Product Name							CON	NTROL PLAI	NI (์ ทันฉ	จา๊ดเ				
Additive Filler Masterbatch							COI	NIKOL PLAI	(ทนน	עע				
Drasses	Process s Flow	Process Name/	Machine,Device	Characteristics		Special		Methods							
Process Number		Operation Description	Jig,Tools For	No.	Product	Process	Char. Class	Product/Process	Evaluation	San	nple	Contro	Method	Responsibilit v	Reaction plan
	Main	Description	Manufacturing	NO.	Floduct	FIOCESS	Class	Specification/Tolerance	Measurement Technique	Size	Freq.	Manuf.	Q.C	Res	
1	\Diamond	Incoming		01	Visual Control			PigmentFillerAdditive	Code No. Lot. R/M Quantity	1	Bag	WH-P-001 WH-F-001 ใบส่งของ Invoice PO COA		<u>△</u>	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	Return
				02	Measure △E			Delta E 0.5-3.00	Spectrophotometer				LA-S-003 CIE Lab WH-F-002 Sticker		Warehouse R/M
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		\triangle	
4		Mixing	High Speed Mixer	01	Mix			Amp Meter 20-70 Amp.	High Speed Mixer	1	Time	PD-P-001 PD-P-002 PD-W-038 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 ; \triangle = Warehouse Operator

▲ = Warehouse Manager

○ = QC & Lap Operator

● = QC & Lap Manager

 \square = Production Operator

= Production Manager

Product Name							CON	NTROL PLAI	N						
Additive Filler Masterbatch							COI	TINOL I LAI							
	Process	Process Name/	Machine,Device	Characteristics			Special		Method	S				ibilit	
Process Number	Flow	Operation Description	Jig,Tools For	No.	Product	Process	Char. Class	Product/Process	Evaluation Measurement		nple		Method		Reaction plan
	Main		Manufacturing		1 100001	1 100000		Specification/Tolerance	Technique	Size	Freq.	Manuf.	Q.C	Re	
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			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			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			Rerun Process
8		Cooling & Pelletizing	Underwater Pelletizer	01	Visual Control			N-A	• Speed 1,000-3,500 rpr	N/A	N/A	PD-W-065			Rerun Process

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Product Name						CON		N							
Additive	Additive Filler Masterbatch		CONTROL PLAN												
Process	Process	Process Name/ Operation Description	Machine,Device	Characteristics			Special		Method	ls				ibilit	Desetion
Number	FIOW		Jig,Tools For	No.	Product	Process	Char. Class	Product/Process	Evaluation Measurement Technique		nple	Control Method		Responsibilit V	Reaction plan
	Main	Description	Manufacturing	INO.	rioduct	1100633	Olass	Specification/Tolerance		Size	Freq.	Manuf.			
9				01	Delta E (Color Shade)		SC	0.5-3.00	Spectrophotometer				LA-P-003 LA-W-040 LA-W-041	10	
	^			02	Dispersion			Visual	Micoscope				CIE Lab LA-W-020 LA-W-031	0	AdJUST Rerun LA-F-006
	\Diamond	Final Test		03	Homogeneity Contamination			Visual	Magnifier				LA-F-006 LA-F-003 LA-F-005	3	(QC-Report) Add Rerun
				04	Moisture			≤ 0.2 %	KARL FISCHER MOISTURE BALANCE	1	Chip		LA-W-019		By Bland
				05	Bulk Density test			Customer STD Spec	Bulk Density				Sticker LA-W-006 LA-W-005	06 05 26	
				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- 13900-6)		
				09	Filter Value			Customer STD (< 2 bar)	• Filter test						
				10	Dispersion Index			Visual	• Film Blowing						
				11	OIT			Customer STD Spec	• Film Blowing						

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Product Name Additive Filler Masterbatch							CON	ITROL PLA	N						
Process Number	Process Flow	Process Name/	Machine,Device		Characteris	stics	Special		Method					ponsibilit y	Reaction
	Main	Operation Description	Jig,Tools For Manufacturing	No.	Product	Process	Char. Class	Product/Process Specification/Tolerance	Evaluation Measurement Technique	Size	rple Freq.	Control Manuf.	Q.C	Respor	plan
10		Packing		01	Weighting			10 g.	Scales Visual	1	Bag	PD-W-028 PD-W-055 PD-F-012 PD-F-021 PD-F-023 PD-F-030 PD-S-002 PL-F-002 Sticker			Rework

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