










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					
										Size	Freq.	Manuf.	Q.C				
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/PREPARATI ON		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>			
4		Mixing	High Speed Mixer	01	Mix			Amp Meter 20-70 Amp.	<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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										Size	Freq.	Manuf.	Q.C		
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-027 PD-W-031 PD-F-003 PL-F-002 PD-F-011 PD-F-016 PD-F-024 PD-F-029 PD-S-002 PL-F-002	<div><input type="checkbox"/> <input checked="" type="checkbox"/></div>	Rerun Process	
		TEK96	02	Gravimetric Feeder		• Max Load 80%		• Single Screw • Twin Screw							
6		Mixing	FARREL	01	Kneader		SC	• Max 625 rpm.	• Twin Screw	1	Time	PD-P-001 PD-P-002 PD-W-027 PD-W-031 PD-F-003 PL-F-002	<div><input type="checkbox"/></div>	Rerun Process	
7		Extrusion	FARREL	01	Extrude			• 1,300-2,500 kg./ Hrs. • Temperature Min 100 °C • Temperature Max 250 °C	• Single Screw Extruder	1	Time	PD-P-001 PD-P-002 PD-W-003 PD-W-005 PD-W-008 PD-W-027 PD-W-031 PD-F-003 PL-F-002 PD-F-011 PD-F-016 PD-F-024 PD-F-029 PD-S-002 PL-F-002	<div><input type="checkbox"/> <input checked="" type="checkbox"/></div>	Rerun Process	
			TEK96	02	Extrude			• 700-1,000 kg./ Hrs. • Temperature Min 150 °C • Temperature Max 260 °C	• Twin Screw Extruder						


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										Size	Freq.	Manuf.	Q.C		
8		Cooling & Pelletizing	Underwater Pelletizer	01	Visual Control			N-A	• Speed 1,000-2,900 rpm	N/A	N/A	PD-W-027		<input type="checkbox"/> <input checked="" type="checkbox"/>	Rerun Process
				02	Visual Control			N-A	• Speed 600-850 rpm.	N/A	N/A	PD-W-008		<input type="checkbox"/> <input checked="" type="checkbox"/>	Rerun Process
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	<input type="radio"/> <input checked="" type="radio"/>	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 LA-W-005		
				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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
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										Size	Freq.	Manuf.	Q.C		
10		Packing		01	Weighting			10 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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