

## Company Profile

### 1. Company profile

**SIG Combibloc Ltd. (Plant Rayong)** located at 33 Moo 4, Highway No. 331 Amphur Pluak Daeng, Rayong 21140, Thailand.



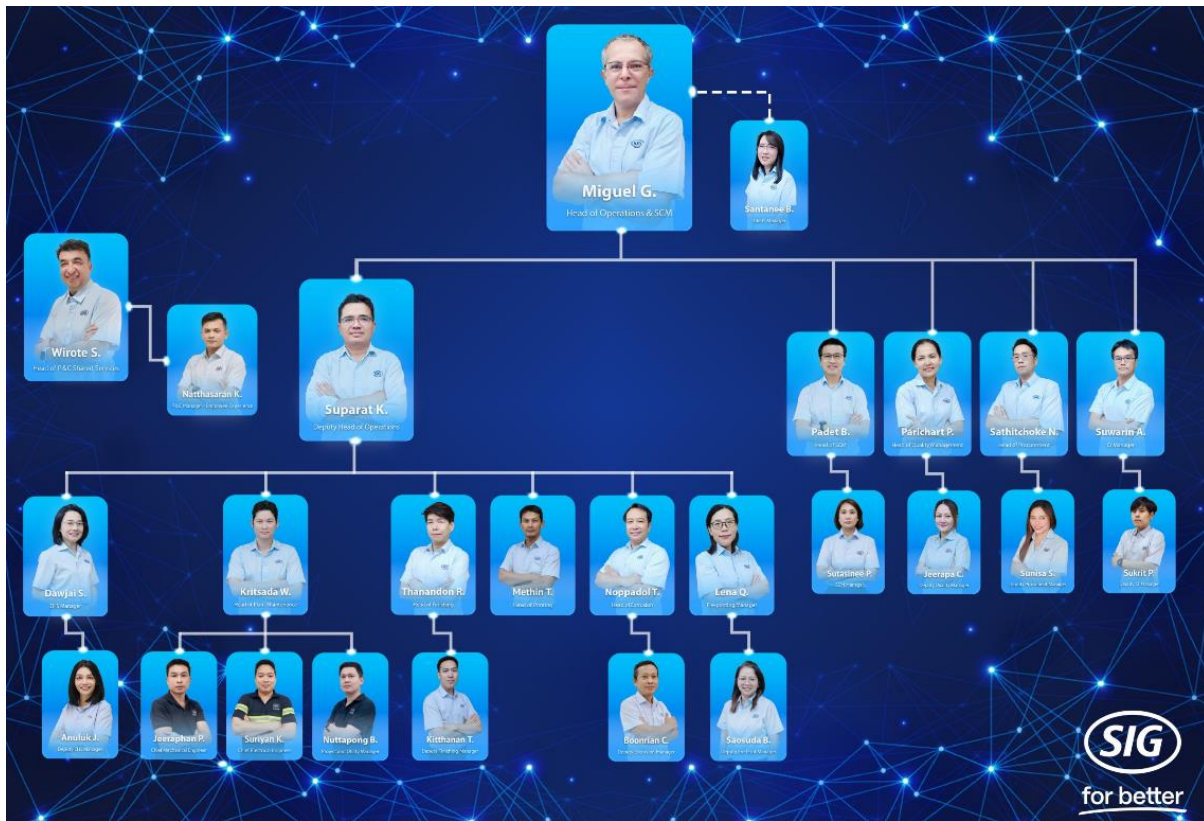
The plant covers an area of 87,000 square meters. Including function department, e.g. Operations, Purchasing, IT, People and Culture (HR). The number of employees in total is around 535 employees, 370 direct. With around 10 Bio Sleeves yearly capacity, the sleeves produced by SIG Plant Rayong (PRA) are supplied to 17 Domestic customers and 66 Oversea customers

Pictures are our Plant's Front Entrance, Front Office and Management Team.



## Organization of SIG Plant Rayong (PRA)

PRA is headed by comprises functional departments. CIS is taking care of SES (TPM) driving and culture establish in plant. Detailed structure of Plant Rayong can be found as below.




## Employee Structure of SIG Plant Rayong

- **Gender Imbalance:** 89% male employee.,
- **Predominantly Blue-Collar Workforce:** 80% of the employees are in blue-collar roles.
- **Education Level Distribution:** Most of the workforce holds diploma-level education (322 employees), with relatively few holdings bachelor's (105) and master's degrees (22).
- **Age and Experience Structure:** The average age being 38 years and the largest group aged 41-50. Additionally, the average year of service is 10, suggesting a relatively stable, experienced workforce.

## Main Product of SIG Plant Rayong

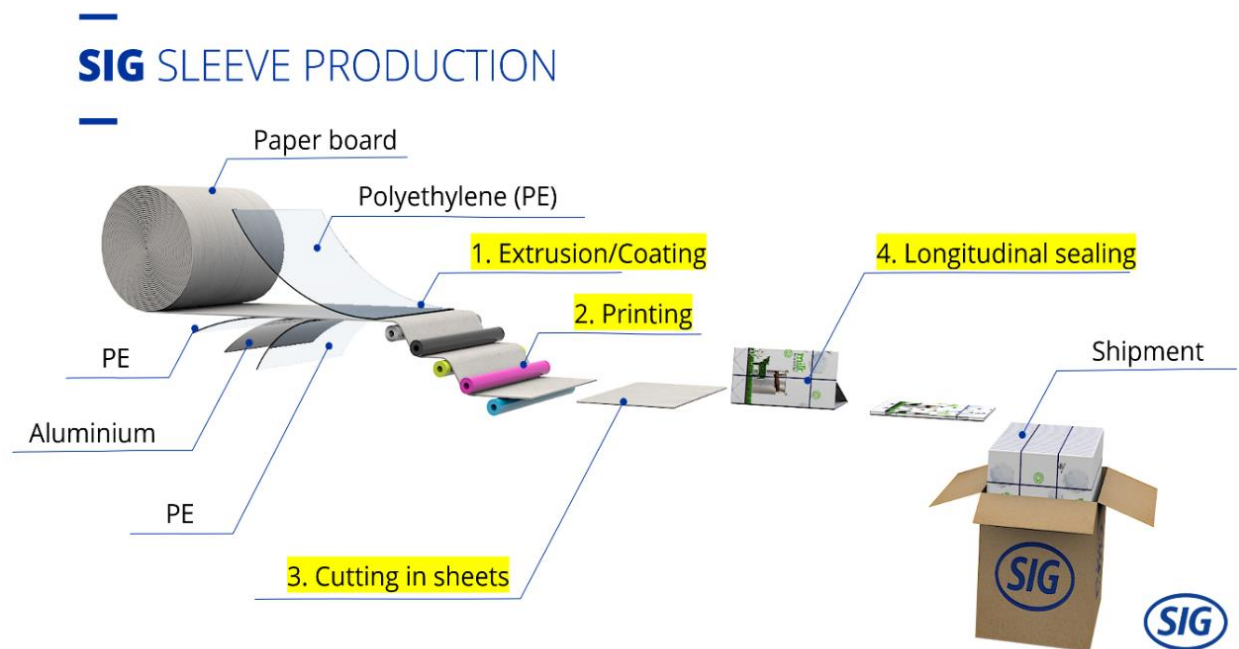
Plant Rayong now produces 6 formats of sleeves. Our biggest customer is Lactasoy, which we supplied CB7-300 format with highest demand, we also list all our format and corresponding volume as well as some examples, matrix is as below.

Format	Volume	Example
CB1	125, 150, 200, 250	   200  250  200
CB6	200, 250, 375, 400, 500	 400  500
CB7	150, 200, 250, 300, 330, 350	 150  200  250  300
CB12	80, 90, 100, 110, 125, 150, 160, 180, 200	  110      180



## Production Processes of SIG Plant Rayong

In SIG, we are turning raw material such raw board, PE and Aluminum into sleeves. Picture below is an overview for our sleeve production. The one marked with yellow are our major processes.



Step1, EXTRUSION or COATING line.

The Paperboard is coated with high-quality Polyethylene (PE) and a thin layer of Aluminum.

Step 2, PRINTING line

The packaging material is printed with up to six colors using a high-quality Gravure printing system.

Step 3, CREASER CUTTER line

The extruded and printed carton is cut to size for different formats and volume. Each is creased and prepared for folding.

Step 4, Folder Sealing line

The longitudinal seam is then sealed, which requires the ultimate in precision. Then the sleeves will be packed and shipped to customer.

## 2. Milestone on the Journey of Manufacturing Excellence

From the beginning,

1996: The company organized a foundation stone laying ceremony for

Rayong plant. After that importing modern machinery and technology from Germany with investment of more than 100 million US dollars.

1998: H.R.H Princess Maha Chakri Sirindhorn made a grand opening Ceremony of the factory and visited the production process.

2007: PRA continued to grow and to meet the increasing demand for Packaging.

PRA has the capacity to produce up to 5,000 million sleeves per year.

2012: The company has started to develop its management system and certified

ISO 9001 and ISO 14001 + HACCP,

2016: Demand for sterile packaging increased from all over the world. The company decided to expand and investment at Rayong plant. To increase the capacity increase to 9,000 million sleeves per year and has introduced automated conveyor systems for the first time.

2017: The company has joined the Halal certification in the year 2017, demonstrating its unmatched service and fulfil the needs of all customers. The Halal certification can ensure customer satisfaction and Muslim customers thoroughly which has the growing trend in the future.

2018: Certified DIN EN ISO 45001: 2018

2019: SIG Chief Executive Officer established SES – SIG EXCELLENCE SYSTEM which has yearly SES Maturity Assessment by Global Team.

**Startup TPM kick off with core pillar.** Align SES with TPM strategy.

2020: CEO Safety Excellent Award 2020

Climate Action Leading Organization Certificate 2020

The province level labour management excellence award 2020

2021: Golder year of Plant Rayong; we started to transform our plant to the Digitalization Plant. We achieved the 2021 Shine Award as the Best Plant of the Year among SIG international group (9 Plants).

Commencing Bronze Level for the 2<sup>nd</sup> Consecutive Year Certificate Hours of 2,001,560 Zero Accident Campaign 2021

2022: Carbon Market “LESS Project” from Garbage to Garden 2022

2023: Innovation BBS Observation Online 2023

Innovation Access Control and Safety Warning System at RM-WH 2023

Innovation Safety Crossway with Interlock System 2023

2024: The 2024 Excellent Practices Establishment On Occupational Safety and Health  
National Level As 3<sup>rd</sup> Year Of Achievement

2025: **Planned for TPM Excellence award assessment.**

2027: Planned for TPM Excellence Consistency award assessment

### **3. Benefits Achieved Explain the benefits that have occurred from:**

#### 3.1 Tangible business results

- OTTR for all customers 100%
- Improve Technical Efficiency by reduced to 1.14%
- Improve Waste rate by reduced to 4.2%
- Improve setup time at Extrusion by reduced to 33.5 mins
- Improve setup time at Printing by reduced to 34.7 mins
- Encourage and Promote Kaizen in Plant up to 584 items
- LTC at 0.19, TRC at 2

#### 3.2 Intangible

- Employee involvement in AM activities.
- Multiskilled improvements.
- Safe place.
- Kaizen improvement create from Operator

### **4. Key of our Manufacturing Excellence**

- Best manufacturing cost.
- Zero customer claim.
- Digital transformation
- Specialist of data analysis