



Process Name/Title:  
**Way of keeping recycle material's FIFO**

Document No: **WI-PRO-SHM-010**

**WORK INSTRUCTION**

Effective Date: **June 13, 2017**

Product Code/Name:


Customer Code:

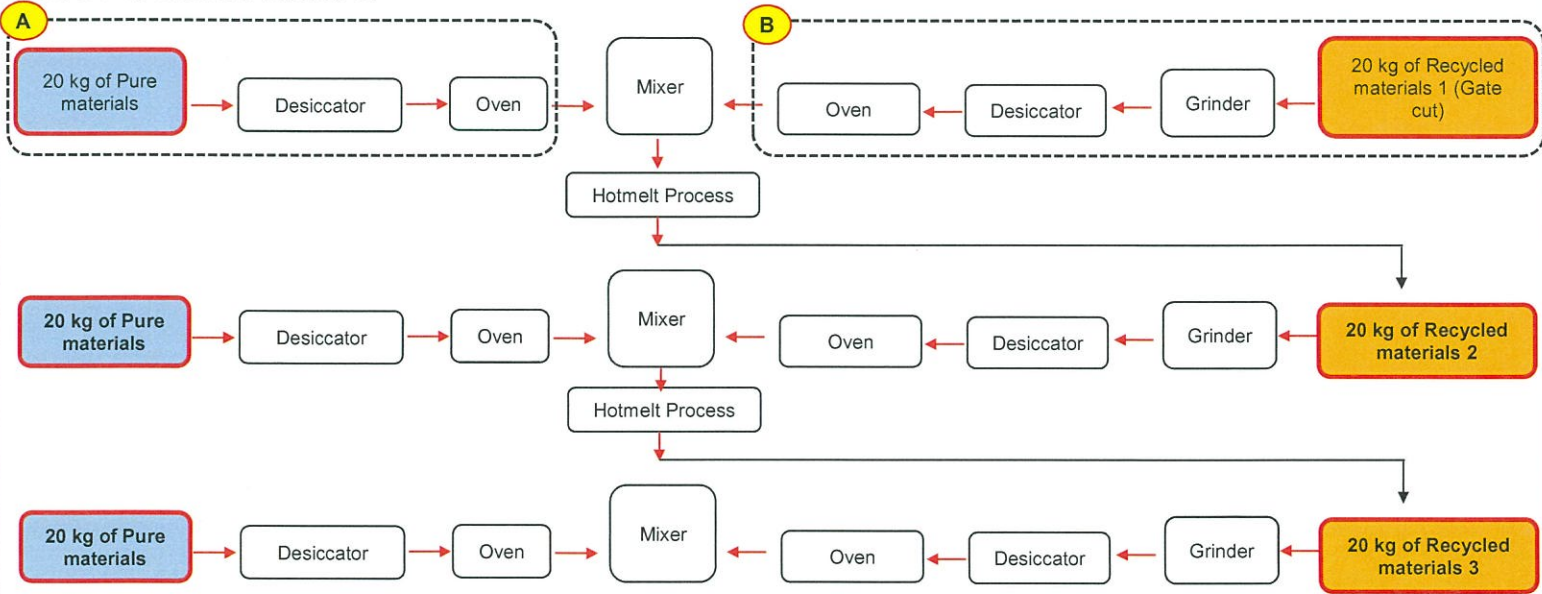
Rev.No.: **0**

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No.	Work Procedure/Illustration	Records/Remarks/Quality Pointers							
1	<p>Prepare 20kg of recycled materials at first.</p> <p>※ Material stored in desiccator which was crushed, and dried absolutely by baking machine.</p> <p>RECYCLED MATERIALS</p> <p>DESICCATOR</p> <p>OVEN</p> <p>Grinder</p> <p>Recycle mat (Gate cut)</p> <p>END</p> <p>EXAMPLE:</p> <p>The yellow tag indicate FIFO</p> <p>Recycle 1 (1/5)</p> <p>Box Order</p> <p>Recycle Sequence Number</p> <p>Total Number of boxes</p> <p>1 2 3</p> <p>4 5</p> <p>RECYCLE 1 (1/5) HATSUMONO RECYCLE 1 (2/5) RECYCLE 1 (3/5)</p> <p>RECYCLE 1 (4/5) RECYCLE 1 (5/5)</p>	<p>Recycle Thermelt can only be used 5 times</p>							
2	<p>Prepare 20kg of pure materials and mixed.</p> <p>Follow instruction #NBPS-9045 [How to mix thermelt by mixer] for mixing.</p> <p>Then use it for production.</p> <p>PURE MATERIALS</p> <p>OVEN</p> <p>DESICCATOR</p> <p>Pure Materials</p> <p>1 2</p> <p>3 4</p> <p>FIRST OUT</p> <p>LAST OUT</p> <p>***Follow the FIFO of pure material on desiccator</p>	<p>NBC (Philippines)</p> <p>MASTER COPY</p>							
Eff. Date	DRCN No.	Rev. No	Details of Change	Prepare	Check	Approve	Prepare	Check	Approve
							J.Ramilo	O. Merin	T. Sugiyama
							Est. date:	06/13/2017	

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3	The remaining 20kg (gate cut) from the process will be mixed with another 20kg of pure materials.	
4	Repeat above process and follow FIFO.	
		<p>Maximum recycle limit is 5 times</p> <p>NBC (Philippines) MASTER COPY</p>