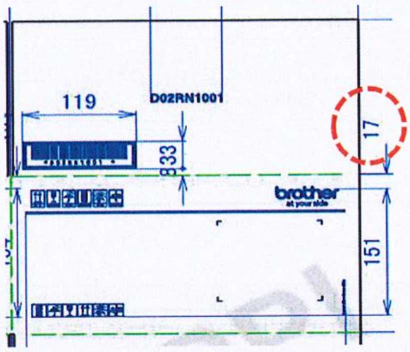
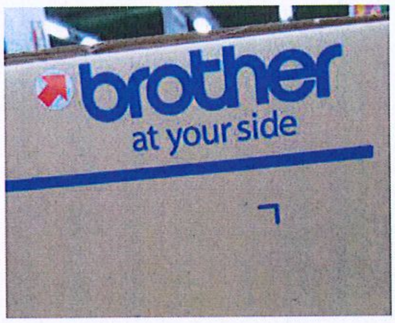
KANEPACKAGE PHILIPPINE INC.	# ABNORMALITY REPORT	Control No. AR2025-10-009

I. Item Information

Item Code	D02RN1001	Customer	BROTHER
Item Description	DEV UNIT ELLE X3	Delivery Date	251004
Inspection Date	251004	Inspection Time	12PM
Lot Quantity	1,400 PCS	Job Order Number	JO25-M-03051-36
Affected Quantity	60 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	4.29% 42,857 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 5
Problem Description	MISALIGN PRINT	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
	

III. Documented Information Review (To be filled out by Qa Line Leader)

Related Doc. Info.	Control Number		
☑ Procedure Manual :	PM-QA-018	Requirement:	17MM (TOLERANCE: +5/-0)
☑ Technical Drawing :	BIP-0645-01		
☑ Work Instruction :	WI-QA-001-010	Actual:	3MM MISALIGN PRINT
☑ Job Order :	JO25-M-03051-36		
☑ Reports :	AR2025-10-009	Conclusion or Recommendation:	REJECT ☑ Applicable ☐ Not Applicable
☑ Defect Limit :	BIPHDEFECT LIMIT		

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
C. MONTANO	A. FILIPINAS		M. CASILLANO	
QA Inspector	QA Line Leader	ME Head	QA Head	QA Staff

	Evaluation	Approved by	Final Disposition
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.*	☐ <80% No Need ☐ >80% Need	Top Management	☐ Backload ☐ Accept ☐ 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.

1

341

Kanepackage Philippine Inc.

MEMO: - None -

PR-001-F12-REV.00

JOB ORDER

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

Customer : BROTHER INDUSTRIES (PHILS.), INC.

ITEM CODE: D02RN1001
Netsuite Itemcode : D02RN1001

JOB ORDER: JO25-M-03051-36

Item Description : CARTON DEV UNIT ELLE X3

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
1400	2025-10-04	Tuiza, Jecille Maduro	2025-09-30

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
1160X1581 CF NPK180	700	10	N/A	710	210531	PW

E2-43-10
H-55B R2-P27

Tooling Ref# CYREL-H / BLADE-E-2-CYREL-55B / BLADE-43 Ctrl/Batch #: RM Issued By: Elmer 10/3

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. EQOS	10/03	JAMM	Ric 10/03	710	G R			
2. DIECUT ETERNA	10/03	JVMAR	Ric 10/03	700	G R 10	57		S 1249 E 1250
3. DETACHING 1	10-4	DJ		700 700	G R			
4. GLUING SA 2600	10/04	Lanie Paje		1320	G R 80			
5. LOT NUMBERING	10/4		Diane	700+700	G R			
6. SCREENING	10-4		CEZAR	1,260	G R	70		
7.								
8.								
9.								

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

ARLENE PALLERMO
Job Controller
KP SYSTEM
10/5

KANEPACKAGE PHILIPPINES INC.

Part Code	D02RN1001
Part Name	CARTON DEV UNIT ELLE (X3)
Production Date	251004
Lot Number	JO25-M-03051-36
Quantity	10 pcs.
P.O.	N/A
Mold No./Cavity	N/A
Operator	QA-CG234
Remarks	MP

STAMP 10/04

STAMP

WHO

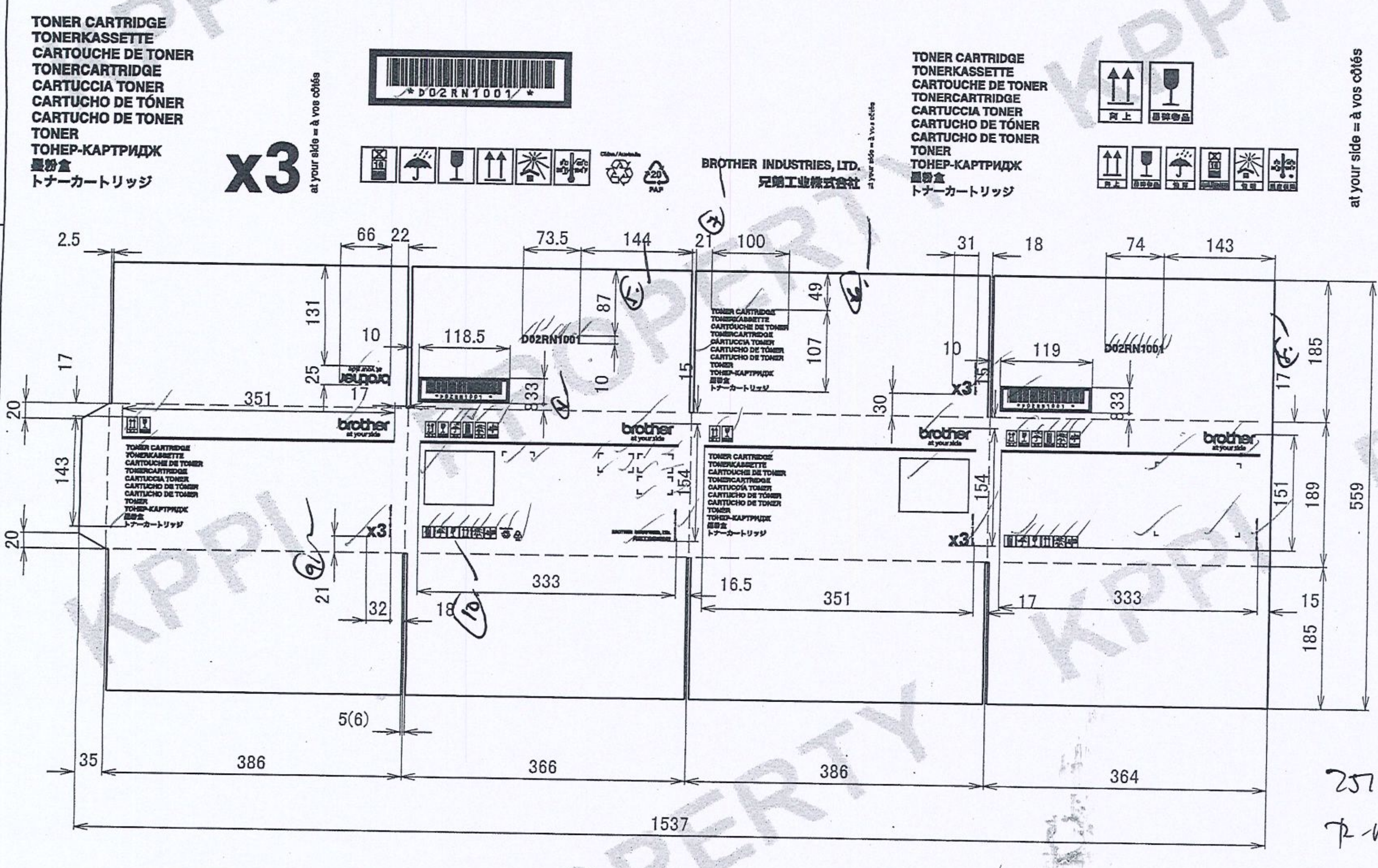
NAME:

REMARKS

PROD PLAN: ADD #0 PLAN 2025-277

*** UNCONTROLLED COPY FOR JOB ORDER ***

2025-09-29 Issued by:



BOX SPECIFICATION		
Inner Dimension	380 X 360 X 180 mm	
Outer Dimension	388 X 368 X 196 mm	
Joint Flap	GLUING INSIDE	
Illustration	SMOOTH SURFACE	
Bursting Strength	9.9 kgf/cm2	
BCT	280.8 kgf	
ECT		
PRINT COLOR	1	2
Flexo	BROTHER BLUE	
Digital Print		
Offset		
Varnish Coating		

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

RoHS

NOTES:

CUTTING LINE SHOULD BE WAVED (2P-3P)

251003

R. Ransugo

CUSTOMER :	BROTHER
ITEM DESCRIPTION/PART CODE:	D02RN1001 CARTON DEV UNIT ELLE X3
CUSTOMERS SUPPLIED REFERENCE NO:	
ITEM KEY :	BIP-0645-01AB
PAGE :	1-2

TOLERANCE	
DIMENSION:	+5/-0
>=50	+/- 1
51~200	+/- 2
201-400	+/- 3
401-700	+/- 4
701-1000	+/- 5
1000<	+/- 8
PRINT:	+/-5

MATERIAL: CF (NPK180/CM150/NPK180)

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	SA2600	10		16	
5	LOT NUMBERING	11		17	
6	SCREENING	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:
	240401		K. IIJIMA

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

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. **SQB-10-000341**

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	251004 — Shift: ☐ Day ☑ Night
		Delivery Date	251004
Location	BATANGAS	Job Order No.	JO25-M-03051-36
Item Code	D02RN1001	Job Order Qty.	1,400
Item Description	CARTON DEV UNIT ELLE X3	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	210531
Drawing Revision No.	00	Gluing Process	☐ Manual Gluing ☑ Semi-Auto Gluing ☐ SD1800
External Provider	PW		

II. Dimensional Inspection

Time Conducted Sample #1: 9:00 Time Conducted Sample #2: 10:15 Time Conducted Sample #3: 11:15

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	320	+5 / -0	320	320	320	16					
2	340		340	340	341	17					
3	180		183	180	180	18					
4	8	+5 / -5	8	9	8	19					
5	87		87	87	86	20					
6	49		50	50	49	21	N				
7	21		23	21	19	22					
8	17		19	17	17	23				A	
9	21		19	21	21	24					
10	18		18	20	18	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: 25-23085-02

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			
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 Print	1		1
Close Gap/ Wide Gap			
Print Color :			
Missing Print/ Character			
Blotted Print			
Smeared Print			
Other Print Defect : misaligned print	60	60	
Linemark			
Fish-eye	1		1
Stain :			
Excess Glue	3		3
Gluing Defect :			
Worn-out			
Dent			
Punctured			
Tear-off			
Peel-off	5		5
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	INSIDE	✓	
STITCHED (Inside or Outside)	N	/	A	

Type of Material			Judgement	
Requirement		Actual	Good	No Good
Corrugated	NPK 100	NPK 100	✓	
Flute	C#	C#	✓	
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	1,320	
Total Qty Good	1,250	
Total Qty NG	70	
Defect Rate in % / in PPM	5.30% / 53,030.30 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 % / in PPM	

VIII. Disposition

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

Abnormality Report Control No.: AR2025-10-001

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
C. MONTANO	[signature]		[signature]
QA Screening Inspector	QA Line Leader	QA Supervisor / QA Asst. Supervisor	QA Head

X. Reject & Reworks Item Verification

Defect	Verification Quantity		Remarks:
	Good	No-Good	
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