Product Name							001	ITDOL DI AL	. •		ສັ້ນເຂົ	ุ่งข้า				
Filler Maste	rbatch						COr	NTROL PLAI	N		я ич	תתי				
D	Proces s Flow	Process Name/	Machine, Device		Characteris	stics	Special		Methods	3				Responsibility		
Process Number	S Flow	Operation Description	, Jig,Tools For	No.	Product	Dragon	Char. Class	Product/Process	Evaluation Measurement	San	nple	Contro	Method	Doous	Reaction plan	
	Main	Description	Manufacturing	INO.	Product	Process	Class	Specification/Tolerance	Technique	Size	Freq.	Manuf.	Q.C	Res		
1	\Diamond	Incoming		01	Visual Control			Pigment Filler Additive	Code No. Lot. R/M Quantity	1	Bag	WH-P-001 WH-F-001 ใบส่งของ Invoice PO COA			Return Supplier / Record Incoming Material (WH-F-	
				02	Weighting			± 1%	Scales	25 kg.		WH-F-001		\triangle	002)	
2	\Diamond	RM/QC		01	Mixing RM			Pigment 0.1 g.Ti02 0.9 g.HPPE 100 g.Zinestearate 0.065 g.	Two roll mill	1	Chip		LA-W-004 LA-S-009 LA-W-032 LA-P-003	009 032 003	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		<u>△</u>		
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							00:	ITDOL DI AT							3-02-23/00/03	
Filler Maste	Filler Masterbatch			CONTROL PLAN												
Danasas	Proces s Flow	Process Name/	Machine,Device		Characteris	stics	Special		Methods					bility	Desetion	
Process Number		Operation Description	, Jig,Tools For Manufacturing	No.	Product	Process	Char. Class	Product/Process Specification/Tolerance	Evaluation Measurement	San	Ī	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-016 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-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

▲ = Warehouse Manager

= QC & Lap Operator= QC & Lap Manager

☐ = Production Operator

■ = Production Manager

Product Name															
Filler Maste	Filler Masterbatch						CON	NTROL PLAI	N						
D	Proces	Process Name/	Machine,Device	Characteristics			Special		Methods					ibility	Desetion
Process Number	s Flow Main	Operation Description	, Jig,Tools For Manufacturing	No.	Product	Process	Char. Class	Product/Process Specification/Tolerance	Evaluation Measurement Technique	San Size	rple Freq.	Control Manuf.	Method Q.C	Responsibility	Reaction plan
9				01	Delta E (Color Shade)			0.5-3.00	Spectrophotometer				LA-P-003 LA-W-040 LA-W-041	<u>«</u>	
				02	Dispersion		Visual	Micoscope	•			CIE Lab LA-W-020 LA-W-031	ab 20	AdJUST Rerun LA-F-006	
	$ \diamondsuit $	Final Test		03	Homogeneity Contamination		SC	Visual	Magnifier	1			LA-F-006 LA-F-003 LA-F-005	:	(QC-Report) Add Rerun By Bland
				04	Moisture			≤ 0.2 %	KARL FISCHER MOISTURE BALANCE		Chip		LA-W-019 Sticker		ву Біапи
				05	Bulk Density test			Customer STD Spec	Bulk Density				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-		
				09	Filter Value			Customer STD (< 2 bar)	• Filter test				13900-6)		
				10	Dispersion Index			Visual	• Film Blowing						
		nhol : A — Ware		11	OIT	. & Lan One		Customer STD Spec	• Film Blowing						

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= Production Manager

Product Name							CO1	ITROL DI AI	\1						
Filler Masterbatch							CON	ITROL PLAI	N						
Dragon	Proces s Flow	Process Name/	Machine, Device		Characteris	tics	Special		Methods					Responsibility	Donation
Process Number	S Flow	Operation	, Jig,Tools For				Char.	Product/Process	Evaluation	San	nple	Control	Method	ons	Reaction plan
Trainiso.	Main	Description	Manufacturing	No.	Product	Process	Class	Specification/Tolerance	Measurement Technique	Size	Freq.	Manuf.	Q.C	Resp	
10		Packing		01	Weighting			1 g.	Scales Visual	1	Bag	PD-W-028 PD-W-055 PD-F-012 PD-F-018 PD-F-021 PD-F-030 PD-S-002 PL-F-002 Sticker			Rework

Responsibility symbol ; \triangle = Warehouse Operator

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= QC & Lap Operator= QC & Lap Manager

☐ = Production Operator

= Production Manager