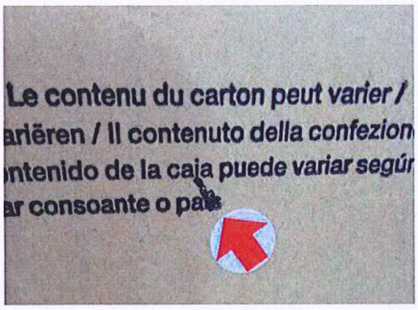
KANEPACKAGE PHILIPPINE INC.	# ABNORMALITY REPORT	Control No. AR2025-12-024

I. Item Information

Item Code	D037MH001	Customer	BROTHER
Item Description	CARTON DCO-J1460DW	Delivery Date	251212
Inspection Date	251211	Inspection Time	3:35AM
Lot Quantity	2,400 PCS	Job Order Number	JO25-M-03625-55A
Affected Quantity	106 PCS	Origin	☑ IN-HOUSE ☐ SUPPLIER:
Rejection Rate and PPM	4.42% 44,167 PPM	Date Received	N/A
Sampling Quantity (IQA)	N/A	Detection (Section / Area)	SCREENING 3
Problem Description	BLOTTED PRINT	Delivery Receipt Number	N/A

II. Visual Reference (Defect Illustration)

GOOD	NO GOOD
NO BLOTTED PRINT	

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

Related Doc. Info.	Control Number		
☑ Procedure Manual :	PM-QA-018	Requirement:	NO BLOTTED PRINT
☑ Technical Drawing :	BIP-0818-01		
☑ Work Instruction :	WI-QA-001-010	Actual:	WITH BLOTTED PRINT
☑ Job Order :	JO25-M-03625-55A		
☑ Reports :	AR2025-12-024	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
For: L. ARISGADO	For: 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.

(8) 10 (461)

PR-001-F12-REV.00

Kanepackage Philippine Inc.

MEMO: - None -

Manaig Rea, Villanueva
SO # : SO25-M-03625

JOB ORDER

Customer : BROTHER INDUSTRIES (PHILS.), INC.

JOB ORDER: JO25-M-03625-55A

ITEM CODE: D037MH001.C1

Netsuite Itemcode : D037MH001.C1

Item Description : CARTON DCP-J1460DW EU-C; A

QTY:	DELIVERY DATE:	CREATED BY:	DATE RELEASED:
2400	2025-12-12	JECEL BALINGBING BUCE	2025-12-05

Raw Material Code:	Qty To Be Used:	Over Run:	Cut Size:	Actual Issued:	DR#:	SUPPLIER:
749X1512 CF NPK280	2400	20	N/A	2420	D00000309	PN

Akita

E1-34

Tooling Ref# E1-34 C-59B R2-P12 Ctrl/Batch #: RM Issued By: 12/10

PROCESS / MACHINE	DATE	IN-CHARGE Operator	IN-CHARGE ME/QA	GOOD QTY	TRIAL RUN		REJECTED QTY INHOUSE	REJECTED QTY SUPPLIER	REMARKS
1. EQOS	12/10	EJMC	12/10	2420	~~G~~	R			
2. DIECUT S1700	12/10	MJRC		370 2050	G	R			
3. GLUING LAMINATION	12/10	REID Chris		1537 883	G	R			
4. GLUING CONVEYOR 3	12/11	Jim Carlo		955	G	R	140	20	
5. SCREENING	12/11 12/11		Efren	1144 936	G	R	19		
6. TRANSFER TO BOX STICKER				1211	G	R			
7.									
8.									
9.									

REJECTION/ ABNORMALITY HISTORY

Customer Claim:

Notes:

INHOUSE OUT
NAME: DATE: 12/10

REMARKS

PROD PLAN: ADD #0 PLAN 2025-346

*** UNCONTROLLED COPY FOR JOB ORDER ***

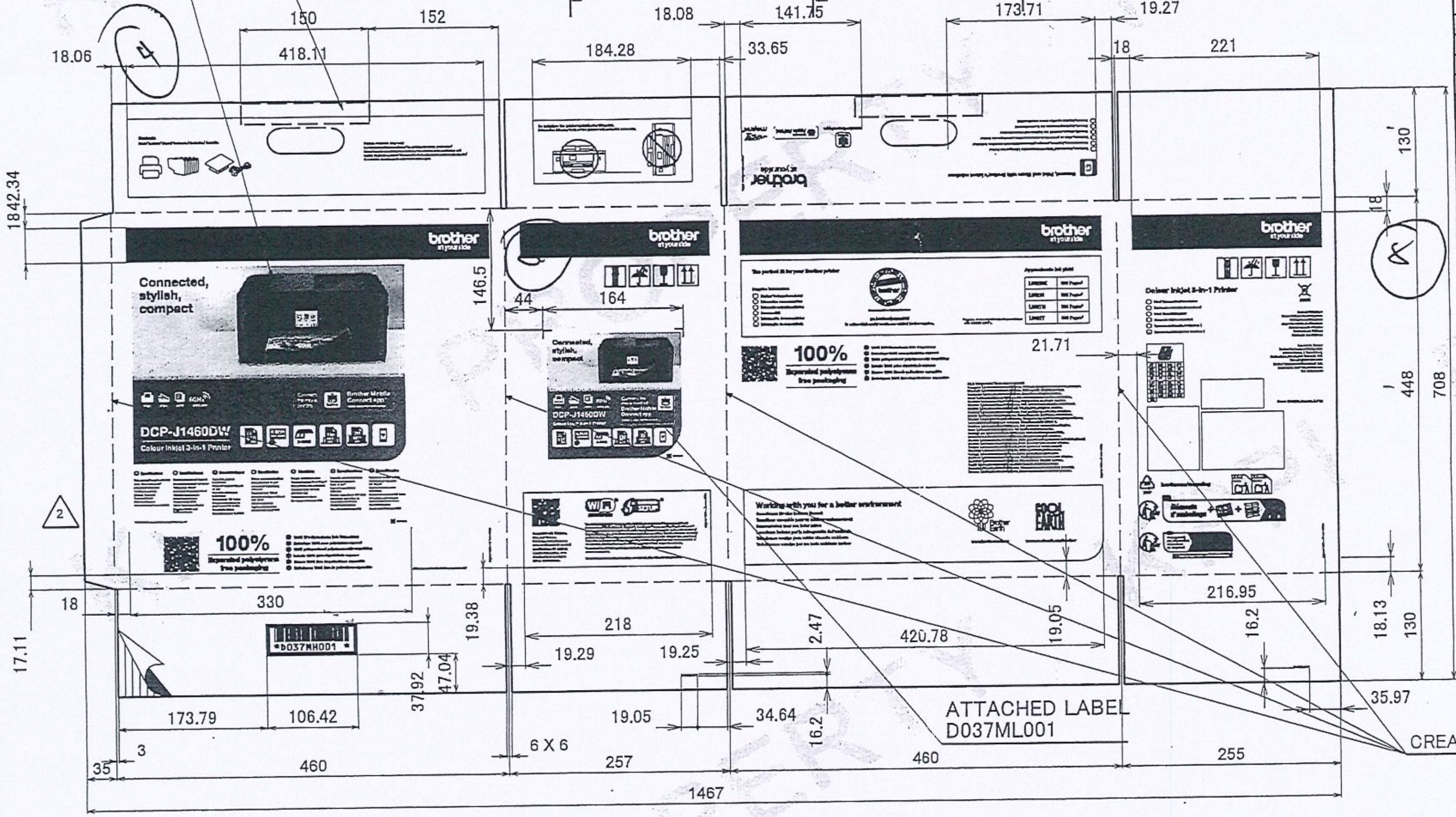
2025-12-05 Issued by:

GOOD AND NG REFERENCE OF USING GUIDEMARK
FOR STICKER

GOOD | GOOD | NOT GOOD (REJECT)

THIS REVERSE IS STICK
CORRUGATED FIBERBOARD (EBF)

ATTACHED LABEL
D037MK001



BOX SPECIFICATION

Inner Dimension	455 X 252 X 440	
Outer Dimension	463 X 260 X 456	
Joint Flap	GLUING INSIDE	
Illustration	SMOOTH SURFACE	
Bursting Strength	800 kPa	
BCT	363.1 kgf	
ECT		
PRINT COLOR	1	2
Flexo	EQ-01 BLACK	
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 BLADE (2-3P)
2. FOR THE STICK CORRUGATED FIBERBOARD, USE BLADE OF EBF CORRUGATED FIBERBOARD
3. EBF CORRUGATED IS GLUED ON THE ROUGH SURFACE
4. USE BLADE OF D02YHE001 CARTON NO BRAND

120

CUSTOMER : BROTHER

ITEM DESCRIPTION/PART CODE:

D037MH001
CARTON DCP-J1460DW EU-C

CUSTOMERS SUPPLIED REFERENCE NO:

ITEM KEY :
BIP-0818-01AB-02

1-2
PAGE :

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

MATERIAL:
CF (NPK280/CM150/NPK280)
CF (OJI280/CM150/OJI280)

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

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

PACKING INSTRUCTION:
10 PCS./BUNDLE

REV. #	DATE	REASON	REQUESTED BY:
2	250219	REMOVE STICKER GUIDE ON THE LOWER PART	K.IJIMA

DRAWN BY:	CHECKED BY:	APPROVED BY:
R. ROBRIGADO	M. ALONSAGAY	

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

DT-002-F01 REV.03

KANEPACKAGE PHILIPPINE INC.	SCREENING INSPECTION REPORT (CORRUGATED AND MOULDED ITEMS)	Control No. SQA-12-000661

I. Item Information

Customer	BROTHER INDUSTRIES (PHILS.), INC.	Inspection Date	251211 — Shift: ☐ Day ☑ Night
		Delivery Date	251212
Location	Laguna	Job Order No.	JO25-M-03625-55A
Item Code	D037MH001.C1	Job Order Qty.	2,400
Item Description	CARTON DCP-J1460DW EU-C; A	Inspection Method	☑ 100% ☐ Sampling
Model	N/A	Delivery Receipt No.	DR000309
Drawing Revision No.	02	Gluing Process	☑ Manual Gluing ☐ Semi-Auto Gluing ☐ SD1800
External Provider	PACKAGE WORLD		

II. Dimensional Inspection

Time Conducted Sample #1: 04 1840	Time Conducted Sample #2:	Time Conducted Sample #3:

Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3	Checkpoints	Drawing Specs	Tolerance	Sample #1	Sample #2	Sample #3
1	455	+/-5	455	454	454	16					
2	252		252	253	253	17					
3	440		440	440	440	18					
4						19					
5						20					
6	44		44	44	44	21					
7						22					
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: 26-2011-110

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)*

AHMS-12-023

A. CORRUGATED ITEM / BOX / DANPLA	In-house	External Provider	Total Quantity
Scoring	3	18	21
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			
Other Print Defect : BROKEN TEXT	14		14
Linemark			
Fish-eye			
Stain : OIL STAIN		2	2
Excess Glue	34 24		28 34
Gluing Defect :			
Worn-out			
Dent			
Punctured			
Tear-off			
Peel-off	3		3
Damages :			
Others :			

AHMS-12-024

AHMS-12-025

100mm

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	MPK270	MPK270	/	
Flute	G	G		
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	/	☐ Good	☐ No Good
Scan 2		A	☐ Good	☐ No Good
BQICS Compliance (For Epson items only)			☐ Good	☐ No Good

VI. Inspection Result

Total Qty Inspected	1428	
Total Qty Good	1268	
Total Qty NG	160	
Defect Rate in %	11.20%	
Defect Rate in PPM	112,044 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	
Total Sampling Qty Good		/
Total Sampling Qty NG		
Defect Rate in %		A
Defect Rate in PPM		

VIII. Disposition

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

Abnormality Report Control No.: ANWMS_12-023/024/027

IX. Remarks

Inspected by	Checked by	Approved by (If there are major concerns)	Verified by (If there are major concerns)
L. APULAN	[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		
				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	Cause of Downtime