




Product Name			CONTROL PLAN										Prepared by	Checked by	Approved by
Filler Masterbatch															
Process Number	Process Flow	Process Name/ Operation Description	Machine, Device, Jig, Tools For Manufacturing	Characteristics			Special Char. Class	Methods						Responsibility	Reaction plan
	Main			No.	Product	Process		Product/Process Specification/Tolerance	Evaluation Measurement Technique	Sample		Control Method			
										Size	Freq.	Manuf.	Q.C		
1		Incoming		01	Visual Control			<ul style="list-style-type: none"> Pigment Filler Additive 	<ul style="list-style-type: none"> Code No. Lot. R/M Quantity 	1	Bag	WH-P-001 WH-F-001 ใบส่งของ Invoice PO COA		▲	Return Supplier / Record Incoming Material (WH-F-002)
				02	Weighting			± 1%	<ul style="list-style-type: none"> Scales 	25 kg.		WH-F-001		▲	
2		RM/QC		01	Mixing RM			<ul style="list-style-type: none"> Pigment 0.1 g. TiO2 0.9 g. HPPE 100 g. Zinestearate 0.065 g. 	<ul style="list-style-type: none"> Two roll mill 	1	Chip		LA-W-004 LA-S-009 LA-W-032 LA-P-003 LA-S-003 CIE Lab WH-F-002 Sticker	○	Return Warehouse R/M
				02	Measure ΔE			Delta E 0.5-3.00	<ul style="list-style-type: none"> Spectrophotometer 					●	
3		RM/PREPARATI ON		01	Weighting		SC	<ul style="list-style-type: none"> ± 0.01 kg./60 kg. ± 0.5 g /7.5 kg 	<ul style="list-style-type: none"> Scales 	1	Time	WH-W-003 PL-F-002 PL-F-003		▲	
4		Mixing	High Speed Mixer	01	Mix			Amp Meter 20-40 Amp.	<ul style="list-style-type: none"> 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-026 PD-F-033 PD-F-035 PD-F-041 PD-S-002 PL-F-002		□	Rerun Process

Responsibility symbol ; ▲ = Warehouse Operator
▲ = Warehouse Manager

○ = QC & Lap Operator
● = QC & Lap Manager

□ = Production Operator
■ = Production Manager

Product Name			CONTROL PLAN										Prepared by	Checked by	Approved by
Filler Masterbatch															
Process Number	Process Flow	Process Name/ Operation Description	Machine, Device, Jig, Tools For Manufacturing	Characteristics			Special Char. Class	Methods						Responsibility	Reaction plan
	Main			No.	Product	Process		Product/Process Specification/Tolerance	Evaluation Measurement Technique	Sample		Control Method			
										Size	Freq.	Manuf.	Q.C		
5		Feeder	FARREL	01	Gravimetric Feeder		SC	• Max Load 80%	• Single Screw Extruder • Twin Screw Extruder	1	Time	PD-P-001 PD-P-002 PD-W-027 PD-W-031 PD-F-003 PL-F-002 PD-F-011 PD-F-016 PD-F-024 PD-F-029 PD-S-002 PL-F-002		<input type="checkbox"/> <input checked="" type="checkbox"/>	Rerun Process
			TEK96	02	Gravimetric Feeder			• Max Load 80%	• Single Screw • Twin Screw						
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		<input type="checkbox"/>	Rerun Process
7		Extrusion	FARREL	01	Extrude			• 1,300-2,500 kg./ Hrs. • Temperature Min 100 °C • Temperature Max 250 °C	• Single Screw Extruder	1	Time	PD-P-001 PD-P-002 PD-W-003 PD-W-005 PD-W-008 PD-W-027 PD-W-031 PD-F-003 PL-F-002 PD-F-011 PD-F-016 PD-F-024 PD-F-029 PD-S-002 PL-F-002	<input type="checkbox"/> <input checked="" type="checkbox"/>	Rerun Process	
			TEK96	02	Extrude		• 700-1,000 kg./ Hrs. • Temperature Min 150 °C • Temperature Max 260 °C	• Twin Screw Extruder							

Responsibility symbol ; = Warehouse Operator



= QC & Lap Operator



☐ = Production Operator


= Warehouse Manager

= QC & Lap Manager



☒ = Production Manager



Product Name			CONTROL PLAN										Prepared by	Checked by	Approved by		
Filler Masterbatch																	
Process Number	Process Flow	Process Name/ Operation Description	Machine, Device, Jig, Tools For Manufacturing	Characteristics			Special Char. Class	Methods						Responsibility	Reaction plan		
	Main			No.	Product	Process		Product/Process Specification/Tolerance	Evaluation Measurement Technique	Sample		Control Method					
										Size	Freq.	Manuf.	Q.C				
8		Cooling & Pelletizing	Underwater Pelletizer	01	Visual Control			N-A	• Speed 1,000-2,900 rpm	N/A	N/A	PD-W-027		<input type="checkbox"/>	Rerun Process		
				02	Visual Control			N-A	• Speed 600-850 rpm.	N/A	N/A	PD-W-008		<input type="checkbox"/>	Rerun Process		
9		Final Test		01	Delta E (Color Shade)		SC	0.5-3.00	• Spectrophotometer	1	Chip		LA-P-003 LA-W-040 LA-W-041 CIE Lab LA-W-020 LA-W-031 LA-F-006 LA-F-003 LA-F-005	<input type="radio"/>	AdJUST Rerun LA-F-006 (QC-Report) Add Rerun By Bland		
				02	Dispersion			Visual	• Micoscope								
				03	Homogeneity Contamination			Visual	• Magnifier								
				04	Moisture			≤ 0.2 %	• KARL FISCHER • MOISTURE BALANCE								
				05	Bulk Density test			Customer STD Spec	• Bulk Density								
				06	Density test			Customer STD Spec	• Density								
				07	Ash Conten			Customer STD Spec	• Furnance								
				08	Additive Conten			Customer STD Spec	• HPLC								
				09	Filter Value			Customer STD (< 2 bar)	• Filter test								
				10	Dispersion Index			Visual	• Film Blowing								
				11	OIT			Customer STD Spec	• Film Blowing								

Responsibility symbol ;  = Warehouse Operator = Warehouse Manager = QC & Lap Operator = QC & Lap Manager = Production Operator = Production Manager

Product Name			CONTROL PLAN						Prepared by		Checked by		Approved by		
Filler Masterbatch									DO NOT COPY						
Process Number	Process Flow	Process Name/ Operation Description	Machine, Device, Jig, Tools For Manufacturing	Characteristics			Special Char. Class	Methods						Responsibility	Reaction plan
	Main			No.	Product	Process		Product/Process Specification/Tolerance	Evaluation Measurement Technique	Sample		Control Method			
										Size	Freq.	Manuf.	Q.C		
10		Packing		01	Weighting			10 g.	<ul style="list-style-type: none"> • 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		<input type="checkbox"/> <input checked="" type="checkbox"/>	Rework

Responsibility symbol ;  = Warehouse Operator
 = Warehouse Manager

 = QC & Lap Operator
 = QC & Lap Manager

 = Production Operator
 = Production Manager