







Product Name			CONTROL PLAN												
Additive Filler Masterbatch			ต้นฉบับ												
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">• Pigment• Filler• Additive	<ul style="list-style-type: none">• Code No.• Lot. R/M• Quantity	1	Bag	WH-P-001 WH-F-001 ใบส่งของ Invoice PO COA		<div>△▲</div>	Return Supplier / Record Incoming Material (WH-F-002)
				02	Weighting			± 1%	<ul style="list-style-type: none">• Scales	25 kg.		WH-F-001		<div>△▲</div>	
2		RM/QC		01	Mixing RM			<ul style="list-style-type: none">• Pigment 0.1 g.• TiO2 0.9 g.• HPPE 100 g.• Zinestearate 0.065 g.	<ul style="list-style-type: none">• 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	<div>○●</div>	Return Warehouse R/M
				02	Measure ΔE			Delta E 0.5-3.00	<ul style="list-style-type: none">• Spectrophotometer						
3		RM/PREPARATION		01	Weighting		SC	<ul style="list-style-type: none">• ± 0.01 kg./60 kg.• ± 0.5 g ./7.5 kg	<ul style="list-style-type: none">• Scales	1	Time	WH-W-003 PL-F-002 PL-F-003		<div>△▲</div>	
4		Mixing	High Speed Mixer	01	Mix			Amp Meter 20-70 Amp.	<ul style="list-style-type: none">• 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		<div>□■</div>	Rerun Process



Responsibility symbol ; △ = Warehouse Operator
▲ = Warehouse Manager



○ = QC & Lap Operator
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5		Feeder	FARREL	01	Gravimetric Feeder		SC	<ul style="list-style-type: none">Max Load 80%	<ul style="list-style-type: none">Single Screw ExtruderTwin 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		<div><input type="checkbox"/><input checked="" type="checkbox"/></div>	Rerun Process
6		Mixing	FARREL	01	Kneader		SC	<ul style="list-style-type: none">Max 750 rpm.	<ul style="list-style-type: none">Twin Screw	1	Time	PD-P-001 PD-P-002 PD-W-065 PD-W-031 PD-F-051 PL-F-002		<div><input type="checkbox"/><input checked="" type="checkbox"/></div>	Rerun Process
7		Extrusion	FARREL	01	Extrude			<ul style="list-style-type: none">1,300-2,700 kg./ Hrs.Temperature Min 100 °CTemperature Max 260 °C (Temperature ± 20 °C)	<ul style="list-style-type: none">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		<div><input type="checkbox"/><input checked="" type="checkbox"/></div>	Rerun Process
8		Cooling & Pelletizing	Underwater Pelletizer	01	Visual Control			N-A	<ul style="list-style-type: none">Speed 1,000-3,500 rpm	N/A	N/A	PD-W-065		<div><input type="checkbox"/><input checked="" type="checkbox"/></div>	Rerun Process



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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>	AdJUST Rerun LA-F-006 (QC-Report) Add Rerun By Bland
02				Dispersion		Visual		• Micoscope					LA-W-019		
03				Homogeneity Contamination		Visual		• Magnifier					Sticker LA-W-006		
04				Moisture		≤ 0.2 %		• KARL FISCHER • MOISTURE BALANCE					LA-W-005		
05				Bulk Density test		Customer STD Spec		• Bulk Density					LA-W-026		
06				Density test		Customer STD Spec		• Density					LA-W-009		
07				Ash Conten		Customer STD Spec		• Furnance					LA-S-011		
08				Additive Conten		Customer STD Spec		• HPLC					ISO18553		
09				Filter Value		Customer STD (< 2 bar)		• Filter test					(AS DINEN-13900-6)		
10				Dispersion Index		Visual		• Film Blowing							
11				OIT		Customer STD Spec		• Film Blowing							



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										Size	Freq.	Manuf.	Q.C		
10		Packing		01	Weighting			10 g.	<ul style="list-style-type: none">• 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><input type="checkbox"/> <input checked="" type="checkbox"/></div>	Rework

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