

KANEPACKAGE PHILIPPINE INC.		ABNORMALITY REPORT		Control No. AR2025-10-003											
I. Item Information															
Item Code	D02RN1001	Customer	BROTHER												
Item Description	CARTON DEV UNIT ELLE X3	Delivery Date	251001												
Inspection Date	251002	Inspection Time	9:00 AM												
Lot Quantity	1000 PCS	Job Order Number	JO25-M-03051-35												
Affected Quantity	41 PCS	Origin	<input checked="" type="checkbox"/> IN-HOUSE <input type="checkbox"/> SUPPLIER:												
Rejection Rate and PPM	4.10% 41,000 PPM	Date Received	N/A												
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 5												
Problem Description	PEEL OFF	Delivery Receipt Number	N/A												
II. Visual Reference (Defect Illustration)															
GOOD			NO GOOD												
<table border="1" style="margin-top: 10px; font-size: 0.8em;"> <thead> <tr> <th>CLASS</th> <th>KANEPACKAGE PROPOSAL</th> <th>BIPH JUDGMENT</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>Maximum 5mm (diameter) Outside prime image of Brother logo, no peeled text and character</td> <td rowspan="3">Edge: Should be <5mm x 10mm Other: Max of 16mm²</td> </tr> <tr> <td>B</td> <td>Upper Top: Maximum 5mm (diameter) Lower Right: Maximum 10mm (diameter) (Exclude Brother logo & no peeled text and character)</td> </tr> <tr> <td>C</td> <td>Maximum 20mm (diameter) (No peeled text and character)</td> </tr> </tbody> </table>			CLASS	KANEPACKAGE PROPOSAL	BIPH JUDGMENT	A	Maximum 5mm (diameter) Outside prime image of Brother logo, no peeled text and character	Edge: Should be <5mm x 10mm Other: Max of 16mm ²	B	Upper Top: Maximum 5mm (diameter) Lower Right: Maximum 10mm (diameter) (Exclude Brother logo & no peeled text and character)	C	Maximum 20mm (diameter) (No peeled text and character)			
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C	Maximum 20mm (diameter) (No peeled text and character)														
III. Documented Information Review (To be filled out by Qa Line Leader)															
Related Doc. Info.		Control Number	Requirement:	PEEL OFF ON EDGE : SHOULD BE <5MM X 10MM											
<input checked="" type="checkbox"/> Procedure Manual :	PM-QA-018		Actual:	PEEL OFF 65MMX30MM											
<input checked="" type="checkbox"/> Technical Drawing :	BIP-0645-01AB														
<input checked="" type="checkbox"/> Work Instruction :	WI-QA-001-010		Conclusion or Recommendation:	<input checked="" type="checkbox"/> REJECT <input type="checkbox"/> Applicable <input type="checkbox"/> Not Applicable											
<input checked="" type="checkbox"/> Job Order :	JO25-M-03051-35														
<input checked="" type="checkbox"/> Reports :	AR2025-10-003														
<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 checked="" type="checkbox"/> Rejected <input type="checkbox"/> Conditional (Please indicate details)													
<input type="checkbox"/> Rejected		<input type="checkbox"/> Backload													
<input type="checkbox"/> Backload		<input type="checkbox"/> Good													
		<input type="checkbox"/> For Sorting													
		<input type="checkbox"/> 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) <input type="checkbox"/> FOR 5 WHY ISSUANCE <input type="checkbox"/> FOR CAR ISSUANCE <input checked="" type="checkbox"/> FOR IRF ISSUANCE													
Detected by	Checked by	Initial Approved by (If Needed)	Approved by	Received By											
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												

Note: All details must be filled out completely.
 Submit this form to Line Leader immediately after accomplishment.



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 Philippines Inc.

PR-001-F12-REV.00

MEMO: - None -

Manaig Rea, Villanueva
SO #: SO25-M-03051

JOB ORDER

Customer : BROTHER INDUSTRIES (PHILS.), INC.		JOB ORDER:	
ITEM CODE: D02RN1001		JO25-M-03051-35	
Netsuite Itemcode: D02RN1001			
Item Description : CARTON DEV UNIT ELLE X3			
QTY: 1000	DELIVERY DATE: 2025-10-01	CREATED BY: Javier, Charlotte Nicole	DATE RELEASED: 2025-09-25

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
1160X1581 CF NPK180	500	10	N/A	510	210 823	pw

Akita

H-550 R2-P27

Tooling Ref# CYREL-H / BLADE-E-2-CYREL-55B / BLADE-43 Ctrl/Batch #:

RM Issued By:

Elmer 10/1

PROCESS / MACHINE	DATE	IN-CHARGE		GOOD QTY	TRIAL RUN		REJECTED QTY		REMARKS
		Operator	ME/QA		G	R	INHOUSE	SUPPLIER	
1. EQOS	9/30	PMFW	21/9/30	510	2				
2. DIECUT ETERNA	9/10/01	JVMW	10/10/1	500					
3. DETACHING 1	10-1	ns		1000					
4. GLUING SA 2600	10/2	D.C		1000					
5. LOT NUMBERING	10-02		even	1000					
6. SCREENING	10-02		Ken	920			70	10	
7.									
8.									
9.									

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

QA INPUT : DATE	25/10/02
TIME	10:00
QTY	1000
QA OUTPUT DATE	25/10/02
TIME	11:05
QTY	920
WIP REJECT DATE	25/10/02
TIME	11:00
QTY	80

REMARKS

PROD PLAN: ADD #3 PLAN 2025-274

PRODUCTION OUT

DATE

KP SYSTEM

KANEPACKAGE PHILIPPINES INC.

Part Code	D02RN1001
Part Name	CARTON DEV UNIT ELLE (X3)
Production Date	251002
Lot Number	JO25-M-03051-35
Quantity	10 pcs.
P.O.	N/A
Mold No./Cavity	N/A
Operator	QA-KP892
Remarks	MP



STAMP

STAMP



KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT
(CORRUGATED AND MOULDED ITEMS)

Control No.

SQB-10-000135

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	25/10/02	Shift:	<input checked="" type="checkbox"/> Day <input type="checkbox"/> Night
Location	BATANGAS	Delivery Date	25/10/01		
Item Code	D02RN1001	Job Order No.	JO25-M-03051-35		
Item Description	CARTON DEV UNIT ELLE X3	Job Order Qty.	1,000		
Model	N/A	Inspection Method	<input checked="" type="checkbox"/> 100% <input type="checkbox"/> Sampling		
Drawing Revision No.	00	Delivery Receipt No.	210323		
External Provider	PW	Gluing Process	<input type="checkbox"/> Manual Gluing <input checked="" type="checkbox"/> Semi-Auto Gluing		
			<input type="checkbox"/> SD1800		

II. Dimensional Inspection

Time Conducted Sample #1:	0920	Time Conducted Sample #2:	0950	Time Conducted Sample #3:	1020						
Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	380	±5	385	385	385	16		X			
2	360		363	365	365	17					
3	180		183	183	185	18					
4	12		13	13	13	19					
5	10	11	13	11	20						
6	8	10	8	7	21						
7	19	19	10	19	22						
8	21	23	23	23	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	20-2203-020

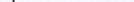

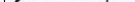
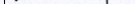
III. Visual Inspection (Leave cell blank if no detection on Applicable Criteria. Ensure to put actual quantity of defect based on classification or "N/A" if Not Applicable)

A. CORRUGATED ITEM / BOX / DANPLA	In-house	External Provider	Total Quantity	B. PALLET	In-house	External Provider	Total Quantity
Scoring	5		7	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		10	10	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
Warping				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:				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: mist Align				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: oil stain	5		5	Scratches	N/A	N/A	N/A
Excess Glue	2		2	Foreign Materials	N/A	N/A	N/A
Gluing Defect:				Wet / Moist	N/A	N/A	N/A
Worn-out	7		7	Dirt	N/A	N/A	N/A
Dent	3		3	Stain:	N/A	N/A	N/A
Punctured	3		3	Discoloration	N/A	N/A	N/A
Tear-off	3		3	Excess Flashes	N/A	N/A	N/A
Peel-off	41		41	Others:	N/A	N/A	N/A
Damages:							
Others:							



Joint Flap		Judgement		Type of Material		Judgement		
Requirement	Actual	Good	No Good	Requirement	Actual	Good	No Good	
GLUED (Inside or Outside)	<i>inside</i>	<i>inside</i>	<i>/</i>	Corrugated	<i>N/A 1/80</i>	<i>N/A 1/80</i>	<i>/</i>	
STITCHED (Inside or Outside)	<i>x</i>	<i>/</i>		Flute	<i>OF</i>	<i>OF</i>	<i>/</i>	
				Others	<i>x</i>	<i>/</i>	<i>/</i>	

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

Requirement	Actual	Good	No Good	V. Barcode Print (If Only with Printed Barcode on Item)			
e				Scan 1		<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

VII. Sampling Inspection Result

Total Qty Inspected		Defect Rate Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$ PPM Formula: $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 1,000,000$	Total Sampling Qty Inspected		
Total Qty Good			Total Sampling Qty Good		
Total Qty NG			Total Sampling Qty NG		
Defect Rate	in % in PPM	8% / 80000 ppm	Defect Rate		in % in PPM

IX. Remarks

- ☒ Good ☐ For Special Acceptance
☐ Backload ☐ Conditional (Please indicate details)
☐ For Sorting
☐ For Rework
- Abnormality Report Control No.: 11

Abnormality Report Control No.: HR007E-101-003

Inspected by

Checked by

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		
X				
				R&R Staff
				Received by (Signature over Printed Name)
Total				QA Inspector

XI. Overall Inspection Time

CORRUGATED AND MOULDED ITEMS

[illegible]