KANEPACKAGE PHILIPPINE INC.

ABNORMALITY REPORT

Control No.

AR2025-11-048

Item Code	D028PU001	Customer	BROTHER
Item Description	PARTITION TN FCL	Delivery Date	251122
Inspection Date	251122	Inspection Time	2:30PM
Lot Quantity	8,000 PCS	Job Order Number	JO-25-IPD-01457-1
Affected Quantity	122 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	1.53% 15,250 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 2
Problem Description	BURSTING	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO BURSTING	

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

Related Doc. Info.	Control Number
☑ Procedure Manual :	PM-QA-018
☑ Technical Drawing :	BIP-0987-01
☑ Work Instruction :	WI-QA-001-010
☑ Job Order :	JO-25-IPD-01457-1
☑ Reports :	AR2025-11-048
☑ Defect Limit :	BIPH DEFECT LIMIT

Requirement:	BURSTING NOT ACCEPTABLE	
Actual:	WITH BURSTING UP TO 107MM	
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
J. ESPINOZA	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 ☐ >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.

o/k

1217

Kanepackage Philippine Inc.

MEMO: IPD

PR-001-F12-REV.00

JOB ORDER

Mary Grace Ubay
SO # : SO-25-IPD-01457

Customer : BROTHER INDUSTRIES (PHILS.), INC.

ITEM CODE: **D028PU001**

Netsuite Itemcode : D028PU001

JOB ORDER: 61265 JO-25-IPD-01457-1

Item Description : PARTITION TN FCL

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
8000	2025-11-22	Tuiza, Jecille Maduro	2025-11-20

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
918X1208 BF TX175	2000	3	N/A	2003	368621	ST

Tooling Ref# - E3 -4 Ctrl/Batch #:________ RM Issued By: 11/21

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN	REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. DIECUT S1700	11/21	WINS SAMES		2003	G R			
2. DETACHING 1	11-21	US		6000 / 2000	12 G R			Tear off
3. LOT NUMBERING	11-22		Diane	2000 / 6000	G R			
4. SCREENING	11-22		Jonas neil	7850	G R	150		
5.					G R			
6.					G R			
7.								
8.								
9.								

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes: 11/22

...TION OUT ... SYSTEM

REMARKS

PROD PLAN: ADD #10 PLAN 2025-326

...000 to QA - JUP 11/22

KANEPACKAGE PHILIPPINES INC.

Part Code	D028PU001	
Part Name	PARTITION TN FCL	
Production Date	251122	STAMP
Lot Number	JO-25-IPD-01457-1	
Quantity	25 pcs.	
P.O.	N/A	
Mold No./Cavity	N/A	STAMP
Operator	QA-CG6126	
Remarks	IPD	

NAME:

add # 23 - NN 21

*** ~~UNCONTROLLED COPY FOR JOB ORDER~~ ***

2025-11-20 Issued by: ______

BOX SPECIFICATION

Inner Dimension		
Outer Dimension		
Joint Flap		
Illustration	Smooth Surface	
Bursting Strength		
BCT		
ECT		
PRINT COLOR	1	2
Flexo		
Digital Print		
Offset		
Varnish Coating		

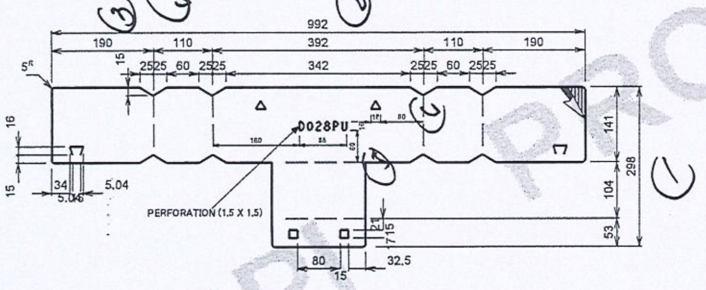
BLADE REQUIREMENT

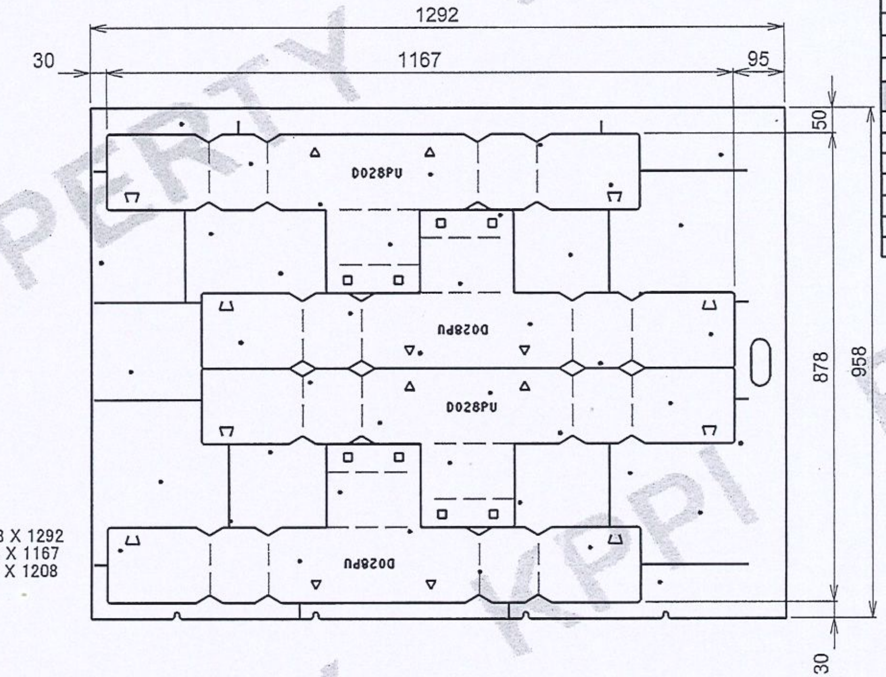
WOOD	Size: 958 X 1292		Thickness: 15	
Type	Height	Thickness	Pitch	Length
Cutting Blade				
Waved Blade	23.8	2 PTS	2-3	15857
Perforation	23.8	2 PTS	1.5 X 1.5	1547
Half-Cut				
Creasing Line	22.8	3 PTS		3970

RoHS

NOTES:

1.) CUTTING LINES SHOULD BE WAVED BLADE (2-3P)





MOULD SIZE: 958 X 1292
BLADE SIZE: 878 X 1167
SHEET SIZE: 918 X 1208

FOR IPD
RELEASED BY
DESIGN & TECH.: ______
IMS / DDC: ______
DATE: 251120

CUSTOMER : BROTHER INDUSTRIES (PHILS.)., INC.

ITEM DESCRIPTION/PART CODE:

D028PU001
PARTITION TN FCL

CUSTOMERS SUPPLIED REFERENCE NO:

ITEM KEY : BIP-0987-01AC

1-4
PAGE :

TOLERANCE

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

MATERIAL:
B FLUTE
(~~TX175~~/CM125/~~TX175~~)
TX200 TX200
251120

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

PROCESS							
1	SLITTER BIG	7	OQA	13	
2	SLITTER SMALL	8		14	
3	DIE-CUT S1700/ETERNA	9		15	
4	PARTITION ASSEMBLY	10		16	
5	QA SCREENING	11		17	
6	LOT NUMBERING	12		18	

PACKING INSTRUCTION:
ASSEMBLED

DRAWN BY:	CHECKED BY:	APPROVED BY:
R. PAGKATOTOHAN	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

REV. #	DATE	REASON	REQUESTED BY:
0	251101		K. IIJIMA

DT-002-F01 REV.03

KANEPACKAGE PHILIPPINE INC.

SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)

Control No. **SQB-11-001217**

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	251122 — Shift: ☑ Day ☐ Night
		Delivery Date	251122
Location	BATANGAS	Job Order No.	JO-25-IPD-01457-1
Item Code	D028PU001	Job Order Qty.	8,000
Item Description	PARTITION TN FCL	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	3686621
Drawing Revision No.	00	Gluing Process	☐ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800
External Provider	ND		

II. Dimensional Inspection

Time Conducted Sample #1: 06:20 Time Conducted Sample #2: 10:00 Time Conducted Sample #3: 14:00

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	298	+/- 3	298	300	300	16					
2	992		992	991	991	17					
3	190		190	190	191	18					
4	110		111	110	109	19					
5	60		60	61	60	20					
6	80		80	81	80	21					
7						22		NA			
8						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: 25-25035-003

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		NA	
Grain Direction			
Paper Shade (Off Color)			
Bubbles			
Blister			
Wrinkle			
Delamination			
Uneven Kraft liner			
Warpage			
Cracking on edge			
Bursting / Bursting on Edge (Crowfeet)	122		122
Wrong die-cut orientation (104 mm)			
Inverted die-cut		NA	
Close Gap/ Wide Gap			
Print Color :			
Missing Print/ Character			
Blotted Print			
Smeared Print			
Other Print Defect :			
Linemark			
Fish-eye			
Stain : Oil stain	~~123~~ 7		~~137~~ 7
Excess Glue			
Gluing Defect :			
Worn-out			
Dent			
Punctured			
Tear-off	8		8
Peel-off			
Damages :	13		13
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)	n/a			
STITCHED (Inside or Outside)				

Type of Material			Judgement	
Requirement		Actual	Good	No Good
Corrugated	TX[illegible]	TX[illegible]	✓	
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	8000	**Defect Rate Formula:** $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 100$
Total Qty Good	7850	
Total Qty NG	150	
Defect Rate in %	1.88%	**PPM Formula:** $\frac{\text{Total Quantity NG}}{\text{Total Qty. Inspected}} \times 1{,}000{,}000$
Defect Rate in PPM	18750 PPM	

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.: Anmrz-11-048

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
J. Espinosa	[signature]		[signature]
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		
n/a				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