

# **Northern Food Complex Co., Ltd.**

## **AUDIT REPORT**

Surveillance 1 (ISO 22000:2018 by UKAS) (2024)

## Northern Food Complex Co., Ltd. **AUDIT REPORT**

<b>Client ID#:</b>	CMPY-082012
<b>Client/Address:</b>	Northern Food Complex Co., Ltd. 99/3 Moo 1, Chiangrai-Dongmada Road, Maekorn, Maung, Chiangrai 57000 Thailand
<b>Audit Criteria:</b>	ISO 22000:2018
<b>Audit Activity:</b>	Surveillance 1 (ISO 22000:2018 by UKAS) (2024)
<b>Date(s) of Audit:</b>	Maung, Thailand: 20-Nov-2024
<b>Auditor(s) (level):</b>	Natipa Mekhanurat (Lead Auditor, Maung, Thailand) Pornthavee Ngampanitchayakit (Auditor, Maung, Thailand)
<b>Scope of Audit and Scope of Certification:</b>	<p><b>Site:</b> <i>Northern Food Complex Co., Ltd., Maung, Chiang Rai, Thailand</i></p> <p><b>ISO 22000:2018:</b> Manufacture of Japanese Soy Sauce, Chinese Soy sauce, Seasoning Sauce, Fermented Vinegar, Hoisin Sauce, Dark &amp; Sweet Soy Sauce and Ferment soy bean paste.</p> <p><b>Exclusions from scope:</b> None</p>

## OVERALL RESULT:

No Action Required

The management system was found to be fully effective. (no nonconformities issued)

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## EXECUTIVE SUMMARY

All performance of FSMS, it was found that the performance of the company was maintained and implemented performance from the last auditing. The result of food safety objectives measuring were achieved on business target and provided safety of products / service to support high customer special specification in scope and This Audit No NC.

Context of the organization; FM-GR-173 R01 Seen defined context of the organization lasted review on 10/2024. Organization determined, monitored, and reviewed external/internal issues affecting ability to achieve intended result(s) of FSMS implementation by determined internal and external issue for

External issues such as sourcing raw material, pandemic outbreaks situation, high competitor, climate change (effect seasonal of raw material), Economic , update regulation.

Internal issue such as Use high technology / program control FIFO stock and tracability (MRPII) and Low technology machine (Koji room), staff has low skill in production technic, Difficult to recruit new staff.

## SWOT ANALYSIS

<b>Strengths</b>	Top management and all staff has a high commitment and food safety awareness. Staff has high competence.
<b>Weaknesses</b>	None
<b>Opportunities</b>	None
<b>Threats</b>	Highly competitive in business.

## INTERTEK MATURITY MODEL

The score descriptions are generic to all management systems and cannot be customized by the auditor, thus allowing for the consistency of interpretation and standardization of audit results worldwide. The scores provided to your organisation are for benchmarking purposes only and are based on the audit team's evaluation.

### Management

Meets Intent

Evidence of management commitment, customer and/or interested party satisfaction, knowledge/awareness of policy and objectives does exist. Responsibility and authority is documented, understood and supported via data, trends and related KPI's. Management reviews are complete and meet the minimum intent.

### Internal Audits

Meets Intent

Internal audits are being performed at planned intervals and are based on status and importance of the Management System. Data is being collected on regular basis. Audit teams are trained, impartial and objective in their approach. Audit reports are clear, concise with respect to content. Actions are being taken as a result of audit findings and timely responses are provided.

### Corrective Action

Meets Intent

The corrective action process meets the minimum requirements as defined by the standard. Data does exist from such sources such as customer and/or interested party complaints, internal audits, warranty analysis, defects, internal metrics and supplier performance. The process includes a review of the effectiveness of the actions taken. There is evidence of problem solving tools being used to support the process.

### Continuous Improvement

Meets Intent

Data streams are being used as sources to drive continual improvement over time. These may include management system policy, objectives, and audit results, analysis of data, CAPA and management reviews.

### Operational Control

Meets Intent

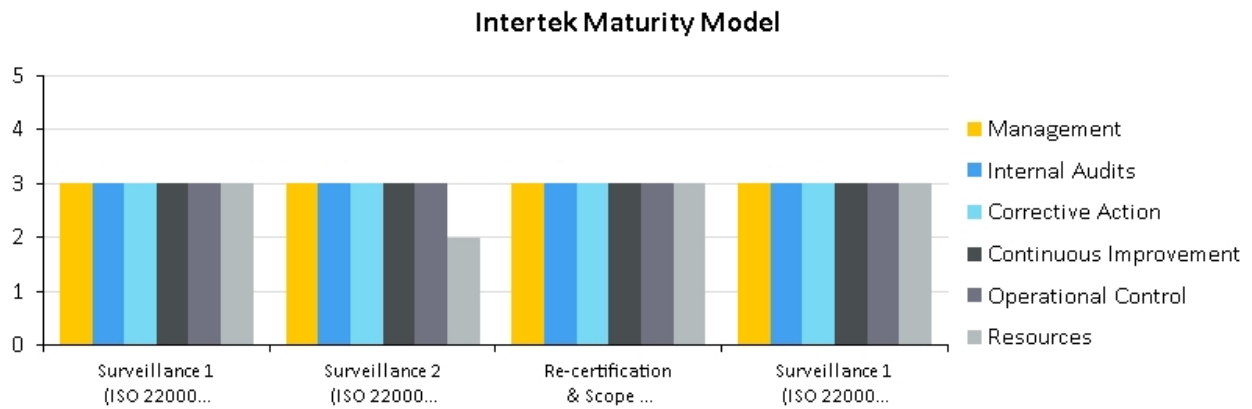
Operational Controls are planned and developed. Planning is consistent with many of the other Management processes. Objectives, process requirements, needs for appropriate additional documents and resources, verification and monitoring activities and records requirements have been determined, as appropriate. Processes and activities run consistently. Some data is collected to verify the adequacy of operational controls with evidence of some improvement trends.

### Resources

Meets Intent

Resources required for the effective maintenance and improvement of the management system have been defined and deployed. Customer and/or interested party satisfaction and overall stability of the management system has been demonstrated. Competency requirements have been defined and implemented.

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Rating: 5=Benchmark | 4=Mature | 3=Meets Intent | 2=Beginning | 1=Not Evident

## FINDING SUMMARY

	Minor	Major
Opportunities for improvement have been identified		
No		

## STATUS OF PREVIOUS AUDIT FINDINGS

**Follow-up on findings issued at previous audit:**

Prior assessment resulted in no non conformities.

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## EVIDENCE SUMMARY

The state of the management system is summarized below:

**Conclusion of Client's Processes/Functional areas audited including KPI/Metrics**

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External issues such as sourcing raw material, pandemic outbreaks situation, high competitor, climate change (effect seasonal of raw material), Economic , update regulation.

Internal issue such as Use high technology / program control FIFO stock and tracability (MRPII) and Low technology machine (Koji room), staff has low skill in production technic, Difficult to recruit new staff.

Understanding the needs and expectation of interested party ; Organization was determined interested parties FM-GR-174 R00 and latest review on 10/10/2024 as below;

- Owner need high efficiency of production machine, Hight profit.
- Employee need suitable of work environment, need suitable of wok, salary
- Customer need product complied with specification, delivery on time.
- Supplier need increasing order, suitable price.
- competitor ; Fair price

**Leadership and commitment**

Top management was demonstrated leadership and commitment with respect to the FSMS, e.g., food safety policy & the objectives of the FSMS were established and aligned with the strategic direction of the organization, implementation of the FSMS requirements into the business processes, resources needed for the FSMS, communicating the importance of effective food safety management and conforming to the FSMS requirements, applicable statutory and regulatory requirements, and mutually agreed customer requirements related to food safety, etc.

Food safety policy was implemented and maintained (announce on JAN 2024) covering a commitment to satisfy applicable food safety requirements, including statutory & regulatory requirements & mutually agreed customer requirements related to food safety and a commitment to continual improvement of the FSMS. Food safety policy was communicated to all staff via training and posted on information board within the site.

Organizational roles, responsibilities and authorities ; Found top management assign all position on organization chart clearly. And found food safety team leader was assigned on food safety manual and communicated to all staff in factory about responsibility of all position.

**Internal and external communication**



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Communication procedure P-P-25-F was established and implemented covering internal communication and external communication. Applicable statutory and regulatory requirements were updated by Top management. Policy, objectives, complaints, standard requirements, food regulations, etc. were communicated by meeting, information on board and training by responsible staff and food safety team. List of applicable statutory & regulatory requirements and customer requirements was controlled and applied. Records were maintained.

List of legal/statutory/regulatory or customer requirements was controlled and continuing applied as MoPH 414, MoPH 416.

Planning of Changes; Top management has reviewed when have new/ change from customer or change policy mission of company and defined appropriately.

Risk/ Opportunity FM-GR-175 R01 : Risk and Opportunity including assessment criteria was defined. Seen defined Risk/Opportunity likelihood of Occurrence (Low, Medium, High) Severity/Profitability of Confitability of Consequence.

Take action plan in High 10-25 Risk score on 2023 found

Result of follow up in timefarm in case

1. PM plan of machine, action plan by PM with MRP program, control spare part FM-GR-177
2. Covid-19 management, action plan by update Covid-19 new, body temperature check, etc.

The action of risk and opportunity maintain in FM-GR-177 and report result on management review and on 2024 found covid 19 in low risk.

Risk assessment on 2024 found High Risk in case PM plan of machine, action plan by PM with MRP program, control spare part FM-GR-177 continouns follow up action plan since 2023-2024, review in next management review.

KPI ; Review by top management and food safety team. Management System Performance: Seen high commitment of Top management and management team into maintaining and improving the food safety management system effectiveness from observed policy and related objectives/ programs, including evidence of periodically review the progress and achievement of them. See performance for food safety objective as ;

Objective targets and planning have been maintained for 2022-2024 as report following e.g.

Swab test result pass 100%, 2022 = 100%, 2023=100%,2024 = 100%

Product test pass as specification 100% in 2022-2024.

Food safety complaint 0 case/year; 2022=11, 2023=7cases,2024=4 case (action in FM-GR-177 )

Correct of COA > 99.96% , 2022-2024 = 100%.

PM on plan =100%, 2022=100, 2023=100%,2024=100%

Break down <5time/year, 2022=5, 2023=7 times,2024=3 time.

% Yeild in PD line > 90% (New KPI on 2024) = achieved

KPI monthly report in FM-GR-153, last review on November 2024, The KPIs that not achieved target was investigate and take action in FM-GR-177.

Food safety meeting as monthly for changed in process, raw material, regulation, complaint, external audit result, pest control result, emergency situation, complaint, IQA, PRP, CCP, traceability, calibration, food defense and food fraud.

Seen high commitment of Top management and management team into maintaining and improving the food safety management system effectiveness from observed policy and related objectives/ programs, including evidences of

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periodically review the progress and achievement of them. Seen appropriately and adequacy resources provision in order to meet customer requirements and expectation, legal compliance, and improving the organization performances. Resources are covering human, equipment, infrastructure, facilities, etc.

### Documented Information Control Process

The company has been established procedure PM-GR-02 R28 for control of document including internal and external document in master list FM-GR-04 R04 . shown as QM, EM, SHE, MM, PM,WI,SP,ST,FM etc. By sampling internal documented revise i.e. Revise documented i.e.

WI-WH-07 R07 effective date 30/10/24, QM-01 R32 effective date 21/10/24 (DAR record in FM-GR-03), PM-GR-19 R14 effective date 21/10/24.External documented control in master list FM-GR-04 R04 (SP) i.e. regulation, Bos FSSC, Logo use (SDE). Seen effectiveness of approval, distribution and recall the obsolete version by document position. Records remain legible, readily identifiable and retrievable include retention time and location use. Electronic file auto backup ever 4 hrs and record in FM-GR-144 lasted on 26/7/2024 . Document control 3 years.

NC, Corrective and preventive action The handling non-conformances and potential unsafe products was identified include clear documentation of the product control, management method and authorized person for product release. In year 2024 there was found 7 NC by sampling NCR No. NCR 061,062 ,021,006/24 found NC report in FM-QC-13 found investigate root cause, corrective action was effectiveness.

Complaint was raised and inform to related person. Seen the follow-up action that prevent the occurrence of problem was set for complaint management. The customer feedback (complaint and satisfaction data) was collected and analyses to improvement company performance. In year JAN – NOV 2024 found 1 1 case (food safety & Quality complaint) By sampling Complaint No. 2,5,6,10,11 record in FM-GR-27 found investigate root cause, correction, corrective action and plan by FSMS team and top management.

Emergency preparedness and response ; The procedures and standard support and risk management defined as also focus on preventing and mitigating the environmental impacts that may be associated with accidents or emergency situations. Specific procedure and it have been good implemented and maintained, review of equipment performance to testing, checking as define on plan SP-HS-XX i.e. fire, flooding, chemical pollution, Earthquake, Gas LPG and First Aid. key contract list manager SP-GR-140. Emergency test fire drills on 2/3/2024, Earthquake on 2/3/2024, chemical pollution on MAR 2024. On 2023-2024 no emergency case.

### Monitoring, measuring, analysis and evaluation

The site evaluated and analysed the data from result of PRPs (swab test result, daily hygiene record, cleaning record, etc.), HACCP plan, oPRP plan and external audit for improvement.

Corrective action from internal audit, complaint and external audit which was analysed and bring into as input of management review.

### Internal Audit

- The internal audit procedure was established. Internal audit plan FM-GR-05 for 2 time/ year defined base on importance and status, Foos safety team 17 member update on 1/2024 lasted training FSSC V 6.0 on 11,19/10/2024

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and internal auditor on 19/10/2024 by Intertek Thailand.

- Lasted internal audit on 26-28/10/2024 use checklist FM-GR-14 R07 cover all requirement i.e. ISO22000-2018, ISO/TS and additional req.
- Seen the internal audit schedule / plan FM-GR-12 R08, audit checklist covered all department and justified criteria for C, NC and OBS. Result from internal audit can identify weak point of organization. In this audit No NC.
- Result shown NCs. Found system set up for taken the action and follow the progressive by auditor and summary audit report. Found many continual improvement points decisions from many channels e.g. Vision, KPIs, Management review, Internal audit, Analysis of data, Corrective & Preventive action and monitoring result that found these information were used for improvement.

Management review The management review was plan in twice time/year and found the process was reviewed by Top management , Food safety team leader and Food safety team which seen last review on 9/9/2024 and 31/10/2024. Review input such as Changes in external and internal issues, Risk , communication , HACCP review , CCP / oPRP monitoring , KPI , additional req V 6.0 and ISO/TS part GHP , the performance of external providers, the adequacy of resources, etc. and shown decision outputs and action plan, responsible person with due date to improvement to the effectiveness of FSMS and company performance. Plan follow up result form MM review will follow up by person who responded i.e. food safety culture plan.

### Continual improvement

- The site review and evaluated the data from complaint, review output, internal and external audit result, and all result from PRP verification. Then analyse for improvement and seen the evidence of personal hygiene control, not found the food safety compliant, and consistency system maintained.

### Updating the system

Refer to data analysed and evaluated for improvement and then seen the system was reviewed and updated and seen the update evidence in latest management review.

Traceability / Mock Recall was established and implemented including responsibility person, recall procedure and frequency of recall test on QP-QM-XX. Identification control cover identification lot No. material, product in process. Contact recall list was defined covered local government. Found mock recall / Backward test lasted on 2/4/2024 product Gluten free soy sauce 1000 L. Qty 4 Drum (Tank IPC) lot 16032024 ( use time 2.19 hrs.) Forward test on 2/4/2024 raw material Salt 97.5% lot 27022024 Qty : 15,000 kgs receiving date 27/2/2024 use for product order since 22/3-30/3/2024 balance 100% (use time 30 minute).

On 2023-2024 no product recall and withdrawal.

### Human resource, competence, awareness and training

- The recruitment and training procedure was established in PM-GR-06 R16. The organization has defined manpower appropriately for the FSMS.
- All resource need are sufficiently provided.
- Competency need and training need for each position are clearly defined in job description and core competence

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i.e. Production staff , production supervisor , QC , QA , PUR.

- training program FM-GR-17 R06 found lasted training FSSC V 6.0 on 11,19/10/2024 and internal auditor on 19/10/2024 , CCP / oPRP on 21/10/2024 , allergen on 29/5/2024 , OJT on 21/10/2024 record in FM-GR-21.
- Health examination conducted latest on 15/2/2024 covered chest x-ray, stool culture, HBsAg, etc.

### Maintenance

#### PM plan FM-EN-26

- Seen detail for monthly PM and FM-EN-04 updtae in every monthly then sampling month June-Nov 2024.
- PM schedule was arranged FM-EN-76 also checklist with machine and equipment; Vinegar mixing tank U29, glass washing machine 6 head U65, capping machine U75, Soybean mill machine A5, screw conveyor to silo A30, screw conveyor to cooker A61, Soybean squeezing machine B11, SBO filter press B45, Screw under cooker C10, bucket wheat flour C54, koji room E2, fermented tank F64, main press cake H31, filter press cotton washer I16, raw soy sauce pump to pasteurization K10, pasteurization K13, chlorine feed pump O7, soft water tank O23, separator vinegar R7, koji for vinegar process R36, lemon squeeze (ponsu sauce) R95.
- Seen the food grade grease “BISON” food contact (H1)
- Seen the fixing work order FM-PD-61 also cleaning and cross contamination checked result after maintenance by sampling: 0030, 0055, 0039
- Training was provided at annual and sampling training course; PRPs, engioneer WI/procedure, PPE used.

### Utility

- Boiler 4 tons and daily cheked in FM-EN-36 and record every 2 hours for control pressure steam (out) 0-7 bar. PM was daily and seen record FM-EN-37 with valve, bowndown, safety system. Chemical was used in boiler which was anti scale chemical and seen detail and MSDS “NEXGUARD” and seen chemical was secure kept. Annual checked by subcontractor on 11/08/2024. Competence of boiler staff was arranged as legal.
- Compressed air was provided by air pump and maintenance as PM plan FM-EN-63. Seen the equipment was done follow as plan in daily (leak and filter) and year. Filter was changed latest on 27/02/2024
- Water system plant and seen PM record chlorine feed pump O7, soft water tank O23 and PM plan was defined.
- Light was checked at working area nd seen result was “suffiency” in working area and sampling test on 04/07/2024 at warehouse and production B2 B3 B4

### Purchasing and outsource control process

- Purchasing control procedure PM-PC-02 R23 covering process of supplier and outsource selection, purchasing process and supplier evaluation.
- Assessment of supplier was done on
- Selection of new vendor which done before approved and registered to supplier list FM-PC-01 R08 over supplier raw material & packaging.
- Purchasing requisitions including, specification, quantity and needed date were received from user. Analysis of evaluation data of supplier performance every lot receiving as criteria PM-PC-01 R29 was done on APR-JUN 2024 by sampling supplier raw material , packaging No. 994 ,T012,S037, HUXXX in FM-PC-12 of quality, delivery on time , price , certificate result grade A.
- On 2023-2024 no new supplier.

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- Storage and Warehousing procedure in place control cover Stock control and specify areas storage i.e Raw material, Packaging, Chemical, Lab QC, ware house , packaging room. Seen appropriately control of raw material and finish products. raw material, packing and finish products were controlled key parameter in storage such as preservation, identification at warehouse and stock control all finish product and majority raw material. Record check condition loading / transportation i.e. clean , lock , pest and personal. Record inspection transportation FM-WH-48.

Verify scope : Manufacture of Japanese Soy Sauce, Chinese Soy Sauce, Seasoning Sauce, Fermented Vinegar, Hoisin Sauce, Dark & Sweet Soy Sauce and Fermented Soybean Paste.

Foos safety team 17 member update on 21/10/2024 lasted training FSSC V 6.0 on OCT 2024.

Site establish and implement FSSC 22000 V 6.0

List of legal/statutory/regulatory or export market specific requirements was controlled and continuing applied such as; No. 61,135,416,414

Product description Ferment soy bean paste products (pasteurized and non-pasteurized) for cooking, packing plastic bag PE 1 kg and glass bottle 200 and 250 gms, shelf-life 10 mths for non-pasteurized in PE bag, 18 months for non-pasteurized in glass bottle, 24 mths for pasteurized

Product description: Sauce products group (Japanese Soy Sauce, Chinese Soy sauce, Seasoning Sauce, Fermented Vinegar, Hoisin Sauce, Dark & Sweet Soy Sauce), glass/plastic/tin can/mini pack/plastic drum/bulk pack 1000l, 3 months - 3.0 years, retail pack/OEM/bulk, allergen, for industry/shop/restaurant.

Product description Fremented vinegar SP-GR-118 sepecification with chemical, micro, heavy metal, RM as specification spec SP-QC-32 control Shelf life 24 months.

Process flow for Fermented vinegar (FM-GR-XX) is receiving, maixing, cooking, fermentation, pasteurization, filtration and filling and verified on 21/10/2024.

FM-GR-XX hazard analysis, and seen the hazard was analyzer for B/C/P/A/F update Decision tree as standard new version as QM-XX.

HACCP Process flow for Sauce products (Japanese Soy Sauce, Chinese Soy Sauce, Seasoning Sauce, Hoisin Sauce, Dark & Sweet Soy Sauce) receiving, sieving, cleaning, steaming, cooling, milling, mixing, seeding, koji production, fermentation, squeeze, pasteurized/sterilization, filtration, filling verified on 21/10/2024.

FM-GR-100 HACCP plan and oPRP plan verified on 21/10/2024

CCP1B; pasteurized/sterilization control temperature depend on each product i.e. 100-110 o C and 15-20 minutes for sauce, temp>90 o C and time>15 min for dark and sweet soy sauce, temp 70-80 C time 15-20 minutes for vinegar, temp 90-95 o C flow rate ≤53 L/min for Chinese soy sauce, temp 95-100 o C. Japanese soy sauce. Control flow≤53 L/min for Japanese soy sauce and temp>100 C time>15 min for hoisin sauce and all record at start ad very 10 minute record in FM-QC-60.

CCP2P; filtration with screen control size filter > 50 micron inspection at before and after working by PD&QC staff.

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Record FM-QC-44.

CCP3P Washing packaging (glass) control pressure  $\geq 1.0$  PSI , time  $\leq 15$  Hz or  $\geq 7$  sec. control pressure sampling 12 pcs / 30 minute. record FM-PS-43.

oPRP Plan Sauce products

oPRP; pasteurized for vinegar, temp  $>70$  C and time  $>15$  minute,

oPRP1B; pasteurized temp 105-110 C time 40 Hz, Flow  $<53$  L/min for Japanese soy sauce, record every 40 minutes in FM-QC-60.

oPRP2B; pasteurized 2 at temp 90-95 C time 15-20 minute for Japanese soy sauce and dark soy sauce by checking start every 15 min and finish process.

oPRP1P; magnetic with strength  $>10,000$  gauss, and check start and stop process and record in FM-PD-58.

Action when deviation from CCP of OPRP e.g. stop line, hold the affect/unsafe product, management the affect/unfase product, check the machine/process as in document.

HACCP plan SD-120

Fermented vinegar SP-GR-118

-Specification with chemical, micro, heavy metal, RM as specification spec SP-QC-32

-Process flow for vinegar is receiving, maixing, cooking, fermentation, pasteurization, filtration and filling and verified on 21/08/2024.

FM-GR-98 hazard analysis, and seen the hazard was analysed for B/C/P/A/F update

Decision tree as standard new version as QM-03

FM-GR-100 HACCP plan and oPRP plan

CCP1B; Pasteurization tempearture 70-80 C time 15-20 minutes for vinegar, time  $>15$  min. Monitoring time and temperature at start, during (every 5 minutes) and finish process by QC and operator. When devation then stop process, reheat and checke before release.

CCP2P; filtration with screen size  $<30$  micron. Monitoring at before and after working by PD&QC staff. When deviation then re-process and checked.

CCP3P; bottle washing with control pressure  $\geq 1$  psi, washing time  $<15$  Hz or  $>7$  sec, check every 12 bottle by PD staff at every 30 minute. When deviation then re-wash and checked.

oPRP

oPRP1; pasteurized for vinegar, critical limit at temp  $>70$  C and time  $>15$  minute. Monitoring by operator and QC at start, during (every 5 minutes) and finish process. When devation then stop process, reheat and checke before release.

Fermented Soybean Paste

receiving, sieving, washing, steaming, cooling, mixing, seeding, fermentation, milling, fermentation, pasteurized, filling, capping, packing and delivery. PFD verified on 21/08/2024

HACCP plan

CCP1B; milling by using screen  $<3$  micron. Mintoirng at before and after filling by PD employee. When deviation then

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re-process and checked.

CCP2B; fermentation, check microorganism and not found Salmonella, S. aureus, Bacillus. Monitoring was arranged at every batch (2 sample per batch). When deviation then re-process and checked.

CCP2B; fermentation, limit was  $A_w < 0.85$ . Monitoring at every batch/tank by QC. When deviation then hold, re-process and checked.

CCP3B; Pasteurization, temperature  $> 75^\circ\text{C}$  time  $> 15$  minutes. Monitoring time and temperature at start, during (every 5 minutes) and finish process by QC and operator. When deviation then stop process, reheat and check before release.

CCP4B; manual capping, check "complete cap" by visual inspection by QC. Monitoring check every pallet by QC as MIL-STD-105E. When deviation then hold, re-process and checked.

### oPRP

oPRP1P; drum cleaning. Visual inspection with not found foreign matter. Monitoring every drum. When deviation then reject, recleaning, and checked before release.

-Control of NC was provided by NCR procedure for handling on NC product and potential NC product and approved the handling NCP by authorized person. Corrective action provided as procedure to provide to prevent reoccurrence and Release evaluation was done by factory manager.

Validation All CCP on 28/9/2024 and oPRP on 30/8/2024 report by external lab.

Rework control established and implemented as QP. Rework product is returned to production step at mixing tank.

Rework products are inspected by QC staff.

On-site Audit found process of product Japanese soy sauce lot 392/24, packing in carons / inkjet product Soja original lot EXP 11/2026 and Fermented vinegar WIP lot JUN – SEP 2024. Verify CCP / oPRP and record control process was comply with plan found record in process control.

Inhouse laboratory test i.e. % salt, TN, pH, Brix, Micro (TPC, Y&M), Heavy metal test with external lab full parameter. Pt test APC lasted on 20/3/2024

Raw material and packaging specification were established as procedure by sampling receiving record in FM-QC-17 as specification SP-QC-32 i.e. Mirin mold, soy bean, Brown Rice packaging in glass bottles 21/6/2024. Test report pesticide 4 group brown rice on 14/3/2022 (Crop 2022), Test report plastic bottles PET 13/11/2023, CAP on 13/11/2023.

Challenge Traceability products Organic Fairtrade Rice Vinegar 5% size 310 ml. DDM 05092026 Lot NFC25974 Qty 6,048 Bottles/310ml. Use raw material organic rice (Brown Rice) on 15/7/2022, Mirin Mold lot 22/4/2019 use time 3 hrs. (target 4 hrs.)

Verification of finished Johin miso / Dark miso / Organic Miso / Johin pasteurized/ Pasteurized Shiro miso/ seasoning miso/Japanese soy sauce and Chinese soy sauce/seasoning soy sauce/Dark & sweet soy sauce/ Hoisin sauce on 8/10/2024 / Organic Rice Vinegar on 28/2/2024 parameter APC, Bacillus cereus, C per, Coliform, E-coli, S aureus, salmonella spp, Y&M, Aflatoxin, Arsenic, Cadmium, copper, Lead, Mercury, Tin, Zinc, synthetic color, Sorbic acid,



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Benzoic acid and pesticide 4 group was comply with specification and regulation.

### PRPs verified

-Water was sourced from deep well water. Water (used water and process water) and daily check for pH and chlorine 0.2-0.5 ppm and seen the weekly micro test FM-QC-88 (Coliform, EC) and test on 06/04/2024 including steam test on 23/04/2024.

-WI-GR-09 Waste control and during factory inspection and then found that effectiveness. Hazardous waste was transfer to external and seen report followed as legal and sampling manifest \*\*27004 on 27/04/2024 for contaminated cotton and used lubricant oil. By-product was sold to external (farmer) and seen detail of contract defined "animal feed" and sampling contract \*\*\*PONG, \*\*\*AGRO.

-WI-GR-08 Glass and plastic was control as layout SP-GR-152 including equipment machine, facility and seen the record for filling room FM-GR-54 at buliding B2, receiving area, cooker area, squeeze process, moromi area, filling area, KOJI area, vinegar production area, filtration of sauce area and check record date in July-Oct 2024. FM-QC-101 check glass control and potential before start production.

-WI-PD-42 Cleaning method B4 with detail of method, chemical and employee and program SP-GR-13 and seen cleaning record plate heat exchanger, soy sauce tank, glass packing machine, capping machine, film shrink machine. Cleaning record was maintained and checked for buliding B2/B4/B5, moromi area, filling area, KOJI area, vinegar production area, squeezing and filtration of sauce area.

Equipment cleaning was done and maintained as WI-PD-xx and seen cleaning record for squeeze machine, plate heat exchanger, soy sauce tank, crusher, and koji room.

Seen the partial CIP system defined at at leaset 2 time/week and seen FM-PD-62 20/11/2023 for sauce process line at pasteurization step by chemical (hot water, NaOH 2%, acid 2%, water final rinse) and pH final 6.5-8.5 also micro test (EC) every time after CIP. Seen record of pH rinse water on FM-QC-90 date 04/10/2024

-WI-GR-07 Pest controls that effective handling by sub-contractor and seen the contract \*\*4512 duration time Aug 2024-Aug 2025 with detail of method and chemical used.

Monthly report for service by supplier on July-Oct 2024.

Monthly infestation (EFK and glue trap) checked record was maintained as in FM-GR-41. In-deep survey was arranged by sub-contrcator (ADV\*\*) as in FM-GR-128 in every 3 months and latest 23/07/2024 and 18/10/2024.

Chemical used was approved by government with license such as; IMIFORCE, FENDONA also personal certificate valid on 02/10/2569

Pest data was analysed as trend in 2023-2024 and seen pest improvement program.

-WI-GR-06 Personal hygiene. QC was assigned to sampling in each process weekly FM-GR-26 by QC as policy for personal hygiene in place. Record and seen the record at each B2 , B4 filling process, B4 squeeze process, B4 sterilization on July-Oct 2024

Seen the control measure and facility for hygiene policy such as; hand washing baht before access production area with liquid soap and hand dryer, protective clothing with long sleeve and changing room provided and jewelry policy.

Workwear and protective clothing was provided to employee and follow as policy. During inspection and foun that



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employee followed as policy such as; filling area (hat, hair net, protective clothing, glove and footwear).

Warehouse, store and delivery

-Raw material was kept in dry and cleaned area and seen area was separated and prevent cross contamination. FG was kept in dry warehouse and clearly identified with tag label.

-Delivery process was done by external provider and sampling record FM-WH-48 with detail of product, quantity, truck condition and seen record on 03/05/2024 and 29/05/2024.

-Raw material and finish goods was kept in secure area and cleaned as program. Found the effectiveness during the site inspection.

-Challenge test the stock balance and FIFO/FEFO control for; wheat flour, organic rice, glass bottle or jar.

Allergen controlled was maintained as PM-GR-25 and seen allergen list (soybean, wheat, sesame) on SP-GR-124. Seen the legal and regulatory for each country. Control measure for control of allergen was in place such as; identification tag, closed packaging, physical barrier, separated weighing room and cleaning method. Allergen detail was arranged for raw material and FG and seen SP-GR-125. Cleaning verification was arranged as plan and seen record 02/08/2024 and 07/08/2024 and validation report on 12/05/2024 (wheat), 18/05/2024 (soybean), 08/06/2024 (sesame). Seen label of product was defined and sampling; soy sauce 10 litre and gluten free soy sauce 200 ml.

Risk assessment for EMP H/M/L not yet

Revised record follow as WI cleaning B1 filling

CIP contact time was not follow time 10 min, WI-GR-09 and no clearly for relation 50Hz and flow rate

Pest improvement program not yet after trend 2023-2024

5 S should be defined equipment

### Conclusions regarding risk assessment/risk treatment processes

Risk/ Opportunity FM-GR-175 R01 : Risk and Opportunity including assessment criteria was defined. Seen defined Risk/Opportunity likelihood of Occurrence (Low, Medium, High) Severity/Profitability of Consequence.

Take action plan in High 10-25 Risk score on 2023 found

Result of follow up in timefarm in case

1. PM plan of machine, action plan by PM with MRP program, control spare part FM-GR-177
2. Covid-19 management, action plan by update Covid-19 new, body temperature check, etc.

The action of risk and opportunity maintain in FM-GR-177 and report result on management review and on 2024 found covid 19 in low risk.

Risk assessment on 2024 found High Risk in case PM plan of machine, action plan by PM with MRP program, control spare part FM-GR-177 continuous follow up action plan since 2023-2024, review in next management review.

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### Conclusions regarding context of the organization

Context of the organization; FM-GR-173 R01 Seen defined context of the organization lasted review on 10/2024. Organization determined, monitored, and reviewed external/internal issues affecting ability to achieve intended result(s) of FSMS implementation by determined internal and external issue for

External issues such as sourcing raw material, pandemic outbreaks situation, high competitor, climate change (effect seasonal of raw material), Economic , update regulation.

Internal issue such as Use high technology / program control FIFO stock and tracability (MRPII) and Low technology machine (Koji room), staff has low skill in production technic, Difficult to recruit new staff.

Understanding the needs and expectation of interested party ; Organization was determined interested parties FM-GR-174 R00 and latest review on 10/10/2024 as below;

- Owner need high efficiency of production machine, Hight profit.
- Employee need suitable of work environment, need suitable of wok, salary
- Customer need product complied with specification, delivery on time.
- Supplier need increasing order, suitable price.
- competitor ; Fair price

### Additional information/unresolved issues

Use of marks and/ or any other reference to certification

-The company uses the certification mark on their website and business card which is complied with "INTERTEK" guideline.

-There was no use of certification and accreditation mark on the products

-Review of the web-site and on-site verification indicated the compliance to "INTERTEK" guidance.

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### Communication/Changes during the visit (if applicable)

NA

### References to appendices:

Audit plan (as executed); Interview record

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**The audit has been performed according to audit plan meeting audit objectives, scopes and duration (on-site and off-site) as given within the audit plan**

Audit date on 20/11/2024 (On site 1.5 Manday , off site 0.5 Manday)

Audit objective : Surveillance – Evaluation of the conformance and effectiveness of the management system with applicable standard(s) for the purpose of continuing of the certification as well evaluation of the effectiveness of the management system to ensure the client organization is continually meeting its specified objectives

Audit scope : Manufacture of Japanese Soy Sauce, Chinese Soy Sauce, Seasoning Sauce, Fermented Vinegar, Hoisin Sauce, Dark & Sweet Soy Sauce and Fermented Soybean Paste.

**Have there been any changes to Scope?**

No

**Have there been any changes to Headcount?**

No

**Have there been any Address Changes?**

No

**Have there been any Sites Added / Removed?**

No

**Have there been any Other Changes?**

Yes

Change contact person to be :

Supawish Jumlong // E-Mail : GM@northernfoodcomplex.com

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## LEAD AUDITOR RECOMMENDATION

### Lead Auditor Recommendation for ISO 22000:2018

The management system is in conformity with the audit criteria and can be considered effective in assuring that objectives will be met. Continued certification is therefore recommended.

## OTHER OR ADDITIONAL LEAD AUDITOR RECOMMENDATION

NA

## CLIENT ACKNOWLEDGEMENT

<b>Client Representative Name and Mailing</b>	Supawish Jumlong
<b>Address:</b>	GM@northernfoodcomplex.com
<b>Acknowledged By:</b>	Supawish Jumlong

This report is based on a sample of evidence collected during the audit; therefore the results and conclusions include an element of uncertainty. This report and all its content is subject to an independent review prior to a decision concerning the awarding or renewal of certification.

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Report issued at 5:33 GMT on 30-Dec-2024