



**FSSC22000 Food Packagng and Packaging  
Materials  
SUR+EXT Audit Report  
FSSC 22000 食品包装和包装材料的生产  
监督和扩项 审核报告**

FSSC 22000 Version 5.1

Standard version 标准版本	5.1.0	PRP Standard PRP 标准	ISO/TS22002-4
GP4163	FSSC Packaging Report 食品包材报告	Issue Number 版本号	4a

Organization profile 组织概述	
SGS Contract Number	AF/TSN8949
Company Name 公司名称	Huiyuan Printing and Packaging Technology (Tianjin) Co., Ltd. 汇源印刷包装科技（天津）股份有限公司
Registration Number 注册号	COID: CHN-1-0587-220089
Address Line 1 地址行 1	No.300, Hangkong Road, Konggang Economic Zone, Tianjin City, P. R. China 中国天津市空港经济区航空路 300 号
Address Line 2 地址行 2	NONE
Town/City 城镇	Tianjin City 天津市
Region 区域	Tianjin City 天津市
Zip/postal Code 邮编	300300
Country 国家	P. R. China 中国
Contact person 联系人	Ms. Zhang Xue张雪
Contact Email Address 联系人邮箱	xue.zhang@hyprinting.cn
General Description of Audited Organization 被审核组织的总体概述	<p><i>Brief history of the company: 简述工厂的历史:</i></p> <p>The company was founded in 2000, the food packaging workshop was put into operation in 2014, and obtained the SGS FSS22000 certificate in 2015</p> <p>公司成立于 2000 年，食品包装车间于 2014 年投产，2015 年获得 SGS FSS22000 证书</p> <p><i>Main markets/customer: 主要市场/顾客:</i></p> <p>The products are currently sold in China, used in the packaging of candy or chocolate products, and the main customers are Mars, Haidilao, etc</p> <p>产品目前在国内销售，用于糖果或者巧克力制品等的包装，主要客户玛氏、海底捞等</p> <p><i>Presentation of the organization / Types of products: 组织简介、产品类型</i></p> <p>The factory is located in No. 300, Hanghang Road, Airport Economic Zone, Tianjin, China, the factory mainly produces paper packaging products, food packaging paper bowl workshop and paper gasket workshop each, for independent workshops, there are printing machines, bowl making machines, die cutting machines, UV lamp</p>

	<p>sterilization machines, etc., there are currently about 20 people, products are packaged by PE bags, carton packaging.</p> <p>工厂位于中国天津市空港经济区航空路 300 号，工厂内主要生产纸包装产品，食品包装用纸碗车间和纸垫片车间各一个，为独立车间，有印刷机、制碗机、模切机、紫外灯杀菌机等，目前约有 20 人，产品均通过 PE 袋包装后，纸箱外包装。</p> <p><i>Short description of the manufacturing process: 简要描述生产过程:</i></p> <p>Paper bowl: raw and auxiliary materials acceptance OPRP1 - base paper printing - die-cutting - paper fan UV sterilization CCP2 - bowl forming - packaging material ultraviolet sterilization OPRP2 - packaging - storage</p> <p>Paper gasket: raw and auxiliary materials acceptance OPRP1 - bonding - die-cutting - UV sterilization CCP2 - packaging materials UV sterilization OPRP2 - packaging - storage</p> <p>Cardboard box: raw material acceptance OPRP1 - base paper printing - die-cutting - box pasting - ultraviolet sterilization CCP2 - packaging material ultraviolet disinfection OPRP2 - packaging - warehousing</p> <p>纸碗：原辅料验收 OPRP1—原纸印刷—模切—纸扇片紫外杀菌 CCP2—制碗成型—包材紫外消毒 OPRP2—包装—入库</p> <p>纸垫片：原辅料验收 OPRP1—粘合—模切—紫外杀菌 CCP2 —包材紫外消毒 OPRP2—包装—入库</p> <p>纸板盒：原辅料验收 OPRP1—原纸印刷—模切—糊盒成型—紫外杀菌 CCP2--包材紫外消毒 OPRP2—包装—入库</p> <p><i>Outsourced activities: 外包活动:</i></p> <p>Transporters, pest control, waste disposal, verification and calibration of measuring equipment and product type inspection. 运输商、虫鼠害控制、废弃物处理、计量设备的检定校准及产品型式检验。</p> <p><i>Design, implementation and maintenance of the FSMS and PRP: 食品安全管理体系和 PRP 的设计、实施和维护情况:</i></p> <p>According to the requirements of FSSC22000 V5.1, the company has established a food safety manual, risk and opportunity response measures and prerequisite programs, and established a hazard control plan by collecting hazard analysis information and hazard analysis. Hazard control plans, etc. are effectively implemented and maintained.</p>
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	<p>公司依据 FSSC22000 V5.1 要求，建立了食品安全手册、风险和机遇应对措施和前提方案等，通过收集危害分析信息、危害分析等建立了危害控制计划，现场审核前提方案、风险和机遇应对措施和危害控制计划等得到有效的实施和维护。</p> <p><i>Conformity of infrastructure, environment and equipment: 基础设施、环境和设备的符合性:</i></p> <p>There are many buildings in the factory area of the company, which are workshops, warehouses and canteens. The ground is hardened or there are vegetation. The facilities, equipment and working environment are established in accordance with the requirements of ISO/TS22002-4:2013, and the facilities and equipment are verified on site. Can provide a hygienic environment to control food safety hazards. The equipment and environment are adequate and suitable and well maintained. Food safety hazards can be controlled within acceptable levels.</p> <p>公司内厂区内有多栋建筑，分别为车间、仓库和食堂等，地面硬化或者有植被，设施设备和工作环境按照 ISO/TS22002-4:2013 的要求建立，现场验证设施设备能够提供卫生的环境以控制食品安全危害。设备和环境是充分的和适宜的，并得到良好的维护。食品安全危害可以控制在可接受水平之内。</p> <p><i>Use of consultant: 顾问的使用情况:</i></p> <p>None 无</p> <p><i>Product license (SC or QS) or registration 生产许可证或登记备案:</i></p> <p>Production license 生产许可证: (津) XK16-205-00053 valid until 2024-04-20</p>
<b>Overview of Seasonal Activities</b> 季节性活动概述	NONE 无

Head Office (where appropriate) 总部（适用时）	
Registered legal name 注册名称	N/A
Trading name(s) 贸易名称	
Registration 注册号	
Location 场所地址	
Contact person 联系人	
Number of sites 场所数量	
Head office functions 总部职能	

Off-site Activities (where appropriate) 非现场活动（适用时）	
Registered legal name 注册名称	N/A
Trading name(s) 贸易名称	
Registration 注册号	
Location(s) 场所地址	
Contact person 联系人	
Activities at locations 场所的活动	

Multi-sites (where appropriate) 多场所（适用时）	
Registered legal name 注册名称	N/A
Trading name(s) 贸易名称	
Registration 注册号	
Location(s) 场所地址	
Contact person 联系人	
Activities at locations 场所的活动	

Audit details 审核信息		
<b>CB Name and office location</b> 认证机构和办公室	SGS United Kingdom - UKAS	
<b>Certificate number</b> 证书号	CN17/10015	
<b>Certificate expiry date</b> 证书到期日期	2026-03-20	
<b>Audit objective</b> 审核目的	<p>The objectives of this audit were 本次审核的目的是:</p> <p>To determine conformity of the management system, or parts of it with audit criteria and its:</p> <p>确定管理体系或部分管理体系与审核准则的符合性:</p> <ul style="list-style-type: none"> <li>ability to ensure applicable statutory, regulatory and contractual requirements are met, 能够确保适用的法律、法规和合同要求得到满足的能力</li> <li>effectiveness to ensure the client can reasonably expect to achieve specified objectives, and 确保客户的合理预期达到指定目标的有效性, 以及</li> <li>ability to identify as applicable areas for potential improvement. 能够识别潜在改进的适用领域的的能力</li> </ul>	
<b>Audit criteria</b> 审核准则	<p>ISO22000:2018, ISO/TS22002-4 and FSSC additional requirements</p> <p>ISO22000 2018, 相关 PRP 方案标准和 FSSC 的额外要求</p> <p>The defined processes and documentation of the management system developed by the organization 由组织开发制定的管理体系的过程和文件</p> <p>Statutory/regulatory requirements (as applicable) 适用法律法规的要求</p> <p>Customer requirements (as applicable) 适用的客户要求</p> <p>CNFM-T-39 食品安全管理体系 食品包装容器及材料生产</p>	
<b>Audit type</b> 审核类型	Surveillance	Announced
<b>Delivery</b> 执行方式	Onsite	
<b>Audit Complexity</b> 审核复杂度	Standalone FSSC22000 Audit	Provide details of the other standards 所整合/联合审核的其他标准:
<b>Audit language</b> 审核语言	CHINESE	

<b>Number of HACCP Studies</b> HACCP 计划数量	3
<b>Number of employees</b> 员工数量	25
<b>Number of Shifts</b> 班次	2
<b>Number of employees per shift</b> 每班次员工数量	12
<b>Total audit time in Hours</b> 总审核小时数	20
<b>Deviation from audit time</b> 审核时间偏差	<i>NO any deviation from the calculated audit time</i> 现场核实与 PWS 显示人天一致

Audit team 审核组						
Auditor Number 审核员注册号	Auditor Name 审核员姓名	Role 组内角色	Date 日期	Hours 小时数	Minutes 分钟数	Delivery 执行方式 Onsite 现场 /Remote 远程
667	Andy yu 于接盛	Lead Auditor	30/01/2024	8	0	Onsite
667	Andy yu 于接盛	Lead Auditor	31/01/2024	6	0	Onsite
1034	Amy zhang	Auditor	31/01/2024	6	0	Onsite
Technical Expert (where used) 技术专家（适用时）						
Name 姓名		Food Chain Category 食品链类别	Date 日期	Hours 小时数	Minutes 分钟数	Delivery 执行方式 Onsite 现场 /Remote 远程
NONE			Click or tap to enter a date.			Choose an item.
Additional attendees and role (if applicable) 其他参与者和角色（适用时）						
Name 姓名		Function 职能	Date 日期			Delivery 执行方式

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			Onsite 现场 /Remote 远程
NONE	Choose an item.	Click or tap to enter a date.	Choose an item.

Audit scope 审核范围		
Food category(ies) 食品类别	I2	
Scope statement 范围表述	Manufacture of paper bowl (printing, cutting and molding), cardboard box (printing, die-cutting, gluing) and paper gasket (cutting and gluing) used for food packaging 食品包装用纸碗（印刷、模切和成型）、纸板盒（印刷、模切和糊盒）和纸垫片（模切、胶合）的生产	
Exclusions (when appropriate and detailed) 删减（适用时请提供具体信息）	No	
Scope Statement Verified? 范围表述验证了吗？	Yes	

Audit program and plan 审核方案和计划		
Deviation from audit program 与审核方案的偏差？	No	
Deviation from audit plan 与审核计划的偏差？	No	

Audit details previous audit 上次审核的信息	
Audit type 审核类型	Recertification
	Announced
Delivery 执行方式	Onsite
Audit dates 审核日期	2023-02-16~17
CB conducting audit 执行审核的认证机构	SGS



<b>Closure of NC's from previous audit</b> 上次审核不符合项的关闭	Yes	
<b>Significant changes since last audit</b> 自上次审核以来的重大变化	<p>The scope has increased cardboard boxes, updated documents such as food safety manuals, procedure documents and hazard control plans, added folder-glue, increased the number of personnel by 5, and there has been no change in the organizational structure.</p> <p>产品范围增加纸板盒，更新了食品安全手册、程序文件和危害控制计划等文件，增加糊盒机，人员增加 5 人，组织架构等没有变化。</p>	

<b>Non-Conformances from Previous audit</b> 上次审核的不符合项				
# 编号	Standard/Clause Reference 标准/条款	Finding 审核发现	Action Taken 所采取的措施	Finding Closed 关闭与否
1- Andy yu 667	ISO/TS22002-4 4.3.5	on-site audit found that the company did not provide evidence of microbiological testing of compressed air used for paper bowl delivery, which did not meet the requirements of the company's inspection plan. 现场审核发现公司未提供用于纸碗输送的压缩空气微生物检测证据，不符合公司检验计划要求。	On-site verification that compressed air microorganisms have been detected, there are no similar problems, and corrective actions are effective 现场验证已检测压缩空气微生物，没有类似问题，纠正措施有效	Yes
2- Andy yu 667	ISO/TS22002-4 4.9.3	on-site audit found that the sewer pipes at the entrance of the paper bowl workshop washbasin were not sealed and there was a risk of pest infestation 现场审核发现纸碗车间入口洗手池下水管道未密封，存在虫害入侵的风险	The sewer line has been sealed on site and there are no similar problems, and the corrective action is effective 现场验证已密封下水道，没有类似问题，纠正措施有效	Yes
3- Andy yu 667	ISO/TS22002-4 4.5.3	The on-site audit found that the tabletop used to hold die-cut paper gaskets in the paper gasket workshop was painted and made of wood, which could not meet the material requirements of the contact surface of food packaging	On-site verification that the desktop has been replaced, there are no similar problems, and the corrective actions are effective 现场验证已更换桌面，没有类似问题，纠正措施有效	Yes

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		现场审核发现纸垫片车间内，用于盛放模切纸垫片的桌面有油漆且为木质材料，不能满足食品包装接触表面的材质要求	
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## Executive summary 执行总结

### Audit summary 审核总结

- The capability of the management system to meet applicable requirements, food safety objectives and expected outcomes; 管理体系满足适用要求、食品安全目标以及预期结果的能力:*

*This was a process-based audit focusing on significant aspects, risks and objectives required by the standard(s). A sampling process was used, based on the information available at the time of the audit. Methods of assessment included interviews, observation and review of documentation. The audit team concludes that the organization HAS established and maintained its management system in line with the requirements of the standard and demonstrated the ability of the system to systematically achieve agreed requirements for products or services within the scope and the organization's policy and objectives.*

这是基于流程的审核，重点关注标准要求的重要方面、风险和目标。根据审核时可用的信息，使用了抽样过程，评估方法包括访谈、观察和文件审查。审核组得出结论，组织已按照标准的要求建立和维护了其管理体系，并证明了该体系有能力在范围和组织的方针和目标内系统地实现对产品或服务的商定要求。

- Progress the organization has made against its objectives since the last audit (however, for an initial certification, this section may need to acknowledge that the organization had not yet developed sufficient history of such achievement for auditing purposes) 自上次审核以来，该组织在实现其目标方面取得的进展（但是，对于初始认证，可能需要认识到，针对本部分该组织尚未有足够多的绩效达成情况的历史数据，来供审核之用）*

Food Safety Objectives:

Final product factory pass rate  $\leq 100\%$

Operational prerequisite implementation pass rate  $\geq 98\%$

Critical Control Point Monitoring Coverage 100%

Market supervision spot check pass rate 100%

The pursuit of food safety accidents is 0%, the goal is achieved, the target decomposition is carried out for each department, the corresponding assessment system is formulated, and the system has been established so far.

食品安全目标:

终产品出厂合格率  $\leq 100\%$

操作性前提方案执行合格率  $\geq 98\%$

关键控制点监控覆盖率 100%

市场监督抽查合格率100%

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	<p>追求食品安全事故为0%，目标达成，针对每个部门进行了目标分解，制定了相应的考核制度，体系建立至今均达成。</p> <ul style="list-style-type: none"> <li> <p><i>Significant food safety issues that senior management need to be aware of (major/critical findings; trends in recalls etc.) 高层管理者需要了解的重大食品安全问题（重大/关键发现点、召回的趋势等等）</i></p> <p>Communicated with senior management that the company has no major food safety issues, no recall trends, etc., and no major or key findings during the audit process.</p> <p>与高层管理者沟通，公司没有重大食品安全问题，没有发生召回趋势等，审核过程中也无重大或者关键发现点</p> </li> <li> <p><i>The internal audit and management review process; 内部审核和管理评审流程：</i></p> <p>Internal Audits</p> <p>The establishment of the "internal audit control procedures", an internal audit is conducted once a year, the latest internal audit is conducted on November 06-08, 2023, the internal audit is based on FSSC 22000 V5.1, all internal auditors are competent, internal auditors: Zhang Xue, Zhang Xueyan, etc., internal audit records include internal audit plans, sign-in sheets, checklists, internal audit reports, non-conformity reports and corrective measures, etc., a total of 2 minor non-conformities have been proposed, and corrective and corrective measures have been taken for the non-conformities issued, and verified to be effective.</p> <p>Management Reviews</p> <p>The management review is conducted once a year, the most recent of which was conducted on 2023-12-25, with the participation of the company's leadership and various departments. In the form of a meeting, the input of the management review includes policies, objectives, audit results, system operation, customer feedback, tracking and verification of previous management evaluations, changes in the internal and external environment, effectiveness of measures to deal with risks and opportunities, improvement opportunities, etc., and the management review conclusions can be proved FSSC22000V5.1 Continued suitability, Adequacy and effectiveness, the output includes the system resource requirements, etc., this management review puts forward 1 improvement suggestion, check the management review records, including the management review plan, input and output, sign-in sheet, management review report, etc.</p> <p>内部审核</p> <p>建立了《内部审核控制程序》，每年进行一次内审，最近一次内审于 2023 年 11 月 06 日-08 日进行，内审依据 FSSC 22000 V5.1，所有的内审员都是能够胜任的，内审员：张雪、张学艳等，内审记录包括内审计划、签到表、检查表、内审报告、不符合报告和纠正措施等，共有 2 个轻微不符合项提出，已经对开具的不符合采取纠正和纠正措施，并验证有效。</p> <p>管理评审</p> </li> </ul>
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	<p>每年进行 1 次管理评审，最近一次于 2023-12-25 进行，有公司的领导层和各个部门参加。采用会议形式，管理评审输入包括方针、目标，审核结果，体系运行情况，顾客反馈，以往管评跟踪验证，内、外部环境变化，应对风险和机遇措施有效性，改进机会等，管理评审结论是能够证明 FSSC22000V5.1 持续的适宜性、充分性和有效性，输出包括体系资源需求等，本次管理评审提出 1 项改进建议，查阅管理评审记录，包括管理评审计划，输入和输出，签到表，管理评审报告等。</p> <ul style="list-style-type: none"> <li>For recertification audit – indicate how the FSMS has evolved over the three-year cycle 对于重新认证审核 -- 说明食品安全管理体系在上三年周期内逐步发展的情况</li> </ul> <p>N/A 本次监督审核</p>	
<b>Conformation that audit objectives have been fulfilled</b> 审核目标是否满足的确认	Yes	
<b>Unresolved issues</b> 未解决的问题	NONE	
<b>Use of logo</b> 标志的使用	Meet the requirement	

#### Summary of audit findings 审核发现总结

# Critical nonconformities 危重关键不符合项	0
# Major nonconformities 严重不符合项	0
# Minor nonconformities 一般不符合项	2

#### Audit recommendation 审核推荐

(Re-)Certification Granted
根据本次审核结果，审核组建议管理体系认证结果为 推荐发证



Minor Nonconformities 一般不符合项（备注：ISO/TS 22002-4 条款提出不符合为 PRP 不符合，即等同 ISO22000: 2018 8.2.4 条款不符合）						
# 编号	Requirement Reference 要求 (std., clause) (标准条款)	Finding details 审核发现 (statement of NC and objective evidence) (不符合项表述和客观证据)	Correction 措施 (to address immediate issue) (即时解决该问题)	Root Cause Analysis 根本原因分析 (determine why it arose) (确定产生的原因)	Corrective Action Plan 纠正措施计划 (action to prevent repeat; person responsible; due date for completion) (预防再发生的措施；责任人； 完成期限)	Review 评审 (detail evidence reviewed, acceptance of correction and CAP for minors) (具体证据评审， 纠正和纠正措施的接 受)
1 -667	ISO/TS22002-4: 2013 4.9.5	The on-site audit found that at the entrance gate of the ink warehouse, a sticky mouse board number fell off 现场审核发现油墨仓库入口大门处，一粘鼠板编号脱落。	Post the shedding number immediately 立即张贴脱落编号	Personnel did not patrol the area 人员未巡检此处	1. require the pest control outsource change the glue of the mouse board. 2. Warehouse manager inspects weekly  Responsible person: Zhang Xue Completion time: 2024-02-03 1. 要求虫害外包方更换质量好的粘合胶 2. 仓库经理每周检查  责任人：张雪	The sticky board number and training records provided show that the non-conformance has been corrected and the corrective action plan is acceptable. 提供的粘鼠板编号及培训记录显示不符合已纠正，纠正措施计划可以接受。

FSSC 22000 Version 5.1

Standard version 标准版本	5.1.0	PRP Standard PRP 标准	ISO/TS22002-4
GP4163	FSSC Packaging Report 食品包材报告	Issue Number 版本号	4a



					完成时间：2024-02-03	
2 -667	ISO/TS22002-4: 2013 4.7.3	The on-site audit found that the folder-gluer rollers were in contact with the product, and that there was dust on the rollers, posing a risk of foreign body contamination 现场审核发现糊盒机滚轮与产品接触，滚轮上有灰尘，存在异物污染的风险。	Clean up the roller dust immediately 立即清理滚轮灰尘	Personnel did not notice the dust 人员未发现此处灰尘	1. The hygiene condition of the rollers is checked by the workshop manager every week 2. The operator cleans every day 3. training the operator for the physical management. Responsible person: Zhang Xue Completion time: 2024-02-031.由 1.车间经理每周检查滚轮卫生状况 2.操作人员每天清洁 3. 对操作人员进行异物管理培训  责任人：张雪 完成时间：2024-02-03	Photos of the post-cleaning rollers provided show that the non-conformance has been corrected and the corrective action plan is acceptable.提供的清洁后滚轮照片显示不符合已纠正，纠正措施计划可以接受。
Reviewed and accepted by 评审和接受人: andy yu					Date 日期:	2024-02-03



Major Nonconformities 严重不符合项（备注：ISO/TS 22002-4 条款提出不符合为 PRP 不符合，即等同 ISO22000: 2018 8.2.4 条款不符合）					
#	Requirement Reference 要求 (std., clause) 标准条款	Finding details 审核发现 (statement of NC and objective evidence) (不符合项表述和客观证据)	Correction 措施 (to address immediate issue) (即时解决该问题)	Root Cause Analysis 根本原因分析 (determine why it arose) (确定产生的原因)	Corrective Action Plan 纠正措施计划 (action to prevent repeat; person responsible; due date for completion) (预防再发生的措施; 责任人; 完成期限)
1	NONE				
2					
Reviewed by 评审人:				Review date 评审日期:	
Evidence of correction/corrective action reviewed 所评审的纠正/纠正措施的证据:				Outcome of follow-up audit 跟踪审核的结果:	
Date of follow-up audit 跟踪审核日期:					

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Critical Nonconformities 危重关键不符合项（备注：ISO/TS 22002-4 条款提出不符合为 PRP 不符合，即等同 ISO22000: 2018 8.2.4 条款不符合）					
#	Requirement Reference 要求 (std., clause) 标准条款	Finding details 审核发现 (statement of NC and objective evidence) (不符合项表述和客观证据)	Correction 措施 (to address immediate issue) (即时解决该问题)	Root Cause Analysis 根本原因分析 (determine why it arose) (确定产生的原因)	Corrective Action Plan 纠正措施计划 (action to prevent repeat; person responsible; due date for completion) (预防再发生的措施; 责任 人; 完成期限)
1	NONE				
Reviewed by 评审人:				Review date 评审日期:	
Evidence of correction/corrective action reviewed 所评审的纠正/纠正措施的证据:					
Date of suspension 暂停日期:					
Date of new audit planned 重新审核策划的日期:					

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### Key processing steps and Control measures 关键过程步骤和控制措施:

During the audit the control of the following key processing steps and operational prerequisite programs (oPRPs) and CCP(s) were verified. All oPRPs and CCP's should be verified.

在审核期间以下关键过程步骤和操作性前提方案，关键控制点被验证。所有的操作性前提方案和关键控制点都应被验证

Paper bowl: Acceptance of raw and auxiliary materials OPRP1 - base paper printing - die-cutting - ultraviolet sterilization CCP2 of paper fan - bowl forming - ultraviolet disinfection of packaging materials OPRP2 - packaging - warehousing

Paper gasket: Raw material acceptance OPRP1 - ultraviolet sterilization CCP2 - bonding - die-cutting - ultraviolet sterilization of conveyor belt CCP1 - packaging material ultraviolet disinfection OPRP2 - packaging - warehousing

Cardboard box: raw material acceptance OPRP1 - ultraviolet sterilization CCP2 - base paper printing - die-cutting - box pasting - conveyor belt ultraviolet sterilization CCP1 - packaging material ultraviolet disinfection OPRP2 - packaging - warehousing

纸碗：原辅料验收 OPRP1—原纸印刷—模切—纸扇片紫外杀菌 CCP2—制碗成型—包材紫外消毒 OPRP2—包装—入库

纸垫片：原辅料验收 OPRP1—紫外杀菌 CCP2--粘合—模切—传输带紫外杀菌 CCP1 —包材紫外消毒 OPRP2—包装—入库

纸板盒：原辅料验收 OPRP1—紫外杀菌 CCP2--原纸印刷—模切—糊盒成型—传输带紫外杀菌 CCP1--包材紫外消毒 OPRP2—包装—入库

Control measure 控制措施	Short description (process step) 过程步骤简述	Food safety hazards to be controlled 所控制的食品安全危害	Monitoring procedure and critical limit 监控程序和关键限值	Verified during audit 在审核中被验证
OPRP1	Inspection and acceptance of raw materials (stock paper \ packaging bag, 804 starch glue)	Chemical hazards: chemical hazards brought in by raw materials, such as heavy metals, fluorescent agents, etc 化学危害：由原料带入的化学性危害，如重金属，荧光剂等	Action criteria: Provide annual type inspection report, including compliance with hygiene standards such as heavy metals, migrating substances, etc.  Correction: Product is returned, the cause is found and corrective action taken	YES

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	原辅料验收--原纸		行动准则：每年提供型式检验报告，包含符合卫生标准如重金属，迁移物质等。 纠偏：产品退回，查找原因并采取纠正措施	
OPRP2	Food packaging paper packaging process 食品包装纸包装工序	Biohazards: pathogenic bacteria 生物危害：致病菌	Action criteria: UV disinfection of each batch of packaging materials for 30min, operator's hands and work surface 75% alcohol disinfection every 4 hours Correction: Product isolation, finding the cause and taking corrective action. 行动准则：每批次包材紫外线消毒30min，操作人员双手、工作台面每4小时75%酒精消毒 纠偏：产品隔离，查找原因及采取纠正措施。	YES
CCP1- 纸垫片和纸板盒	Ultraviolet sterilization 纸片紫外杀菌	Biological hazards, such as bacteria on the surface of paper. 生物危害，如纸表面的细菌等	CL: Irradiation time $\geq 30$ minutes The cumulative use time of the germicidal lamp $\leq 1000$ hours Monitoring measures: operation staff before and after production monitoring Correction: Product isolation, finding the cause and taking corrective action. CL: 照射时间 $\geq 30$ 分钟 杀菌灯累计使用时间 $\leq 1000$ 小时 监控措施：操作员工每班生产前后监控 纠偏：产品隔离，查找原因及采取纠正措施。	YES
CCP2	Ultraviolet sterilization 紫外杀菌	Biological hazards, such as bacteria on the surface of paper. 生物危害，如纸表面的细菌等。	CL: Transfer speed $\leq 30$ m/min The cumulative use time of the germicidal lamp $\leq 1000$ hours Monitoring measures: operation staff before and after production monitoring Correction: Product isolation, finding the cause and taking corrective action. CL: 传送速度 $\leq 30$ m/min	YES

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			杀菌灯累计使用时间≤1000 小时 监控措施：操作员工每班生产前后 监控 纠偏：产品隔离，查找原因及采取 纠正措施。	
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ISO 22000:2018		Conform* 符合与否	Remark 评述
Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
4	Context of the organization 组织环境		
4.1	Understanding the organization and its context	Yes	
4.2	Understanding the needs and expectations of interested parties	Yes	
4.3	Determining the scope of the food safety management system	Yes	
4.4	Food safety management system	Yes	
<p>Summary of Section 4</p> <p>4.1. The company identified various external and internal environments that affect its achievement of the expected results of the food safety management system. Such as: the external environment includes laws and regulations, technology, competition, market, culture, society, economic environment, etc.; The internal environment considers corporate culture, employees, values, knowledge, resource allocation; Food adulteration, food protection, intentional contamination. The company's monitoring and review measures related to these internal and external factors include organizing a comprehensive identification and review of internal and external environmental elements at a management review meeting every year. Review every year, 2023-11-09.</p> <p>4.2. The relevant parties related to the management system identified by the company shall be recorded in the relevant parties' expectation or requirement identification table. Examples include customers, external suppliers, employees, auditors, government regulators, etc. Responses to the needs</p>			

and expectations of these stakeholders have been developed. The needs and expectations of these parties and their measures will be reviewed annually and reviewed on 2023-11-09.

4.3. The company has clarified the scope of the food safety management system: Company name: Huiyuan Printing and Packaging Technology (Tianjin) Co., Ltd., address: No. 300, Hanghang Road, Airport Economic Zone, Tianjin, China, scope: production of paper bowls for food packaging (printing, die-cutting and forming)

4.4. The company determines the processes required for the food safety management system and their interactions, the specific sub-processes of food safety activities and the products, product categories and production sites involved, clarifies the sequence and mutual interface relationship between processes, clarifies the methods and guidelines for process control, and identifies processes including external suppliers, sales processes, production processes, warehouse management, equipment management and other processes.

4.1、公司识别了影响其实现食品安全管理体系预期结果的各种外部和内部环境。如：外部环境包括法律法规、技术、竞争、市场、文化、社会、经济环境等方面；内部环境考虑了企业文化、员工、价值观、知识、资源配置；食品掺假、食品防护、故意污染。公司对这些内部和外部因素的相关信息的监视和评审措施有：每年在管理评审会议上组织一次全面的内外部环境要素识别与评审。每年进行评审，2023-11-09 评审。

4.2、公司识别了的与管理体系有关的相关方，记录在相关方期望或要求识别表中。例如客户、外部供方、员工、审核机构、政府监管机构等。对这些相关方的需求与期望均制定了应对措施。每年对这些相关方的需求与期望及其措施进行评审，2023-11-09 评审。

4.3、公司明确了食品安全管理体系的范围：公司名称：汇源印刷包装科技（天津）股份有限公司，地址：中国天津市空港经济区航空路 300 号，范围：食品包装用纸碗（印刷、模切和成型）、纸板盒（印刷、模切和糊盒）和纸垫片（模切、胶合）的生产

4.4、公司确定了食品安全管理体系所需的过程及其相互作用，具体的食品安全活动的子过程和所涉及的产品、产品类别和生产场地，明确过程之间的顺序和相互接口关系，明确对过程进行控制的方法和准则，识别的过程包括外部供方、销售过程、生产过程、仓库管理、设备管理等过程。

Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体 不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
5	Leadership 领导作用		
5.1	Leadership and commitment	Yes	
5.2	Policy	Yes	
5.2.1	Establishing the food safety policy	Yes	
5.2.2	Communicating the food safety policy	Yes	
5.3	Organizational roles, responsibilities and authorities	Yes	

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5.3.1	The food safety team leader shall be responsible for: a) - d)	Yes	
5.3.2	All persons shall have responsibility to report problem(s) with regards to the FSMS to identified person(s)	Yes	

#### Summary of Section 5

Established a food safety management manual, described the leadership role, communicated with the quality manager Ms. Zhang, established the food safety policy and objectives, provided sufficient resources, supported other relevant managers to play a leadership role in their area of responsibility, communicated within the company the importance of effective food safety management and compliance with the requirements of the food safety management system, conducted internal audits and management reviews every year, and promoted continuous improvement.

#### Food Safety Culture:

In the process of communicating with the general manager of the company, understand that the company has formulated a food safety culture plan, built and promoted food safety and quality culture, and clarified all processes and activities that affect product safety.

Communication and training: through daily shift handover meetings, monthly quality meetings, publicity boards and banners to publicize the food safety policy, daily shift handover meetings to train operators on food safety requirements, at the same time formulate food safety requirements training plans every year, and train department employees on food safety knowledge;

Communication and feedback: Every day, employees directly report the food safety problems found to the supervisor or food safety team, and the managers of each department report food safety matters to the general manager at monthly quality meetings, and propose countermeasures and track the implementation;

Performance measurement: The company evaluates the performance of food safety culture, reports the performance gap to the general manager by the leader of the food safety team, and takes measures to improve and implement, and checks the records such as food safety knowledge training and employee feedback on 2023.

#### Food Safety Policy:

Maintain a documented food safety policy: "Quality-oriented, customer first, scientific management, law-abiding operation, hazard control, aiming at safety, continuous improvement, the pursuit of excellence, 2020-01-10 issued by the factory quality manager in the "Management System Manual", published in the manual, the food safety policy reflects the requirements of the standard and the purpose of the enterprise, and is effectively communicated and understood within the organization.

Establish internal communication channels, stipulate reports and communication between functional departments, superiors and subordinates, and how to communicate. Through meetings, publicity boards, WeChat, regular training and other means to publicize that all employees have included the review of policies and objectives into the scope of management review

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Establish and document organizational structures, clarify responsibilities and authorities, and communicate with different functional levels. Including production, personnel, equipment, quality and other positions, the responsibilities and authority of each position are specified in the manual.

The organizational structure of the Food Safety Management System has not changed since the last audit.

Appointed quality manager Zhang Xueyan as the leader of the food safety team, and clarified his responsibilities in the Food Safety Manual, the responsibilities of the team leader are: to manage the food safety team and organize its work; Ensure that food safety teams receive relevant training; Ensure that the processes required for the management system are established, implemented, maintained and updated; Report to the Company on the performance of the management system and any need for improvement and the effectiveness and suitability of the system; Ensure that awareness of meeting customer requirements is raised within the company; Responsible for external communication and liaison on matters related to the company's management system. Provide sufficient resources including plant facilities, equipment, related personnel, funds, etc.; Conduct regular management reviews to ensure that the management system is effective and continuously improved.

建立了食品安全管理手册，描述了领导作用，与质量经理张女士沟通，建立了食品安全方针和目标，提供充足的资源，支持其他相关管理者在其职责范围内发挥领导作用，在公司内部沟通有效的食品安全管理和符合食品安全管理体系要求的重要性，每年进行内审和管理评审，推动持续改进。

#### 食品安全文化：

与公司总经理沟通过程中，了解公司制定了食品安全文化计划，建设和推进食品安全和质量文化，明确了影响产品安全的所有过程和活动。

沟通及培训：通过每天交接班会议、每月质量会议、宣传栏和条幅宣传食品安全方针，每天交接班会议对操作人员进行食品安全要求培训，同时每年制定食品安全要求培训计划，并对部门员工进行食品安全知识培训；

沟通及反馈：每天员工对发现的食品安全问题直接报告主管人员或者食品安全小组，每月质量会议各部门经理向总经理报告食品安全事项，并提出应对措施且追踪实施；

绩效测量：公司对食品安全文化绩效进行评估，对存在绩效差距由食品安全小组组长向总经理汇报，并采取改进措施并实施，现场查看 2023 年员工反馈和评估等记录。

#### 食品安全方针：

保持了文件化的食品安全方针：“质量为本，顾客至上，科学管理，守法经营，控制危害，旨在安全，持续改进，追求卓越，2020-01-10 由工厂质量经理在《管理体系手册》中发布，在手册中发布，食品安全方针体现了标准的要求和企业宗旨，并在组织内部得到有效传达和理解。

建立内部沟通渠道，规定职能部门之间，上下级之间的报告和沟通，采用何种方式沟通等。通过会议、宣传栏、微信、定期培训等方式宣贯到全体员工已将方针、目标的评审纳入管理评审范围

建立组织架构并形成文件，明确职责和权限，并与不同职能层级进行沟通。包括生产、人事、设备、品质等岗位，各岗位的职责和权限在手册中规定。

自上次审核以来，食品安全管理体系的组织架构未发生变更。

任命质量经理张学艳为食品安全小组组长，在《食品安全手册》中明确了其职责，组长的职责是：管理食品安全小组并组织其工作；确保食品安全小组获得相关的培训；确保管理体系所需的过程得到建立、实施、保持和更新；向公司报告管理体系的业绩和任何改进的需求及体系的有效性、适宜性；确保在公司内提高满足顾客要

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求的意识；负责公司管理体系有关事宜的对外部沟通与联络。提供充分的资源包括厂房设施、设备、相关人员、资金等；年定期进行管理评审，确保管理体系有效，并持续改进。			
Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体 不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
6	Planning 策划		
6.1	Actions to address risks and opportunities	Yes	
	When planning for the FSMS, the organization shall consider the issues referred to in 4.1 and the requirements in 4.2 and 4.3 and determine the risks and opportunities that need to be addressed to: a) - d)	Yes	
6.1.1	The organization shall plan: a) - b)	Yes	
6.1.2	The actions taken by the organization to address risks and opportunities shall be proportionate to: a) - c)	Yes	
6.2	Objectives of the food safety management system and planning to achieve them	Yes	
6.2.1	The organization shall establish objectives for the FSMS at relevant functions and levels. The objectives of the FSMS shall: a) - f)	Yes	
6.2.2	When planning how to achieve its objectives for the FSMS, the organization shall determine: a) - e)	Yes	
6.3	Planning of changes	Yes	
<p>Summary:</p> <p>Measures to address risks and opportunities:</p> <p>The company considers external and internal environmental factors, the needs and expectations of relevant parties, the scope of the system, etc., conducts comprehensive analysis according to the risk judgment matrix (severity * probability of occurrence), severity and probability of occurrence, evaluates different risk levels (high risk, medium risk, low risk) for different risks, identifies the risks and opportunities existing in the company, and reduces the risk level or avoids risks by formulating and implementing countermeasures, seizes opportunities, and can fully reflect "risk-based thinking." Risk and opportunity response measures are reviewed annually, and the latest review date: 2023-11-09 After the review, the response measures are effective.</p>			

#### Food Safety Objectives:

The company has established food safety objectives at the organizational level:

Final product factory qualification rate  $\leq 100\%$

Operational prerequisite program implementation pass rate  $\geq 98\%$

100% monitoring coverage of critical control points

100% pass rate of market supervision spot check

The pursuit of food safety accidents is 0%, etc., food safety goals are decomposed into various departments, the responsible department for food safety objectives, completion time, required resources, etc. are determined, and the company conducts internal and external communication through performance appraisal and publicity and training, and the goals have been achieved since the last audit.

#### Planning for changes:

The company identified and compiled the "Change Management Procedure", which mainly involves the content of changes: changes in laws and regulations, changes in production processes, changes in raw materials, management and control of food safety affecting products in the production process, so that these factors can be safely and reasonably changed within the scope of ensuring food safety, so as to ensure the stability and improvement of product food safety, in line with standards and customer requirements. On-site inspection of the December 2023 cardboard box products to add folder-glue, cardboard, etc. to the approval records, in line with the requirements of the change procedure.

#### 应对风险和机遇的措施:

公司考虑了外部和内部环境因素, 相关方需求和期望, 体系范围等, 根据风险判定矩阵 (严重性\*发生可能性), 严重性、发生可能性进行综合分析, 对于不同风险评定不同的风险级别 (高风险、中等风险、低风险), 识别了公司存在的风险和机遇, 通过制定并实施应对措施, 降低了风险级别或规避了风险, 抓住了机遇, 能够充分体现“基于风险的思维”。每年对风险和机遇应对措施进行评审, 最近一次评审日期: 2023-11-09 评审后, 应对措施有效。

#### 食品安全目标:

公司在组织层面建立了食品安全目标:

终产品出厂合格率  $\leq 100\%$

操作性前提方案执行合格率  $\geq 98\%$

关键控制点监控覆盖率 100%

市场监督抽查合格率 100%

追求食品安全事故为 0%, 等, 食品安全目标分解到各个部门, 确定了食品安全目标负责部门、完成时间、所需资源等, 公司通过绩效考核和宣传培训的方式进行内外部沟通, 上次审核至今, 目标均达成。

#### 变更的策划:

公司识别编制有《变更管理程序》, 主要涉及变更的内容: 法律法规的变更、生产工艺的变更、原料的变更, 在生产过程中, 对影响产品食品安全进行管理和控制, 使这各个因素在保证食品安全的范围内安全合理的变动, 从而保证产品食品安全的稳定和提高, 符合标准及客户要求。现场查看 2023 年纸板盒产品增加糊盒机、纸板等的变更审批记录, 符合变更程序的要求。



Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体 不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
7	Support 支持		
7.1	Resources	Yes	
7.1.1	General	Yes	
7.1.2	People	Yes	
7.1.3	Infrastructure	Yes	
7.1.4	Work environment	Yes	
7.1.5	Externally developed elements of the FSMS	Yes	
7.1.6	Control of externally provided processes, products or services	Yes	
7.2	Competence	Yes	
7.3	Awareness	Yes	
7.4	Communication	Yes	
7.4.1	General	Yes	
7.4.2	Internal Communication	Yes	
7.4.3	External Communication	Yes	
7.5	Documented information	Yes	
7.5.1	General	Yes	
7.5.2	Creating and Updating	Yes	
7.5.3	Control of documented information	Yes	
7.5.3.1	Documented information required by the FSMS and by this document shall be controlled to ensure: a) - b)	Yes	
7.5.3.2	For the control of documented information, the organization shall address the following activities as applicable: a) - d)	Yes	
<p>Summary of section 7</p> <p>The company provides a large number of human and material resources for the establishment, implementation, maintenance and updating of the food safety management system.</p> <p>Human resource management</p>			

The training plan for 2023 has been established, and the date of development is: 2022.12.26;

Spot check training records:

Human Resource Management Procedures HY-RLZY-RZ-P01 have been formulated to specify the responsibilities of human resource management, personnel development, and relevant requirements for training

The training plan for 2023 was established, and the date of development is: 2022.12.27;

Spot check training records:

2023-03-22 , 5S training, training instructor: Zhao Jing Participants: 19 people, training records, sign-in sheets, written test assessment results, etc.;

2023.11.15, Product Quality Law, Food Safety Knowledge, Training Instructor: Zhang Xue, providing training records, sign-in sheets, written test assessment results, etc.;

2023-07-10, Specification of control points of each process of anti-confusion measures, training lecturer: Yang Lin, participants: 14 people, etc., training sign-in form, self-evaluation form, etc.;

2023-9-15 Clearance Management Regulations, Training Instructor: Yang Lin There are 12 participants, and training records, sign-in sheets, written test assessment results, etc. are provided;

2023-11-13 Foreign Object Control Specifications Training Instructor: Yang Lin There are 12 participants, providing training records, sign-in sheets, written test assessment results, etc.;

2023-11-13 , Warehouse Sanitation and Cleaning Training Lecturer: Wang Zhen 15 participants, providing training records, sign-in sheets, written test assessment results, etc.;

2023-6-15 Equipment Maintenance and Repair Training Training Lecturer: Zhao Jing 10 participants, providing training records, sign-in sheets, written test results, etc.;

Health certificate: Tianjin Airport Hubin Community Health Service Center.

Huang Qinong, valid until: 2024.2.24;

Zhai Fuma, valid until: 2025.1.19;

Guo Lixia, valid until: 2024.2.24;

Wu Junlan, valid until: 2024.7.26;

Guo Junhua, valid until: 2024.10.18;

Yang Fengying, valid until: 2025.1.19;

The induction training for new employees includes San'an education, factory discipline and factory rules, corporate culture, food safety, etc., spot check: Zhang Zhikun training records, training date: 2024.1.9, training records are provided, and written examinations are provided.

Personnel Qualifications:

High-voltage electrician, Tian Yongliang, certificate number: T131133\*\*\*2810, valid until: 2028.7.7, issuing authority: Tianjin Emergency Management Bureau;

Forklift, Yang Zhiqiang, license number: 120110\*\*\*1212, valid until: September 2024, issuing authority: Tianjin Binhai New Area Market Supervision and Administration Bureau;

Special Equipment Management, Zhou Dong, License No.: 371425\*\*\*8174, valid until: July 2026, Issuing Authority: Tianjin Municipal Market Supervision and Administration Commission;

Equipment maintenance

The equipment and facility management procedure HY-SC-P02 has been formulated to manage the provision and maintenance of the company's equipment and facilities to ensure that the compliance

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requirements of products are met, and the needs of environmental treatment and pollution prevention and safety protection are met. Establish control procedures for equipment and facilities to ensure the smooth production of each process and ensure the safe operation of equipment and human safety.

Equipment maintenance requirements have been established, and equipment ledgers have been established, including printing machines, folder-glueers, paper bowl machines, purple sterilizers, etc

The 2023 equipment maintenance plan has been established

View

2023-10-13 2# Paper Bowl Machine Inspection Records of Heating Elements and Transmission Parts;

2022-10-07 2# printing machine tachogenerator, main motor inspection record;

2023-12-2 Manual die-cutting machine Transmission motor and various transmission parts inspection records

2023-08-19 Embossing machine Gearbox inspection record;

2023-08-21 UV antivirus machine inspection record;

2023-07-14 Chip remover Transmission motor and various transmission parts inspection records

2023-8-16 Inspection records of the transmission motor and each transmission part of the smart paper cup machine

Maintenance Record:

2023-08-08 2# Paper Bowl Machine Bearing base casting crack Replace the new bearing

2024-01-19 UV lamp anti-virus motor defect motor winding

Special Equipment:

Forklift: Vehicle number: factory Neijin T-06147, report number: Binchang Dingjian No. 2023-02127, inspection date: 2023-4-12, valid until 2025.4, verification unit: Tianjin Binhai New Area Inspection and Testing Center;

Compressed air storage tank, unit number: 01, report number: Binrong Dingjian No. 2022-02413, inspection date: 2022.8.1, valid until October 2026, verification unit: Tianjin Binhai New Area Inspection and Testing Center;

Safety valve, condenser, report number: Binhai valve calibration 2023-03690, inspection date: 2023-11-16, valid until November 15, 2024, verification unit: Tianjin Binhai New Area Inspection and Testing Center;

Pressure gauge, seismic pressure gauge, report number: ZHJYL24010336, inspection date: 2024.1.8, valid until July 7, 2024, verification unit: Zhongheng Inspection and Testing Technology (Tianjin) Co., Ltd.;

The company has formulated the requirements of the working environment, considered the temperature and humidity of the workshop and office, personnel psychology, discrimination and other factors, and audited the working environment on site to meet the standard requirements.

External development factors: The company's products are carried out by customers or group headquarters, and the factory is responsible for trial production samples. There have been no new products in the past year after the on-site audit.

There is no external training, consulting services and internal audits for FSMS.

## External supplier management

The main responsibilities are to ensure that the quality of production materials is guaranteed and does not affect the production progress. Establish procurement process control procedures.

Evaluate the performance of the supplier every month, from the timely arrival rate, arrival qualification rate, NCR times, and service evaluation:

Check the supplier's performance evaluation form: 2023-08, 2023-10, 2023-12 evaluation records:

Paper stock, Anhui Kailai Paper Effective Company, score: 92 points;

Ink, Tianjin Toyo Ink Co., Ltd., score: 98 points;

Glue, Hengruiyuan Technology Development (Beijing) Co., Ltd., score: 98 points;

## Supplier qualification and tripartite test report spot check:

OPRP1 coated cardboard, Anhui Kailai Paper, provide a valid business license, industrial product production license, valid until 2028.2.7, tripartite test report, number: C2023-Q0343, test items, appearance quality, sensory requirements, size deviation, coliform bacteria, Salmonella, etc., according to GB4806.8-2022, Bengbu Institute of Product Quality Supervision and Inspection, CMA181200111277;

OPRP1 cardboard, Zhuhai Hongta Yanlord Packaging Co., Ltd., No. HCWT2301376, according to GB4806.8-2022, CNAS L1300.

Glue, Dongguan Heyu Paste Products Co., Ltd., provide a valid business license, manufacturer: Shanghai Aopu Chemical Co., Ltd., provide a business license, tripartite test report, number: T52310320422TC, test items: lead, mercury, chromium, polybrominated biphenyls, dibutyl phthalate, etc., testing agency: Shenzhen SGS laboratory;

Ink, Tianjin Toyo Ink Co., Ltd., provide a valid business license, tripartite test report, number: TSNE2303486210, test items, according to ROHS Directive 2011/65/EU Annex II Amendment Directive EU2015/863 - lead, mercury, chromium, polybrominated biphenyls, dibutyl phthalate, etc., testing agency: SGS Tianjin Co., Ltd. CNAS L2274;

PE film bag, Panjin Jintian Plastic Industry Effective Company, report number: Anhui Quality Inspection No. 2023-SL-1371, according to GB4806.7, CNAS L10568.

## Outsourcing Services:

This includes waste disposal, transportation services, and pest treatment. Management according to the purchase contract.

The waste includes packaging products with the customer's LOGO, which are uniformly shredded and disposed of by Zaoqiang Shunxing Paper Products Co., Ltd., and a disposal agreement has been signed, which is valid until December 31, 2024.

Hazardous Waste Service Provider: Processor: Tianjin Binhai Hejia Veolia Environmental Services Co., Ltd., with a service contract valid until July 19, 2024.

Logistics service providers: according to the transportation area, Tianjin Changyu, Tianjin Jincheng Logistics, Beijing Jinchenda, China Post and other 14 logistics companies. All have signed a contract for transportation and service.

Tianjin Changyu Logistics Co., Ltd. was spot-checked, and the business scope and term of the business license met the requirements. The road transport business license is valid until June 11, 2026;

The logistics provider is evaluated on a monthly basis, including the timeliness of delivery, the arrival rate at the agreed time, the customer satisfaction rate, the damage rate, etc.

#### Pest Control:

Pest pest outsourcing party: Zhejiang Bangbang Environmental Technology Group Co., Ltd., signed a contract until May 9, 2024, Prevention and control projects: rats, cockroaches, flies, mosquitoes, operation frequency: twice a month from March to October every year, once a month from November to February. The business scope and business period of its business license meet the requirements, and the A-level certificate of pest control service is valid until 2024.3.25, and a list of drug uses is provided, including the name of the drug, target pests, active ingredients, manufacturer, pesticide registration certificate number, etc. The registration certificates of fluorratin and permethrin tetraflurane pesticides are all within the validity period, and drug labels and MSDS are provided. Floor plans of pest infestation facilities are available.

Service records: 2023-08, 2023-10, 2024-01 and other monthly service records.

The pest control officer provides a pest control officer qualification certificate and a health certificate, which are valid.

Provide monthly service reports every month, and spot check the integrated pest management reports for December 2022 and January 2023, including service plans, service summaries, trend analysis, risk assessments, service plans and service priorities for the next month.

#### Communication:

The content of external communication includes: suppliers, related parties, customers, laws and regulations supervision department, etc., the responsibilities and authority of external communication have been clearly defined, and the external communication personnel are the leaders of the food safety team for major impact events.

Internal communication: The company has formed a good internal communication mechanism, and will hold regular meetings every month to review the food safety status of the previous month and formulate plans and improvement measures for the next month. In the event of a change, the company will communicate the information according to the urgency of the problem, such as internal meetings, document transmission, etc. The on-site factory audit was conducted for the November 2023 factory meeting.

#### Sale:

The process mainly includes the collection and review of customer requirements, product quotation, contract review, order receipt and delivery confirmation, delivery monitoring, receipt and handling of customer complaints, etc.

The contract review management regulations, HY-YX-KF-P01-S01, have been formulated, which stipulate the contract signing process and review process

The sample is as follows

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100% of domestic orders, Mars, Nestle, Haoliyou, Mengniu and other customers, the company has established the "Product Complaint Handling Control Procedure"

View order: YSD230210025, carton (wafer substitute cocoa butter), customer: Nestle, specific requirements reflected in the order, special requests by phone or e-mail.

Order No.: YSD2312080027 Color Printing Box (Longan Lotus Seed Eight Treasure Porridge) Customer: Hebei Dali Food The specific requirements are reflected in the order, and the special requirements are communicated by phone or email.

The customer declares that there are no food-related complaints in 2023.

#### Documented information management

The "Written Information Control Procedure" has been formulated, and the company's document structure is defined as three levels, and the preparation procedures and filing methods are clarified, such as the manual is the first level, the program documents are the second level, and the third level documents are the departmental operating procedures. Among them, manuals and procedures are created, updated, stored and retained by the quality inspection department, and other departments can be borrowed, and departmental documents are archived to the quality management department. The electronic version of the written information is kept by the quality inspection department, backed up on at least two computers, and the issuance records of the department's documents and the electronic version of the written information are viewed on the spot, such as:

Internal audit control procedures

Manage review control procedures

Potentially Unsafe Product Control Procedures

Documentation is reviewed annually and records are kept for 2 years.

The quality management department is responsible for identifying and collecting relevant laws and regulations to form a "list of foreign folders", and the collected laws and regulations basically meet the needs of the company, such as GB4806.6 GB4806.8, etc., the Food Safety Law of the People's Republic of China, etc.

公司提供了大量的人力和物力资源用于 食品安全管理体系的建立、实施、保持和更新。

#### 人力资源管理

建立了 2023 年培训计划，制定日期：2022.12.26；

抽查培训记录：

制定了人力资源管理程序 HY-RLZY-RZ-P01 规定了人力资源管理的职责、人员的开发，培训的相关要求

建立了 2023 年培训计划，制定日期：2022.12.27；

抽查培训记录：

2023-03-22，5S 培训，培训讲师：赵静参加人员：19 人，提供有培训记录、签到表、笔试考核成绩等；

2023.11.15，产品质量法、食品安全知识，培训讲师：张雪，提供有培训记录、签到表、笔试考核成绩等；

2023-07-10，防混淆措施各工序管控点规范，培训讲师：杨琳，参加人员：14 人等，提供有培训签到表、自我评价表等；

2023-9-15 清场管理规定，培训讲师：杨琳 参加人员 12 人，提供有培训记录、签到表、笔试考核成绩等；

2023-11-13 异物管控规范 培训讲师：杨琳 参加人员 12 人，提供有培训记录、签到表、笔试考核成绩等；

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2023-11-13，库房卫生清洁 培训讲师：王震 参加人员 15 人，提供有培训记录、签到表、笔试考核成绩等；  
2023-6-15 设备保养与维修培训 培训讲师：赵静 参加人员 10 人，提供有培训记录、签到表、笔试考核成绩等；

健康证：天津空港湖滨社区卫生服务中心。

黄起农，有效期至：2024.2.24；

翟福马，有效期至：2025.1.19；

郭丽霞，有效期至：2024.2.24；

吴俊兰，有效期至：2024.7.26；

郭俊花，有效期至：2024.10.18；

杨凤英，有效期至：2025.1.19；

新员工入职培训包括三安教育、厂纪厂规、企业文化、食品安全等，抽查：张志坤培训记录，培训日期：2024.1.9，提供有培训记录，笔试考核。

人员资格：

高压电工，田勇亮，证号：T131133\*\*\*2810，有效期至：2028.7.7，发证机关：天津市应急管理局；

叉车，杨志强，证号：120110\*\*\*1212，有效期至：2024 年 9 月，发证机关：天津市滨海新区市场监督管理局；

特种设备管理，周栋，证号：371425\*\*\*8174，有效期至：2026 年 7 月，发证机关：天津市市场监督管理委员会；

#### 设备维护

制定了设备设施管理程序 HY-SC-P02 对公司设备设施的提供和维护实施管理，以保证满足产品的符合性要求，同时满足环境治理和污染防治以及安全防护的需要。建立设备设施的控制程序，使各工序顺利生产及确保设备的安全运行和人的安全保障。

建立了设备维护要求，建立了设备台账，包括 印刷机、糊盒机、纸碗机、紫消毒机等

建立了 2023 设备维护计划

查看

2023-10-13 2#纸碗机 加热元件、各传动部位检查记录；

2022-10-07 2#印刷机 测速发电机、主电机检查记录；

2023-12-2 手动模切机 传动电机、各传动部位检查记录

2023-08-19 压纹机 减速箱检查记录；

2023-08-21 紫外杀毒机 检查记录；

2023-07-14 除屑机 传动电机、各传动部位检查记录

2023-8-16 智能纸杯机 传动电机、各传动部位检查记录

维修记录：

2023-08-08 2#纸碗机 轴承底座铸造有裂痕 更换新的轴承

2024-01-19 紫外灯杀毒 电机缺陷 电机绕组

特种设备：

叉车：车号：厂内津 T-06147，报告编号：滨场定检 2023-02127 号，检验日期：2023-4-12，有效期至 2025.4，检定单位：天津市滨海新区检验检测中心；

压缩空气储罐，单位内编号：01，报告编号：滨容定检 2022-02413 号，检验日期：2022.8.1，有效期至 2026 年 10 月，检定单位：天津市滨海新区检验检测中心；

安全阀，冷凝器，报告编号：滨阀校验 2023-03690，检验日期：2023-11-16，有效期至 2024 年 11 月 15 日，检定单位：天津市滨海新区检验检测中心；

压力表，抗震压力表，报告编号：ZHJYL24010336，检验日期：2024.1.8，有效期至 2024 年 7 月 7 日，检定单位：中恒检验检测科技（天津）有限公司；

公司制定了工作环境的要求，考虑了车间及办公室的温湿度，人员心理、歧视等因素，现场审核工作环境满足标准要求。

外部开发因素：公司的产品均有客户或者集团总部进行，工厂负责试制样品。现场审核近一年未有新产品。没有 FSMS 的外部培训，咨询服务和内部审核。

#### 外部供方管理

主要职责，物料采购入供应商评价等，保证生产物料质量有保障，不影响生产进度。建立采购过程控制程序。每月对供方业绩进行评价，从到货及时率、到货合格率、NCR 次数、服务进行评价：

查看供方业绩评价表：2023-08、2023-10、2023-12 评估记录：

纸料，安徽开来纸业有效公司，得分：92 分；

油墨，天津东洋油墨有限公司，得分：98 分；

胶，恒瑞源技术发展（北京）有限公司，得分：98 分；

#### 供应商资质及三方检测报告抽查：

OPRP1 淋膜纸板，安徽开来纸业，提供有效期内的营业执照，工业产品生产许可证，有效期至 2028.2.7，三方检测报告，编号：C2023-Q0343，检测项目，外观质量、感官要求、尺寸偏差、大肠菌群、沙门氏菌等，依据 GB4806.8-2022，蚌埠产品质量监督检验研究院，CMA181200111277；

OPRP1 纸板，珠海红塔仁恒包装股份有限公司，编号：HCWT2301376，依据 GB4806.8-2022，CNAS L1300.

胶水，东莞市合裕粘贴制品有限公司，提供有效期内的营业执照，生产商：上海奥普化工有限公司，提供有营业执照，三方检测报告，编号：T52310320422TC，检测项目：铅、汞、铬，多溴联苯、邻苯二甲酸二丁酯等，检测机构：深圳 SGS 实验室；

油墨，天津东洋油墨有限公司，提供有效期内的营业执照，三方检测报告，编号：TSNE2303486210，检测项目，依据 ROHS 指令 2011/65/EU 附录 II 修正指令 EU2015/863-铅、汞、铬，多溴联苯、邻苯二甲酸二丁酯等，检测机构：SGS 天津有限公司 CNAS L2274；



PE 膜袋，盘锦金田塑业有效公司，报告编号：皖质检字第 2023-SL-1371, 依据 GB4806.7, CNAS L10568.

#### 外包服务：

包括有废弃物处理、运输服务、虫鼠害处理。依据采购合同管理。

废弃物包括带客户 LOGO 的包装产品，公司统一切碎处理，由枣强县顺兴纸制品有限公司负责，签订有处理协议，有效期至 2024 年 12 月 31 日。

危险废弃物服务商：处理方：天津滨海合佳威立雅环境服务有限公司，签订有服务合同，有效期至 2024 年 7 月 19 日。

物流服务商：依据运输区域进行划分，天津昌宇、天津金成物流、北京金辰达、中国邮政等 14 家物流公司。均签订有运输和服务合同。

抽查天津昌宇物流有限公司，营业执照经营范围和期限均符合要求。道路运输经营许可证有效期至 2026 年 6 月 11 日；

对物流供应商每月进行评价，评价内容包括发货及时性、约定时间到货率、顾客满意率、破损率等内容。

#### 虫害控制：

虫鼠害外包方：浙江帮帮环境科技集团有限公司，签订有承包合同至 2024 年 5 月 9 日，防治项目：老鼠、蟑螂、苍蝇、蚊子，作业频次：每年 3-10 月份每月两次，11-2 月，每月一次。其营业执照经营范围和营业期限均符合要求，有害生物防制服务 A 级证书，有效期至 2024.3.25；提供有药品使用清单，清单包括药品名称、靶标害虫、有效成分、生产厂家，农药登记证号等内容。抽查氟鼠灵、氯菊四氟醚农药登记证均在有效期内，提供有药品标签、MSDS。提供有虫鼠害设施平面图。

服务记录：2023-08、2023-10、2024-01 等月度服务记录。

有害生物防制员提供有有害生物防制员资格证及健康证，均有效。

每月提供月度服务报告，抽查 2022 年 12 月、2023 年 1 月虫害综合管理报告，包括服务计划、服务汇总、趋势分析、风险评估、次月服务计划及服务重点等。

#### Communication 沟通：

外部沟通的内容包括：供应商、相关方、客户、法律法规监管部等，外部沟通的职责权限得到了明确规定，重大影响事件，外部沟通人员为食品安全小组组长。

内部沟通：公司形成了良好的内部沟通机制，每月都会举行例会，回顾上月的食品安全状况，并制定下面一个月的计划和改进措施。发生变更的信息，公司会视问题的紧急情况实施沟通，如内部会议、文件传送等。现场审核工厂进行了 2023 年 11 月工厂会议。

#### 销售：

该过程主要包括客户要求的收集和评审，产品报价、合同评审、订单接收与交期确认、交付监控、客户投诉的接收和处理等。

制定了合同评审管理规定，HY-YX-KF-P01-S01，规定了合同的签订流程和评审流程等

#### 抽样如下

国内订单 100%；玛氏、雀巢、好丽友、蒙牛等客户；公司建立了《产品投诉处理控制程序》

查看订单：YSD230210025，纸盒（威化代可可脂巧克力），客户：雀巢，具体要求体现订单中，特殊要求通过电话或邮件沟通。

订单号: YSD2312080027 彩印箱 (桂圆莲子八宝粥) 客户: 河北达利食品 具体要求体现订单中, 特殊要求通过电话或邮件沟通。

客户申明 2023 年没有食品相关投诉。

#### 成文信息管理

制定了《成文信息控制程序》，明确了公司的文件架构为三级，编写规程、归档方法等，如手册为一级、程序文件为二级，三级文件为部门操作规程。其中手册、程序由质检部创建、更新、存储和保留，其他部门可以借阅，部门文件归档到质量管理部，各部门更改时递交更改申请，并批准后重新发布，作废文件直接销毁。电子版成文信息由质检部统一保管，在至少两台电脑备份，现场查看了部门文件的发放记录和电子版成文信息，如：

内部审核控制程序

管理评审控制程序

潜在不安全产品控制程序

文件每年回顾一次，记录保存 2 年。

相关的法律法规由质量管理部负责识别并收集形成“外来文件夹清单”，收集的法律法规基本满足公司的需要，如 GB4806.6 GB4806.8 等，中华人民共和国食品安全法等。

Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
8	Operation 运行		
8.1	Operational planning and control	Yes	
8.2	Prerequisite programs (PRPs)	Yes	
8.2.1	The organization shall establish, implement, maintain and update PRPs to facilitate the prevention and/or reduction of contaminants (incl food safety hazards) in the products, product processing and work environment	Yes	
8.2.2	The PRPs shall be: a) - d)	Yes	
8.2.3	When selecting and/or establishing PRPs, the organization shall ensure that applicable statutory, regulatory and mutually agreed customer requirements are identified. The organization should consider: a) - b)	Yes	
8.2.4	When establishing PRPs the organization shall consider: a) - l)	Yes	
8.3	Traceability system	Yes	

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8.4	Emergency preparedness and response	Yes	
8.4.1	General	Yes	
8.4.2	Handling of emergencies and incidents	Yes	
8.5	Hazard control	Yes	
8.5.1	Preliminary steps to enable hazard analysis	Yes	
8.5.1.1	General	Yes	
8.5.1.2	Characteristics of raw materials, ingredients and product contact materials	Yes	
8.5.1.3	Characteristics of end products	Yes	
8.5.1.4	Intended use	Yes	
8.5.1.5	Flow diagrams and description of processes	Yes	
8.5.1.5.1	Preparation of the flow diagrams	Yes	
8.5.1.5.2	On-site confirmation of the flow diagrams	Yes	
8.5.1.5.3	Description of processes and process environment	Yes	
8.5.2	Hazard analysis	Yes	
8.5.2.1	General	Yes	
8.5.2.2	Hazard identification and determination of acceptable levels	Yes	
8.5.2.2.1	The organization shall identify and document all food safety hazards that are reasonably expected to occur in relation to the type of product, type of process and process environment. The identification shall be based on: a) -e)	Yes	
8.5.2.2.2	The organization shall identify step(s) (e.g. receiving raw materials, processing, distribution and delivery) at which each food safety hazard can be present, be introduced, increase or persist. When identifying hazards the organization shall consider: a) - c)	Yes	
8.5.2.3	The organization shall determine the acceptable level in the end product of each food safety hazard identified, whenever possible. When determining	Yes	

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	acceptable levels, the organization shall: a) - c)		
8.5.2.3	Hazard assessment	Yes	
8.5.2.4	Selection and categorization of control measure(s)	Yes	
8.5.2.4.1	Based on the hazard assessment, the organization shall select an appropriate control measure or combination of control measures that will be capable of preventing or reducing the identified significant food safety hazard to defined acceptable levels	Yes	
8.5.2.4.2	In addition, for each control measure, the systematic approach shall include an assessment of the feasibility of: a) - c)	Yes	
8.5.3	Validation of control measure(s) and combination of control measures	Yes	
8.5.4	Hazard control plan (HACCP/OPRP plan)	Yes	
8.5.4.1	General	Yes	
8.5.4.2	Determination of critical limits and action criteria	Yes	
8.5.4.3	Monitoring systems at CCPs and for OPRPs	Yes	
8.5.4.4	Actions when critical limits or action criteria are not met	Yes	
8.5.4.5	Implementation of the hazard control plan	Yes	
8.6	Updating the information specifying the PRPs and the hazard control plan	Yes	
8.7	Control of monitoring and measuring	Yes	
8.8	Verification related to PRPs and the hazard control plan	Yes	
8.8.1	Verification	Yes	
8.8.2	Analysis of results of verification activities	Yes	
8.9	Control of product and process nonconformities	Yes	
8.9.1	General	Yes	
8.9.2	Corrections	Yes	
8.9.2.1	The organization shall ensure that when critical limits at CCPs and/or action criteria for OPRPs are not met, the products affected are identified and	Yes	

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	controlled with regard to their use and release		
8.9.2.2	When critical limits at CCPs are not met, affected products shall be identified and handled as potentially unsafe products (see 8.9.4)	Yes	
8.9.2.3	Where action criteria for an OPRP are not met, the following shall be carried out: a) - c)	Yes	
8.9.2.4	Documented information shall be retained to describe corrections made on nonconforming products and processes, including a) - c)	Yes	
8.9.3	Corrective actions	Yes	
8.9.4	Handling of potentially unsafe products	Yes	
8.9.4.1	General	Yes	
8.9.4.2	Evaluation for release	Yes	
8.9.4.3	Disposition of nonconforming products	Yes	
8.9.5	Withdrawal/recall	Yes	

#### Summary:

The manual established by the company clearly stipulates the process of the established food safety management system and the connection between the processes, and clarifies the company's operation methods for each process according to the requirements of the food safety management system. Risks and opportunities are planned and effectively implemented by each department, and the outsourcing processes such as logistics and transportation, pest control, etc. are identified.

The company has established a prerequisite plan in accordance with GB31603 and ISO/TS22002-4 and related requirements, stipulating PRP requirements for infrastructure, raw materials, storage and pest control, on-site verification infrastructure, plant layout, waste management, pest control, cleaning and disinfection, personnel sanitation and facilities, rework, withdrawal, food packaging information and customer communication, food protection and bioterrorism, etc., as detailed in the ISO/TS22002-4 checklist.

#### Traceability and recall

Establish product traceability and recall control procedures: 2023-5-12, cardboard box milk chocolate beans, production date: 2022-12-07, quantity 20000, and traceability can be traced back to all raw and auxiliary material batches and production records, It takes less than 3 hours, and the material balance can be controlled within the range, and the traceability is effective. At the same time, the recall is 100%, and the simulated recall is effective.

On-site traceability of paper bowl batch 2023-08-23, it takes 2 hours, the material balance can be controlled within the range, and the corresponding raw and auxiliary material batches and production records can be traced.

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#### Emergency drills:

The "Emergency Response Control Procedures" have been established to identify and manage emergencies that affect food safety. Identified emergencies include: sudden power outages, water outages, and fires during the production process.

Check the most recent drill is: 2023-10-24 Fire drill, training records and drill reports have been archived and are valid.

Zhang Xueyan, the quality manager of the factory, is the leader of the food safety team, responsible for maintaining the food safety management system, with more than 5 years of work experience in food packaging enterprises, and the members of the food safety team have many years of experience in the production of food packaging materials or management system.

The food safety team comes from a variety of departments and its members are well educated and trained, knowledgeable and experienced.

In the company's hazard control plan documents, the characteristics of raw materials, excipients, materials in contact with the product, and the final product are described, based on the corresponding laws and regulations, customer requirements, internal requirements and other requirements, and the description of the characteristics includes: chemical, biological and physical properties, composition of the formulated excipients, including additives and processing aids, place of origin, production method, packaging and delivery method, storage conditions and shelf life, and pretreatment before use or production. As:

Single-gloss white kraft paper:

#### 1. Physical Characteristics:

- a) Sensory: normal color, no odor, mildew or other dirt
- b) Immersion solution: The immersion solution obtained from the migration test should not have sensory deterioration such as color and odor.

#### 2. Chemical Properties:

- a) Lead (Pb)  $\leq 3.0\text{mg/kg}$
- b) Arsenic (as As)  $\leq 1.0\text{mg/kg}$
- c) Formaldehyde  $\leq 1.0\text{mg/dm}^2$
- d) Fluorescent substances (wavelengths 254nm and 365nm): negative
- e) Total migration  $\leq 10\text{ mg/dm}^2$
- f) Potassium permanganate consumption (water, 60 °C, 2h)  $\leq 40\text{ mg/kg}$
- g) Heavy metals (Pb) (4% acetic acid, 60 °C, 2h)  $\leq 1\text{ mg/kg}$
- h) 1,3-Dichloro-2-propanol ug/L
- i) 3 chloro1,2 propylene glycol ug/L  $\leq 12\text{ mg}$

#### 3. Biological characteristics:

- a) Coliform / (/50 cm<sup>2</sup>): not detectable
- b) Salmonella/(/50cm<sup>2</sup>): not detectable
- c) Mold  $\leq 50\text{ CFU/g}$

Executive standard: GB4806.8-2022

Final product

Food packaging cardboard boxes:

1) Physical Characteristics:

- a) Molding quality: regular and upright molding
- b) Surface quality: The surface is clean and free of foreign matter
- c) Printing quality: the outline of the pattern is clear and complete, the color is uniform, and there is no obvious color spot
- d) Peculiar smell: no peculiar smell
- e) Dimensional deviation of  $\pm 5\text{mm}$ ; Thickness deviation is  $\pm 15\%$ ; Quantitative deviation of  $\pm 10\%$

2. Chemical Properties:

- a) Lead (Pb)  $\leq 3.0\text{mg/kg}$
- b) Arsenic (as As)  $\leq 1.0\text{ mg/kg}$
- c) Formaldehyde  $\leq 1.0\text{ mg/dm}^2$
- d) Fluorescent substances (wavelengths 254nm and 365nm): negative
- e) Total migration  $\leq 10\text{ mg/dm}^2$
- f) Potassium permanganate consumption (water, 60 °C, 2h)  $\leq 40\text{ mg/kg}$
- g) Heavy metals (Pb) (4% acetic acid, 60°C, 2h)  $\leq 1\text{ mg/kg}$
- h) 1,3-dichloro-2-propanol ug/L
- i) 3 chloro1,2 propylene glycol ug/L  $\leq 12\text{ mg}$

3. Biological characteristics:

- a) Coliform bacteria/(/50cm<sup>2</sup>) should not be detected
- b) Salmonella/(/50 cm<sup>2</sup>) should not be detected
- c) Mold  $\leq 50\text{ CFU/g}$

Executive standard: Q/HLBZ02-2020 "Cartons for Food Packaging"

Intended use of finished products: for packaging of chocolates, candies, etc., non-intended use: cannot be reused

On-site confirmation of flowcharts:

The company clarified the production process of the product, and the food safety team verified the entire process flow chart, and the on-site visit verified that the process flow chart fully reflected the production process of the company's products. The food safety team confirmed the flow chart on site on 2023-10-13, and the flow chart was consistent with the actual situation.

Description of the process and process environment:

The food safety team describes the process and process environment in the premise plan, providing the plant/workshop plan, people/airflow/logistics diagram, etc., and the production process description part of the HACCP plan describes the material flow direction, process parameters, control measures, etc. during the processing process. It is detailed enough to carry out a hazard analysis.

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#### Hazard Identification and Determination of Acceptable Levels:

The HACCP team identified each food safety hazard according to the preparatory steps, including physical, chemical, biological, allergens, etc., and determined the acceptability of the hazard.

#### Hazard Assessment:

Based on the described characteristics of raw materials, final product characteristics, and process descriptions, the food safety team conducted a hazard analysis for the raw materials, product contact materials, and each production process, and the identified hazards were evaluated based on the severity (S) and probability (L) of their occurrence to determine their significance.

#### Selection and classification of control measures

CCP and OPRP were classified, considering the severity and likelihood of control failures, and the feasibility of monitoring control failures. For each identified significant hazard, the food safety team has developed 2 OPRP plans and 2 HACCP plans to control the hazards at an acceptable level.

#### Confirmation of control measures and combinations of control measures:

The company has established requirements for the validation of control measures and control combinations, and the confirmation is carried out before the implementation of control measures and control combinations or annually, check the latest OPRP/HACCP plan confirmation: 2023-10-13;

#### Determination of key limits and guidelines for action:

The hazard control plan specifies the critical limits for measurable critical control points and the operational prerequisites for measurable or observable operational scenarios, and the basis for the critical limits and action guidelines has been documented.

#### Monitoring system for CCP points and OPRP points:

A hazard control plan monitoring system has been established, and corresponding control measures have been formulated for CCP/OPRP, including: control hazards, control methods, monitoring personnel, monitoring frequency, corrective measures, etc. See the "Key processing steps and Control measures:" section for details.

#### Actions taken when critical limits or action guidelines are not met:

The hazard control plan specifies the corrective and corrective actions to be taken when critical limits and action guidelines are not met. See the "Key processing steps and Control measures:" section for details

#### Implementation of the Hazard Control Plan:

OPRP/HACCP program monitoring records are as follows:

OPRP1 coated cardboard, Anhui Kailai Paper, provide a valid business license, industrial product production license, valid until 2028.2.7, tripartite test report, number: C2023-Q0343, test items,



appearance quality, sensory requirements, size deviation, coliform bacteria, Salmonella, etc., according to GB4806.8-2022, Bengbu Institute of Product Quality Supervision and Inspection, CMA181200111277; OPRP1 cardboard, Zhuhai Hongta Yanlord Packaging Co., Ltd., No. HCWT2301376, according to GB4806.8-2022, CNAS L1300.

#### Production process control

On-site production, printing, production, wine, chocolate, cardboard box, glue box production, Disney Iron Listening Locket CCP1 paper gasket UV disinfection  $\leq 40\text{m/min}$ ,  $\leq 1000$  hours, CCP2 paper discs are sterilized for 30min,  $\leq 1000$  hours, OPRP2 is sterilized every 4 hours

Spot check past production records:

#### Paper gaskets

Order No. SCD2306050019, Production Date 2023-06-25, Paper Gasket

Production construction order, workshop hygiene inspection record, CCP2 sterilization monitoring record -  $40\text{m/min}$  331 hours,

Embossing machine process parameter monitoring record

OPRP2 - 30min of packaging material disinfection record, personnel hand disinfection record every half hour

Make a job product inspection record - the first inspection is OK

At the same time, check the 2023-11-22 gasket production record, and the OPRP/CCP control meets the requirements

#### Paper bowls

Paper bowl, order number SCD2312110028, production date 2023-12-12

Production construction order, workshop hygiene inspection record,

Printing machine process parameter monitoring record -  $4500\text{ps/h}$

Job product inspection record - printing machine first inspection OK,

Process parameter monitoring record - cutting machine

Operation product inspection record - cutting machine first inspection OK,

Process parameter monitoring record - paper bowl machine, heat sealing  $330$  degrees

The inspection record of the second operation product - the first inspection of the paper bowl machine is OK

CCP2 disinfection monitoring record - 30min, 30w, 510 hours for the inlet of base paper and paper discs

Ultraviolet disinfection of CCP1 conveyor belt  $\leq 40\text{m/min}$ ,  $\leq 1000$  hours

OPRP2—Disinfection record of packaging material for 30min, and hand disinfection record of personnel every 4 hours

Make a job product inspection record - the first inspection is OK

At the same time, check the following paper bowl production records: order number SCD2311060009 Date: 2023-11-10, OPRP/CCP control meets the requirements

#### Cardboard box

Order number SCD2311150002, production date 2023-12-27  
 Production construction order, workshop hygiene inspection record,  
 Printing machine process parameter monitoring record - 5500ps/h  
 Job product inspection record - printing machine first inspection OK,  
 Process parameter monitoring record - cutting machine  
 Operation product inspection record - cutting machine first inspection OK,  
 CCP2 disinfection monitoring record - 30min, 30w, 1000 hours  $\leq$  the inlet of base paper discs  
 Ultraviolet disinfection of CCP1 conveyor belt  $\leq$ 40m/min,  $\leq$ 1000 hours  
 OPRP2—Disinfection record of packaging material for 30min, and hand disinfection record of personnel every 4 hours  
 Make a job product inspection record - the first inspection is OK  
 At the same time, check the following production records: order number SCD202310130001 Date: 2023-10-23, OPRP/CCP control meets the requirements;

A cleaning plan has been established to clean environmental equipment, etc. Clean the floor, walls, tuyere, etc. every month, check the workshop hygiene inspection records, 2023-10, 2023-11 and other packaging workshops, drying room hygiene inspection records.

Warehouse management  
 It is equipped with a raw material warehouse, a chemical warehouse and a finished product warehouse, which can be first-in, first-out, and inspect the environmental hygiene of logistics and warehousing every day.  
 Warehouse hygiene inspection records, including raw and auxiliary material warehouses and finished product warehouses.  
 View the finished product library  
 Cardboard box batch 2024-01-15;  
 Paper Bowl Lot 2023-08-23;  
 raw material warehouse,  
 Coated Paper Batch 2023-11-26;  
 504 Glue Glue Lot 2024-01-05;  
 Yellow ink batch2023-11-07;  
 Base Paper Lot 2023-11-10  
 Sanitation and cleaning inspection of the delivery vehicle: check whether there is no peculiar smell, no shedding, no mildew, no debris in the container compartment, the integrity of the container door, whether the truck is locked and sealed, etc., take photos after loading, and keep videos of the loading process;  
 View:  
 2023-12-26, Tianjin C23885 sent to good \* friends  
 2023-12-25 津 FP2136 Sent to good friends  
 2023- 12-28 Tsu ALM125 to Mars

#### Updates to pre-premise scenarios and hazard control plans

When raw materials, excipients and products come into contact with material properties, flow charts and processes, etc., they are updated by the food safety team, and the on-site review prerequisite plan and hazard control plan are up to date.

#### Control of monitoring and measurement:

Establish a monitoring and measurement equipment ledger and develop an inspection plan.

Provide a measuring equipment ledger and a certificate of external inspection of sampling and measurement:

Electronic balance, report number: DN230086590004, calibration unit: Dongguan Dien Testing Co., Ltd., CNAS L6483;

Electronic stiffness tester, report number: DN230086590005, calibration unit: Dongguan Dien Testing Co., Ltd., CNAS L6483;

Burst Strength Tester, Report No.: DN230086590009, Calibration Unit: Dongguan Dien Testing Co., Ltd., CNAS L6483;

Thermohygrometer, report number: DN230086590011, calibration unit: Dongguan Dien Testing Co., Ltd., CNAS L6483;

Steel ruler, report number DN220446180009, calibration unit: Dongguan Dien Testing Co., Ltd., CNAS L6483;

#### Validation related to prerequisite scenarios and hazard control plans:

The verification is planned, including the verification frequency, verification content, verification method, etc., and the CCP/OPRP/PRP is verified once a year

#### On-site viewing:

PRP Verification: 2023-10-16;

OPRP/HACCP Program Verification : 2023-10-31,

Analysis of verification results: 2023-09-28

#### Acceptance of raw and auxiliary materials

70g hand-kneaded white food kraft paper Inspection date: 2023-10-07;

60g glossy food kraft paper, inspection date: 2023-10-06;

Coated paper, inspection date: 2023-09-16;

804 water-based glue inspection date: 2023-09-28

Water-based laminating adhesive Inspection date: 2023-10-04;

Toyo White Ink Inspection date: 2023-10-08

Water-based varnish inspection date: 2023-12-18

#### Factory inspection report:

Paper bowl , order number SCD2311150002

Paper gasket, order number SCD2306050019  
Cardboard box, order number SCD2311150002

#### Environmental Monitoring:

2023-09-19、2023-08-13、2023-07-12 Workshop air, work surface, personnel hands, die-cutting machine, embossing machine, paper bowl machine and other total bacteria detection, OK,

Water Testing: Report No.A223065595\*\*001C According to GB5749, CNAS L4157;

#### Tripartite test report:

Paper bowl, report number: TJS20231201-0058, GB/T27591-2011, GB4806.8, Total migration, heavy metals, Salmonella, etc., CNAS L0227;

Paper Gasket, Report No.: TJS20231201-0059, Q/120110HY001-2020, GB4806.8, Total Migration, Heavy Metals, Salmonella, etc., CNAS L0227;

Cardboard Box, Report No.TJS20231201-0060, Q/04C1964S-2017, Total Migration, Heavy Metals, Salmonella, etc., CNAS L0227;

#### Products and processes are not in control

The company has established product and process non-compliance control requirements, and stipulates the classification and handling process of potentially unsafe products and nonconforming products.

Deviations from the OPRP Code of Conduct and CCP key limits are treated as potentially unsafe products. When raw materials, semi-finished products and finished products do not meet the relevant standards after inspection, they will be treated as unqualified products. According to the company, there have been no deviations from the OPRP Code of Conduct and CCP key limits in the past year.

Rework requirements: When the product or process product is unqualified, it will be selected after evaluation by the quality department, and the unqualified product can not be reworked, but can only be scrapped.

The customer declares that there are no non-conforming products and reworked products.

公司建立的手册明确规定了所确立的食品安全管理体系的过程以及各过程之间的衔接，并对各过程依据食品安全管理体系的要求明确了公司的运作方法。风险和机遇应对措施由各部门依据策划并进行有效的实施，识别的外包过程如：物流运输、虫害控制等。

公司依据 GB31603 和 ISO/TS22002-4 以及相关要求建立了前提方案，规定了基础设施、原辅料、仓储和虫害控制等 PRP 方面的要求，现场验证基础设施、厂房布局、废弃物管理、虫害控制、清洁消毒、人员卫生和设施、返工、撤回、食品包装信息与 客户沟通、食品防护和生物恐怖主义等进行了有效的控制，详见 ISO/TS22002-4 检查表。

#### 追溯和 召回

建立产品追溯与召回控制程序：2023-5-12，纸板盒 牛奶巧克力豆，生产日期：2022-12-07，数量 20000，同时进行追溯，能够追溯到所有的原辅料批次及生产记录，用时小于 3 小时，物料平衡能控制在范围内，追溯有效。同时进行召回，召回 100%，模拟召回有效。

现场追溯纸碗 批次 2023-08-23，用时 2 小时，物料平衡能控制在范围内，能够追溯到相应的原辅料批次及生产记录。

#### 应急演练：

建立《应急响应控制程序》，对影响食品安全的紧急状况等进行了识别及应急管理。识别的紧急情况有：生产过程中突然停电、停水和火灾等，

查最近一次演练为：2023-10-24 消防演练，培训记录和演练报告已存档，有效。

工厂质量经理张学艳为食品安全小组组长，负责维护食品安全管理体系，超过 5 年的食品包装企业工作经验，食品安全小组成员均具有多年的食品包材生产经验或管理体系工作经验。

食品安全小组来自于各个部门，小组成员受到充分的教育和培训，具有相应的知识和经验。

在公司的危害控制计划文件中，对于原料、辅料、与产品接触材料、终产品的特性予以了描述，描述的依据是相应的法律法规、客户要求、公司内部要求及其他要求，特性描述内容包括：化学、生物和物理特性；配制辅料的组成，包括添加剂和加工助剂；产地；生产方法；包装和交付方式；贮存条件和保质期，和使用或生产前的预处理等。如：

单光面白牛皮纸：

#### 1.物理特性：

a)感官：色泽正常，无异嗅、霉斑或其他污物

b)浸泡液：迁移试验所得浸泡液不应有着色、异臭等感官性的劣变。

#### 2.化学特性：

a)铅（以 Pb 计） $\leq 3.0\text{mg/kg}$

b)砷（以 As 计） $\leq 1.0\text{mg/kg}$

c)甲醛 $\leq 1.0\text{mg/dm}^2$

d)荧光性物质（波长 254nm 及 365nm）：阴性

e)总迁移量 $\leq 10\text{mg/dm}^2$

f)高锰酸钾消耗量（水，60℃，2h） $\leq 40\text{mg/kg}$

g)重金属（以 Pb 计）（4%乙酸，60℃，2h） $\leq 1\text{mg/kg}$

h) 1,3-二氯-2-丙醇 ug/L

i) 3 氯 1, 2 丙二醇 ug/L  $\leq 12\text{ mg}$

#### 3.生物特性：

a)大肠菌群/(/50cm<sup>2</sup>): 不得检出

b)沙门氏菌/(/50cm<sup>2</sup>): 不得检出

c)霉菌 $\leq 50\text{CFU/g}$

执行标准：GB4806.8-2022

#### 终产品

食品包装纸板盒：

#### 1) 物理特性：

- a) 成型质量：成型规整、端正
- b) 表面质量：表面清洁，无异物
- c) 印刷质量：图案轮廓清晰完整，色泽均匀，无明显色斑
- d) 异味：无异味
- e) 尺寸偏差为 $\pm 5\text{mm}$ ;厚度偏差为 $\pm 15\%$ ;定量偏差为 $\pm 10\%$

## 2.化学特性：

- a)铅（以 Pb 计） $\leq 3.0\text{mg/kg}$
- b)砷（以 As 计） $\leq 1.0\text{ mg/kg}$
- c)甲醛 $\leq 1.0\text{ mg/dm}^2$
- d)荧光性物质（波长 254nm 及 365nm）： 阴性
- e)总迁移量 $\leq 10\text{ mg/dm}^2$
- f)高锰酸钾消耗量（水，60℃，2h） $\leq 40\text{mg/kg}$
- g)重金属（以 Pb 计）（4%乙酸，60℃，2h） $\leq 1\text{ mg/kg}$
- h) 1,3 -二氯-2 -丙醇 ug/L
- i) 3 氯 1, 2 丙二醇 ug/L  $\leq 12\text{ mg}$

## 3.生物特性：

- a)大肠菌群/(/50cm<sup>2</sup>)不得检出
- b)沙门氏菌/(/50cm<sup>2</sup>)不得检出
- c)霉菌 $\leq 50\text{ CFU/g}$

执行标准:Q/HLBZ02-2020《食品包装用纸盒》

成品预期用途：用于巧克力、糖果等包装，非预期用途：不能重复使用

## 流程图的现场确认：

公司明确了产品的生产的工艺流程，，食品安全小组对整个工艺流程图进行了验证，现场走访验证了工艺流程图完整反应了公司的产品的生产流程。食品安全小组于 2023-10-13 对流程图进行了现场确认，流程图和实际一致。

## 过程和过程环境的描述：

食品安全小组在前提方案中对过程和过程环境的描述，提供了厂区/车间平面图、人流/气流/物流图等；HACCP 计划的生产工艺描述部分对加工过程中对物料流向、工艺参数、控制措施等进行了描述。其详略程度足以实施危害分析。

## 危害识别及可接受水平的确定：

HACCP 小组根据预备步骤进行了危害识别，识别了每一个食品安全危害，包括了物理性、化学性、生物性、过敏原等，同时确定了危害的可接受程度。

## 危害评估：



基于描述的原辅料特性、终产品特性、过程描述，针对原辅料、产品接触材料和每个生产工艺，食品安全小组进行了危害分析，识别的危害基于其发生的严重性(S)和可能性(L)进行评估判断其显著性。

#### 控制措施的选择和分类

对 CCP 和 OPRP 进行了分类，考虑了控制措施失效的严重性和可能性、控制措施失效的监控可行性等。针对每一个已确定的显著危害，食品安全小组有针对性地制定了 2 个 OPRP 计划和 2 个 HACCP 计划进行控制，能将危害控制在可接受水平。

#### 控制措施和控制措施组合的确认：

公司制定了控制措施和控制措施组合的确认的要求，在实施控制措施和控制措施组合前或者每年进行确认，查看最近一次 OPRP/HACCP 计划确认：2023-10-13；

#### 关键限值和行动准则的确定：

危害控制计划中明确了可测量的关键控制点的关键限值及可测量或可观察的操作性前提方案的行动准则，关键限值和行动准则的依据已经形成文件。

#### CCP 点和 OPRP 点的监视系统：

建立了危害控制计划监视系统，针对 CCP/OPRP 制定了相应的控制措施，内容包括：控制的危害、控制方法、实施监控的人员、监控频率、纠偏措施等。详见“Key processing steps and Control measures:”部分。

#### 未满足关键限值或行动准则时采取的措施：

危害控制计划中明确了关键限值和行动准则未满足时所采取的纠正和纠正措施。详见“Key processing steps and Control measures:”部分

#### 危害控制计划的实施：

OPRP/HACCP 计划监控记录如下：

OPRP1 淋膜纸板，安徽开来纸业，提供有效期内的营业执照，工业产品生产许可证，有效期至 2028.2.7，三方检测报告，编号：C2023-Q0343，检测项目，外观质量、感官要求、尺寸偏差、大肠菌群、沙门氏菌等，依据 GB4806.8-2022，蚌埠产品质量监督检验研究院，CMA181200111277；

OPRP1 纸板，珠海红塔仁恒包装股份有限公司，编号：HCWT2301376，依据 GB4806.8-2022，CNAS L1300.

#### 生产过程控制

现场生产印刷生产酒心巧克力纸板盒，糊盒生产 迪士尼铁听小盒 CCP1 纸垫片紫外消毒  $\leq 40\text{m/min}$ ， $\leq 1000$  小时，CCP2 纸片消毒 30min， $\leq 1000$  小时，OPRP2 每 4 小时消毒

抽查以往生产记录：

#### 纸垫片

订单号 SCD2306050019，生产日期 2023-06-25，纸垫片

生产施工单，车间卫生检查记录，CCP2 杀菌监控记录— $40\text{m/min}$  331 小时，

压纹机工艺参数监控记录



OPRP2—包材消毒记录 30min, 人员手部消毒记录每半小时  
制一作业产品检验记录—首检 OK  
同时查看 2023-11-22 垫片生产记录, OPRP/CCP 控制符合要求

#### 纸碗

纸碗, 订单号 SCD2312110028, 生产日期 2023-12-12

生产施工单, 车间卫生检查记录,

印刷机工艺参数监控记录— 4500ps/h

作业产品检验记录—印刷机 首检 OK,

工艺参数监控记录—扣切机

作业产品检验记录—扣切机 首检 OK,

工艺参数监控记录— 纸碗机, 热封 330 度

制二作业产品检验记录—纸碗机首检 ok

CCP2 消毒监控记录—原纸纸片入口 30min , 30w, 510 小时

CCP1 输送带紫外消毒  $\leq 40\text{m/min}$  ,  $\leq 1000$  小时

OPRP2—包材 消毒记录 30min, 人员手部消毒记录每 4 小时

制一作业产品检验记录—首检 OK

同时查看以下纸碗生产记录: 订单号 SCD2311060009 日期: 2023-11-10 , OPRP/CCP 控制符合要求

#### 纸板盒

订单号 SCD2311150002, 生产日期 2023-12-27

生产施工单, 车间卫生检查记录,

印刷机工艺参数监控记录— 5500ps/h

作业产品检验记录—印刷机 首检 OK,

工艺参数监控记录—扣切机

作业产品检验记录—扣切机 首检 OK,

CCP2 消毒监控记录—原纸纸片入口 30min , 30w,  $\leq 1000$  小时

CCP1 传输带紫外消毒  $\leq 40\text{m/min}$  ,  $\leq 1000$  小时

OPRP2—包材 消毒记录 30min, 人员手部消毒记录每 4 小时

制一作业产品检验记录—首检 OK

同时查看以下生产记录: 订单号 SCD202310130001 日期: 2023-10-23, OPRP/CCP 控制符合要求;

制定了清洁计划, 对环境设备等进行清洁。每月对地面、墙壁、风口等进行清洁, 查看车间卫生检查记录, 2023-10、2023-11 等包装车间、晾味房卫生检查记录。

#### 仓库管理

设有原料库, 化学品库和成品库, 能够做到先入先出, 每日对物流仓储环境卫生进行检查,

库房卫生检查记录, 包括原辅料库和成品库。

#### 查看成品库

纸板盒 批次 2024-01-15;

纸碗 批次 2023-08-23;

原料库,

淋膜纸 批次 2023-11-26;

504 糊盒胶 批次 2024-01-05;

黄色油墨批次 2023-11-07;

原纸 批次 2023-11-10

发货车辆卫生清洁检查: 发货时对货柜车厢内是否无异味、无脱落、无发霉、车厢内是否无碎屑, 货柜门的完整性、货车是否上锁并贴封条等进行检查, 装车完毕拍照, 装车过程录像留存等;

查看:

2023-12-26, 津 C23885 发往好\*友

2023-12-25 津 FP2136 发往好\*友

2023-12-28 津 ALM125 发往玛氏

#### 前提方案和危害控制计划的信息更新

当原料、辅料和产品接触材料特性, 流程图和工艺等发生变化, 由食品安全小组进行更新, 现场查看前提方案和危害控制计划是最新的。

#### 监视和测量的控制:

建立监视和测量设备台账, 并制定送检计划。

提供有计量设备台账, 抽检计量外检证书:

电子天平, 报告编号: DN230086590004, 校准单位: 东莞市帝恩检测有限公司, CNAS L6483;

电子挺度试验仪, 报告编号: DN230086590005, 校准单位: 东莞市帝恩检测有限公司, CNAS L6483;

耐破强度试验仪, 报告编号: DN230086590009, 校准单位: 东莞市帝恩检测有限公司, CNAS L6483;

温湿度计, 报告编号: DN230086590011, 校准单位: 东莞市帝恩检测有限公司, CNAS L6483;

钢直尺, 报告编号 DN220446180009, 校准单位: 东莞市帝恩检测有限公司, CNAS L6483;

#### 与前提方案和危害控制计划相关的验证:

对验证进行了策划, 包括验证频次、验证内容、验证方式等, 每年验证一次 CCP/OPRP/PRP

现场查看:

PRP 验证: 2023-10-16;

OPRP/HACCP 计划验证: 2023-10-31,

验证结果分析: 2023-09-28

#### 原辅料验收

70g 手揉白食品牛皮纸 检验日期: 2023-10-07;

60g 光面食品牛皮纸, 检验日期: 2023-10-06;



淋膜纸, 检验日期: 2023-09-16;  
804 水性糊盒胶 检验日期 2023-09-28  
水性覆膜胶 检验日期 2023-10-04;  
东洋白墨 检验日期 2023-10-08  
水性光油 检验日期 2023-12-18

出厂检验报告:

纸碗, 订单号 SCD2311150002  
纸垫片, 订单号 SCD2306050019  
纸板盒, 订单号 SCD2311150002

环境监控:

2023-09-19、2023-08-13、2023-07-12 车间空气、工作台面、人员手部、模切机、压纹机、纸碗机等总菌检测, OK,

水质检测: 报告编号 A223065595\*\*001C 依据 GB5749, CNAS L4157;

三方检测报告:

纸碗, 报告编号: TJS20231201-0058, GB/T27591-2011, GB4806.8, 总迁移量、重金属、沙门氏菌等, CNAS L0227;

纸垫片, 报告编号: TJS20231201-0059, Q/120110HY001-2020, GB4806.8, 总迁移量、重金属、沙门氏菌等, CNAS L0227;

纸板盒, 报告编号: TJS20231201-0060, Q/04C1964S-2017, 总迁移量、重金属、沙门氏菌等, CNAS L0227;

产品和过程不符合控制

公司建立了产品和过程不符合控制要求, 规定了潜在不安全产品、不合格品等分类和处理流程。

OPRP 行动准则和 CCP 关键限值出现偏离时, 按潜在不安全产品处理。原料、半成品及成品经检验不符合相关标准时, 按不合格品处理。公司称, 最近一年未出现 OPRP 行动准则和 CCP 关键限值偏离情况。

返工要求: 当产品或过程产品出现不合格时, 经质量部门评估后挑选, 不合格品不能返工, 只能报废。

客户申明未发生不合格品及返工产品。

Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体 不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
9	Performance evaluation 绩效评价		
9.1	Monitoring, measuring, analysis and evaluation	Yes	
9.1.1	General	Yes	

The audit itself and this report represent only the extent of assessment that took place within the time available; as such they are a sample. They cover only what became evident at the time. 审核本身和本报告仅代表在可用时间内进行的评估程度; 因此它们是一个样本。他们只覆盖了当时显而易见的內容。

9.1.2	Analysis and evaluation	Yes	
9.2	Internal audit	Yes	
9.2.1	The organization shall conduct internal audits at planned intervals to provide information on whether the FSMS conforms to: a) - b)	Yes	
9.2.2	The organization shall a) - g)	Yes	
9.3	Management review	Yes	
9.3.1	General	Yes	
9.3.2	Management review input	Yes	
9.3.3	Management review output	Yes	

#### Summary:

The organization evaluates the performance of the food safety management system through the monitoring of the FSMS process, and the content of monitoring and testing includes operational controls such as PRPs, hazard control plans, system processes such as customer satisfaction surveys, supplier reviews, training effects, etc., and stipulates the corresponding purposes, methods, timing and retention results;

For the results of process monitoring and measurement, the organization analyses and evaluates the operation process including objectives, performance, etc. in the relevant part of the management review requirements and forms the document information in the management review section input to report to the top management.

组织通过对 FSMS 过程的监控，对食品安全管理体系绩效进行评价，监控和测试的内容包括运行控制如 PRPs，危害控制计划，体系过程如客户满意调查，供应商评审，培训效果等，规定了相应目的，方法，时机并保留了结果；

对于过程监控和测量的结果，组织在管理评审要求相关部分对运行过程包括目标，绩效等进行了分析和评价，并在管理评审部分输入中形成了文件信息，向高层管理汇报。

#### Internal Audits

The establishment of the "internal audit control procedures", an internal audit is conducted once a year, the latest internal audit is conducted on November 06-08, 2023, the internal audit is based on FSSC 22000 V5.1, all internal auditors are competent, internal auditors: Zhang Xue, Zhang Xueyan, etc., internal audit records include internal audit plans, sign-in sheets, checklists, internal audit reports, non-conformity reports and corrective measures, etc., a total of 2 minor non-conformities have been proposed, and corrective and corrective measures have been taken for the non-conformities issued, and verified to be effective.

#### Management Reviews

The management review is conducted once a year, the most recent of which was conducted on 2023-12-25, with the participation of the company's leadership and various departments. In the form of a meeting, the input of the management review includes policies, objectives, audit results, system operation, customer feedback, tracking and verification of previous management evaluations, changes in the internal and external environment, effectiveness of measures to deal with risks and opportunities, improvement opportunities, etc., and the management review conclusions can be proved FSSC22000V5.1 Continued suitability, Adequacy and effectiveness, the output includes the system

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resource requirements, etc., this management review puts forward 1 improvement suggestion, check the management review records, including the management review plan, input and output, sign-in sheet, management review report, etc.

#### 内部审核

建立了《内部审核控制程序》，每年进行一次内审，最近一次内审于 2023 年 11 月 06 日-08 日进行，内审依据 FSSC 22000 V5.1，所有的内审员都是能够胜任的，内审员：张雪、张学艳等，内审记录包括内审计划、签到表、检查表、内审报告、不符合报告和纠正措施等，共有 2 个轻微不符合项提出，已经对开具的不符合采取纠正和纠正措施，并验证有效。

#### 管理评审

每年进行 1 次管理评审，最近一次于 2023-12-25 进行，有公司的领导层和各个部门参加。采用会议形式，管理评审输入包括方针、目标，审核结果，体系运行情况，顾客反馈，以往管评跟踪验证，内、外部环境变化，应对风险和机遇措施有效性，改进机会等，管理评审结论是能够证明 FSSC22000V5.1 持续的适宜性、充分性和有效性，输出包括体系资源需求等，本次管理评审提出 1 项改进建议，查阅管理评审记录，包括管理评审计划，输入和输出，签到表，管理评审报告等。

Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
10	Improvement 改进		
10.1	Nonconformity and corrective action	Yes	
10.1.1	When a nonconformity occurs, the organization shall: a) - e)	Yes	
10.1.2	The organization shall retain documented information as evidence of: a) - b)	Yes	
10.2	Continual improvement	Yes	
10.3	Update of the food safety management system	Yes	

#### Summary:

The factory has formulated a corrective action control procedure to identify the measures taken to control the nonconformity of the FSMS process, including cause analysis, correction and corrective actions, verification, etc. 1 non-conformities are identified in this year's audit, corresponding corrective actions have been taken. Including further inspection of the process and personnel training.

The food safety management system defines the requirements for continuous improvement, through communication, management review, internal audit, verification and confirmation, corrective actions and system updates to continuously improve the FSMS.

The senior management clarifies the FSMS update requirements, and regularly evaluates the FSMS to identify the update requirements and implement the update.

工厂制定了纠正措施控制程序，识别对 FSMS 过程不合格控制所采取的措施，包括原因分析，纠正和纠正措施，验证等，如本年度审核给出 1 个不符合项，均采取了相应纠正措施，包括对过程的进一步检查和人员培训等。

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食品安全管理体系界定了持续改进的要求，通过沟通，管理评审，内部审核，验证和确认，纠正措施及体系更新来对 FSMS 持续改进。

高层管理明确 FSMS 更新要求，定期对 FSMS 进行评价以识别更新的要求并实施更新。

\* indicate compliance (Yes), non-conformance (No), nonconformities to be detailed in nonconformity table;

注明符合 (Yes)、不符合 (No)，不符合项在不符合项表中详细说明

ISO/TS 22002-4: 2013		Conform* 符合与否	Remark 评述
Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体 不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
4.1	Establishment 建筑物		
4.1.1	General requirements	Yes	
4.1.2	Environment	Yes	
4.1.3	Locations of establishments	Yes	
<p>Summary:</p> <p>PRP describes the requirements of building structure and layout, the construction and layout of the company's buildings are designed in accordance with the requirements of ISO/TS22002-4:2013 and the industry specifications and the actual situation of the company's product production, there are several buildings in the factory area used as workshops and warehouses, offices, building materials are concrete, the building and factory area are kept in good condition, there have been no important changes since the last audit.</p> <p>There are no potential pollution sources around the factory area, there is no open paddock, and when the company verifies PRP every year, it evaluates potential pollution from the perspective of risk, and the latest assessment is 2023-10-16, and the measures are effective.</p> <p>There is a fence around the factory area, there is no source of pollution, there is a doorman at the entrance of the gate, and the factory area is well maintained.</p> <p>PRP 描述了建筑结构和布局的要求，公司建筑物的建设和布局按照 ISO/TS22002-4:2013 的要求以及行业规范和公司产品生产的实际情况进行设计，厂区内有几栋楼分别用做车间和仓库、办公室，建筑材料均为混凝土，建筑和厂区均保持良好的状态，从上次审核后没有重要变化。</p> <p>厂区周边没有潜在污染源，没有露天围场，公司每年验证 PRP 时，从风险的角度，评估潜在污染，最近一次评估为 2023-10-16，措施有效。</p> <p>厂区周边有围墙，没有污染源，大门入口处有门卫，厂区内进行了良好的维护。</p>			
4.2	Layout workspace 工作场所和场所布局		
4.2.1	General requirements	Yes	

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4.2.2	Internal design, layout and traffic patterns	Yes	
4.2.3	Internal structures and fittings	Yes	
4.2.4	Equipment	Yes	
4.2.5	Temporary/mobile structures	Yes	
4.2.6	Storage	Yes	

**Summary:**

The internal design of the workshop is good, the flow of people and logistics in the workshop is basically separated, and the equipment layout is reasonably designed, which can effectively reduce potential pollution.

The inner area of the building is suitable, the material flow, product flow and people flow in the production area are reasonably designed, and the material outlet and inlet system can effectively prevent the intrusion of insects.

The walls and floors of the production area are in line with the production of food packaging, and can withstand cleaning materials and cleaning methods. The doors and windows are designed to be ventilated and open, and the installation of filters can effectively prevent the invasion of insects.

The design and placement of the equipment is easy to operate, clean and maintain. Routine maintenance and annual maintenance have been reviewed during the audit, and the equipment is running well. Relevant auxiliary equipment such as air compressors are also well maintained.

In order to ensure that the storage environment of raw materials, auxiliary materials and products meets the requirements and avoid pollution caused by improper storage, combined with the characteristics of products, the warehouse include raw material warehouse and chemical box. All raw materials in the warehouse are stored off the floor and the wall. Materials follow the principle of first-in, first-out.

The company stores alcohol in locked chemical box.

厂房内部设计良好, 车间内部人流和物流基本分开, 设备布局设计合理,能有效减少潜在的污染。

建筑物的内部区域是适宜的, 生产区域物料流,产品流和人流设计合理,物料出口,入口系统能有效防止昆虫侵入。

生产区域的墙和地面符合食品包装的生产, 能经受清洗材料和清洗方法, 门窗的设计通风的开放状态, 而且加装了滤网能有效防止昆虫的入侵。

设备的设计和摆放便于操作、清洁和维护, 日常维护及年度维护进行在审核中已查看, 设备运行良好。相关辅助设备如空压机也得到了良好的维护保养。

为保证原、辅材料及产品存储的环境符合要求, 避免因存储不当造成的污染, 结合产品的特性, 库房分为原料仓和化学品仓库, 库房内所有的原材料均离地离墙存放, 物料遵循先进先出的原则。

公司将酒精存放在上锁化学品柜内。

4.3	Utilities 公共设施		
4.3.1	General requirements	Yes	
4.3.2	Water supply	Yes	
4.3.3	Air quality and ventilation	Yes	

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4.3.4	Compressed air and other gases	Yes	
4.3.5	Lighting	Yes	
<p>Summary:</p> <p>The infrastructure is in good condition and the distribution piping design has identified no possible contamination.</p> <p>Ice is not used in the production process, municipal water is used for hand washing, and 75% alcohol is used for hand sanitization.</p> <p>There is sufficient air ventilation in the production area, and the maintenance of the filter is carried out as required.</p> <p>The compressed air passes through a multi-stage filter for the conveying of paper bowls, and is in direct contact with the product, view: 2023-09-19 、2023-08-13、2023-07-12 Workshop air, work surface, personnel hands, die-cutting machine, embossing machine, paper bowl machine and other total bacteria detection, OK,</p> <p>The production and inspection sites are well lit and the lamps are protected to prevent contamination of the product when broken.</p> <p>基础设施处于良好的状态，分布管路设计未发现有可能的污染。</p> <p>生产工艺过程不使用冰，洗手使用市政用水，员工手部消毒使用 75%酒精。</p> <p>生产区域内有足够的空气通风，过滤网的维护保养按要求进行，</p> <p>压缩空气经过多级过滤器，用于纸碗的输送，与产品直接接触，查看：2023-09-19 、2023-08-13、2023-07-12 车间空气、工作台面、人员手部、模切机、压纹机、纸碗机等总菌检测，OK，</p> <p>生产和检验现场光照充足，灯具都进行了防护，防止破碎时污染产品。</p>			
4.4	Waste 废弃物		
4.4.1	General requirements	Yes	
4.4.2	Waste handling	Yes	
4.4.3	Drains and drainage	Yes	
<p>Summary:</p> <p>The waste management requirements are formulated. The waste is transported to the designated location by cleaning personnel every day, and the designated person is responsible for the unified collection to the designated area of the plant.</p> <p>The waste disposal is managed by the waste contractor, Local government garbage disposal agency, the contract is valid and the requirements are specified.</p> <p>External waste is stored in containers, collection containers have labels and lids, and external waste collection containers are promptly cleaned.</p> <p>Disposal of unsafe products or substandard trademark materials shall first be destroyed by own employees, with control records, and then confirmed with contractors.</p> <p>There are underground drainage pipes in the factory area, and the waste water from the production process is discharged to the sewage treatment system. The rainwater pipes in the factory area are separated from the sewage pipes, and the rainwater pipes are connected with the municipal drainage pipes. All drainage outlets are provided with protective barriers.</p> <p>制定了废物管理要求，废弃物每天由清洁人员运送到指定地点，由专人负责统一收集至厂区指定区域，</p>			

废物处理由废物承包商管理：当地政府垃圾处理机构，合同有效，其中明确了要求。

外部废物储存在容器中，收集容器有标签和盖子，及时清理外部垃圾收集容器。

处理的不安全产品或不合格商标材料，首先由自己的员工销毁，并有控制记录，然后与承包商确认。

厂区有地下排水管道，生产过程废水排放至污水处理系统。厂区雨水管道和污水管道分开，雨水管道和市政排水管道连接，所有排水口均有防护隔罩。

4.5	Equipment suitability, cleaning and maintenance 设备适宜性，清洁和维护		
4.5.1	General requirements	Yes	
4.5.2	Hygienic design	Yes	
4.5.3	Food packaging and contact surfaces	Yes	
4.5.4	Maintenance	Yes	

#### Summary:

The equipment used in the workshop is set up in a suitable area, which is very convenient for cleaning and maintenance, and there is no sanitary dead corner in the equipment location. The production equipment is made of stainless steel and materials that can be used for food contact to prevent potential contamination, and the equipment has no irradiable equipment and wet processing processes. An equipment maintenance system has been established, and the sampling is as follows:

Equipment maintenance requirements have been established, and equipment ledgers have been established, including printing machines, folder-glueers, paper bowl machines, purple sterilizers, etc

#### View:

The equipment and facility management procedure HY-SC-P02 has been formulated to manage the provision and maintenance of the company's equipment and facilities to ensure that the compliance requirements of products are met, and the needs of environmental treatment and pollution prevention and safety protection are met. Establish control procedures for equipment and facilities to ensure the smooth production of each process and ensure the safe operation of equipment and human safety.

Equipment maintenance requirements have been established, and equipment ledgers have been established, including printing machines, folder-glueers, paper bowl machines, purple sterilizers, etc

The 2023 equipment maintenance plan has been established

#### View

2023-10-13 2# Paper Bowl Machine Inspection Records of Heating Elements and Transmission Parts;

2022-10-07 2# printing machine tachogenerator, main motor inspection record;

2023-12-2 Manual die-cutting machine Transmission motor and various transmission parts inspection records

2023-08-19 Embossing machine Gearbox inspection record;

2023-08-21 UV antivirus machine inspection record;

2023-07-14 Chip remover Transmission motor and various transmission parts inspection records

2023-8-16 Inspection records of the transmission motor and each transmission part of the smart paper cup machine

Maintenance Record:

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2023-08-08 2# Paper Bowl Machine Bearing base casting crack Replace the new bearing  
2024-01-19 UV lamp anti-virus motor defect motor winding

#### Special Equipment:

Forklift: Vehicle number: factory Neijin T-06147, report number: Binchang Dingjian No. 2023-02127, inspection date: 2023-4-12, valid until 2025.4, verification unit: Tianjin Binhai New Area Inspection and Testing Center;

Compressed air storage tank, unit number: 01, report number: Binrong Dingjian No. 2022-02413, inspection date: 2022.8.1, valid until October 2026, verification unit: Tianjin Binhai New Area Inspection and Testing Center;

Safety valve, condenser, report number: Binhai valve calibration 2023-03690, inspection date: 2023-11-16, valid until November 15, 2024, verification unit: Tianjin Binhai New Area Inspection and Testing Center;

Pressure gauge, seismic pressure gauge, report number: ZHJYL24010336, inspection date: 2024.1.8, valid until July 7, 2024, verification unit: Zhongheng Inspection and Testing Technology (Tianjin) Co., Ltd.;

车间使用的设备设置在合适的区域，非常方便清洁和维护，设备位置无卫生死角。生产设备由不锈钢和可用于食品接触的材料制成，以防止潜在的污染，设备没有可辐射设备和湿加工工序。建立了设备维护体系，抽样如下：

建立了设备维护要求，建立了设备台账，包括 印刷机、糊盒机、纸碗机、紫消毒机等

查看：

制定了设备设施管理程序 HY-SC-P02 对公司设备设施的提供和维护实施管理，以保证满足产品的符合性要求，同时满足环境治理和污染预防以及安全防护的需要。建立设备设施的控制程序，使各工序顺利生产及确保设备的安全运行和人的安全保障。

建立了设备维护要求，建立了设备台账，包括 印刷机、糊盒机、纸碗机、紫消毒机等

建立了 2023 设备维护计划

查看

2023-10-13 2#纸碗机 加热元件、各传动部位检查记录；

2022-10-07 2#印刷机 测速发电机、主电机检查记录；

2023-12-2 手动模切机 传动电机、各传动部位检查记录

2023-08-19 压纹机 减速箱检查记录；

2023-08-21 紫外杀毒机 检查记录；

2023-07-14 除屑机 传动电机、各传动部位检查记录

2023-8-16 智能纸杯机 传动电机、各传动部位检查记录

维修记录：

2023-08-08 2#纸碗机 轴承底座铸造有裂痕 更换新的轴承

2024-01-19 紫外灯杀毒 电机缺陷 电机绕组

特种设备：

叉车：车号：厂内津 T-06147，报告编号：滨场定检 2023-02127 号，检验日期：2023-4-12，有效期至 2025.4，检定单位：天津市滨海新区检验检测中心；

压缩空气储罐，单位内编号：01，报告编号：滨容定检 2022-02413 号，检验日期：2022.8.1，有效期至 2026 年 10 月，检定单位：天津市滨海新区检验检测中心；

安全阀，冷凝器，报告编号：滨阀校验 2023-03690，检验日期：2023-11-16，有效期至 2024 年 11 月 15 日，检定单位：天津市滨海新区检验检测中心；

压力表，抗震压力表，报告编号：ZHJYL24010336，检验日期：2024.1.8，有效期至 2024 年 7 月 7 日，检定单位：中恒检验检测科技（天津）有限公司；

4.6	Management of purchased materials and services 采购材料和服务的管理		
4.6.1	General requirements	Yes	
4.6.2	Selection and management of suppliers	Yes	
4.6.3	Incoming material requirements	Yes	

#### Summary:

An external supplier management system has been established to regularly evaluate the performance of the supplier every year, and the supplier will be included in the list of qualified suppliers after evaluation, and the list of qualified suppliers will be viewed. Evaluate suppliers every year from the aspects of qualification, quality, service, delivery, price, etc.

The samples are as follows:

#### External supplier management

The main responsibilities are to ensure that the quality of production materials is guaranteed and does not affect the production progress. Establish procurement process control procedures.

Evaluate the performance of the supplier every month, from the timely arrival rate, arrival qualification rate, NCR times, and service evaluation:

Check the supplier's performance evaluation form: 2023-08, 2023-10, 2023-12 evaluation records:

Paper stock, Anhui Kailai Paper Effective Company, score: 92 points;

Ink, Tianjin Toyo Ink Co., Ltd., score: 98 points;

Glue, Hengruiyuan Technology Development (Beijing) Co., Ltd., score: 98 points;

#### Supplier qualification and tripartite test report spot check:

OPRP1 coated cardboard, Anhui Kailai Paper, provide a valid business license, industrial product production license, valid until 2028.2.7, tripartite test report, number: C2023-Q0343, test items, appearance quality, sensory requirements, size deviation, coliform bacteria, Salmonella, etc., according to GB4806.8-2022, Bengbu Institute of Product Quality Supervision and Inspection, CMA181200111277;

OPRP1 cardboard, Zhuhai Hongta Yanlord Packaging Co., Ltd., No. HCWT2301376, according to GB4806.8-2022, CNAS L1300.

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Glue, Dongguan Heyu Paste Products Co., Ltd., provide a valid business license, manufacturer: Shanghai Aopu Chemical Co., Ltd., provide a business license, tripartite test report, number: T52310320422TC, test items: lead, mercury, chromium, polybrominated biphenyls, dibutyl phthalate, etc., testing agency: Shenzhen SGS laboratory;

Ink, Tianjin Toyo Ink Co., Ltd., provide a valid business license, tripartite test report, number: TSNE2303486210, test items, according to ROHS Directive 2011/65/EU Annex II Amendment Directive EU2015/863 - lead, mercury, chromium, polybrominated biphenyls, dibutyl phthalate, etc., testing agency: SGS Tianjin Co., Ltd. CNAS L2274;

PE film bag, Panjin Jintian Plastic Industry Effective Company, report number: Anhui Quality Inspection No. 2023-SL-1371, according to GB4806.7, CNAS L10568.

#### Outsourcing Services:

This includes waste disposal, transportation services, and pest treatment. Management according to the purchase contract.

The waste includes packaging products with the customer's LOGO, which are uniformly shredded and disposed of by Zaoqiang Shunxing Paper Products Co., Ltd., and a disposal agreement has been signed, which is valid until December 31, 2024.

Hazardous Waste Service Provider: Processor: Tianjin Binhai Hejia Veolia Environmental Services Co., Ltd., with a service contract valid until July 19, 2024.

Logistics service providers: according to the transportation area, Tianjin Changyu, Tianjin Jincheng Logistics, Beijing Jinchenda, China Post and other 14 logistics companies. All have signed a contract for transportation and service.

Tianjin Changyu Logistics Co., Ltd. was spot-checked, and the business scope and term of the business license met the requirements. The road transport business license is valid until June 11, 2026;

The logistics provider is evaluated on a monthly basis, including the timeliness of delivery, the arrival rate at the agreed time, the customer satisfaction rate, the damage rate, etc.

The inspection standards for raw and auxiliary materials have been established, and the raw materials are accepted when they enter the factory, and the COA and DOC are checked to ensure the safety of the products. Spot check:

Acceptance of raw and auxiliary materials

70g hand-kneaded white food kraft paper Inspection date: 2023-10-07;

60g glossy food kraft paper, inspection date: 2023-10-06;

Coated paper, inspection date: 2023-09-16;

804 water-based glue inspection date: 2023-09-28

Water-based laminating adhesive Inspection date: 2023-10-04;

Toyo White Ink Inspection date: 2023-10-08

Water-based varnish inspection date: 2023-12-18

建立了外部供方管理制度，每年定期对供方的业绩进行评价，供应商经评估后列入合格供方名录，查看合格供方名录。每年对供应商和进行评价，从资质、质量、服务、交付、价格等方面进行评价，

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抽样如下：

#### 外部供方管理

主要职责，物料采购入供应商评价等，保证生产物料质量有保障，不影响生产进度。建立采购过程控制程序。

每月对供方业绩进行评价，从到货及时率、到货合格率、NCR 次数、服务进行评价：

查看供方业绩评价表：2023-08、2023-10、2023-12 评估记录：

纸料，安徽开来纸业有效公司，得分：92 分；

油墨，天津东洋油墨有限公司，得分：98 分；

胶，恒瑞源技术发展（北京）限公司，得分：98 分；

#### 供应商资质及三方检测报告抽查：

OPRP1 淋膜纸板，安徽开来纸业，提供有效期内的营业执照，工业产品生产许可证，有效期至 2028.2.7，三方检测报告，编号：C2023-Q0343, 检测项目，外观质量、感官要求、尺寸偏差、大肠菌群、沙门氏菌等，依据 GB4806.8-2022, 蚌埠产品质量监督检验研究院，CMA181200111277；

OPRP1 纸板，珠海红塔仁恒包装股份有限公司，编号：HCWT2301376，依据 GB4806.8-2022，CNAS L1300.

胶水，东莞市合裕粘贴制品有限公司，提供有效期内的营业执照，生产商：上海奥普化工有限公司，提供有营业执照，三方检测报告，编号：T52310320422TC，检测项目：铅、汞、铬，多溴联苯、邻苯二甲酸二丁酯等，检测机构：深圳 SGS 实验室；

油墨，天津东洋油墨有限公司，提供有效期内的营业执照，三方检测报告，编号：TSNE2303486210，检测项目，依据 ROHS 指令 2011/65/EU 附录 II 修正指令 EU2015/863-铅、汞、铬，多溴联苯、邻苯二甲酸二丁酯等，检测机构：SGS 天津有限公司 CNAS L2274；

PE 膜袋，盘锦金田塑业有效公司，报告编号：皖质检字第 2023-SL-1371, 依据 GB4806.7, CNAS L10568.

#### 外包服务：

包括有废弃物处理、运输服务、虫鼠害处理。依据采购合同管理。

废弃物包括带客户 LOGO 的包装产品，公司统一切碎处理，由枣强县顺兴纸制品有限公司负责，签订有处理协议，有效期至 2024 年 12 月 31 日。

危险废弃物服务商：处理方：天津滨海合佳威立雅环境服务有限公司，签订有服务合同，有效期至 2024 年 7 月 19 日。

物流服务商：依据运输区域进行划分，天津昌宇、天津金成物流、北京金辰达、中国邮政等 14 家物流公司。均签订有运输和服务合同。

抽查天津昌宇物流有限公司，营业执照经营范围和期限均符合要求。道路运输经营许可证有效期至 2026 年 6 月 11 日；

对物流供应商每月进行评价，评价内容包括发货及时性、约定时间到货率、顾客满意率、破损率等内容。



建立了原辅材料检验标准，对原料入厂时进行验收，查看 COA 和 DOC，以确保产品的安全性。抽查：  
原辅料验收

70g 手揉白食品牛皮纸 检验日期：2023-10-07；

60g 光面食品牛皮纸，检验日期：2023-10-06；

淋膜纸，检验日期：2023-09-16；

804 水性糊盒胶 检验日期 2023-09-28

水性覆膜胶 检验日期 2023-10-04；

东洋白墨 检验日期 2023-10-08

水性光油 检验日期 2023-12-18

	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
4.7	Measures for prevention of contamination 交叉污染的预防措施		
4.7.1	General requirements	Yes	
4.7.2	Microbiological contamination	Yes	
4.7.3	Physical contamination	No	The on-site audit found that the folder-gluer rollers were in contact with the product, and that there was dust on the rollers, posing a risk of foreign body contamination 现场审核发现糊盒机滚轮与产品接触，滚轮上有灰尘，存在异物污染的风险。
4.7.4	Chemical contamination	Yes	
4.7.5	Chemical migration	Yes	
4.7.6	Food allergen management	Yes	

Summary:

Through hazard analysis, the company has formulated preventive measures for cross-contamination, physical pollution, microbial contamination, chemical migration and chemical pollution measures including environmental health control, personnel hygiene control, product contact surface hygiene control, chemical control, etc., and on-site audit control measures have been effectively implemented.

Physical pollution: the company has formulated foreign matter management requirements, workshop and warehouse operators check foreign bodies every day; The product does not touch the ground, away from debris, no sharp or loose tools are found in the workshop or warehouse, and no breakable blades are in use; Shift operators clean equipment and floors every day, and the hygiene is acceptable.

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Control measures for chemical pollution: printing process, after drying, will not be reversed or transferred to the food contact surface, the lubricating oil used is food grade, cleaning supplies and lubricating oil are stored separately;

Chemical migration: the packaging material of the product is PE film, which is food grade and will not contaminate the product; The outer packaging is a carton in contact with a plastic pallet.

Biological pollution: For this product, the national standard has microbial requirements, enterprise standards and customer requirements, the company through personnel hand disinfection, change of work clothes, cleaning and replacement of air filters and blister molding machine on ultraviolet lamp disinfection and other control measures, on-site inspection control measures are effective.

At the same time, the company has developed a microbial testing plan and implemented it.

Allergens: The Allergen Control Program has been established, a list of allergens has been collected, and the raw materials, processes and finished products of the company's products are free of allergens,

However, control measures were taken: the company's employee canteen only provides dining places, away from the production floor; transport vehicles for inspection; The company prohibits employees from bringing food (including food containing allergenic substances) into the workshop, and on-site inspection of the effectiveness of control measures.

公司通过危害分析，制定了交叉污染的预防措施，物理污染、微生物污染、化学迁移和化学污染措施包括环境卫生控制、人员卫生控制、产品接触面卫生控制、化学品控制等，现场审核控制措施得到有效实施。

物理污染：公司制定了异物管理要求，车间和仓库操作人员每天检查异物；产品不接触地面，远离碎片，未发现有尖锐或者松动工具在车间或者仓库，没有可折断刀片在使用；每天交接班操作人员清洁设备和地面等，卫生状况可接受。

化学污染的控制措施：印刷工序，烘干后，不会反印或转移到食品接触面，所用润滑油为食品级，清洁用品和润滑油均单独存放；

化学迁移：产品的包装材料为 PE 薄膜，为食品级，不会污染产品；外包装为纸箱与塑料栈板接触。

生物污染：针对该产品，国家标准有微生物要求，企业标准和客户有要求，公司通过人员洗手消毒、更换工作服、清洁和更换空气过滤网及吸塑成型机上有紫外灯消毒等控制措施，现场查看控制措施有效。

同时公司制定了微生物检测计划并执行。

过敏原：《过敏原控制程序》已建立，收集了过敏原清单，公司产品的原料、过程和成品没有过敏原，但采取了控制措施：公司员工餐厅仅提供就餐场所，远离生产车间；运输车辆进行检查；公司禁止员工把食品（包括含有过敏原物质的食品）带进车间，现场查看控制措施有效。

4.8	Cleaning 清洁		
4.8.1	General requirements	Yes	

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4.8.2	Cleaning programmes	Yes	
4.8.3	Cleaning agents and tools	Yes	
4.8.4	Monitoring cleaning programme effectiveness	Yes	

**Summary:**

Develop, implement and monitor cleaning plans, including cleaning protocols and cleaning tools, disinfect the outer surfaces of the equipment with rags and 75% alcohol, clean the inner surfaces of the equipment mainly with hot water or disinfectant, and verify the cleaning effect by visual observation or microbial application.

**samples:**

Established a cleaning plan to clean environmental equipment, etc. Clean the ground, walls, air vents, etc. every month, check the workshop hygiene inspection records, 2023-10, 2023-11 and other packaging workshop and drying room hygiene inspection records.

制定、实施和监测清洁计划，包括清洁方案和清洁工具，设备外表面用抹布及 75%酒精进行消毒，设备内表面主要用热水或者消毒液进行清洁，通过肉眼观察或者微生物涂抹验证清洁效果。

**抽样如下：**

制定了清洁计划，对环境设备等进行清洁。每月对地面、墙壁、风口等进行清洁，查看车间卫生检查记录，2023-10、2023-11 等包装车间、晾味房卫生检查记录。

4.9	Pest control 虫害控制		
4.9.1	General requirements	Yes	
4.9.2	Control programmes	Yes	
4.9.3	Preventing access	Yes	
4.9.4	Harbourage and infestations	Yes	
4.9.5	Monitoring and detection	No	The on-site audit found that at the entrance gate of the ink warehouse, a sticky mouse board number fell off 现场审核发现油墨仓库入口大门处，一粘鼠板编号脱落。
4.9.6	Eradication	Yes	

**Summary:**

The company established the "Pest Control Procedure"

Pest pest outsourcing party: Zhejiang Bangbang Environmental Technology Group Co., Ltd., signed a contract until May 9, 2024, Prevention and control projects: rats, cockroaches, flies, mosquitoes, operation frequency: twice a month from March to October every year, once a month from November to February. The business scope and business period of its business license meet the requirements, and the A-level certificate of pest control service is valid until 2024.3.25, and a list of drug uses is provided, including the name of the drug, target pests, active ingredients, manufacturer, pesticide registration certificate number, etc. The registration certificates of fluorratin and permethrin tetraflurane pesticides are all within the validity period, and drug labels and MSDS are provided. Floor plans of pest infestation facilities are available.

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Service Records: 2023-08, 2023-10, 204-01, etc.

The pest control officer provides a pest control officer qualification certificate and a health certificate, which are valid.

Provide monthly service reports on a monthly basis, and spot check the integrated pest management report for October 2023, including service plan, service summary, trend analysis, risk assessment, service plan and service focus for the next month, etc.

公司建立《虫害控制程序》

虫鼠害外包方：浙江帮帮环境科技集团有限公司，签订有承包合同至 2024 年 5 月 9 日，防治项目：老鼠、蟑螂、苍蝇、蚊子，作业频次：每年 3-10 月份每月两次，11-2 月，每月一次。其营业执照经营范围和营业期限均符合要求，有害生物防制服务 A 级证书，有效期至 2024.3.25；提供有药品使用清单，清单包括药品名称、靶标害虫、有效成分、生产厂家，农药登记证号等内容。抽查氟鼠灵、氯菊四氟醚农药登记证均在有效期内，提供有药品标签、MSDS。提供有虫鼠害设施平面图。

服务记录：2023-08、2023-10、204-01 等。

有害生物防制员提供有害生物防制员资格证及健康证，均有效。

每月提供月度服务报告，抽查 2023 年 10 月虫害综合管理报告，包括服务计划、服务汇总、趋势分析、风险评估、次月服务计划及服务重点等。

4.10	Personal hygiene and employee facilities 人员卫生和员工设施		
4.10.1	General requirements	Yes	
4.10.2	Personnel hygiene changing facilities and toilets	Yes	
4.10.3	Staff canteens and designated eating and smoking areas	Yes	
4.10.4	Workwear and protective clothing	Yes	
4.10.5	Illness and injuries	Yes	
4.10.6	Personal cleanliness	Yes	
4.10.7	Personal behaviour	Yes	

Summary:

Develop and implement documented personal hygiene control procedures GMP. Perform hand cleaning with a reasonable frequency and regularly check the effectiveness of hygiene procedures. Employees and management did not wear watches, jewelry and rings. It is inspected and monitored by designated employees before entering the workshop.

Male and female toilets are fully segregated and do not face directly to the workshop

The catering facilities are fully isolated from the workshop by walls.

Personal belongings are stored in small cabinets in the changing room, and no food is allowed in the production and storage areas.

The changing room is located at the entrance before entering the workshop, and employees must change personal items and put on work clothes in the changing room.

Health certificate: Tianjin Airport Lakeside Community Health Service Center.

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Health Certificate:

Tianjin Airport Hubin Community Health Service Center.

Huang Qinong, valid until: 2024.2.24;

Zhai Fuma, valid until: 2025.1.19;

Guo Lixia, valid until: 2024.2.24;

Wu Junlan, valid until: 2024.7.26;

Guo Junhua, valid until: 2024.10.18;

Yang Fengying, valid until: 2025.1.19;

制定并实施记录在案的个人卫生控制程序 GMP。以合理的频率进行手部清洁，并定期检查卫生程序的有效性。员工和管理层没有佩戴手表、珠宝和戒指。并在进入车间前由指定员工进行检查和监控。

男女厕所充分隔离，不直接面向于车间

餐饮设施与车间有墙体充分隔离。

个人物品存放在更衣室的小柜子里，生产和储存区域内不得进食。

更衣室位于进入车间前的入口处，员工必须在更衣室内更换个人物品并穿上工作服。

健康证：

天津空港湖滨社区卫生服务中心。

黄起农，有效期至：2024.2.24；

翟福马，有效期至：2025.1.19；

郭丽霞，有效期至：2024.2.24；

吴俊兰，有效期至：2024.7.26；

郭俊花，有效期至：2024.10.18；

杨凤英，有效期至：2025.1.19；

4.11	Rework 返工		
4.11.1	General requirements	Yes	
4.11.2	Storage, identification and traceability	Yes	
4.11.3	Rework usage	Yes	

Summary:

The company has established rework procedures and established responsibilities, for example, the food safety team is responsible for determining whether rework operations can be carried out and developing a rework plan. The production department performs the rework operation, and the QC is responsible for the inspection of the reworked product. The products of this plant are not allowed to be reworked and are directly scrapped. On-site audits of products without rework.

公司制定了返工程序并规定了责任，例如：食品安全小组负责判断是否可以进行返工操作，并制定返工计划。生产部执行返工操作，QC 负责返工产品检验。这家工厂的产品不允许返工，直接报废。现场审核没有返工产品。

4.12	Withdrawal procedures 撤回程序	Yes	
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Summary:

The company established the product withdrawal and recall control procedure to recall the defective products, especially any products involving food safety. Withdrawal and recall exercise should be carried out at least once a year;

No actual recall from FSMS system implemented.

Mock recall, date: 2023-05-12

公司建立了产品撤回和召回控制程序，召回有缺陷的产品，尤其是涉及食品安全的产品。每年至少进行一次撤退和召回演习；没有从 FSMS 系统中进行实际召回。

公司声称没有实际召回发生；

最近一次模拟召回日期：2023-5-12，纸板盒 牛奶巧克力豆，生产日期：2022-12-07，数量 20000，同时进行追溯，能够追溯到所有的原辅料批次及生产记录，用时小于 3 小时，物料平衡能控制在范围内，追溯有效。同时进行召回，召回 100%，模拟召回有效。

Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体 不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
4.13	Storage 储存		
4.13.1	General requirements	Yes	
4.13.2	Warehousing requirements	Yes	
4.13.3	Vehicles, conveyances and containers	Yes	

#### Summary:

The company has established a warehouse management system, the warehousing department is responsible for the warehousing management of raw and auxiliary materials, semi-finished products and finished products, inventory management, pre-loading inspection of transport vehicles, etc., and the use of material management system in and out of the warehouse, which can better achieve FIFO. Waste products and chemicals are stored separately, and there is a separate non-conforming product area to avoid non-conforming products being shipped.

Documented transport control procedures are established, warehouse employees will inspect vehicles before loading and unloading, raw material and packaging transportation is arranged by the supplier, finished products are transported by third-party companies, all facilities for product transportation, on-site transportation and finished product transportation are suitable and maintained in good repair and sanitary conditions.

#### Sampling:

It is equipped with a raw material warehouse, a chemical warehouse and a finished product warehouse, which can be first-in, first-out, and inspect the environmental hygiene of logistics and warehousing every day.

Warehouse hygiene inspection records, including raw and auxiliary material warehouses and finished product warehouses.

View the finished product library

Cardboard box batch 2024-01-15;

Paper Bowl Lot 2023-08-23;

raw material warehouse,

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Coated Paper Batch 2023-11-26;

504 Glue Lot 2024-01-05;

Yellow ink batch 2023-11-07;

Base Paper Lot 2023-11-10

Sanitation and cleaning inspection of the delivery vehicle: check whether there is no peculiar smell, no shedding, no mildew, no debris in the container compartment, the integrity of the container door, whether the truck is locked and sealed, etc., take photos after loading, and keep videos of the loading process;

View:

2023-12-26, Tianjin C23885 sent to good \* friends

2023-12-25 津 FP2136 Sent to good friends

2023- 12-28 Tsu ALM125 to Mars

公司建立了仓库管理制度，仓储部负责原辅料、半成品、成品的出入库管理，库存物资管理、运输车辆装货前检查等工作，出入库使用物料管理系统，能够较好做到 FIFO. 废品和化学品单独存放，有单独不合格品区域，避免不合格品被发运。

建立了文件化运输控制程序，仓库员工将在装载和卸载前检查车辆，原材料和包装运输由供应商安排车辆，成品由第三方公司运输，用于产品运输、现场运输和成品输送的所有设施均适合，并保持良好维修和卫生条件。

抽样:

设有原料库，化学品库和成品库，能够做到先入先出，每日对物流仓储环境卫生进行检查，库房卫生检查记录，包括原辅料库和成品库。

查看成品库

纸板盒 批次 2024-01-15;

纸碗 批次 2023-08-23;

原料库,

淋膜纸 批次 2023-11-26;

504 糊盒胶 批次 2024-01-05;

黄色油墨批次 2023-11-07;

原纸 批次 2023-11-10

发货车辆卫生清洁检查：发货时对货柜车厢内是否无异味、无脱落、无发霉、车厢内是否无碎屑，货柜门的完整性、货车是否上锁并贴封条等进行检查，装车完毕拍照，装车过程录像留存等；

查看:

2023-12-26, 津 C23885 发往好\*友

2023-12-25 津 FP2136 发往好\*友

2023- 12-28 津 ALM125 发往玛氏

4.14	Food packaging information and customer communication 食品包材信息和顾客沟通	Yes	
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Summary:



Label management requirements have been formulated, and the company has identified the label information in compliance with GB4806.1 and customers, etc. At present, all the company's products are not exported for domestic sales, and the product name, production date, implementation standards, etc. are identified on the product packaging and COA, and the cardboard box batch 2024-01-15 is spot-checked, and the product name, production date, product implementation standard, manufacturer's name and address are identified to confirm that they meet the requirements, and other information is reflected in the COA, and at the same time transmitted to the customer.

制定了标签管理要求，公司识别了标签信息符合 GB4806.1 和客户等。目前本公司的产品全部内销没有出口，产品包装和 COA 上标识了产品名称、生产日期、执行标准等，现场抽查纸板盒批次 2024-01-15，标识了产品名称、生产日期、产品执行标准、生产商名称和地址，确认符合要求，其他信息体现在 COA，同时传递至客户。

4.15	Food defense and bioterrorism 食品防护和生物恐怖主义	Yes	
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#### Summary:

A food safety protection plan has been established. Visitors entering the factory must be confirmed and released by the company's security personnel. No foreign vehicles and personnel are allowed to enter the factory without permission. At the same time, the factory have relevant personnel to control visitors entering the sensitive areas such as the workshop and warehouse. Monitoring sensitive areas by vedio of the production site, such as production area and warehouse area.

The company conducts risk assessment for food production enterprises in accordance with the GB/T 27320-2010 food protection plan and its application guidelines, and identifies the company's external safety, internal safety, processing safety, storage safety, transportation and reception safety, water vapor safety, personnel safety, and information safety, Supply chain security, laboratory security and other weak links, established control measures. A routine assessment of the food safety protection plan is carried out once a year. The most recent assessment was conducted on 2023-10-12.

#### Samples:

建立了食品防护要求，进入厂区的访客须经公司保安人员确认并放行，外来车辆和人员未经许可不得进厂，同时工厂派相关人员到公司对进入车间、仓库等敏感区域的访客进行控制。对生产现场的敏感区域，如生产区、仓库区进行视频监控。

公司按照 GB/T 27320-2010 食品保护计划及其应用指南食品生产企业进行风险评估，识别了公司外部安全、内部安全、加工安全、储藏安全、运输和接收安全、水汽安全、人员安全、信息安全、供应链安全、化验室安全等方面的薄弱环节，建立了控制措施。每年 1 次对食品安全防护计划进行例行评估。最近一次评估时间 2023-10-12 进行。

\* indicate compliance (Yes), non-conformance (No), nonconformities to be detailed in nonconformity table; detail any not-applicable clauses with reasons

注明符合 (Yes)、不符合 (No)，不符合项在不符合项表中详细说明；不适用条款详细说明原因

FSSC 22000, Additional Requirements 额外要求	Conform* 符合与否	Remark 评述
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Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体 不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
2.5.1	Management of services 服务的管理	Yes	
<p>Summary:</p> <p>A small number of raw materials are tested by in-house laboratories such as external materials, size, content, etc., using proven test methods to produce accurate and repeatable test results. The internal laboratory is compared with the external laboratory through ISO17025, and the ability is compared with the third-party laboratory on an annual basis.</p> <p>In the case of an organization using the analytical services of external laboratories for the verification of food safety, these services are carried out by competent laboratories that have been managed by ISO17025 or in accordance with ISO17025. Check the test report of the tripartite laboratory of raw materials, the tripartite laboratory has passed the ISO17025 certification or management according to the ISO17025, certificate number: CNAS L1300, CNAS L2274, etc.</p> <p>Emergency procurement: Procurement control procedures have been established, and the process and content of emergency procurement have been stipulated, and no emergency procurement incidents have occurred.</p> <p>Product specification review: The specification review system of raw and auxiliary materials has been established, which is reflected in the acceptance standards of raw and auxiliary materials, and the acceptance standards of cardboard raw and auxiliary materials are checked to meet the planning requirements.</p> <p>少数原辅料项目由内部实验室进行检测，如：外官、尺寸、含量等，使用经过验证的测试方法能够产生精确和可重复的测试结果。内部实验室通过与外部通过 ISO17025 的实验室进行比对，每年与第三方实验室进行能力比对。</p> <p>组织在使用外部实验室的分析服务进行食品安全的验证情况下，这些服务由有能力的实验室进行，这些实验室已通过 ISO17025 或者按照 ISO17025 管理。查看原料三方实验室检测报告，三方实验室通过 ISO17025 认证或者按照 ISO17025 管理，证书编号如：CNAS L1300，CNAS L2274 等。</p> <p>紧急采购：建立了采购控制程序，对紧急采购流程及内容进行了规定，没有发生紧急采购事件。</p> <p>产品规格审查：建立了原辅料规格审查制度，体现在原辅材料验收标准中，查看纸板原辅材料验收标准，符合策划要求。</p>			
2.5.2	Product labelling 产品标签	Yes	
Summary:			

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Label management requirements have been formulated, and the company has identified the label information in compliance with GB4806.1 and customers, etc. At present, all the company's products are not exported for domestic sales, and the product name, production date, implementation standards, etc. are identified on the product packaging and COA, and the cardboard box batch 2024-01-15 is spot-checked, and the product name, production date, product implementation standard, manufacturer's name and address are identified to confirm that they meet the requirements, and other information is reflected in the COA, and at the same time transmitted to the customer.

制定了标签管理要求，公司识别了标签信息符合 GB4806.1 和客户等。目前本公司的产品全部内销没有出口，产品包装和 COA 上标识了产品名称、生产日期、执行标准等，现场抽查纸板盒批次 2024-01-15，标识了产品名称、生产日期、产品执行标准、生产商名称和地址，确认符合要求，其他信息体现在 COA，同时传递至客户。

2.5.3	Food defense 食品防护	Yes	
2.5.3.1	Threat assessment	Yes	
2.5.3.2	Plan	Yes	

**Summary:**

A food safety protection plan has been established. Visitors entering the factory must be confirmed and released by the company's security personnel. No foreign vehicles and personnel are allowed to enter the factory without permission. At the same time, the factory have relevant personnel to control visitors entering the sensitive areas such as the workshop and warehouse. Monitoring sensitive areas by video of the production site, such as production area and warehouse area.

The company conducts risk assessment for food production enterprises in accordance with the GB/T 27320-2010 food protection plan and its application guidelines, and identifies the company's external safety, internal safety, processing safety, storage safety, transportation and reception safety, water vapor safety, personnel safety, and information safety, Supply chain security, laboratory security and other weak links, established control measures. A routine assessment of the food safety protection plan is carried out once a year. The most recent assessment was conducted on 2023-10-12.

**Samples:**

建立了食品防护要求，进入厂区的访客须经公司保安人员确认并放行，外来车辆和人员未经许可不得进厂，同时工厂派相关人员到公司对进入车间、仓库等敏感区域的访客进行控制。对生产现场的敏感区域，如生产区、仓库区进行视频监控。

公司按照 GB/T 27320-2010 食品保护计划及其应用指南食品生产企业进行风险评估，识别了公司外部安全、内部安全、加工安全、储藏安全、运输和接收安全、水汽安全、人员安全、信息安全、供应链安全、化验室安全等方面的薄弱环节，建立了控制措施。每年 1 次对食品安全防护计划进行例行评估。最近一次评估时间 2023-10-12 进行。

2.5.4	Food fraud mitigation 食品欺诈缓解	Yes	
2.5.4.1	Vulnerability assessment	Yes	
2.5.4.2	Plan	Yes	

**Summary:**

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Food fraud prevention and control requirements are established, a comprehensive evaluation method for the likelihood and severity of food fraud is stipulated, and the food safety team conducts a vulnerability assessment of raw materials according to the procedure.

Annual assessment, the latest evaluation time: 2023-10-31, the evaluation of raw materials and processes, etc., through the past history, raw material characteristics, economic drivers, supplier relationships, etc., the assessment results are medium and low risk, the current measures are controllable, and the control measures developed for raw materials with different risk levels such as: incoming testing and verification COA, regular third-party test reports, supplier declaration of conformity etc.

建立了食品欺诈预防控制要求，规定了食品欺诈的可能性及严重性进行综合评价方法，食品安全小组依据程序对原物料进行脆弱性评估。

每年评估，最近一次评估时间：2023-10-31，对原辅料及过程等进行评估，通过过往历史，原料特性，经济驱动因素，供应商关系等，评估结果均为中低风险，目前措施可控，针对不同风险等级的原料制定的控制措施如：进厂的检测和验证 COA，定期的第三方检测报告等、供应商的符合性声明等。

2.5.5	Logo use 标志使用	Yes	
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Summary: meet the requirement

2.5.6	Management of allergens 过敏原管理	Yes	
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Summary:

The company has established an allergen management system, after identifying that the company's materials, processes and finished products do not have allergens, but may be artificially brought in, the vehicle is brought in, the company's measures are: each time the vehicle enters the factory for inspection, personnel change clothes and wash hands and disinfect, prohibit employees from bringing food into the workshop, and train employees. On-site assessment of the effectiveness of allergen measures taken.

Samples:

公司建立了过敏原管理制度，经识别公司物料、过程及成品没有过敏原，但可能人为带入，车辆的带入，公司采取的措施为：车辆每次进入厂区进行检查，人员更衣洗手消毒，禁止员工带食品进入车间，对员工进行了培训。现场评估采取的过敏原措施有效。

Clause 条款	Requirement 要求	Yes No	If No – detail NC reference 如 No-具体 不符合项内容及编号 Justify “not applicable” clauses 对“不适用”条款解释理由
2.5.7	Environmental monitoring 环境监控	Yes	

Summary:

The "Allergen Control Procedure" has been established to identify that the company's raw materials and finished products do not contain allergens, but control measures are stipulated in procurement, transportation, storage and production processes, and personnel entering and leaving the workshop are regulated. On-site allergen control measures are effective, so the risk is very low and allergen testing is not required.

The company has established an environmental monitoring plan, formulated a cleaning plan, and cleaned environmental equipment. Clean the floor, walls, tuyere, etc. every month, check the

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workshop hygiene inspection records, 2023-10, 2023-11 and other packaging workshops, drying room hygiene inspection records.

建立了《过敏原控制程序》，识别公司原料和成品中不含有过敏原，但在采购、运输、储存和生产过程时规定了控制措施，对人员进出车间进行了规定。现场查看过敏原控制措施有效，所以风险非常低，不需要检测过敏原。

公司建立了环境监控计划，制定了清洁计划，对环境设备等进行清洁。每月对地面、墙壁、风口等进行清洁，查看车间卫生检查记录，2023-10、2023-11 等包装车间、晾味房卫生检查记录。

2.5.10	Storage and Warehousing 仓储	Yes	
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Summary:

A food safety protection plan has been established. Visitors entering the factory must be confirmed and released by the company's security personnel. No foreign vehicles and personnel are allowed to enter the factory without permission. At the same time, the factory have relevant personnel to control visitors entering the sensitive areas such as the workshop and warehouse. Monitoring sensitive areas by vedio of the production site, such as production area and warehouse area.

The company conducts risk assessment for food production enterprises in accordance with the GB/T 27320-2010 food protection plan and its application guidelines, and identifies the company's external safety, internal safety, processing safety, storage safety, transportation and reception safety, water vapor safety, personnel safety, and information safety , Supply chain security, laboratory security and other weak links, established control measures. A routine assessment of the food safety protection plan is carried out once a year. The most recent assessment was conducted on 2023-10-12.

Samples:

建立了食品防护要求，进入厂区的访客须经公司保安人员确认并放行，外来车辆和人员未经许可不得进厂，同时工厂派相关人员到公司对进入车间、仓库等敏感区域的访客进行控制。对生产现场的敏感区域，如生产区、仓库区进行视频监控。

公司按照 GB/T 27320-2010 食品保护计划及其应用指南食品生产企业进行风险评估，识别了公司外部安全、内部安全、加工安全、储藏安全、运输和接收安全、水汽安全、人员安全、信息安全、供应链安全、化验室安全等方面的薄弱环节，建立了控制措施。每年 1 次对食品安全防护计划进行例行评估。最近一次评估时间 2023-10-12 进行。

2.5.11	Hazard Control and measures for preventing cross-contamination 危害控制和防止交叉污染的措施	Yes	
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Measures to prevent cross-contamination are described in ISO/TS22002-4:2013 4.7.

The product has no effect of extending shelf life.

防止交叉污染的措施详见 ISO/TS22002-4:2013 4.7 中描述。

该产品没有延长保质期作用。

2.5.12	PRP Verification 前提方案验证	Yes	
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Summary:

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The company has established a verification system that specifies the purpose, method, frequency and responsibilities of verification activities, such as: the hazard control plan is verified once a year, and the PRP is verified once a month.

Prerequisite program verification date: 2023-10-16, the frequency and content of verification are based on the previous sampling and risk, including ISO/TS22002-4 4.1-4.15.

公司建立了验证制度，规定了验证活动的目的、方法、频次和职责，如：危害控制计划每年验证一次，PRP 每年验证一次。

前提方案验证日期：每月验证，查看 2023-10-16 PRP 验证记录，验证的频次和内容依据了上一次的抽样和风险，包含 ISO/TS22002-4 4.1-4.15 内容。

2.5.13	Product Development 产品开发	Yes	
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Summary:

The company has established design and development requirements, product appearance, size, raw materials and performance requirements are jointly designed and developed by customers and the company's R & D department, R & D department design is completed, factory small, pilot production, by R & D department design and development department output finished product specification table, raw and auxiliary material requirements, etc., factory output process parameters, hazard control plan, equipment maintenance requirements, resources and training, new food safety hazards and other requirements, on-site customers declare that there are no new products. On-site audit of the design and development of cardboard box products, the factory updated the hazard control plan and raw material acceptance requirements for the new cardboard box, the equipment maintenance plan included a folder-gluer, and the process parameters for the cardboard box were developed, all of which were approved.

公司建立了设计开发要求，产品的外观、尺寸、原料和性能等要求均由客户和公司研发部门共同设计开发，研发部门设计完成后，工厂小、中试生产，由研发部门设计开发部门等输出成品规格表、原辅料要求等，工厂输出工艺参数、危害控制计划、设备维护要求、资源和培训、新增加的食品安全风险等要求。现场审核纸板盒产品的设计开发，工厂针对新产品纸板盒更新了危害控制计划和原材料验收要求，设备维护计划包括了糊盒机，制定了针对纸板盒的工艺参数，均经过了批准。

\* indicate compliance (Yes), non-conformance (No), nonconformities to be detailed in nonconformity table; detail any not-applicable clauses with reason

注明符合 (Yes)、不符合 (No)，不符合项在不符合项表中详细说明；不适用条款详细说明原因

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