-400	+/- 3		
		401-700	+/- 4		
		701-1000	+/- 5		
		1000<	+/- 8		
	ITEM KEY : EMO-0098-01AB-06	1/5	PAGE :	PRINT: +/- 5 mm	

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

PROCESS						
1	EQOS	7	OQA	13		
2	DIE-CUT ETERNA	8		14		
3	DETACHING	9		15		
4	GLUING SD1800	10		16		
5	LOT NUMBERING	11		17		
6	QA SCREENING	12		18		

PACKING INSTRUCTION : 10 PCS./ BUNDLE

REV. #	DATE	REASON	REQUESTED BY:
6	25/07/04	ADDITIONAL AUTO STRIPPER	R.VILLANUEVA

DRAWN BY: L. AVILES | CHECKED BY: M. ALONSAGAY | APPROVED BY: S. LUBAG

KANEPACKAGE PHIL. 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

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. SQB-10-000252

I. Item Information

Customer	KOWA-EMORI PHILIPPINES, INC.	Inspection Date	251003 Shift: ☐ Day ☑ Night
Location	BATANGAS	Delivery Date	251003
Item Code	HP33D1057-1	Job Order No.	JO25-M-03055-43
Item Description	CARTON BOX	Job Order Qty.	2,000
Model	N/A	Inspection Method	☑ 100% ☐ Sampling
Drawing Revision No.	06	Delivery Receipt No.	210613
External Provider	PW	Gluing Process	☐ Manual Gluing ☐ Semi-Auto Gluing ☑ SD1800

II. Dimensional Inspection

Time Conducted Sample #1: 8:10 Time Conducted Sample #2: 8:15 Time Conducted Sample #3: 1:05

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	183	+2	183	183	183	16					
2	183		183	183	183	17					
3	41	-2	41	41	41	18					
4	50	+1	50	50	50	19	N				
5	18		18	18	18	20					
6	9		9	9	9	21					
7	7	-3	7	7	7	22					
8	7		7	7	7	23					
9	10		10	10	10	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: 25-25129-090

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)*

A. CORRUGATED ITEM / BOX / DANPLA	In-house	External Provider	Total Quantity
Scoring	2		2
Grain Direction			
Paper Shade (Off Color)			
Bubbles	N		
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 : _____			
Linemark			
Fish-eye			
Stain : Glue stain / dirt stain	10		10
Excess Glue			
Gluing Defect : _____			
Worn-out			
Dent			
Punctured			
Tear-off	36		36
Peel-off			
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

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

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

Type of Material			Judgement	
Requirement		Actual	Good	No Good
Corrugated	TX200	TX200	✓	
Flute	BF	BF	✓	
Others	N/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	1998
Total Qty Good	1950
Total Qty NG	48
Defect Rate in %	2.40%
Defect Rate in PPM	24024 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	
Total Sampling Qty Good	N/A
Total Sampling Qty NG	
Defect Rate in %	
Defect Rate in PPM	

VIII. Disposition

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

Abnormality Report Control No.: ~~ANOMALY-10-007~~

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
R. ORAP – E. SANTOS			
QA Screening Inspector	QA Line Leader	QA Supervisor / QA Asst. Supervisor	QA Head

X. Reject & Reworks Item Verification

Defect	Verification Quantity	
	Good	No-Good
Total		

Remarks:

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
25/003	2	1998	8:10	1:00	N/A	5hrs	—