

Written at Parent level XXX (but shows as 000)

Not currently used, needs discussion, perhaps selecting country can do translation

Assembly RPPS Report

script in KP looks at all shades in SAP '001-999 to see if drug flag indicator, if some are some aren't, then we list as art specific

Shelf life used to be here on paper copy, but we removed it. only on digital record now

Date: 10/4/2021
Time: 11:30:20AM
Page: 1

Status: Appro

RM Request No: 2019-0182
Version: 3
Item#: 7246618000
Product Name: RV SL RESTAGE LS
M No: 987844(4708066000,4708064000,4708063000,4708062000,4708061000,4708060000,4708059000,4708058000,4708057000,4708056000,4708055000,4708054000,4708053000,4708052000,4708051000,4708050000,4708049000,4708048000,4708047000,4708046000,4708045000,4708044000,4708043000,4708042000,4708041000,4708040000,4708039000,4708038000,4708037000,4708036000,4708035000,4708034000,4708033000,4708032000,4708031000,4708030000,4708029000,4708028000,4708027000,4708026000,4708025000,4708024000,4708023000,4708022000,4708021000,4708020000,4708019000,4708018000,4708017000,4708016000,4708015000,4708014000,4708013000,4708012000,4708011000,4708010000,4708009000,4708008000,4708007000,4708006000,4708005000,4708004000,4708003000,4708002000,4708001000,4708000000)

Bulk No: 987844,000592,463208,463207
Supporting Documents:

Drug Item: OAll @None OArtwork specific

Formula/bulk # (SAP material code)
This is a mess because issued at parent level. It makes document too long and causes mistakes. We want to write the document at parent level but want the factory to only see what is relevant for the shade they are filling.

TOPS Required: ☒ Yes ☐ No

Critical Instructions: THIS RPPS IS FINALIZED BASED UPON APPROVAL OF 72 pcs per shipper (36 flow-wraps/2)

***CRITICAL: FILLING TEMPERATURES AND BREAK/SQUEEZE SPECIFICATIONS ARE SPECIFIC TO THE CREME OR PEARL FORMULAS. USE THE M NUMBER LISTED AND THE BULK NUMBER LISTED ABOVE. EXAMPLE: USE 987844 FOR CREME, USE 000592 FOR PEARLS.

USE STANDARD CREME/PEARL MOLDS FOR RIKAS.

IF 2211488000 SHIPPER IS ON THE BOM, USE THE 2ND PAGE OF THE TOPS (LABELED - 7246618000- SHIPPER 221488000).

IF 2240829000 COMES OUT, USE THE FIRST PAGE OF THE ATTACHED TOPS PALLET PATTERN.

pallet pattern will be attached if this box checked... tote does not

Sections: ☒ Fill Spec ☐ Cap Torque ☒ Coding ☒ Label Info

Filling Specification Notes (updated instructions starting in April 2019):

- For all process orders, the operator is required to sample and record the fill weights in a paper or electronic document control system.
- Operator must review the filling specifications below to confirm if the label claim type is by volume or by weight and if there are aesthetic concerns.
- It is critical that the average net contents of each lot filled must meet or exceed the TARGET fill. The operator is responsible for making sure the line is adjusted to maintain this requirement.
- In the course of filling, if weights exceed the upper control limit (max), or if weights not meet the lower control limit (min), the operator should make immediate adjustments to return to target. This applies to aesthetic limits as well, if any noted in OTHER FILLING REQUIREMENTS.
- For products with label claim copy in NET. WT, this is a weight claim type. Use the Lower Control Limit (Min), Target, and Upper Control Limit (Max) weights as stated in filling instructions below for each bulk.
- For products with label claim copy in Fluid Ounces/MLs the filling specifications this is volume claim type. The weights must be calculated using the following formula: Actual bulk SPG x mL's = GRAMS. Operators will need to obtain the SPG of the batch and then multiply by specified ml values for Upper Control Limit, Target and Lower Control limit. Use blank space provided in the filling spec below. These values to be recorded on the paper or computer quality document for record keeping. Along with the measured weights of the samples taken during production.
- For each bulk material number on the BOM, refer to the corresponding bulk parent number to identify which bulk instructions to follow.
- The label stated claim and BOM fill are only for reference.
- When checking weights, the tare weight must be re-established each time a component lot is changed.

These checks drive what detail sections are included

This is "boiler plate" instruction on filling. Same for all docs with Fill spec checked

Fill Spec:

Applicable Bulk(s): 987844

Formula / bulk #

Description:

Type: Weight

Label Stated: 4.2 g

BOM Fill Wt: 0.00442 kg (These values for reference only)

Parameter	Weight of product
UPPER CONTROL LIMIT	4.6 GRAMS
TARGET SETPOINT	4.42 GRAMS
LOWER CONTROL LIMIT	4.25 GRAMS

Other Filling Requirements:

Engineer selects type being weight or volume claim... in the future we want to have a third option for "aesthetic" which may include a small table with a min/target/max distance for fill level

Cap Torque: n/a for lipstick package
Fill Temp./Meltdown:

Status: Approved

Description: 000592
Product Category: LIPSTICKS
Product Type: Anhydrous Hot Pour
Filling cleaning:

Flush- hot Mineral oil
RM#92574-00 or Dimethicone RM# 98508-00 (Primary formula ingredient*)
Clean - Risil Mat (2-3%) or Blast/Spectak (3 - 5 %)
Not required(Hot process)

Flash Point: >150 C
Meltdown Temp: Min(C°): 88.00 Max(C°): 90.00 Target(C°): 89.00
Min(F°): 190.40 Max(F°): 194.00 Target(F°): 181.40

Meltdown Instructions: SL PEARL/FROST FORMULA:
REMELT TEMPERATURE 88-92C
TRANSFER LINE 83-86C
COLD TANK 10-14C

REMELT/MOLDING KETTLE EQUIPPED WITH FLUID-HEATED JACKET, VARIABLE SPEED AGITATION WITH BOTTOM-CONTACT SCRAPER BLADE OR OTHER APPROVED AGITATION. AUTOMATIC LINE(REFER TO LS-004). SPLIT MOLDS AND CHILL PLATE (REFER TO LS-005).

HOT TANK 28-32C

LINE SPEED 40 PIECES PER MINUTE. WATER/SARTO COOLANT LEVEL = MAXIMUM WEIR HEIGHT. SURFACE HEATER SETTING (PRIOR TO BACK FILL) HEATER #1=70%, HEATER #2=OFF
AIR PRESSURE=0.75-1.25 LBS PSI

Fill Temp: Min(C°): 82.00 Max(C°): 84.00 Target(C°): 83.00
Min(F°): 179.60 Max(F°): 183.20 Target(F°): 181.40

Fill Instructions: Fill temp range: 82-84C

CRITICAL NOTE: FILLING TEMPERATURES AND BREAK/SQUEEZE SPECIFICATIONS ARE SPECIFIC TO THE CREME OR PEARL FORMULAS. REFER TO BOTTOM LABEL TO ENSURE THAT THE PRODUCT IS LABELED AS "FROST" BEFORE USING THE BELOW SPECIFICATIONS.

BULK MAY BE HELD HOT FOR 8 HOURS. SALVAGE 10% MAX. CHARGE ENTIRE STORAGE CONTAINER INTO REMELT KETTLE PRIOR TO THE BEGINNING OF THE REMELT CYCLE. REFER TO REMELT PROCEDURE LS-003.

A CUSTOMIZED LINE EQUIPPED WITH PISTON FILL HEAD, INFRA-RED HEAT BULBS, HEAT LAMPS, COOLING TUNNEL AND HIGH EFFICIENCY SURFACE HEATER. POSITIVE DISPLACEMENT-TYPE TRANSFER PUMP OR POINT-TYPE FILLER.

Finished Goods
Specifications:
Break/Squeeze:

CHATILLON UNIT
0.5" LIPSTICK BULLETS @ 25C
AVERAGE BREAKAGE 6 LIPSTICK BULLETS (1 HOUR): range TBD (16 HOUR): 0.90-1.40 AVERAGE SQUEEZE 6 LIPSTICK BULLETS (1 HOUR): range TBD (16 HOUR): 7.50-9.50

Description: 463207
Product Category: LIPSTICKS
Product Type: Anhydrous Hot Pour
Filling cleaning:

Flush- hot Mineral oil
RM#92574-00 or Dimethicone RM# 98508-00 (Primary formula ingredient*)
Clean - Risil Mat (2-3%) or Blast/Spectak (3 - 5 %)
Not required(Hot process)

Flash Point: >150 C
Meltdown Temp: Min(C°): 88.00 Max(C°): 92.00 Target(C°):
Min(F°): 190.40 Max(F°): 197.60 Target(F°):

Meltdown Instructions: SL LS FORMULA WITH PEARLS:
REMELT TEMPERATURE 88-92C
TRANSFER LINE 83-86C
COLD TANK 10-14C

REMELT/MOLDING KETTLE EQUIPPED WITH FLUID-HEATED JACKET, VARIABLE SPEED ANCHOR-TYPE AGITATION WITH BOTTOM-CONTACT SCRAPER BLADE OR OTHER APPROVED AGITATION. AUTOMATED LIPSTICK MOLDING LINE(REFER TO LS-004). SPLIT MOLDS AND CHILL PLATE (REFER TO LS-005).

HOT TANK 28-32C

LINE SPEED 40 PIECES PER MINUTE. WATER/SARTO COOLANT LEVEL = MAXIMUM WEIR HEIGHT. SURFACE HEATER SETTING (PRIOR TO BACK FILL) HEATER #1=70%, HEATER #2=OFF
AIR PRESSURE=0.75-1.25 LBS PSI

Fill Temp: Min(C°): 84.00 Max(C°): 86.00 Target(C°):
Min(F°): 183.20 Max(F°): 186.80 Target(F°):

Fill Instructions: FILLING TEMPERATURE: 84-86C

CRITICAL NOTE: FILLING TEMPERATURES AND BREAK/SQUEEZE SPECIFICATIONS ARE SPECIFIC TO THE CREME OR PEARL FORMULAS. REFER TO BOTTOM LABEL TO ENSURE THAT THE PRODUCT IS LABELED AS "FROST" BEFORE USING THE BELOW SPECIFICATIONS.

BULK MAY BE HELD HOT FOR 8 HOURS. SALVAGE 10% MAX. CHARGE ENTIRE STORAGE CONTAINER INTO THE REMELT KETTLE PRIOR TO THE BEGINNING OF THE REMELT CYCLE. REFER TO REMELT PROCEDURE LS-003.

A CUSTOMIZED LINE EQUIPPED WITH PISTON FILL HEAD, INFRA-RED HEAT BULBS, HEAT LAMPS, COOLING TUNNEL AND HIGH EFFICIENCY SURFACE HEATER. POSITIVE DISPLACEMENT-TYPE TRANSFER PUMP OR POINT-TYPE FILLER.

There are 4 bulk rpps that are merged in the document since the parent material supports 4 different formula types across the multitude of shades

Date: 10/4/2021
Time: 11:30:20AM
Page: 2

in general.... bulk rpps describes how the assembly team handles the bulk before it comes out of the filling nozzle. A "PPS" or SBI is different and describes how the bulk itself is made.

Would love to have live linkage to reference specs/ procedures

Status: Approved

Finished Goods

Specifications:

Break/Squeeze: 0.5" LIPSTICK BULLETS @ 20C
AVERAGE BREAKAGE 6 LIPSTICK BULLETS (1 HOUR): 1.0-1.50 (16 HOUR): 1.10-1.60
AVERAGE SQUEEZE 6 LIPSTICK BULLETS (1 HOUR): 6.0-9.0 (16 HOUR): 6.0-9.0

Description:

Product Category: LIPSTICKS

Product Type:

Anhydrous Hot Pour

Filling cleaning:

Flush- hot Mineral oil
RM#92574-00 or Dimethicone RM# 98508-00 (Primary formula ingredient*)
Clean - Risil Mat (2-3%) or Blast/Spectak (3 - 5 %)
Not required(Hot process)

Filling sanitizing:

Flash Point:

>150C

Meltdown Temp:

Min(C°):	88.00	Max(C°):	92.00	Target(C°):	90.00
Min(F°):	190.40	Max(F°):	197.60	Target(F°):	194.00

Meltdown Instructions:

REMELT TEMPERATURE: 88-92C
TRANSFER LINE: 83-85C
COLD TANK: 12-18C (Target 18C)
HOT TANK: 27-29C
LINE SPEED: 40 PIECES/MINUTE
WATER/SARTO COOLANT LEVEL = MAXIMUM WEIR HEIGHT
SURFACE HEATER SETTING (PRIOR TO BACK FILL) HEATER #1 = 100% HEATER #2 = OFF
AIR PRESSURE = 0.75-1.25 LBS PSI

Fill Temp:

Min(C°):	81.00	Max(C°):	83.00	Target(C°):	82.00
Min(F°):	177.80	Max(F°):	181.40	Target(F°):	179.60

Fill Instructions:

FILLING TEMPERATURE: 81-83C
CRITICAL NOTE: FILLING TEMPERATURES AND BREAK/SQUEEZE SPECIFICATIONS ARE SPECIFIC TO THE CREME OR PEARL FORMULAS. REFER TO BOTTOM LABEL TO ENSURE THAT THE PRODUCT IS LABELED AS "CREME" BEFORE USING THE BELOW SPECIFICATIONS.
BULK MAY BE HELD HOT FOR 8 HOURS. SALVAGE 10% MAX. CHARGE ENTIRE STORAGE CONTAINER INTO THE REMELT KETTLE PRIOR TO THE BEGINNING OF THE REMELT CYCLE. REFER TO REMELT PROCEDURE LS-003.

A CUSTOMIZED LINE EQUIPPED WITH PISTON FILL HEAD, INFRA-RED HEAT BULBS, HEAT LAMPS, COOLING TUNNEL AND HIGH EFFICIENCY SURFACE HEATER. POSITIVE DISPLACEMENT-TYPE TRANSFER PUMP OR POINT-TYPE FILLER.

Finished Goods

Specifications:

Break/Squeeze: 0.5" LIPSTICK BULLETS @ 20C
AVERAGE BREAKAGE 6 LIPSTICK BULLETS (1 HOUR): 1.0-1.50
AVERAGE SQUEEZE 6 LIPSTICK BULLETS (1 HOUR): 6.0-9.0

Description:

Product Category: LIPSTICKS

Product Type:

Anhydrous Hot Pour

Filling cleaning:

Flush- hot Mineral oil
RM#92574-00 or Dimethicone RM# 98508-00 (Primary formula ingredient*)
Clean - Risil Mat (2-3%) or Blast/Spectak (3 - 5 %)
Not required(Hot process)

Filling sanitizing:

Flash Point:

>150C

Meltdown Temp:

Min(C°):	88.00	Max(C°):	90.00	Target(C°):	89.00
Min(F°):	190.40	Max(F°):	194.00	Target(F°):	192.20

Meltdown Instructions:

SL CREME FORMULA:
REMELT TEMPERATURE: 88-92C
TRANSFER LINE: 83-85C
COLD TANK: 12-15C
HOT TANK: 27-29C
LINE SPEED: 40 PIECES/MINUTE
WATER/SARTO COOLANT LEVEL = MAXIMUM WEIR HEIGHT
SURFACE HEATER SETTING (PRIOR TO BACK FILL) HEATER #1 = 100% HEATER #2 = OFF
AIR PRESSURE = 0.75-1.25 LBS PSI
VARIABLE SPEED ANCHOR-TYPE AGITATION WITH BOTTOM-CONTACT SCRAPER BLADE OR OTHER APPROVED AGITATION.

Fill Temp:

Min(C°):	82.00	Max(C°):	84.00	Target(C°):	83.00
Min(F°):	179.60	Max(F°):	183.20	Target(F°):	181.40

quality team is asking if we can combine our in process checklist/record sheet (SAR sheet) with the RPPS document. Meaning we put in some area for the operator to write the temperatures/ torques/ weights on this printed document directly

Status: **Approved**

Fill Instructions: Fill temp range: 82-84C

Suitable re-melt/molding kettle equipped with fluid-heated jacket, variable speed anchor-type agitation with bottom contact scraper blade, or equivalent

CRITICAL NOTE: FILLING TEMPERATURES AND BREAK/SQUEEZE SPECIFICATIONS ARE SPECIFIC TO THE CREME OR PEARL FORMULAS. REFER TO BOTTOM LABEL TO ENSURE THAT THE PRODUCT IS LABELED AS "CREME" BEFORE USING THE BELOW SPECIFICATIONS.

BULK MAY BE HELD HOT FOR 8 HOURS. SALVAGE 10% MAX. CHARGE ENTIRE STORAGE CONTAINER INTO THE REMELT KETTLE PRIOR TO THE BEGINNING OF THE REMELT CYCLE. REFER TO REMELT PROCEDURE LS-003.

A CUSTOMIZED LINE EQUIPPED WITH PISTON FILL HEAD, INFRA-RED HEAT BULBS, HEAT LAMPS, COOLING TUNNEL AND HIGH EFFICIENCY SURFACE HEATER. POSITIVE DISPLACEMENT-TYPE TRANSFER PUMP OR POINT-TYPE FILLER.

Finished Goods

Specifications:

Break/Squeeze:

COLOR: TMS

ODOR: FRAGRANCE-FREE

APPEARANCE: SOLID

CHATILLON UNIT

0.5" LIPSTICK BULLETS @ 25C

AVERAGE BREAKAGE 6 LIPSTICK BULLETS (1 HOUR): range TBD(16 HOUR): 0.90-1.40

AVERAGE SQUEEZE 6 LIPSTICK BULLETS (1 HOUR): range TBD (16 HOUR): 8.50-10.50

Coding:(For applicable code dates, Revlon Mfg. must retrieve from SAP system; Third Party Mfg. shall refer to TPM Manual for further instructions)

Description: BASE

Coding: Laser Etch

Type:

Batch Code

Size(inch):

1/16

Color:

Placement/Instructions: LASER ETCH BATCH CODE ON SIDE OF BASE. 1/16 MAX.

Label Information:

Description:

Type:

Bottom

Tolerance:

Placement/Instructions: BOTTOM OF BASE, CENTERED

Description:

Type:

UPC Label

Tolerance:

Placement/Instructions: SIDE OF CAP, 1/6 - 1/8 INCH ABOVE METAL BAND, CENTERED TOP TO BOTTOM.

Assembly Instructions:

BULLET INFORMATION: CAVITY = NEW SHAPE (SL), FINISH = SMOOTH, STYLE = SL. POMADE MAX HEIGHT PROTRUDES 1/16 INCH ABOVE TOP SURFACE OF A-SHELL. POMADE MIN HEIGHT SITS 1/16 INCH BELOW A-SHELL. BULLET SHOULD BE FULLY SEATED WITHIN THE CUP. BULLET AESTHETICS TAKE PRECEDENCE OVER FILL WEIGHTS.

APPLY SHRINKBAND: POSITION = FULL LENGTH EXCEPT FOR 1/4 INCH OF THE BASE EXPOSED AT BOTTOM DUE TO PUCK DEPTH. THE SHRINKBAND WILL BE PUSHED FLUSH TO TOP SURFACE OF CAP FOR ACCURACY WHEN PLACED.

Packout Instructions:

PACK WITH BULLET TIP UP IN FLOW WRAP

PACK UPRIGHT INTO SHIPPERS OF UNIFORM COUNT, PER THE SHIPPING INFO BELOW.

PALLET PATTERN AS PER TOPS 7246618000. (IF 2211488000 SHIPPER IS ON THE BOM, USE THE 2ND PAGE OF THE TOPS (LABELED - 7246618000- SHIPPER 221488000).

IF 2240829000 COMES OUT, USE THE FIRST PAGE OF THE ATTACHED TOPS PALLET PATTERN.)

Shipping Info:

Pieces Per Pallet: 33264

Pieces Per Chip: 2

Pieces Per Casepack: 72

Tie:

High:

Linkage to SAP for tech pack data

Revision History:

Revision Date

10/10/2019

Revision History

REVISED TO SHOW UPDATES TO BULK NUMBERS FOR FORMULA UPDATES. K MANSBERGER 10/10/2019

QA Review Comments:

Does not have QA comments because this is not OTC drug

Reviewed By:

Date:

RPPS Request Documents:

RPPS Comments:

need to discuss version control, if live linked document to SAP

Status: Approved

Signed By: Kale Mansberger

Date: 10/10/2019

In the future, we want ability to attach pictures of product standards and other helpful instructions



Revlon

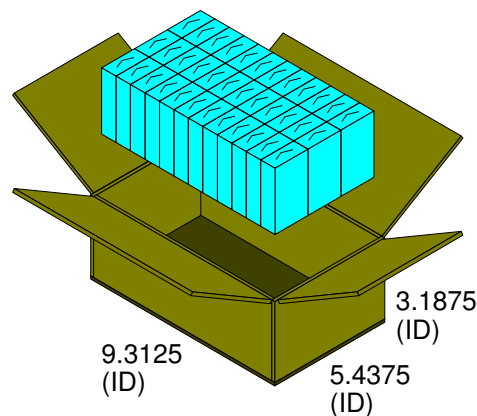
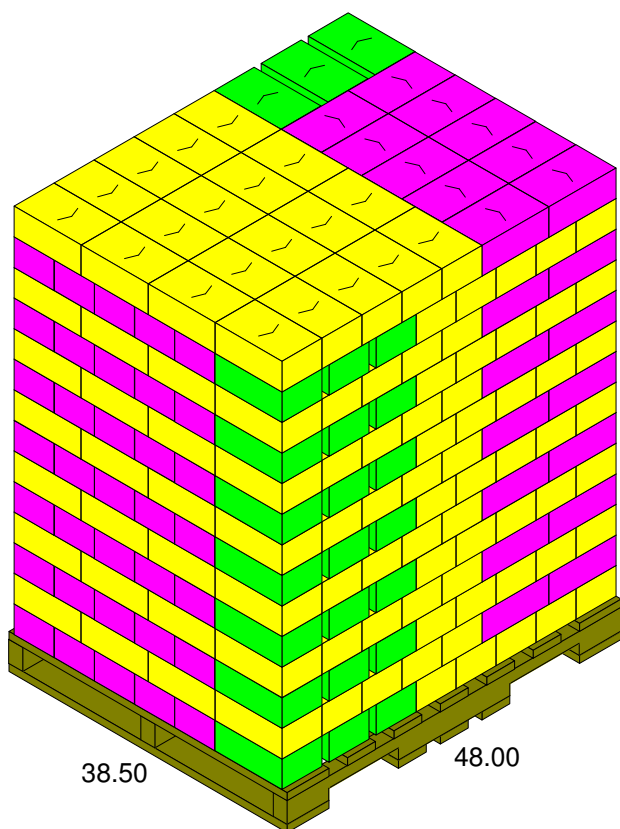
7246618000

Date Printed : 7/1/2019
Last Saved : 6/14/2019

pallet pattern is made in TOPS, then saved to a network folder where KP merges the files together. SAP picks up the merge file and it can be found in CV04N transaction

GMA (Notched) 48.00x40.00x5.00

	Carton (OD)	Shipper (OD)	UnitLoad (Incl. Pal)
Ln:	1.7200 in	5.7500 in	48.00 in
Wd:	0.7552 in	9.6250 in	38.50 in
Ht:	3.0000 in	3.8125 in	58.38 in
Net:	0.00 oz	0.00 lb	0.00 lb
Grs:	0.00 oz	0.29 lb	197.57 lb
Cube:	3.897 in3	0.122 ft3	62.429 ft3
	Height Vert	Height Vert	
Carton:		36	16632
Shipper:			462
Area Efficiency:		92.35 %	95.12 %
Cubic Efficiency:		86.92 %	94.02 %
Cases per layer:			33
Layers/load:			14
Pattern:		3x12x1	Triblock
RSC Area:		2.87 ft2	1326 ft2
Density (gr/cc):		0.0376	



Notes:

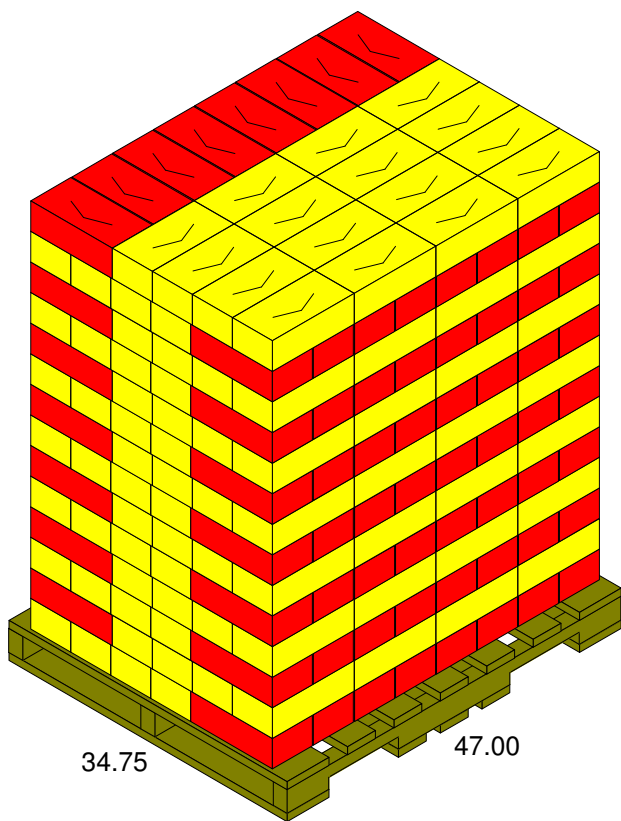


This is a second TOPS because of a material phase out situation. Not a typical scenario, but does occur.

Revlon

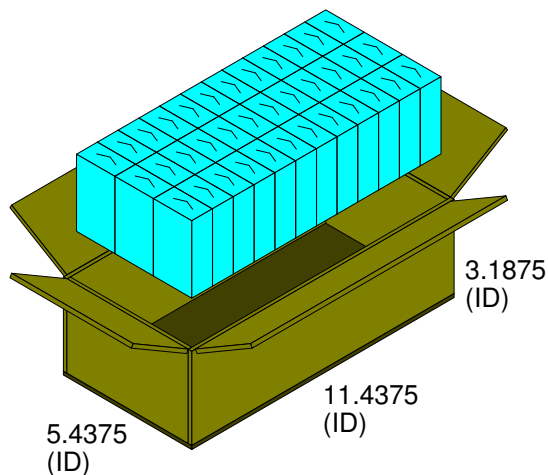
7246618000 -Shipper 2211488000

Date Printed : 7/1/2019
Last Saved : 7/1/2019



GMA (Notched) 48.00x40.00x5.00			
	Carton (OD)	Shipper (OD)	UnitLoad (Incl. Pal)
Ln:	1.7200 in	11.7500 in	47.00 in
Wd:	0.9300 in	5.7500 in	34.75 in
Ht:	3.0000 in	3.8125 in	58.38 in
Net:	0.00 oz	0.00 lb	0.00 lb
Grs:	0.00 oz	0.23 lb	143.09 lb
Cube:	4.799 in3	0.149 ft3	55.174 ft3
	Height Vert	Height Vert	
Carton:		36	12096
Shipper:			336
Area Efficiency:		92.59 %	84.45 %
Cubic Efficiency:		87.15 %	83.47 %
Cases per layer:			24
Layers/load:			14
Pattern:		12x3x1	Interlock
RSC Area:		2.32 ft2	781 ft2
Density (gr/cc):		0.0250	

58.38



Notes: PALLET PATTERN TO BE USED WITH SUBSTITUTE SHIPPER 2211488000 ONLY