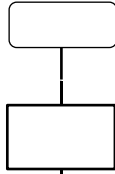
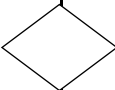
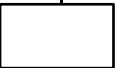
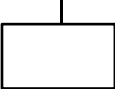
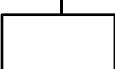
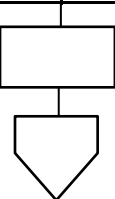
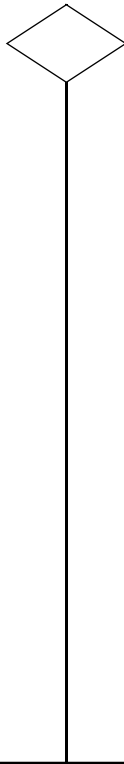
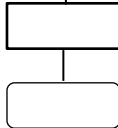


Product Name		PROCESS FLOW CHART			
Colour Masterbatch		ต้นฉบับ			
Step	Graphical Symbol	Process Name	Equipment	Key Product & Key Control Characteristics	Corrective Action
1		Start  Raw Material Received	Scales	• Code No., Quantity  • Weighting ± 1 % / Container	Return Supplier / Record Incoming Material  (WH-F-002)
2		Incoming Inspection	Two Roll Mill  Spectrophotometer	• Mixing RM Temperature 150-200 °C  • Delta E (Color Shade) 0.5-3.00	Report To Warehouse
3		Material Preparation	Scales	• Weighting ± 0.5 g./ 7.5 kg.  • Weighting ± 0.01 kg./ 60 kg.	
4		Mixing	High Speed Mixer	• Max 100 kg./ Batch  • Amp Meter 20-70 Amp.	
5		Extrusion	Twin Screw Extruder	• 25-300 kg./ Hrs.  • Temperature 100-300 °C	Rerun Process
6		Cooling & Pelletizing	Water bath & Pelletizer	• Speed 300-1,300 rpm.	Rerun Process

Product Name		PROCESS FLOW CHART			
Colour Masterbatch					
Step	Graphical Symbol	Process Name	Equipment	Key Product & Key Control Characteristics	Corrective Action
7		Final Inspection	Spectrophotometer Microscope Magnifier Karl Fischer Moisture Balance Bulk Density Tester Density Tester Furnance High Performance Liquid Chromatography (HPLC) Filter Test Film Blowing Differential Scanning Calorimeter (DSC)	<ul style="list-style-type: none"><li>• Delta E (Color Shade)</li><li>• Dispersion</li><li>• Homogeneity</li><li>• Contamination</li><li>• Moisture</li><li>• Bulk Density</li><li>• Density</li><li>• Ash Content</li><li>• Additive Content</li><li>• Filter Value</li><li>• Dispersion Index</li><li>• Oxidation Induction Time (O.I.T)</li></ul>	Adjust/ Rerun/ Record QC-Report (LA-F-006)
8		Packing  End	Scales	<ul style="list-style-type: none"><li>• Weighting/ Identify Tag &amp; Lable</li></ul>	Standard Packaging Operation