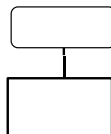



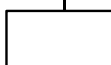
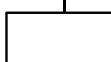
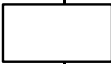
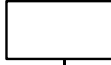
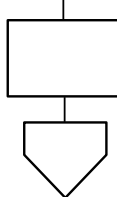

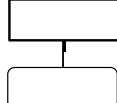


Product Name		PROCESS FLOW CHART			Prepared by	Checked by	Approved by
Filler Masterbatch					DO NOT COPY		
Step	Graphical Symbol	Process Name	Equipment	Key Product & Key Control Characteristics	Corrective Action		
1		Start Raw Material Received	Scales	<ul style="list-style-type: none">• Code No., Quantity• Weighting ± 1 % / Container	Return Supplier / Record Incoming Material (WH-F-002)		
2		Incoming Inspection	Two Roll Mill Spectrophotometer	<ul style="list-style-type: none">• Mixing RM Temperature 120-300 °C• Delta E (Color Shade) 0.5-3.00	Report To Warehouse		
3		Material Preparation	Scales	<ul style="list-style-type: none">• Weighting ± 0.5 g./ 7.5 kg.• Weighting ± 0.01 kg./ 60 kg.			
4		Mixing	High Speed Mixer	<ul style="list-style-type: none">• Max 100 kg./ Batch• Amp Meter 20-40 Amp.			
5		Feeder	Gravimetric Feeder	<ul style="list-style-type: none">• Max Load 80%			
6		Mixing	Kneader	<ul style="list-style-type: none">• Max 625 rpm.			
7		Extrusion	Single Screw Extruder	<ul style="list-style-type: none">• 1,300-2,500 kg./ Hrs.• Temperature 100-250 °C	Rerun Process		
		Extrusion	Twin Screw Extruder	<ul style="list-style-type: none">• 700-1,000 kg./ Hrs.• Temperature 150-260 °C	Rerun Process		

Product Name		PROCESS FLOW CHART			Prepared by	Checked by	Approved by
Filler Masterbatch					DO NOT COPY		
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					