








ต้นฉบับ

Product Name			CONTROL PLAN													ต้นฉบับ	
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			<ul style="list-style-type: none"><li>• Pigment</li><li>• Filler</li><li>• Additive</li></ul>	<ul style="list-style-type: none"><li>• Code No.</li><li>• Lot. R/M</li><li>• Quantity</li></ul>	1	Bag	WH-P-001 WH-F-001 ใบส่งของ Invoice PO COA		<div>△</div> <div>▲</div>	Return Supplier / Record Incoming Material (WH-F-002)		
				02	Weighting			± 1%	<ul style="list-style-type: none"><li>• Scales</li></ul>	25 kg.		WH-F-001		<div>△</div> <div>▲</div>			
2		RM/QC		01	Mixing RM			<ul style="list-style-type: none"><li>• Pigment 0.1 g.</li><li>• TiO2 0.9 g.</li><li>• HPPE 100 g.</li><li>• Zinestearate 0.065 g.</li></ul>	<ul style="list-style-type: none"><li>• Two roll mill</li></ul>	1	Chip	LA-W-004 LA-S-009 LA-W-032 LA-P-003 LA-S-003 CIE Lab WH-F-002 Sticker	<div>○</div> <div>●</div>	Return Warehouse R/M			
				02	Measure ΔE			Delta E 0.5-3.00	<ul style="list-style-type: none"><li>• Spectrophotometer</li></ul>								
3		RM/PREPARATION		01	Weighting		SC	<ul style="list-style-type: none"><li>• ± 0.01 kg./60 kg.</li><li>• ± 0.5 g ./7.5 kg</li></ul>	<ul style="list-style-type: none"><li>• Scales</li></ul>	1	Time	WH-W-003 PL-F-002 PL-F-003		<div>△</div> <div>▲</div> <div></div>			
4		Mixing	High Speed Mixer	01	Mix			Batch Size 5 - 250 kg.  Amp Meter 0 - 80 Amp.  Speed 450 - 1750 rpm.	<ul style="list-style-type: none"><li>• High Speed Mixer</li></ul>	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	<div>□</div> <div>■</div>	Rerun Process			



Responsibility symbol △ = Warehouse Operator  
▲ = Warehouse Manager

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


□ = Production Operator  
■ = Production Manager



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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	• 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 250-4,500 rpm.	N/A	N/A	PD-W-065		<input type="checkbox"/> <input checked="" type="checkbox"/>	Rerun Process



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									Size	Freq.	Manuf.	Q.C			
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	<div><div></div><div></div></div> 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	LA-W-019						
			05	Bulk Density test		Customer STD Spec		• Bulk Density	Sticker LA-W-006						
			06	Density test		Customer STD Spec		• Density	LA-W-005						
			07	Ash Conten		Customer STD Spec		• Furnance	LA-W-026						
			08	Additive Conten		Customer STD Spec		• HPLC	LA-W-009						
			09	Filter Value		Customer STD (< 2 bar )		• Filter test	LA-W-039						
			10	Dispersion Index		Visual		• Film Blowing	LA-S-011						
			11	OIT		Customer STD Spec		• Film Blowing	ISO18553						

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10		Packing		01	Weighting			1 g.	<ul style="list-style-type: none"><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	<div><input type="checkbox"/> <input checked="" type="checkbox"/></div>	Rework	

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 = Warehouse Manager       = QC & Lap Manager       = Production Manager