KANEPACKAGE PHILIPPINE INC.	# ABNORMALITY REPORT	Control No.
		AR2025-10-097

I. Item Information

Item Code	D028GY001	Customer	BROTHER
Item Description	CARTON TN FCL X4	Delivery Date	251103
Inspection Date	251029	Inspection Time	3:40AM
Lot Quantity	1,500 PCS	Job Order Number	JO25-M-03321-66
Affected Quantity	31 PCS	Origin	[√] IN-HOUSE [ ] SUPPLIER:
Rejection Rate and PPM	2.07% 20,667 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 3
Problem Description	SMEARED PRINT	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO SMEARED PRINT	

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

Related Doc. Info.	Control Number		
[√] Procedure Manual :	PM-QA-018	Requirement:	SMEARED PRINT NOT ACCEPTABLE
[√] Technical Drawing :	BIP-0646-01		
[√] Work Instruction :	WI-QA-001-010	Actual:	WITH SMEARED PRINT
[√] Job Order :	JO25-M-03321-66		
[√] Reports :	AR2025-10-097	Conclusion or Recommendation:	REJECT — [√] Applicable [ ] Not Applicable
[√] 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
M. MAGAYANES	A. FILIPINAS		M. CASILLANO	
QA Inspector	QA Line Leader	ME Head	QA Head	QA Staff

Important: Backloading Policy (External Provider Rejects)	Evaluation	Approved by	Final Disposition
Rejection rate that is more than 80% of the total quantity shall be approved by Top Management before backloading.	[ ] <80% No Need		[ ] Backload
	[ ] >80% Need		[ ] Accept
		Top Management	[ ] 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.

3 1915

PR-001-F12-REV.00

Kanepackage Philippine Inc.

MEMO: - None -

JOB ORDER

Manaig Rea, Villanueva
SO # : SO25-M-03321REV.01

Customer : BROTHER INDUSTRIES (PHILS.), INC.

ITEM CODE: **D028GY001**

Netsuite Itemcode : D028GY001

JOB ORDER: JOM005865? JO25-M-03321-66

Item Description : CARTON TN FCL X4

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
1500	2025-11-03	Pallermo, Arlene Gonzales	2025-10-27

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:		Actual Issued:	DR#:	SUPPLIER:
1186X929 CF NPK210	750	10	N/A		760	0211435	
1186X929 CF NPK210	750	10	N/A	Akita	760		
	0						
	0						
	0						
	0						
E2-16-340	0						
	0						
E-40A N-P85	0						
	0						

Tooling Ref# CYREL-E/ BLADE-E-2-CYREL-40A/ BLADE-16 Ctrl/Batch #:__________ RM Issued By: 10/28

PROCESS / MACHINE	DATE	IN-CHARGE Operator	ME/QA	GOOD QTY	TRIAL RUN	REJECTED QTY INHOUSE	SUPPLIER	REMARKS
1. EQOS	10/28	JAIME	10/28	1520	G R			
2. DIECUT ETERNA	10/28	GBB		1,520	G R			
3. DETACHING 1	10-29			1520	G R			
4. GLUING CONVEYOR 2					G R			
5. LOT NUMBERING					G R			
6. SCREENING	10/29			460	G R	40		
7.								
8.								
9.								

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

REMARKS

PROD PLAN: ADD #0 PLAN 2025-307

KANEPACKAGE PHILIPPINES INC.

Part Code	D028GY001
Part Name	CARTON TN FCL X4
Production Date	251029
Lot Number	JO25-M-03321-66
Quantity	10 pcs.
P.O.	N/A
Mold No./Cavity	N/A
Operator	QA-CG6126
Remarks	MP

STAMP

STAMP

NAME:

*** UNCONTROLLED COPY FOR JOB ORDER ***

2025-10-27 Issued by:

COLOR TONER CARTRIDGE
FARBTONERKASSETTE
CARTOUCHE DE TONER COULEUR
KLEUREN TONERCARTRIDGE
CARTUCCIA TONER A COLORI
CARTUCHO DE TÓNER A COLOR
CARTUCHO DE TONER COLORIDO
TONER KOLOROWY
КОЛЬОРОВИЙ ТОНЕР-КАРТРИДЖ
彩色墨粉盒
トナーカートリッジ

brother at your side

x4

at your side = à vos côtés

D028GY001

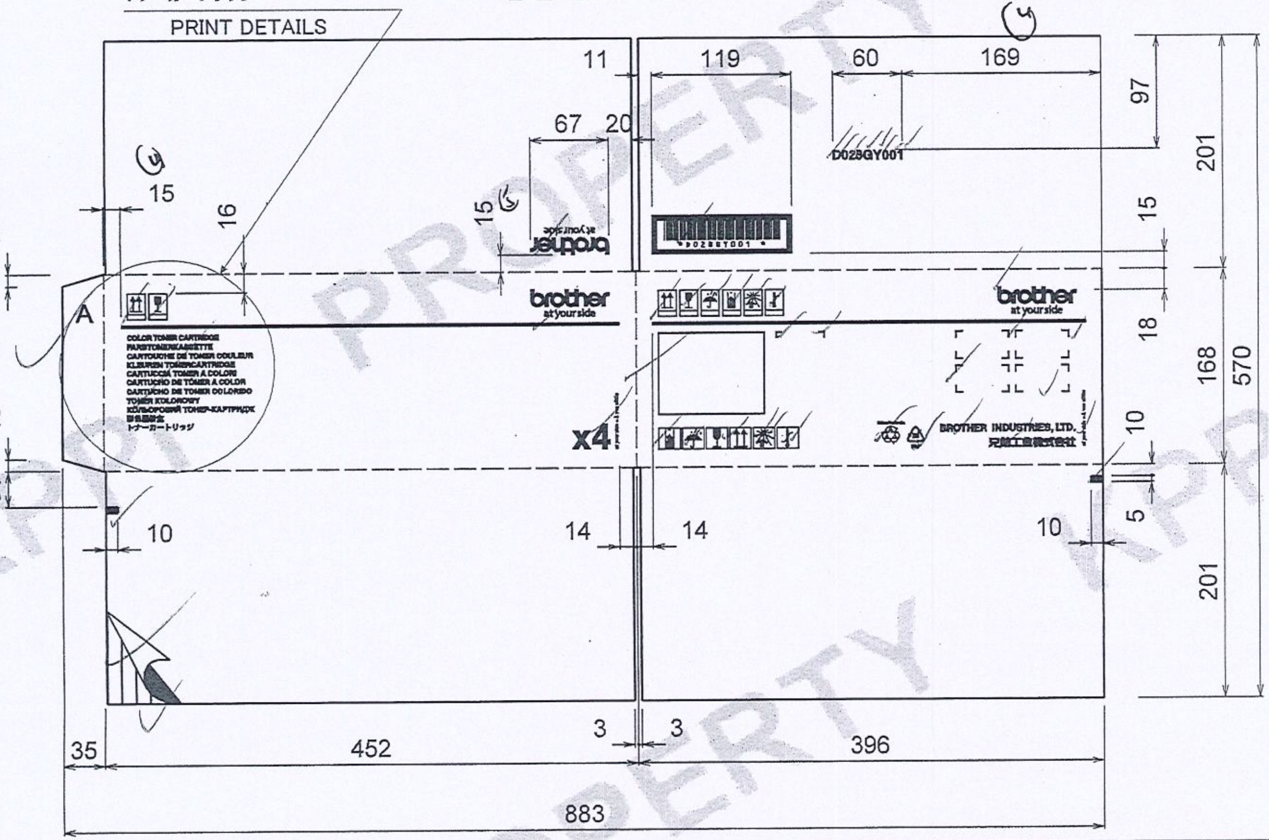
China/Australia

PAP

BROTHER INDUSTRIES, LTD.
兄弟工业株式会社

at your side = à vos côtés

PRINT DETAILS



BOX SPECIFICATION		
Inner Dimension	447 X 393 X 159 mm	
Outer Dimension	455 X 401 X 175 mm	
Joint Flap	GLUING INSIDE (2 JOINTS)	
Illustration	SMOOTH SURFACE	
Bursting Strength	1090kPa (11.1 kgf/cm2) MIN	
BCT	2533N (258.3kgf) MIN	
ECT		
PRINT COLOR	1	2
Flexo	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 SHOULD BE WAVED (2-3P)

10

CUSTOMER :	BROTHER	
ITEM DESCRIPTION/PART CODE: D028GY001 CARTON TN FCL X4 PART A	CUSTOMERS SUPPLIED REFERENCE NO:	
	ITEM KEY : BIP-0646-01AB-01	PAGE : 1-3

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

MATERIAL: C FLUTE
NPK210/CM125/NPK210

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

PROCESS					
1	EQOS	7	OQA	13	
2	DIE-CUT S1700	8		14	
3	DETACHING	9		15	
4	GLUING	10		16	
5	LOT NUMBERING	11		17	
6	SCREENING	12		18	

PACKING INSTRUCTION: 10 PCS. / BUNDLE

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

REV. #	DATE	REASON	REQUESTED BY:
1	250324	CHANGE POKAYOKE "B" POSITION FROM UPPER TO LOWER	K. IIJIMA

KANEPACKAGE PHILIPPINE INC.
#5 Ring Rd, LISP 2 Brgy. Lamesa Calamba, Laguna
Tel. Nos. :(049)545-7165 to 69
Fax Nos. :(049)545-7170/(049)545-6302

DT-002-F01 REV.03

*** UNCONTROLLED COPY FOR JOB ORDER ***

2025-10-27 Issued by:

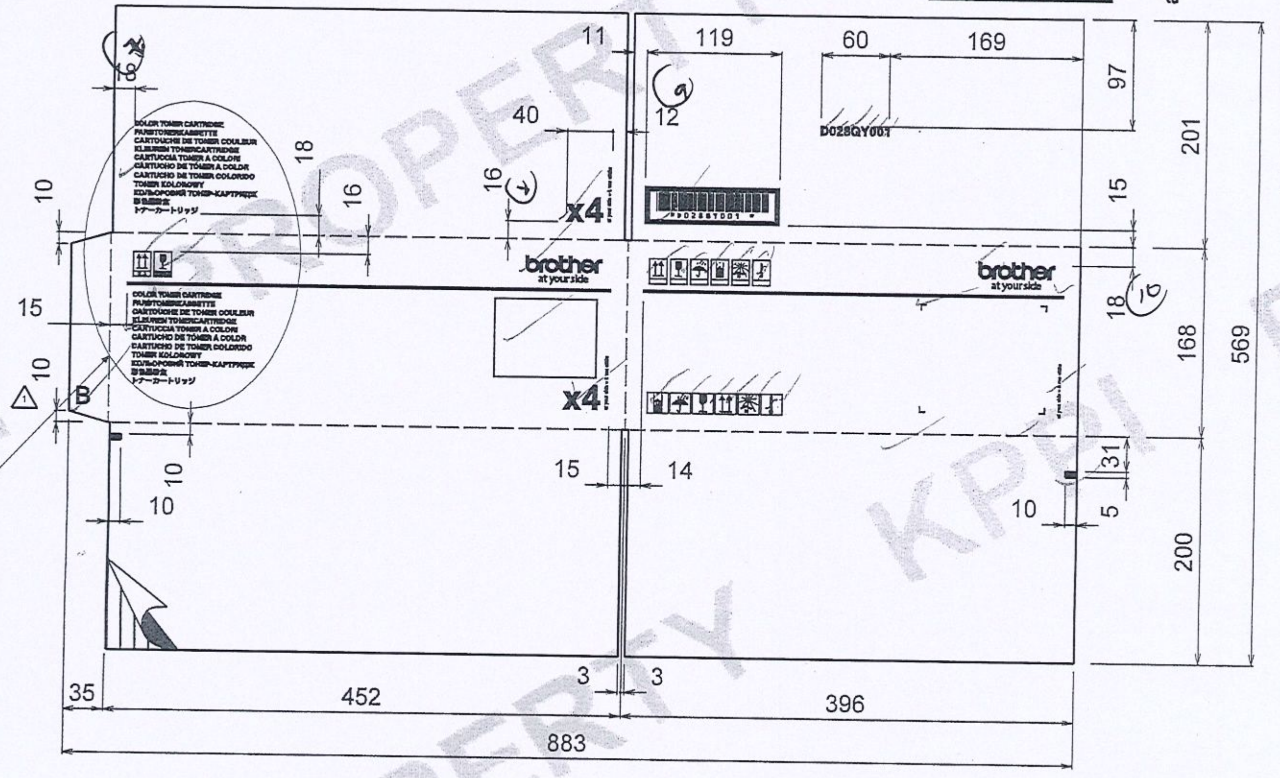
x4 at your side = à vos côtés D028GY001 brother at your side

at your side = à vos côtés

COLOR TONER CARTRIDGE
FARBTONERKASSETTE
CARTOUCHE DE TONER COULEUR
KLEUREN TONERCARTRIDGE
CARTUCCIA TONER A COLORI
CARTUCHO DE TÓNER A COLOR
CARTUCHO DE TONER COLORIDO
TONER KOLOROWY
КОЛЬОРОВИЙ ТОНЕР-КАРТРИДЖ
彩色墨粉盒
トナーカートリッジ

COLOR TONER CARTRIDGE
FARBTONERKASSETTE
CARTOUCHE DE TONER COULEUR
KLEUREN TONERCARTRIDGE
CARTUCCIA TONER A COLORI
CARTUCHO DE TÓNER A COLOR
CARTUCHO DE TONER COLORIDO
TONER KOLOROWY
КОЛЬОРОВИЙ ТОНЕР-КАРТРИДЖ
彩色墨粉盒
トナーカートリッジ

PRINT DETAILS



BOX SPECIFICATION		
Inner Dimension	447 X 393 X 159 mm	
Outer Dimension	455 X 401 X 175 mm	
Joint Flap	GLUING INSIDE (2 JOINTS)	
Illustration	SMOOTH SURFACE	
Bursting Strength	1090kPa (11.1 kgf/cm2) MIN	
BCT	2533N (258.3kgf) MIN	
ECT		
PRINT COLOR	1	2
Flexo	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 SHOULD BE WAVED (2-3P)

CUSTOMER :	BROTHER	TOLERANCE	MATERIAL: C FLUTE NPK210/CM125/NPK210
ITEM DESCRIPTION/PART CODE: D028GY001 CARTON TN FCL X4 PART B	CUSTOMERS SUPPLIED REFERENCE NO:		
	ITEM KEY : BIP-0646-01AB-01	PAGE : 2-3	

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

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

PROCESS					
1	EQOS	7	OQA	13	
2	DIE-CUT S1700	8		14	
3	DETACHING	9		15	
4	GLUING-MANUAL	10		16	
5	LOT NUMBERING	11		17	
6	SCREENING	12		18	

PACKING INSTRUCTION:
10 PCS. / BUNDLE

REV. #	DATE	REASON	REQUESTED BY:
1	250324	CHANGE POKAYOKE "B" POSITION FROM UPPER TO LOWER	K. IIJIMA

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

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

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No.: SQB-10-001915

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	251029 — Shift: ☐ Day ☑ Night
		Delivery Date	251103
Location	BATANGAS	Job Order No.	JO25-M-03321-66
Item Code	D028GY001	Job Order Qty.	1,500
Item Description	CARTON TN FCL X4	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	0211435
Drawing Revision No.	01	Gluing Process	☑ Manual Gluing ☐ Semi-Auto Gluing
External Provider	DW		☐ SD1800

II. Dimensional Inspection

Time Conducted Sample #1: 22:00 | Time Conducted Sample #2: 00:10 | Time Conducted Sample #3: 00:40

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	447	± 3	445	448	448	16					
2	393		393	395	393	17					
3	159		160	160	159	18					
4	15	± 5	15	15	14	19					
5	15		14	15	16	20					
6	169		170	168	170	21					
7	18		18	19	18	22					
8	16		15	16	17	23					
9	12		12	12	11	24					
10	18		18	18	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: 25-25035023

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	13		13
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	31		31
Other Print Defect :			
Linemark			
Fish-eye			
Stain :			
Excess Glue	3		3
Gluing Defect :			
Worn-out			
Dent			
Punctured			
Tear-off			
Peel-off	9		9
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: NPK210	NPK210	✓	
Flute: CF	CF	✓	
Others			

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	D02867001	☑ Good	☐ No Good
Scan 2		☑ Good	☐ No Good
BQICS Compliance (For Epson items only)		☐ Good	☐ No Good

VI. Inspection Result

Total Qty Inspected	500
Total Qty Good	460
Total Qty NG	40
Defect Rate in %	8.00%
Defect Rate in PPM	8000 PPM

Defect Rate Formula: Total Quantity NG / Total Qty. Inspected x100

PPM Formula: Total Quantity NG / Total Qty. Inspected x1,000,000

VII. Sampling Inspection Result

Total Sampling Qty Inspected	
Total Sampling Qty Good	
Total Sampling Qty NG	n/a
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.: Annore-10-097

IX. Remarks

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

X. Reject & Reworks Item Verification

Defect	Verification Quantity: Good	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
25/10/01	1		22:00	03:40	22:50 - 23:10	5 hrs	Break time
					01:50 - 02:10		Break time