










ต้นฉบับ



Product Name			CONTROL PLAN												ต้นฉบับ	
Additive 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				
1		Incoming		01	Visual Control			• Pigment • Filler • Additive	• 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%	• Scales	25 kg.		WH-F-001		△ ▲		
2		RM/QC		01	Mixing RM			• Pigment 0.1 g. • TiO2 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 LA-S-003 CIE Lab WH-F-002 Sticker	○ ●	Return Warehouse R/M	
				02	Measure ΔE			Delta E 0.5-3.00	• Spectrophotometer							
3		RM/PREPARATION		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			Batch Size 5 - 250 kg.  Amp Meter 0 - 80 Amp.  Speed 450 - 1750 rpm.	• 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      ○ = QC & Lap Operator      □ = Production Operator  
 ▲ = Warehouse Manager      ● = QC & Lap Manager      ■ = Production Manager

Product Name			CONTROL PLAN												
Additive 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-065 PD-W-031 PD-F-051 PD-F-011 PD-F-016 PD-F-024 PD-S-002 PL-F-002		<input type="checkbox"/> <input checked="" type="checkbox"/>	Rerun Process
6		Mixing	FARREL	01	Kneader		SC	• Max 750 rpm.	• Twin Screw	1	Time	PD-P-001 PD-P-002 PD-W-065 PD-W-031 PD-F-051 PL-F-002		<input type="checkbox"/>	Rerun Process
7		Extrusion	FARREL	01	Extrude			• 1,300-2,700 kg./ Hrs. • Temperature Min 100 °C • Temperature Max 260 °C (Temperature ± 20 °C)	• Single Screw Extruder	1	Time	PD-P-001 PD-P-002 PD-W-065 PD-W-031 PD-F-051 PD-F-011 PD-F-016 PD-F-024 PD-S-002 PL-F-002		<input type="checkbox"/> <input checked="" type="checkbox"/>	Rerun Process
8		Cooling & Pelletizing	Underwater Pelletizer	01	Visual Control			N-A	• Speed 1,000-3,500 rpm.	N/A	N/A	PD-W-065		<input type="checkbox"/> <input checked="" type="checkbox"/>	Rerun Process



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 = Warehouse Manager



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Product Name			CONTROL PLAN												
Additive 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			
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  LA-W-019  Sticker LA-W-006 LA-W-005 LA-W-026 LA-W-009 LA-W-039 LA-S-011 ISO18553 (AS DINEN-13900-6)	<div><div></div><div></div></div>	AdJUST Rerun LA-F-006 (QC-Report) Add Rerun By Bland
02				Dispersion		Visual		• Microscope							
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							
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	<div><div></div><div></div></div>	Rework	

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