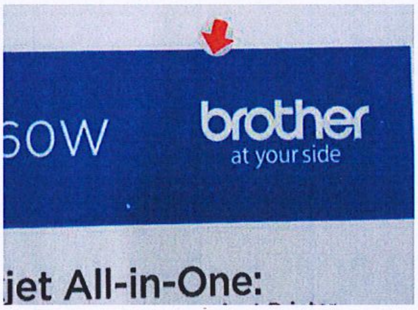
KANEPACKAGE PHILIPPINE INC.	ABNORMALITY REPORT	Control No. AR2025-10-087

I. Item Information

Item Code	D038PE001	Customer	BROTHER
Item Description	CARTON MFC-J1260W US/CAN-C;A	Delivery Date	251027
Inspection Date	251027	Inspection Time	4AM
Lot Quantity	1,187 PCS	Job Order Number	JO25-M-03385-2A
Affected Quantity	25 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	2.11% 21,061 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 3
Problem Description	POOR PRINT	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO POOR PRINT	

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

Related Doc. Info.	Control Number		
☑ Procedure Manual :	PM-QA-018	Requirement:	POOR PRINT NOT ACCEPTABLE
☑ Technical Drawing :	BIP-0841-01	Actual:	WITH POOR PRINT
☑ Work Instruction :	WI-QA-001-010		
☑ Job Order :	JO25-M-03385-2A	Conclusion or Recommendation:	REJECT ☑ Applicable ☐ Not Applicable
☑ Reports :	AR2025-10-087		
☑ Defect Limit :	BIPH DEFECT LIMIT		

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

☐ Good	☐ Conditional (Please indicate details)	☑ Rejected	☐ Conditional (Please indicate details)	
☐ Rejected		☐ Backload	If item is for sorting, for backload, or for rework, fill-out below,	
☐ Backload		☐ Good	Person In Charge	Target Date	Signature
		☐ For Sorting		
		☐ 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
K. VERAS	A. FILIPINAS		for M. CASILLANO	251028
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 ☐ <80% No Need ☐ >80% Need	Approved by Top Management	Final Disposition ☐ Backload ☐ Accept ☐ Other ________

KANEPACKAGE PHILIPPINE INC. **ABNORMALITY REPORT**

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

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 1745

Kanepackage Philippine Inc.

PR-001-F12-REV.00

MEMO: URGENT REQUEST

JOB ORDER

Manaig Rea, Villanueva
SO # : SO25-M-03385

Customer : BROTHER INDUSTRIES (PHILS.), INC.	JOB ORDER:
ITEM CODE: D038PE001.C1 Netsuite Itemcode : D038PE001.C1	JO25-M-03385-2A
Item Description : CARTON MFC-J1260W US/CAN-C; A	

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
1187	2025-10-27	JECEL BALINGBING BUCE	2025-10-25

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
712X1424 CF WKL220	1187	20	N/A	1035	211604	PO

Tooling Ref# - E1-11 Ctrl/Batch #: RM Issued By: DEN 10/25

PROCESS / MACHINE	DATE	IN-CHARGE Operator	ME/QA	GOOD QTY	TRIAL RUN G	TRIAL RUN R	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. EQOS	10/27	JAMB	mc 10/27	1028	2	7			
2. DIECUT S1100	10-27	PMWA		1027	1	1			
3. GLUING LAMINATION	10/27	PT		1027					
4. GLUING CONVEYOR 3	10-27	CJ		885					
5. SCREENING	10/27		KERWIN	842			43		
6. TRANSFER TO BOX STICKER									
7.									
8.									
9.									

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

REMARKS BSL 172 172 10/27
PROD PLAN: ADD #15 PLAN 2025-300

W/HOUSE OUT
NAME: DE DATE: 10/31

add #15 - Oct 27

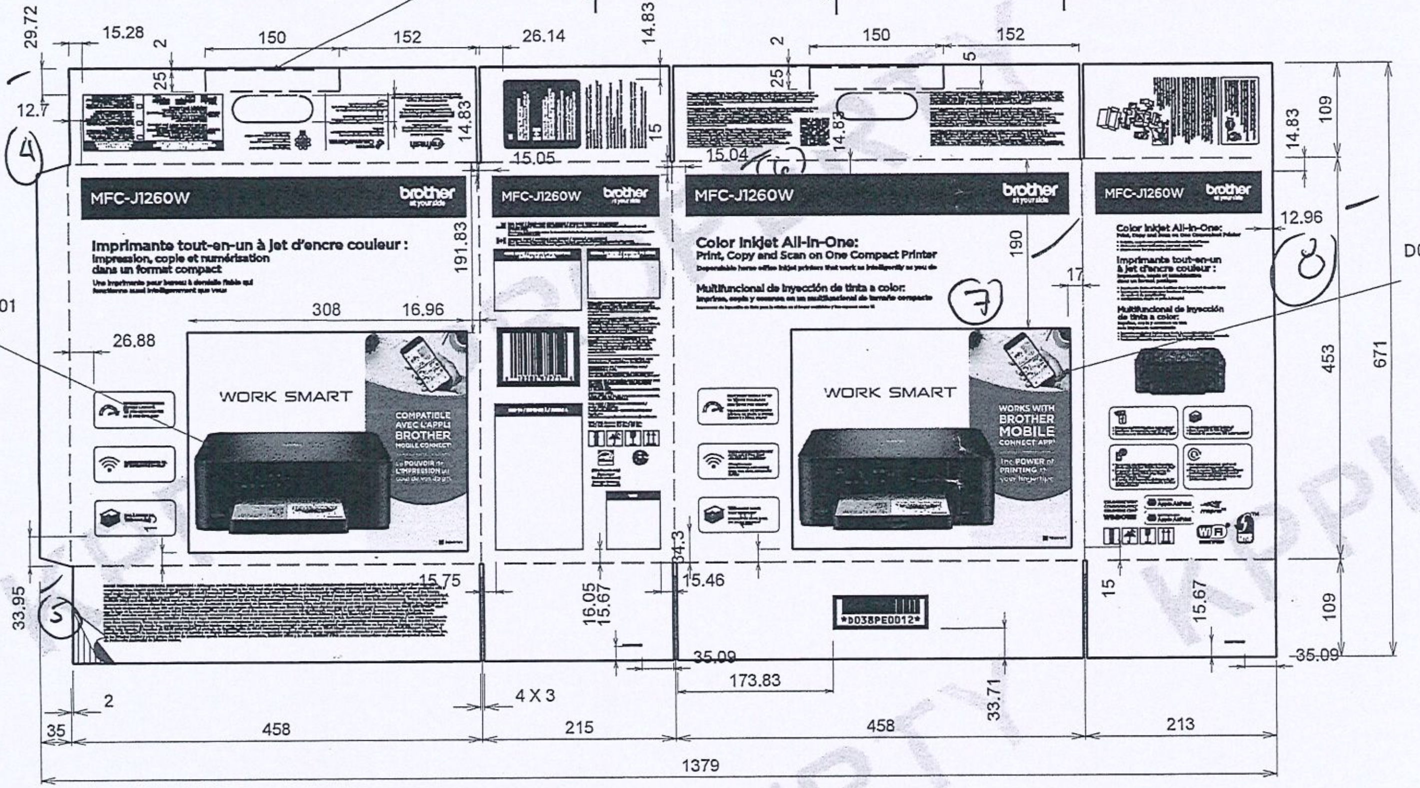
*** UNCONTROLLED COPY FOR JOB ORDER ***

2025-10-25 Issued by:

THIS REVERSE IS STICK CORRUGATED FIBERBOARD EB FLUTE

GOOD AND NG REFERENCE OF USING GUIDEMARK FOR STICKER

GOOD GOOD NOT GOOD (REJECT)



BOX SPECIFICATION

Inner Dimension	453 X 210 X 445 (+5/-0)	
Outer Dimension	461 X 218 X 461	
Joint Flap	GLUING INSIDE	
Illustration	SMOOTH SURFACE	
Bursting Strength	1176kPa (12kgf/cm2) MIN	
BCT	3162N (322.65kgf) MIN	
ECT		
PRINT COLOR	1	2
Flexo	EQ-01 BLACK	EQ-18 BRO 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:

1. CUTTING LINE SHOULD BE WAVED (2-3P)
2. FOR THE STICK CORRUGATED FIBERBOARD, USED DIEBLADE OF EBF CORRUGATED FIBERBOARD
3. EBF CORRUGATED FIBERBOARD IS GLUED ON THE ROUGH SURFACE
4. USE BLADE OF D02XFU001 CARTON J1265N 1VBLF

+20

CUSTOMER :	BROTHER		
ITEM DESCRIPTION/PART CODE: D038PE001 CARTON MFC-J1260W US/CAN-C	CUSTOMERS SUPPLIED REFERENCE NO:		
	ITEM KEY : BIP-0841-01AB-02	1–3 PAGE :	

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

MATERIAL: C FLUTE
WKL220/TX175/NPK210

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

PROCESS					
1	EQOS	7	STICKER ATTACHMENT	13	
2	DIE-CUT ETERNA/S1700	8	QA 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:
2	250725	ADDITIONAL DRAWING PAGE FOR THE ENLARGED PRINT	K. IIJIMA

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

DT-002-F01 REV.03

KANEPACKAGE PHILIPPINE INC.	SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)	Control No. SQB-10-001745

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	251027 — Shift: ☐ Day ☑ Night
		Delivery Date	251027
Location	BATANGAS	Job Order No.	JO25-M-03385-2A
Item Code	D038PE001.C1	Job Order Qty.	1,187
Item Description	CARTON MFC-J1260W US/CAN-C;A	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	211604
Drawing Revision No.	02	Gluing Process	☑ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800
External Provider	PV		

INSPECTED BY:

II. Dimensional Inspection

Time Conducted Sample #1: 10:30 | Time Conducted Sample #2: 11:40 | Time Conducted Sample #3: 3:10

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	453	±5	453	453	453	16	N/A				
2	210		210	210	210	17					
3	445		445	445	445	18					
4	12.7		12	12	12	19					
5	33.95		33	33	33	20					
6	15.04		15	15	15	21					
7	190		190	190	190	22					
8	12.96		12	12	12	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: 25-24011-026

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	5		5
Grain Direction			
Paper Shade (Off Color)			
Bubbles			
Blister			
Wrinkle			
Delamination			
Uneven Kraft liner			
Warpage			
Cracking on edge		N/D	
Bursting / Bursting on Edge (Crowfeet)			
Wrong die-cut orientation			
Inverted die-cut			
Close Gap/ Wide Gap			
Print Color :			
Missing Print/ Character			
Blotted Print	5		5
Smeared Print			
Other Print Defect : POOR PRINT	25		25
Linemark			
Fish-eye			
Stain : INK/GLUE STAIN	~~4~~ 3+2		~~4~~ 3+2
Excess Glue			
Gluing Defect :			
Worn-out	1		1
Dent			
Punctured			
Tear-off	1		1
Peel-off	1		1
Damages :			
Others : SPOT	3		3

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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	WK2220	WK220	/	
Flute	CF	CF	/	
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	885
Total Qty Good	842
Total Qty NG	43
Defect Rate in %	4.86%
Defect Rate in PPM	48 587 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 %	
Defect Rate in PPM	

VIII. Disposition

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

Abnormality Report Control No.: AMMRS-11-038 87 k

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
K. VILLEGAS	[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:	Verified by (Signature over Printed Name)
				R&R Staff
				Received by (Signature over Printed Name)
Total				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
		N			A.		