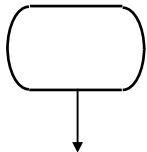
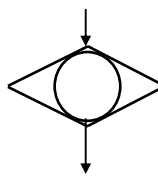
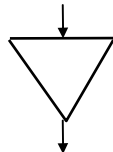
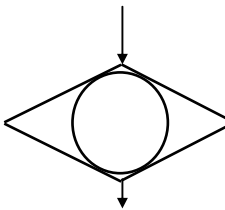


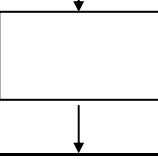


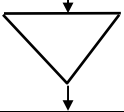







## A/ Material receipt

SYNOPTIC MANUFACTURING - CONTROL Extrusion Unit	PIECE	OP NB	Operation	Process Parameters Product Features	Machine Mean Tool	Maintenance Sheet	Bolt	Reference Document	Process Product Follow-up	Picking size/frequency per level			Reaction Plan	Archiving
										1	2	3		
Granulated raw material administrative receipt  (Silos and bags)	Raw material	Op. 12	Transport & delivery note control	Material Nb & tonnage			Padlock on the silos  Buffer zone	Transport and delivery note	Supplier analysis certificate			●  Per material batch	Express some reservations  Registered letter with receipt confirmation within 48 H	5 years
Receipt control 		Op. 13	Picking for control and tests	Extrusion test  MFI  Density	Extrusion machine  Melt index  Scales		Padlock on the silos  Bag buffer zone	Raw material technical specification  AQ/PO- SOF/033/G "Control and tests in receipt" procedure	Laboratory control report			●  Per material batch	NO DEROGATION ALLOWED - AQ/PO- SOF/034/B supplier non conformity management	5 years
Raw material storage  (in silos or bags)		Op. 14	Unloading material in silo: "Accepted" label stocken and storage	Unloading in accordance with AQ/IT-SOF/02A procedure			Padlock on the silos "Accepted" label on the pallet		Traceability book Receipt folder			●  Per material batch	In accordance with AQ1/IT/SOF/02/A procedure	

## B/ Scroll extrusion and cut

SYNOPTIC MANUFACTURING - CONTROL Extrusion Unit	PIECE	OP	Operation	Process Parameters Product Features	Machine  Mean  Tool	Maintenance  Sheet	Bolt	Reference  Document	Process	Picking size/frequency			Reaction	Archiving	
		NB							Product	per level					Plan
		Follow-up							1	2	3				
<div>Tooling assembly</div> <div></div> <div>Starting</div> <div></div> <div></div> <div></div> <div>Mass production start</div> <div></div>	Scroll	OP. 11	Tooling set-up	Tooling  Nb	Extrusion machine  Rotary blade cutting tool	Log book  and Tooling sheets	buffer zone bunker + tool prison	Manufacturing order  Tooling using procedure  Assembling sheet		<div><div></div><div></div></div>		Tooling prison in accordance with SM/MO-SOF/584/H procedure	Tooling life		
										Every assemblings					
		OP. 15 & 16	Manufacturing order Manufacturing launching	Temperature Pressure Screw rotation speed Time  Aspect, cut quality, burr  Dimensions I.C: ID thickness length overlap %  Weight	Tempera- ture, speed and pressure indicators  Visual and standard part  Calliper Ruler Coned measuring rod  Scales	Control tool gauging	Temperature, and pressure alarms	Manufacturing order Manufacturing sheet  - Control sheet: Nb GC/SCROLL/G EN/OR - Control card: Nb CC/SCROLL/G EN/OR	Log book  Control card: Nb CC/SCROLL/ GEN/OR	<div><div></div><div></div></div>	Each launching			Internal non conformity management in accordance with AQ1/IT/SOF/12B procedure	Quality follow-up sheet and process control card: 5 years
OP. 17	Mass production: Extrusion + cut	Temperature Pressure Screw rotation speed Time  Aspect, cut quality, burr  Dimensions I.C: ID thickness length overlap %  Weight	Temperature , speed and pressure indicators  Visual and standard part  Calliper Ruler Coned measuring rod  Scales	Control tool gauging	Temperature and pressure alarms	Manufacturing sheet  - Control sheet: Nb GC/SCROLL/G EN/OR - Control card: Nb CC/SCROLL/G EN/OR	Log book  Control card: Nb CC/SCROLL/ GEN/OR	<div><div></div><div></div></div>	1 part per packing unit						

SYNOPTIC MANUFACTURING - CONTROL Extrusion Unit	PIECE	OP	Operation	Process Parameters Product Features	Machine Mean Tool	Maintenance sheet	Bolt	Reference  document	Process	Picking size/frequency	Reaction	Archiving						
		NB							Product				Follow-up	per level	plan			
														1	2	3		
Process audit		Scroll	18 A OP.	Process control by audit	Audit criterion				Manufacturing sheet	Quality follow- up sheet				Internal non conformity management in accordance with AQ1/IT/SOF/12B procedure	5 years			
Product process			18 B OP.	Product control by audit	I.C dimensions: diameter thickness length overlap %  Aspect and burrs Cut quality Material centring	Calliper and ruler  Standard part  Visual	Gauging of control tool	- Control sheet: Nb GC/SCROLL/G EN/OR - Control card: Nb CC/SCROLL/G EN/OR - Scroll drawing	Quality follow- up sheet	Product audit card MSP follow- up <b>I.C</b>	1 Audit per week							
																1 per year		
Packaging		19 OP.	Final packaging	Galia label	box or case			Manufacturing order Manufacturing sheet Packaging sheet	Manufacturin g order Nb Description PN Quantity									
1 per packing unit																		
finished product storage		20 OP. 20	Finished product storage	Finished product area Galia label	Area with floor marking		FIFO	Follow-up sheet Galia label					Each manufacturing order					
Shipment preparation		21 & 22 OP.	Preparation and shipment of products	Shipping area	Area with floor marking		FIFO	Delivery note					Each manufacturing order					