

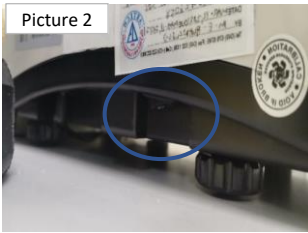
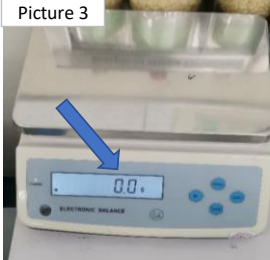
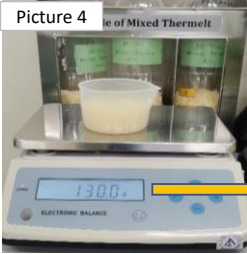


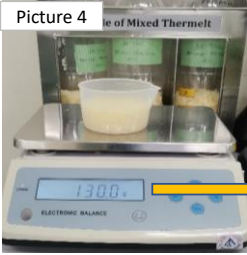




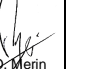
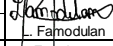
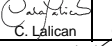
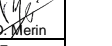
	Process Name/ Title:		Document No:	WI-PRO-SHM-014		
	Mixing Thermelt Procedure		Effective Date:	April 8, 2022		
	WORK INSTRUCTION		Rev. No.:	2		
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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	Put PURE THERMELT into measuring 	Weight of empty cup Standard of Cup : 30g 
2	Turn on weighing scale , set to "0" <i>Note : The power button found under the scale at the right side</i>  	Make sure to confirm weight of recycle thermelt with scale since it is bigger volume than pure thermelt
3	Put cup with PURE THERMELT at the weighing scale 100g ± 10g (weight in weighing scale) Then pour inside the bottle <u>NOTE : 30g. is the measurement of cup</u>  Weight of thermelt + weight of empty cup = 130grms.	Measure materials using weighing scale . Do not measure visually
4	Put GRINDED RECYCLE MATERIAL into measuring cup and put on the weighing scale 100g ± 10g (weight in weighing scale) Then pour into same bottle provided from procedure no. 3  	If volume is not correct ,materials cannot be mixed well even using mixer. So follow rules . * If there is less than half of space ,materials cannot be mixed well . * Must surely mix very well . Use mixer *Make sure cap is properly closed .
5	Put cup another PURE THERMELT at the weighing scale 100g ± 10g (weight in weighing scale) Then pour inside the bottle  Weight of thermelt + weight of empty cup = 130grms.	Ensure that Pure and recycle is alternate in the bottle.
6	Put another GRINDED RECYCLE MATERIAL into measuring cup and put on the weighing scale 100g ± 10g (weight in weighing scale) Then pour into same bottle provided from procedure no. 3  	






04/08/2022	2	General revision based on actual procedure	L. Famodulan	C. Lalican	O. Merin	Prepare	Check	Approve
04/10/2018	1	Add +10g tolerance for 100g weight during weighing of thermelt	M. Demiden	O. Merin	O. Merin			
06/13/2017	0	Established ISO Format	J. Ramilo	O. Merin	T. Sugiyama			
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	06/13/2017	

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No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
7	Refer to picture 7 for the condition after pouring both pure and recycled thermelt in one bottle .	<div>Picture 7</div> 	
8	Set the bottle into mixer Refer to WI-PRO-SHM-013 for the mixer procedure	<div>Picture 8</div>  <div>Picture 9</div>  <div>Picture 10</div> 	Sample mixed of PURE and RECYCLE thermelt
9	Put into the dessicator Refer to WI-PRO-SHM-036 for the Dessicator FIFO . Note : Update Label if not same Recycle no.	<div>Picture 11</div>  <div>Picture 12</div> 