Product Name						CON	ITROL PLAN	J	<b>စုံ</b> ၅	นฉา	ไ <b>ท</b> ี				
Black Fille	er Masterb	atch						TINGE I EAT	•	VII	M MI	עי			
Process	Process Flow	Process Name/	Machine, Device,		Characteris	stics	Special		Methods	5				Responsibility	- ·
Number	FIOW	Operation	Jig,Tools For		Б.,		Char. Class	Product/Process	Evaluation	San	nple	Contro	l Method	Suoc	Reaction plan
	Main	Description	Manufacturing	No.	Product	Process	Class	Specification/Tolerance	Measurement Technique	Size	Freq.	Manuf.	Q.C	Res	
1	$\Diamond$	Incoming		01	Visual Control			<ul><li>Pigment</li><li>Filler</li><li>Additive</li></ul>	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- 002)
				02	Weighting			± 1%	• Scales	25 kg.		WH-F-001		$\triangle$	002)
2	$\Diamond$	RM/QC		01	Mixing RM			<ul><li>Pigment 0.1 g.</li><li>Ti02 0.9 g.</li><li>HPPE 100 g.</li><li>Zinestearate 0.065 g.</li></ul>	• 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-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

= Production Manager

● = QC & Lap Manager

▲ = Warehouse Manager

	Product Name						001	ITDOL DI AA							
Black Fille	r Masterba	atch					CON	ITROL PLAN	N.						
	Process	Process Name/	Machine, Device,		Characteris	tics	Special		Methods					ibility	Danation
Process Number	Flow	Operation Description	Jig,Tools For Manufacturing	No.	Product	Process	Char. Class	Product/Process Specification/Tolerance	Evaluation Measurement	Sam	i	Control		Responsibility	Reaction plan
5	Main	Feeder	FARREL	01	Gravimetric Feeder		SC	Max Load 80%	Technique  Single Screw Extruder Twin Screw Extruder	Size	Freq.	Manuf.  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	Q.C	■ □ Re	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	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 250-4,500 rpm.	N/A	N/A	PD-W-065			Rerun Process

Responsibility symbol ;  $\triangle$  = Warehouse Operator

○ = QC & Lap Operator

☐ = Production Operator

▲ = Warehouse Manager

= QC & Lap Manager

= Production Manager

Product N	Name						CO1	ITDOL DI AA	ı						
Black Fille	er Masterb	CONTROL PLAN													
Drassas	Process	Process Name/	Machine, Device,		Characteris	stics	Special		Method	S				Responsibility	Desetion
Process Number	Flow	Operation Description	Jig,Tools For Manufacturing	No.	Product	Process	Char. Class	Product/Process	Evaluation Measurement	Sar	nple	Contro	l Method	Suod	Reaction plan
	Main	Description	Wandlacturing	INO.	Product	Process	Class	Specification/Tolerance	Technique	Size	Freq.	Manuf.	Q.C	Res	
9				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	(QC-Report) Add Rerun
	$  \diamondsuit  $	Final Test	O3 Homogeneity Contamination  O4 Moisture	03				Visual	Magnifier				LA-F-006 LA-F-003 LA-F-005	•	
					SC	≤ 0.2 %	KARL FISCHER     MOISTURE     BALANCE	1	Chip		LA-W-019		By Bland		
				05	Bulk Density test		-	Customer STD Spec	Bulk Density	1			Sticker LA-W-006		
				06	Density test		_	Customer STD Spec	Density				LA-W-005 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						

Responsibility symbol ;  $\triangle$  = Warehouse Operator

se Operator O = QC & Lap Operator

☐ = Production Operator

▲ = Warehouse Manager

● = QC & Lap Manager

= Production Manager

Product Name  Black Filler Masterbatch							CON	ITROL PLAN	I							
	Process Flow	Process Name/	Machine, Device,		Characteris	tics	Special		Methods	3				sibility	Atiii Reaction plan	
Process Number	1 1000	Operation Description	Jig,Tools For Manufacturing	No.	Product	Process	Char. Class	Product/Process	Evaluation Measurement		nple	Contro	l Method	book	plan	
	Main	2000	g	140.	1 Toddot	1 100000	0.000	Specification/Tolerance	Technique	Size	Freq.	Manuf.	Q.C	Resp		
10		Packing		01	Weighting				<ul><li>Scales</li><li>Visual</li></ul>	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	

Responsibility symbol ;  $\triangle$  = Warehouse Operator

▲ = Warehouse Manager

= QC & Lap Operator= QC & Lap Manager

= Production Operator

= Production Manager