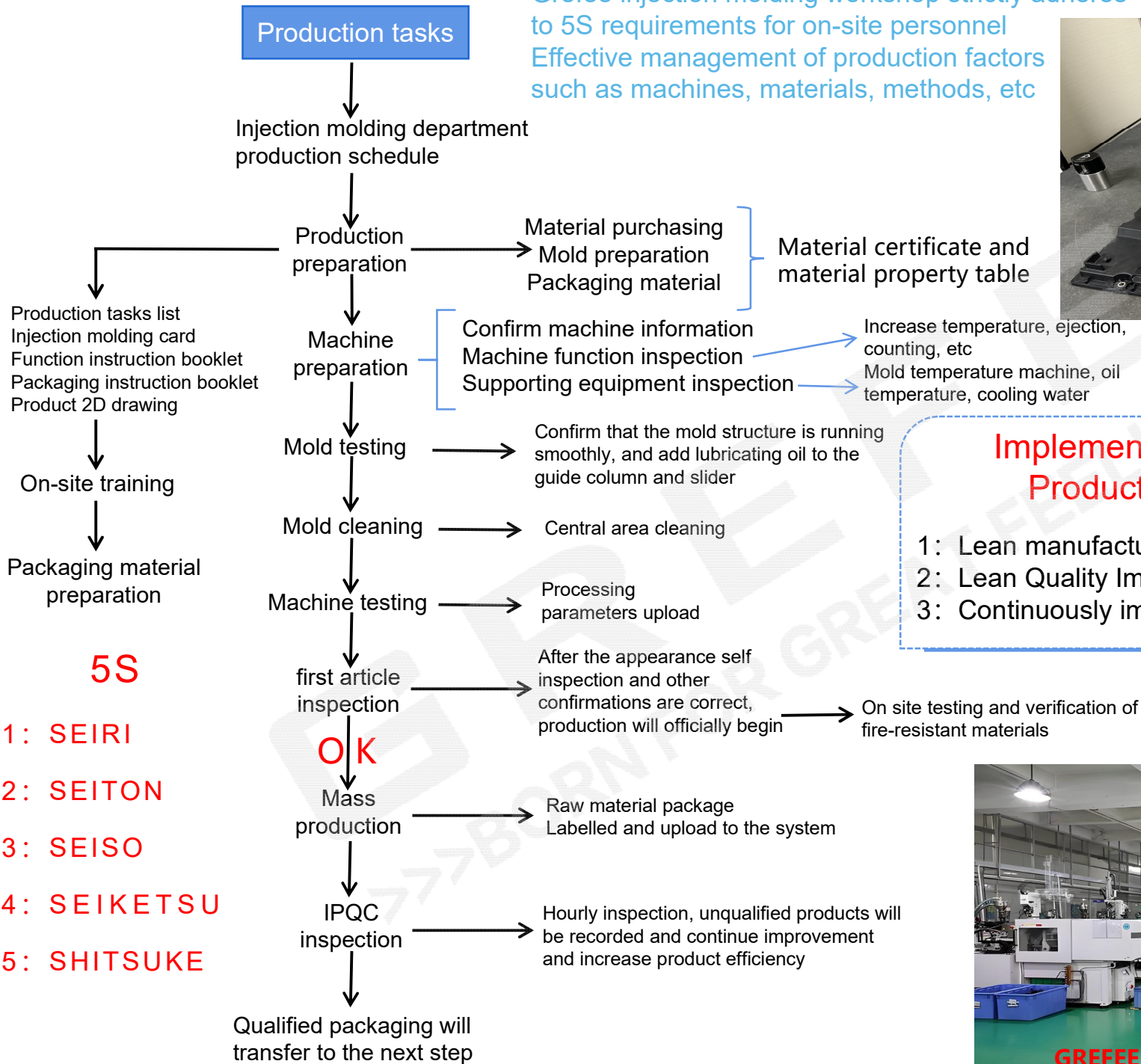


Injection molding management

Greefee injection molding workshop strictly adheres to 5S requirements for on-site personnel Effective management of production factors such as machines, materials, methods, etc



First article inspection



Implementation Objectives of Production Management

- 1: Lean manufacturing to reduce costs
- 2: Lean Quality Improvement
- 3: Continuously improve and increase efficiency

5S

- 1: SEIRI
- 2: SEITON
- 3: SEISO
- 4: SEIKETSU
- 5: SHITSUKE

5S Injection molding workshop



Raw material

Grefee collaborates with various brand raw material suppliers to provide material certification and material property lists, ensuring the quality of materials

Material property table and certificate

All raw materials are photographed and recorded with product numbers and production batches before entering the injection molding machine



VALOXTM FR RESIN 553

Table with 4 columns: PROPERTY, TEST METHOD, RESULT, and UNIT. Contains technical specifications for VALOXTM FR RESIN 553.

VALOXTM FR RESIN 553

Table with 4 columns: PROPERTY, TEST METHOD, RESULT, and UNIT. Contains technical specifications for VALOXTM FR RESIN 553.

Product Quality Document

Certificate of Compliance

Table with columns: Customer Order Number, Customer Part Number, Requirement Number, Material (Grade/Color), Lot Number, Quantity, UOM, Shipped From, SABC Innovative Plastics (Shanghai) Co., Ltd., Manufactured Date, 3-APR-16.

Table with columns: Name of Test, Standard, LSL, USL, Result, UOM. Lists test results for QC, Audit, and TS.

Jean Shao Quality Manager, Edward Yin Plant Manager, SABIC Innovative Plastics (Shanghai) Co., Ltd. Tel: (8621) 5046 0000, Fax: (8621) 5046 0100

LEXAN™ 121 resin

Table with columns: PROPERTY, TEST METHOD, RESULT, and UNIT. Contains technical specifications for LEXAN™ 121 resin.

LEXAN™ 121 resin

Table with columns: PROPERTY, TEST METHOD, RESULT, and UNIT. Contains technical specifications for LEXAN™ 121 resin.

LEXAN™ 121 resin

Table with columns: PROPERTY, TEST METHOD, RESULT, and UNIT. Contains technical specifications for LEXAN™ 121 resin.

IMG20241016203302



IMG20241016203332



IMG20241016203453



IMG20241016203505



IMG20241016203507



12 July 2018, Houston TX, USA. Version 5.8. Subject: Status of our products with respect to REACH SVHC. Dear Most Valued Customer, Thank you for using SABIC Products. SABIC has manufacturing facilities in about 60 locations across 35 countries in the world. We manufacture and sell the CYCOLOGY™, CYCOLOY™, EXTEM™, CELOY™, LEXAN™, NORLY™, NORLY GTX™, NORLY PXX™, ULTEM™, SILTEM™, VALOX™, XENOXY™, XYLEX™ resins and LEXAN™, ULTEM™, VALOX™, THE RAMOCLEAR™, FILMOR and COLOR COMPO™, FARADEX™, KRONIT™, LUBRICOMP™, LUBRILOY™, STAT-KON™, STAT-LOY™, THERMOCOMP™, THERMOFUS™, VERTON™ compounds, SABIC™ PC. All existing grades of the above mentioned Resins / Films / Sheets Compounds, except products which are designed to consume Post Consumer Recycled (PCR), are referred in this document as 'SABIC Products' here after.

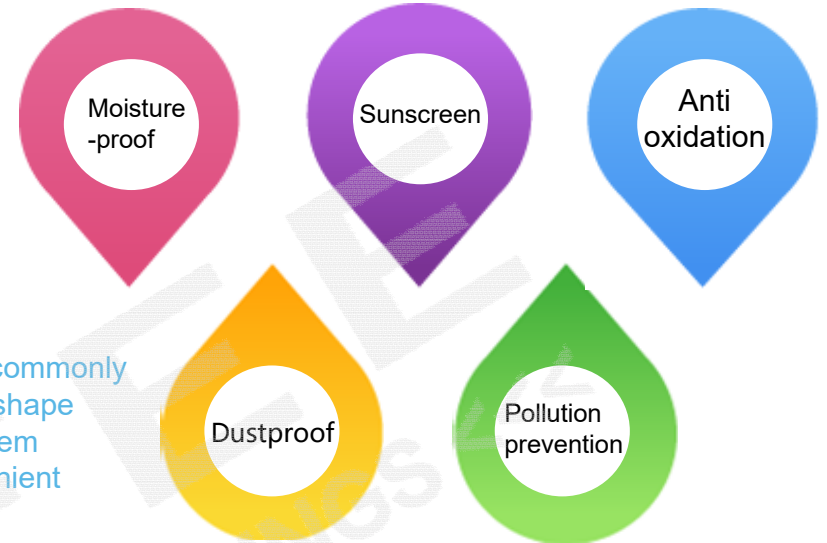
Table with columns: Reference Detail / Reference Regulation, Restricted Substances, Threshold Limits (% w/w). Lists SVHC substances and their thresholds.

Raw material regulation

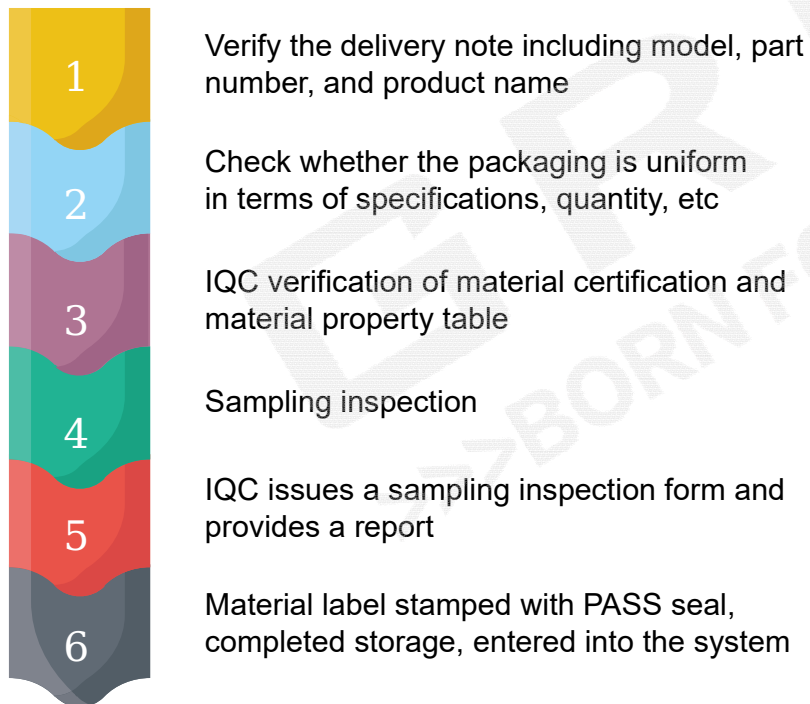


Environmental requirement:
plastic products have high requirements on environment, such as temperature, humidity, cleaning, etc

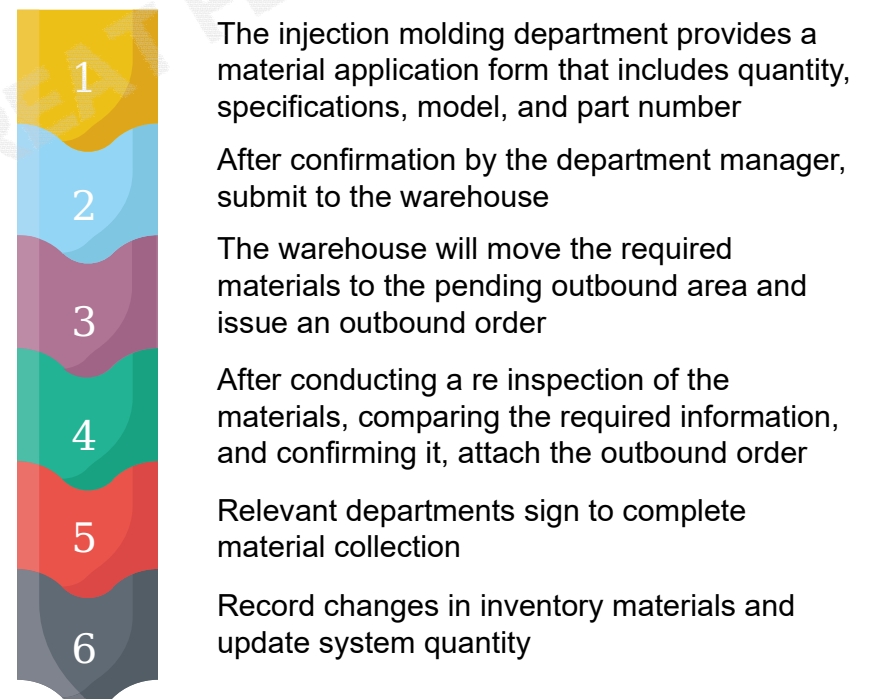
Placement standards based on the inventory records of commonly used materials and the packaging shape
Distinguish the nature and place them according to the standard of convenient storage and retrieval



Material warehousing process



Material outbound process



Production

Before mass production, prepare corresponding instruction manuals to guide production personnel to produce according to standards

Each batch of production will provide pre job training for personnel, and only qualified personnel can enter production positions

To ensure the consistency of each batch of products, we conduct a full inspection of the first piece of each batch to avoid batch abnormalities



Process instruction booklet

	Part name: UPPER COVER		GREFEE GREFEE PRECISION TECHNOLOGY CO., LTD. CNC assembly department
	Process: precision casting		
Working Instructions 1. Before the start of production, the operator shall check the drawings and the work order, and confirm the part number, quantity, and material. If there is any error, it shall be reported to the supervisor immediately. 2. After the mold is prepared, the operator shall check the mold and confirm the mold number, cavity number, and quantity. 3. The operator shall check the material and confirm the material name and specifications. 4. The operator shall check the quantity and confirm the quantity. 5. The operator shall check the quality and confirm the quality. 6. The operator shall check the safety and confirm the safety. 7. The operator shall check the environment and confirm the environment. 8. The operator shall check the equipment and confirm the equipment. 9. The operator shall check the tool and confirm the tool. 10. The operator shall check the parameter and confirm the parameter. 11. The operator shall check the process and confirm the process. 12. The operator shall check the product and confirm the product. 13. The operator shall check the packaging and confirm the packaging. 14. The operator shall check the inspection and confirm the inspection. 15. The operator shall check the storage and confirm the storage. 16. The operator shall check the transportation and confirm the transportation. 17. The operator shall check the delivery and confirm the delivery. 18. The operator shall check the return and confirm the return. 19. The operator shall check the maintenance and confirm the maintenance. 20. The operator shall check the improvement and confirm the improvement. 21. The operator shall check the safety and confirm the safety. 22. The operator shall check the environment and confirm the environment. 23. The operator shall check the equipment and confirm the equipment. 24. The operator shall check the tool and confirm the tool. 25. The operator shall check the parameter and confirm the parameter. 26. The operator shall check the process and confirm the process. 27. The operator shall check the product and confirm the product. 28. The operator shall check the packaging and confirm the packaging. 29. The operator shall check the inspection and confirm the inspection. 30. The operator shall check the storage and confirm the storage. 31. The operator shall check the transportation and confirm the transportation. 32. The operator shall check the delivery and confirm the delivery. 33. The operator shall check the return and confirm the return. 34. The operator shall check the maintenance and confirm the maintenance. 35. The operator shall check the improvement and confirm the improvement.		Product: UPPER COVER Part No: W0310 Qty: 20 Material: 6061-T6 Process: Precision casting Date: 2019-07-11	

Supernumerary training record

生产培训记录 设备型号: HAITLAN250T 培训记录号: HSF-2019-0711-03 培训时间: 2019/7/11 培训地点: 生产培训: 生产任务, 新订单批量生产 注意事项:	
培训大纲: 检查产品外观, 产品表面不能有缩水、凹陷、缺损等缺陷, 套啤金属件不能高出产品表面, 顶针印凸起不能超过0.03mm, 检查密封槽内部是否有缺损	
参加培训人员: 白旗和夜班各1人, IPQC共1人。 实际操作各10啤。	
培训结果: 合格	

First article inspection

首件检验记录表 记录号: HSP20190711-08					
生产任务	物料	规格	图号	工序	数量
设备	规格	图号	工序	数量	日期
1. 文件 是否有二次作业指导书或客户图面? OK 2. 工具 是否有齐全的工器具、夹具、胎具? OK 3. 其它 OK 4. 外观 是否有缩水、凹陷、缺损等缺陷? OK 5. 尺寸 是否合格? OK 6. 性能 是否符合要求? OK 7. 包装 是否符合要求? OK 8. 标识 是否正确? OK 9. 其它 OK					
检验项目: 外观 尺寸 性能 包装 标识 其它 1. 外观 OK 合格 2. 尺寸 OK 合格 3. 性能 OK 合格 4. 包装 OK 合格 5. 标识 OK 合格 6. 其它 OK 合格					
检验结论: 合格					

First article Full inspection size report

Measuring Report				
Customer	Part Name	Part No.	Inspection Date	Inspection Place
Material	Quantity	Inspection Item	Inspection Result	Inspection Method
1. 尺寸 2. 外观 3. 性能 4. 包装 5. 标识 6. 其它				
检验结论: 合格				

IPQC conducts a sampling inspection of all produced products every two hours

Our details also include packaging. We develop corresponding packaging specifications based on the characteristics of the product

For large-scale production projects, update the production schedule daily and share it with customers to help them understand the production progress in real time

Conduct final sampling inspection on products during shipment to ensure that all products meet the requirements

IPQC Inspection Report

IPQC制程巡检记录表					
产品名称	物料号	规格	数量	单位	日期
生产工序	设备	操作者	检验员	检验日期	检验结果
1. 检查产品的数量是否与订单一致。 2. 检查产品的规格是否与物料号一致。 3. 检查产品的尺寸是否符合要求。 4. 检查产品的外观是否有缺陷。 5. 检查产品的性能是否符合要求。 6. 检查产品的包装是否符合要求。 7. 检查产品的标识是否正确。 8. 检查产品的其它要求。 9. 检查产品的安全。 10. 检查产品的环境。 11. 检查产品的设备。 12. 检查产品的工具。 13. 检查产品的参数。 14. 检查产品的过程。 15. 检查产品的产品。 16. 检查产品的包装。 17. 检查产品的检验。 18. 检查产品的存储。 19. 检查产品的运输。 20. 检查产品的交付。 21. 检查产品的返回。 22. 检查产品的维护。 23. 检查产品的改进。					
检验结论: 合格					

Packaging Specification

Packaging instructions			
customer name	W0310	product number	108-8000-001
product name	UPPER COVER	quantity per box	20
packing material	material name: 450 X 210 X 280 paper box	packing specifications	usage per box: 40 sets
1. 将上盖和下盖进行连接 2. 用汽泡膜包裹产品四周 3. 纸糊盒用胶订连接角开 4. 4 pieces per layer, 5 layers per box, total: 40 sets/box 5. The product placement method should be unified, and the quantity of each box should be consistent. 6. Apply box head paper to the I-shaped box seal.			
检验结论: 合格			

Batch Production Schedule

Cavity number	Procedure	Production schedule																				
		06 Feb	07 Feb	08 Feb	09 Feb	10 Feb	11 Feb	12 Feb	13 Feb	14 Feb	15 Feb	16 Feb	17 Feb	18 Feb	19 Feb	20 Feb	21 Feb					
W0205-1	injection molding	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	
	UV	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	
W0205-2	injection molding	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	
	UV	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	
W0205-3	injection molding	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	
	UV	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	
W0205-4	injection molding	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	
	UV	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	
W0205-5	injection molding	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	
	UV	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	

Shipment Inspection Form

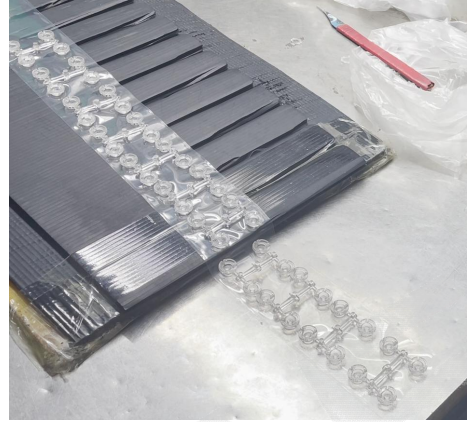
产品名称	物料号	规格	数量	单位	日期
生产工序	设备	操作者	检验员	检验日期	检验结果
1. 检查产品的数量是否与订单一致。 2. 检查产品的规格是否与物料号一致。 3. 检查产品的尺寸是否符合要求。 4. 检查产品的外观是否有缺陷。 5. 检查产品的性能是否符合要求。 6. 检查产品的包装是否符合要求。 7. 检查产品的标识是否正确。 8. 检查产品的其它要求。 9. 检查产品的安全。 10. 检查产品的环境。 11. 检查产品的设备。 12. 检查产品的工具。 13. 检查产品的参数。 14. 检查产品的过程。 15. 检查产品的产品。 16. 检查产品的包装。 17. 检查产品的检验。 18. 检查产品的存储。 19. 检查产品的运输。 20. 检查产品的交付。 21. 检查产品的返回。 22. 检查产品的维护。 23. 检查产品的改进。					
检验结论: 合格					

Injection molding related processing

Our engineers will conduct fixture testing and complete fixture manufacturing once we have received your order, including packaging material application, production details development to lower down the cost of other process and increase the qualified rate



During the production of transparent products, the staff is requested to wear finger gloves to prevent the finger prints from affecting the next step



All transparent products are packaged with low adhesive film and transported to protect the surface of the product



Low mucosal transport of semi-finished products



The finger gloves are necessary for the products with surface requirements



Full inspection is required before going to the next stage

Assembly

Grefee has a dust-free assembly workshop, 4 assembly production lines, each workstation is equipped with assembly instructions, and each production line is equipped with an IPQC for inspection. A full inspection of the product will be conducted during final packaging



Customized foam box, internal transportation



Assembly dust-free workshop



IPQC sampling inspection of assembly line



Full inspection of the product before packaging



Full inspection of product appearance surface

Packaging and storage

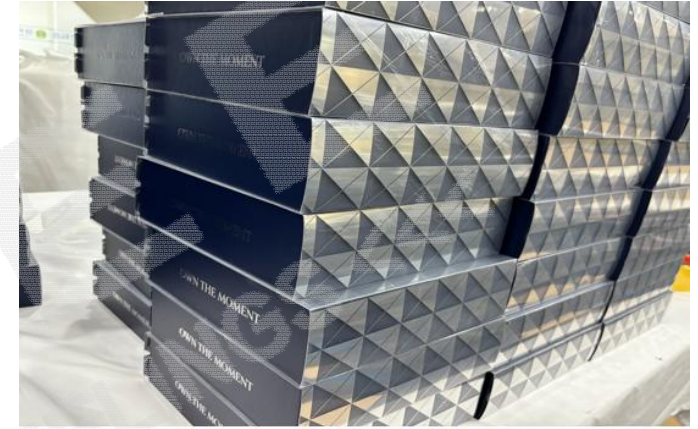
The finished product warehouse and packaging materials are the first impression of the product. We have set high standards for the finished product warehouse and packaging materials, and have a complete warehouse management process. The warehouse has fire and moisture prevention capabilities. The warehouse is inspected three times a day for ventilation and other conditions to ensure that the cardboard boxes are free from any abnormal conditions such as decay



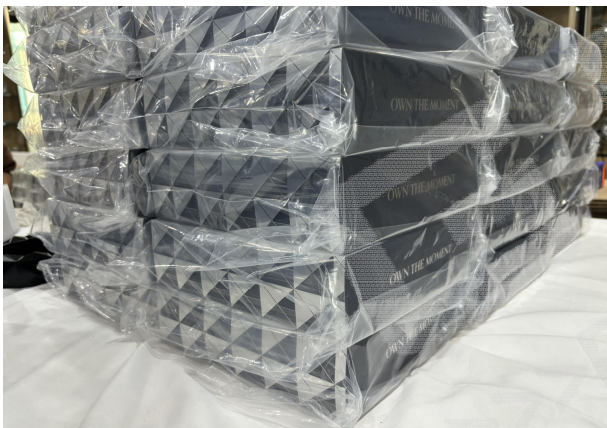
Carton warehouse



Regularly inspect the internal packaging boxes to ensure timely delivery



Clean the packaging boxes before shipment



Packaging moisture-proof PE bag to prevent packaging box from rotting during transportation



The shipping packaging meets the requirements of moisture-proof and anti-collision, with 7 layers of hard cardboard boxes and 8T thick foam



Finished product warehouse and waiting for shipment area