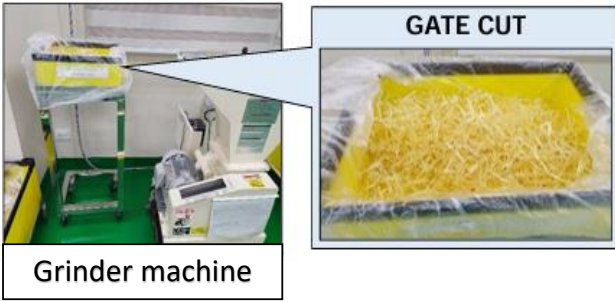

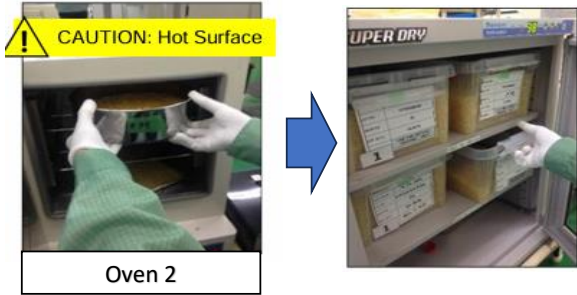
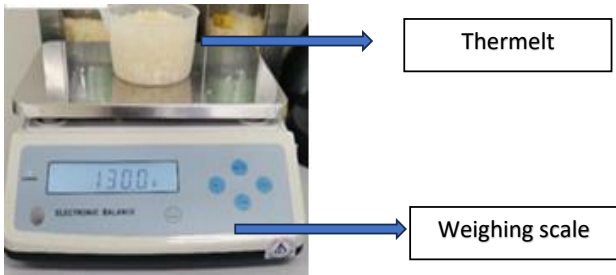
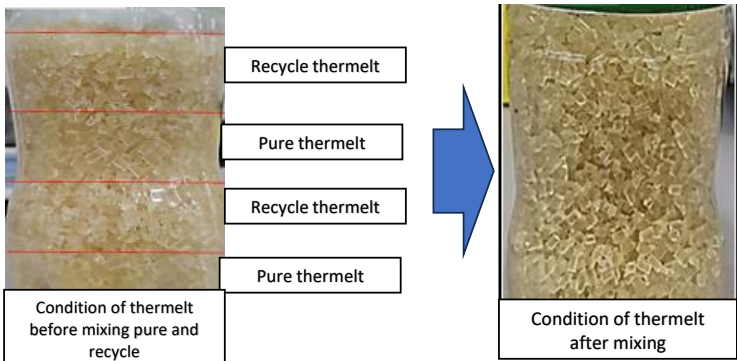
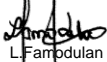

	Process Name/ Title:		Document No:		WI-PRO-SHM-035		
	Mixing Flow		Effective Date:		April 23, 2025		
	WORK INSTRUCTION		Product Code/Name:		Customer Code:		
	ALL		ALL		Rev. No.:	1	Page No.:

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	<p>Grind gate cut using grinder machine.</p> <p>Refer to WI-PRO-SHM-012 on how to operate grinder machine</p>  <p>Grinder machine</p>	
2	<p>Put recycled thermelt into baking strainer for baking and drying and put into the Oven no.2.</p> <p>Refer to WI-PRO-SHM-007 how to operate oven.</p>  <p>5 cups = 1250ml</p>	<p>Note:</p> <p>Stored hours for oven</p> <p>Recycle Thermelt : <u>10 hrs.</u></p> <p>Pure thermelt : <u>12 hrs.</u></p>
3	<p>After drying, transfer the recycled thermelt from baking strainer(oven) to box (desiccator).</p> <p>Refer to WI-PRO-SHM-036 how to observe FIFO</p>  <p>Oven 2</p>	<p>Note :</p> <p>Use of Oven</p> <p>Oven 1 : For pure</p> <p>Oven 2 : For recycle</p>
4	<p>Measure the weight of pure thermelt using weighing scale and prepare the same weight of recycled thermelt as pure thermelt.</p> <p>Refer to WI-PRO-SHM-014 for mixing thermelt procedure</p>  <p>Thermelt</p> <p>Weighing scale</p>	
5	<p>Mix the recycled thermelt and pure thermelt using mixer and put into the PET bottle.</p> <p>Refer to WI-PRO-SHM-014 for mixing thermelt procedure</p>  <p>Recycle thermelt</p> <p>Pure thermelt</p> <p>Recycle thermelt</p> <p>Pure thermelt</p> <p>Condition of thermelt before mixing pure and recycle</p> <p>Condition of thermelt after mixing</p>	<p>Follow FIFO procedure for supplying recycled thermelt from dessicator and refilling to PET bottle to line</p>

						Prepare	Check	Approve
4/23/2025	1	General revision , include illustration,change customer code		L.Famodulan	A.Ayop	W.Carbillon		
7/1/2017	0	Previously established Work Instruction from NBC Japan (for history purpose only)		A. Yocor	O. Merin	T. Suguyama	L.Famodulan	W.Carbillon
Est./Rev. Date	Rev. No.	Details of change		Revise	Check	Approve	Est. Date:	July 1, 2017

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