Product Name												Prepared	d by Check	Checked by Approve						
Filler Masterbatch						l	CON	ITROL PLA	N			DO	NO	Ţ	T COPY					
	Process	Process Name/	Machine, Device,		Characteris	stics	Special		Metho	ods				ibility						
Process Number	Flow	Operation Description	Jig,Tools For Manufacturing	No.	Product	Process	Char. Class	Product/Process	Evaluation Measurement		nple	1	l Method	F	Reaction plan					
	Main	·	Ū					Specification/Tolerance	Technique	Size	Freq.	Manuf.	Q.C	Re						
1	\Diamond	Incoming		01	Visual Control			PigmentFillerAdditive	Code No.Lot. R/MQuantity	1	Bag	WH-P-001 WH-F-001 ใบส่งของ Invoice PO COA	1		Return Supplier / Record Incoming Material (WH-F-					
				02	Weighting			± 1%	• Scales	25 kg.		WH-F-001		\triangle	002)					
2	\Diamond	RM/QC		01	Mixing RM			Pigment 0.1 g.Ti02 0.9 g.HPPE 100 g.Zinestearate 0.065 g.	• Two roll mill	1	Chip		LA-W-004 LA-S-009 LA-W-032 LA-P-003	0						
		1411740		02	Measure △E			Delta E 0.5-3.00	Spectrophotometer	·	Omp		LA-S-003 CIE Lab WH-F-002 Sticker		Warehouse R/M					
3		RM/PREPARATI ON		01	Weighting		SC	• ± 0.01 kg./60 kg. • ± 0.5 g ./7.5 kg	Scales	1	Time	WH-W-003 PL-F-002 PL-F-003								
4		Mixing	High Speed Mixer	01	Mix			Amp Meter 20-40 Amp.	High Speed Mixer	1	Time	PD-P-001 PD-P-002 PD-W-038 PD-W-039 PD-F-009 PD-F-024 PD-F-033 PD-F-035 PD-F-041 PD-S-002 PL-F-002			Rerun Process					

Responsibility symbol ; \triangle = Warehouse Operator

▲ = Warehouse Manager

○ = QC & Lap Operator

● = QC & Lap Manager

 \square = Production Operator

Product Name							_					Prepared			Approved by
	Filler Mast					CON	ITROL PLA	N			DO	NO	Ţ	COPY	
	Process	Process Name/	Machine, Device,		Characteri	stics	Special		Metho	ds				ibility	
Process Number	Flow	Operation Description	Jig,Tools For Manufacturing	No.	Product	Process	Char. Class	Product/Process	Evaluation Measurement	San	nple	Contro	Method		Reaction plan
	Main		3					Specification/Tolerance	Technique	Size	Freq.	Manuf.	Q.C		
٠			FARREL	01	Gravimetric Feeder		Max Load 80%	Max Load 80%	Single Screw Extruder Twin Screw Extruder			PD-P-001 PD-P-002 PD-W-027 PD-W-031 PD-F-003 PL-F-002			
5		Feeder	TEK96	02	Gravimetric Feeder		- SC	Max Load 80%	Single Screw Twin Screw	1	Time	PD-F-011 PD-F-016 PD-F-024 PD-F-029 PD-S-002 PL-F-002		-	Rerun Process
6		Mixing	FARREL	01	Kneader		SC	• Max 625 rpm.	Twin Screw	1	Time	PD-P-001 PD-P-002 PD-W-027 PD-W-031 PD-F-003 PL-F-002			Rerun Process
			FARREL	01	Extrude			• 1,300-2,500 kg./ Hrs. • Temperature Min 100 °C • Temperature Max 250 °C				PD-P-001 PD-P-002 PD-W-003 PD-W-005 PD-W-008 PD-W-027 PD-W-031			
7		Extrusion	TEK96	02	Extrude			• 700-1,000 kg./ Hrs. • Temperature Min 150 °C • Temperature Max 260 °C		1	Time	PD-F-003 PL-F-002 PD-F-011 PD-F-016 PD-F-024 PD-F-029 PD-S-002 PL-F-002			Rerun Process

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Product Name												Prepare			Approved by
	Filler Mast		CONTROL PLAN									NO	T	COPY	
	Process	Process Name/	Machine, Device,		Characteris	stics	Special		Method	ds				ibility	
Process Number	Flow	Operation Description	Jig,Tools For	No.	Product	Process	Char. Class	Product/Process	Evaluation Measurement	Sar	nple	Contro	l Method	Responsibility	Reaction plan
	Main	Doomption	Manadaming	140.	rioddol	1100033	Olado	Specification/Tolerance	Technique	Size	Freq.	Manuf.	Q.C	Res	
8		Cooling &	Underwater	01	Visual Control			N-A	• Speed 1,000-2,900 rpr	N/A	N/A	PD-W-027			Rerun Process
		Pelletizing	Pelletizer	02	Visual Control			N-A	• Speed 600-850 rpm.	N/A	N/A	PD-W-008			Rerun Process
	_			01	Delta E (Color Shade)			0.5-3.00	Spectrophotometer				LA-P-003 LA-W-040 LA-W-041		
				02	Dispersion			Visual	Micoscope				CIE Lab LA-W-020 LA-W-031	0	AdJUST Rerun LA-F-006
9	$ \diamond \rangle$	Final Test		03	Homogeneity Contamination		SC	Visual	Magnifier	1	Chip		LA-F-006 LA-F-003 LA-F-005)3	(QC-Report) Add Rerun By Bland
				04	Moisture			≤ 0.2 %	KARL FISCHER MOISTURE BALANCE				LA-W-019 Sticker		By Blatiu
				05	Bulk Density test			Customer STD Spec	Bulk Density				LA-W-006 LA-W-005		
				06	Density test			Customer STD Spec	Density				LA-W-026 LA-W-009		
				07	Ash Conten			Customer STD Spec	Furnance				LA-W-039 LA-S-011		
				08	Additive Conten]	Customer STD Spec	• HPLC				ISO18553 (AS DINEN-		
				09	Filter Value			Customer STD (< 2 bar)	• Filter test				13900-6)		
				10	Dispersion Index			Visual	• Film Blowing						
				11	OIT			Customer STD Spec	• Film Blowing						

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Product Name							_					Prepared	by Che	cked by	Approved by
	Filler Mast	erbatch					CON	TROL PLA	N			DO	NC	T	COPY
	Process	Process Name/	Machine, Device,		Characteris	stics	Special		Metho	ds				ponsibility	
Process Number	Flow	Operation	Jig,Tools For		Decile	D	Char.	Product/Process	Evaluation	San	nple	Control	Method	suod	Reaction plan
	Main	Description	Manufacturing	No.	Product	Process	Class	Specification/Tolerance	Measurement Technique	Size	Freq.	Manuf.	Q.C	L (A	
10		Packing		01	Weighting			10 g.	Scales Visual	1	Bag	PD-W-028 PD-W-055 PD-F-012 PD-F-018 PD-F-021 PD-F-023 PD-F-030 PD-S-002 PL-F-002 Sticker			Rework

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