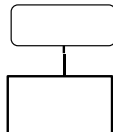




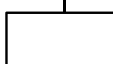
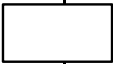
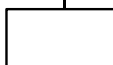
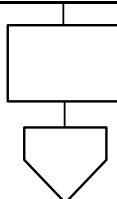

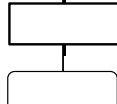


| Product Name | | PROCESS FLOW CHART | | | |
|--------------------|---|--------------------------------|------------------------------------|--|--|
| Filler Masterbatch | | | | | |
| Step | Graphical Symbol | Process Name | Equipment | Key Product & Key Control Characteristics | Corrective Action |
| 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 120-300 °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 |  | Feeder | Gravimetric Feeder | • Max Load 80% | |
| 6 |  | Mixing | Kneader | • Max 625 rpm. | |
| 7 |  | Extrusion | Single Screw Extruder | • 1,300-2,500 kg./ Hrs. • Temperature 100-250 °C | Rerun Process |
| |  | Extrusion | Twin Screw Extruder | • 700-1,000 kg./ Hrs. • Temperature 150-260 °C | Rerun Process |

| Product Name | | PROCESS FLOW CHART | | | |
|--------------------|---|-----------------------|---|--|---|
| Filler Masterbatch | | | | | |
| Step | Graphical Symbol | Process Name | Equipment | Key Product & Key Control Characteristics | Corrective Action |
| 8 |  | Cooling & Pelletizing | Underwater Pelletizer | <ul style="list-style-type: none">• Speed 1,000 - 2,900 rpm.• Speed 600 - 850 rpm. | Rerun Process |
| 9 |  | Final Inspection | <div>Spectrophotometer</div> <div>Microscope</div> <div>Magnifier</div> <div>Karl Fischer</div> <div>Moisture Balance</div> <div>Bulk Density Tester</div> <div>Density Tester</div> <div>Furnance</div> <div>High Performance Liquid</div> <div>Chromatography (HPLC)</div> <div>Filter Test</div> <div>Film Blowing</div> <div>Differential Scanning</div> <div>Calorimeter (DSC)</div> | <ul style="list-style-type: none">• Delta E (Color Shade)• Dispersion• Homogeneity• Contamination• Moisture• Bulk Density• Density• Ash Content• Additive Content• Filter Value• Dispersion Index• Oxidation Induction Time (O.I.T) | Adjust/ Rerun/ Record QC-Report (LA-F-006) |
| 10 |  | Packing | Scales | <ul style="list-style-type: none">• Weighting/ Identify Tag & Lable | Standard Packaging Operation |
| | | End | | | |