

Northern Food Complex Co., Ltd.

AUDIT REPORT

Re-certification & Scope Extension (ISO
22000:2018 by UKAS) (2023)

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

Client ID#:	CMPY-082012
Client/Address:	Northern Food Complex Co., Ltd. 99/3 Moo 1, Chiangrai-Dongmada Road, Maekorn, Maung, Chiangrai 57000 Thailand
Audit Criteria:	ISO 22000:2018
Audit Activity:	Re-certification & Scope Extension (ISO 22000:2018 by UKAS) (2023)
Date(s) of Audit:	Maung, Thailand: 18-Dec-2023 to 19-Dec-2023
Auditor(s) (level):	Fontip Chuchouysuwan (Lead Auditor, Lead Auditor, Maung, Thailand) Pornthavee Ngampanitchayakit (Auditor, Auditor, Maung, Thailand)
Scope of Audit and Scope of Certification:	Site: Northern Food Complex Co., Ltd., Maung, Chiang Rai, Thailand ISO 22000:2018: Manufacture of Japanese Soy Sauce, Chinese Soy Sauce, Seasoning Sauce, Fermented Vinegar, Hoisin Sauce, Dark & Sweet Soy Sauce and Fermented Soybean Paste. Exclusions from scope: None

OVERALL RESULT:

Action Required

The management system was found to be effectively implemented although minor nonconformities were cited.

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EXECUTIVE SUMMARY

This audit found 3 NC.

The company's processes for determining, setting and communicating policies and objectives were effectiveness to measurement and deploy to all section. Seen appropriately monitoring and measuring performance against quality objectives which have analyzed and summarized every month/ year that was reviewed the progressive in management meeting for KPI issued.

The management review procedure was planned meeting at annually per year and found the process was reviewed by Top management/FSTL and FST which seen review latest on 1/9/2023, Review input such as Changes in external and internal issues that are relevant to the FSMS, including changes in the organization and its context, Relevant information obtained through external and internal communication, including requests and complaints from interested parties, analysis of the results of verification activities related to PRPs and the hazard control plan, 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.

The internal audit procedure was established and planned at least annually. Found internal audit evidence on 11/4/23 and 17-31/10/23. 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.

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SWOT ANALYSIS

Strengths	- Top Management and Team have the strong commitment to food safety management system.
	- Food safety objectives have been monitored and reported to Top management.
	- The company has experience in business.
Weaknesses	- Root cause analysis and correction of unachieved objective target was unappropriated.
	- Hazard analysis of MISO product was unappropriated.
	-Prerequisite programmes (PRPs) was unappropriated.
Opportunities	None
Threats	High 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

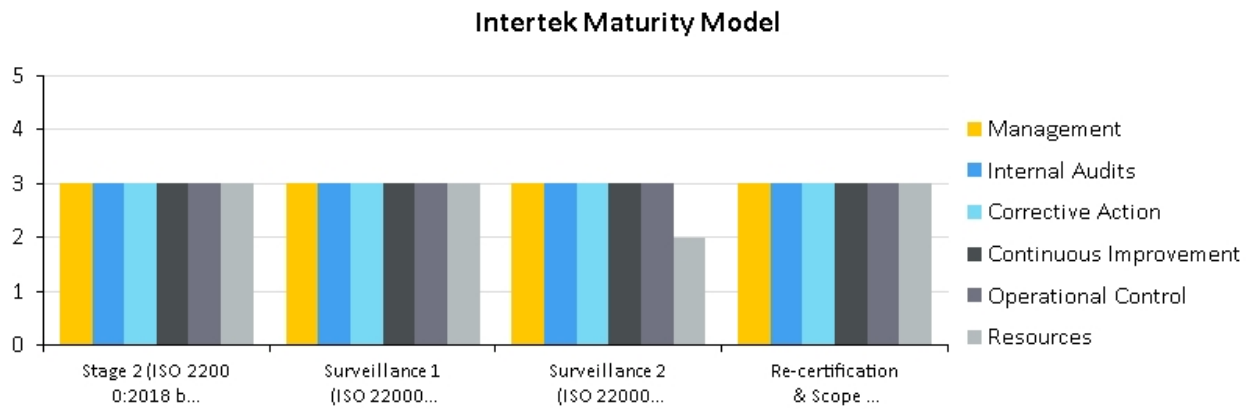
Operational Controls are planned and developed. Planning is consistent with many of the other Management processes. Objectives, process requirements, needs for appropriate additional documents and resources, verification and monitoring activities and records requirements have been determined, as appropriate. 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
Issued during current activity	3	0
Closed from previous activities	1	0

Opportunities for improvement have been identified

No

STATUS OF PREVIOUS AUDIT FINDINGS

Follow-up on findings issued at previous audit:

Non conformities raised at the last audit have been closed. No further actions required.

Report on closure of previous findings

Found training evidence for ISO 22000, FSSC 22000 ver 5.1 requirement of food safety team last on 20/5/2023.

Findings from the previous activity that could not be closed

Yes

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FINDING DETAIL

Finding #:	Audit Criteria:	Corrective Action Plan Due Date:	Corrective Action Implementation Date:
Finding 1509971 - 1	ISO 22000:2018	02-Jan-2024	19-Mar-2024
Issued by:	Classification:	Document Ref#:	Action Required:
Fontip Chuchouysuwan	Minor	FM-GR-153	Submit corrective action plan

Finding:

Root cause analysis and correction of unachieved objective target was unappropriated.

Requirement:

10.1.1

When a nonconformity occurs, the organization shall:

a) react to the nonconformity and, as applicable:

1) take action to control and correct it;

2) deal with the consequences;

b) evaluate the need for action to eliminate the cause(s) of the nonconformity, in order that it does not recur or occur elsewhere, by:

1) reviewing the nonconformity;

2) determining the causes of the nonconformity;

3) determining if similar nonconformities exist, or could potentially occur;

c) implement any action needed;

d) review the effectiveness of any corrective action taken;

e) make changes to the FSMS, if necessary.

Corrective actions shall be appropriate to the effects of the nonconformities encountered.

Objective Evidence:

There was no evidence to root cause analysis and correction of unachieved objective target in year 2023 i.e. break down < 5 time/year, Food safety complaint 0 issue/year, etc.

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Finding #:	Audit Criteria:	Corrective Action Plan Due Date:	Corrective Action Implementation Date:
Finding 1509971 - 2	ISO 22000:2018	02-Jan-2024	19-Jan-2024
Issued by:	Classification:	Document Ref#:	Action Required:
Pornthavee Ngampanitchayakit	Minor	FM-GR-99	Submit corrective action plan

Finding:

Hazard analysis of MISO product was unappropriated.

Requirement:

8.5.2

Hazard analysis

Objective Evidence:

Refer to HACCP manual FM-GR-99 for MISO product and then found that there was not clearly define covered related hazard analysis for step of fermentation of non-pasteurized product and packing step.

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Finding #:	Audit Criteria:	Corrective Action Plan Due Date:	Corrective Action Implementation Date:
Finding 1509971 - 3	ISO 22000:2018	02-Jan-2024	19-Jan-2024
Issued by:	Classification:	Document Ref#:	Action Required:
Pornthavee Ngampanitchayakit	Minor	Factory inspection	Submit corrective action plan

Finding:

Prerequisite programmes (PRPs) was unappropriated.

Requirement:

8.2.1

The organization shall establish, implement, maintain and update PRP(s) to facilitate the prevention and/or reduction of contaminants (including food safety hazards) in the products, product processing and work environment.

Objective Evidence:

During the site inspection and then found that glass bottle placed near RM, light covered was dirty, sauce filtration area was dirty and waste and drinking bottle was at squeezing and pasteurized#1 .

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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

FS team announce on 9/10/2023 (fm-gr-92/Rev.02) total 10 persons, new members K. Phitchai (QMR, QA, haccp team leader)

Policy announced on 6/1/2023 approve by General Manager, not change from previous audit.

Food safety manual QM-01, rev. 30 update on 21/6/23 for ISO 22000:2018

Management System Performance (Objectives / Targets / KPIs / Trend Analysis)

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 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.

Responsibility and authority

Director defined responsibility and authority in the JD and communicated to related person.

Food safety team leader is assigned for problem reported and review the problem by team in monthly meeting. Food safety culture plan in 2022-2023 (FM-GR-111) with detail of action for awareness of food safety and GHP effectiveness such as install in-direct contact hand open, install sieve, using alcohol gel, etc. and evalatuaed result by set up KPI.

Food safety = focus cleaning >> coz complaint micro contamination

KPI

The company's processes for determining, setting and communicating policies and objectives were effectiveness to measurement and deploy to all section. Seen appropriately monitoring and measuring performance against quality objectives which have analyzed and summarized every month/ year that was reviewed the progressive in management meeting for

Swab test result pass 100 %, 2021 = 100%, 2022 = 100%, 2023=100%

Product test pass as specification 100% in 2021-2023.

Food safety complaint 0 case/year; 2023=6, 2022=11, 2021=2

Correction of COA > 99.96% , 2021-2023 = 100%.

PM on plan =100%, 2021-2023=100%

Break down <5time/year ; 2021=7, 2022=5, 2023=7,

KPI monthly report in FM-GR-153, last review on November 2023, The KPIs that not achieved target was investigate and take action in FM-GR-177.

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Planning of Changes;

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

Management review

The management review procedure was planned meeting at least 1 time per year and found the process was reviewed by Top management/FSTL and FST with 10 persons attended which seen last review result on 1/9/2023 in FM-GR-02. Review input such as analysis of the results of verification activities related to PRPs and the hazard control plan, 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.

In this management review shown continuous improvement product and process for supply market HoReCa (hotel , hos[ital, restaurant, cafeteria), review document system by parato technic, NFC knowledge center, focus improvement ncr product release, chemµ out of control, etc.

New product in year 2023 5 recipe i.e. organic mirin, soy sauce for egg.

HACCP review last on 12/12/23

Customer Performance / Satisfaction/ Complaint

Customer complaint was control procedure. There were 6 food safety complaint and 4 quality complaint product with in 2023. Customer complaint was summarized and corrective action feedback to customer shown to be satisfied.

Complaint was raised and inform to related person such as; sale and QC. Seen the follow-up action that prevent the occurrence of problem. The customer feedback (complaint and satisfaction data) was collect and analyses to improvement company performance achieved from customer satisfaction. Sampling food safety complaint Light soy sauce ibc pd 26/5/23 detected bc, tpc >> complaint/CAR record FM-GR-07 on 5/7/2023>> change chemical to be Evo form and check swab E. coli, check value check tpc, ym, bc; reject product was reprocess on 23/6/23.

Internal audit

The internal audit procedure was established. Internal audit plan on 11/4/23 and 17-31/10/23 for GHP&HACCP, ISO22000, FSSC 22000. Internal audit plan for 2 time/ year defined base on importance and status. Seen the checklist defined FM-GR-14 which sampling QMR, QC, warehouse, production, RD and HR and justified criteria for C, NC and OBS. Result from internal audit can identify weak point of organization. Result found 5 NC (11/4/23), and 1 NC (17-31/10/23), sampling NC no.PD (B2,B3.B5) in FM-GR-07. Found 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. The internal audit auditor Mr. Yodsaporn P. trained on 28/10/2023 for ISO 22000:2018 requirement & internal audit, GHP&HACCP ver.5, BRC issue 9, TAS 1004 on 10/3/2022, FSSC 22000 v5.1 on 14/6/2021.

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NC, Corrective and preventive action

The company has maintained procedure defined for handling non-conformances identified include clear documentation of the non-conformity by a suitably competent and authorised person, identification of the corrective action to address the immediate issue and timescale. And sampling internal CAR which found effectiveness control. NCR (FM-qc-13) date 4/11/23 for B. cereus swab over std at filling tool of bottling line and NCR no. 0395/23 wheat lot 5/8/23 total nitrogen over std. was investigate and action, and approve by QMR or General manager.

Emergency preparedness and response

The procedures and standard support PM-GR-26 also focus on preventing and mitigating the environmental impacts that may be associated with accidents or emergency situations.

Specific procedure SP-GR-127, SP-HS-04, SP-HS-05 for action plan with emergency situation and it have been good implemented and maintained, review of equipment performance to testing, checking as define on plan i.e. fire drill, electricity failure, water shortage, flooding, emergency of delivery vehicle, chemical leakage, epidemic, etc. No actual emergency effected product occurred from last audit until now and seen test on 25/2/23 for fire drill, chemical leak, earthquake, flood, etc. and trained staff, record in FM-EM-09. And found outbreak situation management on notice PBP 03/3564.

Product withdrawal / Recall procedure / Traceability system

Traceability and identification procedure and Recall procedure was established, procedure including responsibility person, recall procedure and frequency of recall test. Identification control cover identification lot No. material, product in process.

Traceability backward conduct on 3/11/2023 for standard soy sauce 10 lit lot 15082023, total 430 cartons which found all document concern complied with procedure set up and shown effectiveness of traceability system.

And found forward conduct on 15/2/2023 for salt 97.5% lot 18012023 total 15,000 kg record in FM-GR-85 which found all document concern complied with procedure set up and shown effectiveness of traceability system.

Mock recall and traceability conducted on 3/11/2023 for standard soy sauce 10 lit lot 15082023, total 430 cartons, 16/2/2023 for John standard soy sauce no.2 10 lit, lot 30012023 total 475 cartons record in FM-QC-65, with time within 4 hours with 100% recovery which shown effectiveness process.

Internal and external communication

The system set up as procedure P-P/25/F for Internal communication and External communication, review and updated of related legal requirement by QC and communicated to related person/department by email.

List of legal/statutory/regulatory or customer requirements was controlled and continuing applied as MoPH 414, MoPH 416 in management review last on 1/9/2023.

Documented Information Control Process

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The company has been established of control document including internal and external document. The Master list FM-GR-04 shown as procedure, WI, Standard etc. Sampling document such as QM-01 rev. 30 update on 21/6/2023 etc. Seen effectiveness of DAR record FM-GR-03, approval, distribution and recall record FM-GR-05 the obsolete version by document position and Web server. Records remain legible, readily identifiable and retrievable include retention time with shelf life plus 1 year and location use. All documents and records have implemented to up-date revision and provided adequately to operation and backed up clearly. Electronic file back up every week by IT in FM-GR-144 last on 16/12/2023.

Maintenance procedure, PM Plan FM-EM-76 was maintained cover pasteurizing machine, glass filling machine, bottle cleaning machine, etc. Service report / History machine record in FM-EM-23. Found food grade grease Sani-g NLGL:1, was NSF registration no. 137757. Water treatment method WI-EN-04 was maintained, record in FM-EN-44 check hardness, back wash, etc.

Purchasing /outsource / service control process : Purchasing control procedure PM-PC-01 R29 was established defined for process of supplier and outsource selection, purchasing process and supplier evaluation. Selection of new vendor which done before approved and registered to supplier and service in AVL list FM-PC-01. Purchasing requisitions including, specification, quantity and needed date were received from user. Sampling evaluation data of supplier/service performance Raw material / Packaging FM-PC-12 last on November 2023. Sampling supplier of organic soy bean, organic jasmine white broken rice, salt, seed koji, glass bottle, black lug cap, etc. and sampling service evaluation of transportation, pest control, external maintenance, laboratory and security guard, etc.

Recruitment, Training process and Awareness : The recruitment procedure , training procedure and training program update on 2023 i.e. CCP past. on 2/9/23, PM&WI QC on 14/8/23, CCP/OPRP on 15/8/23, food allergen on 20/5/23, FSSC22000/ISO22000/GHP&HACCP on 20/5/23, OJT was established and implemented. The system control as recruitment procedure and evaluation after probation period and the job description depend on position defined covered all function. New staff on 9/11/2023 found sampling job spec, OJT trained on 9/11/2023. Health examination 20/2/2023 by A.M Medical Lab covering PE, Chest x-ray, etc.

Production process SD-120

-Food safety team FM-GR-92

-HACCP study FM-GR-93 = Japanese Soy Sauce, fermented Vinegar

Production during onsite inspection; Japanese Soy sauce Shoyu 600 ml.

-Product description: sauce product, 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; miso product (pasteurized and non-pasteirized) for cooking, packing plastic bag PE 1 kg and glass bottle 200 and 250 gms, shelf-life 10 mths for non-pasteirized in PE bag, 18 mths for non-pasteirized in glass bottle, 24 mths for pasteirized

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

-Process flow for sauce product is receiving, sieving, cleaning, steaming, cooling, milling, mixing, seeding, koji production, fermentation, squeeze, pasteurized/sterilization, filtration, filling verified on 09/10/2023

-Process flow for vinegar is receiving, mixing, cooking, fermentation, pasteurization, filtration and filling and verified on 09/10/2023

FM-GR-99 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

CCP; bottle washing with control pressure ≥ 1 psi, 15 Hz or 10 sec, check every 12 bottle by PD staff, 30 minute or 12 bottles

CCP; sterilization 100-110 C and 15-20 minutes for sauce, temp > 90 C and time > 15 min for dark and sweet soy sauce, temp 70-80 C time 15-20 minutes for vinegar, temp 90-95 C flow rate ≤ 53 L/min for Chinese soy sauce, temp 95-100 C flow ≤ 53 L/min for Japanese soy sauce and temp > 100 C time > 15 min for hoisin sauce and all record at start and every 10 minute.

CCP; filtration with screen diameter < 5 mm, at before and after working by PD&QC staff

oPRP

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

oPRP; pasteurized temp 105-110 C time 40 Hz, Flow < 53 L/min for Japanese soy sauce, record every 40 minutes.

oPRP; 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.

oPRP; magnetic with strength > 10000 gauss, and check start and stop process.

oPRP; Bottle washing by water pressure ≥ 1.0 psi at ≥ 7 second check 12 bottle per 30 min for dark soy sauce

-Validation CCP/oPRP was maintained by test report; miso product 24/05/2021, Japanese soy sauce on 24/22/2022, Hoi Sin sauce on 24/11/2022, rice vinegar 24/02/2022 at step mixing, after pasteurization and test report for FG with TPC, Coliform, EC, S.aureus, Salmonella, Bacillus. Filtration was done 2020 with 50 micron.

Magnet TM-701 step was done as plan on 25/01/2023.

Bottle washer validation and 25/01/2019.

Miso pasteurization step was done on 24/06/2022 and verified 06/05/2023

Verification

-incoming inspection FM-QC-xx for raw material, ingredient and packaging against SD-QC-xx such as; celite 545 (As, Pb), salt 22/11/2023, organic white rice, organic brown rice 23/09/2023, white sesame, organic Jasmine rice 23/09/2023, soy bean, koji seed 22/04/2019, organic soy bean 30/09/2023, organic cassava flour, 220 ml glass bottle, salt received 10/10/2023, PE cap, brown hom mali rice, organic fresh garlic, organic fresh onion, 10 L PET and check specification.

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-Migration test for packaging i.e., PET bottle 01/11/2023, PE cap, glass bottle 25/01/2023, 200 L plastic drum, gallon PET 01/11/2023, metal can 18 liter + seal inner 11/01/2023, IBC plastic tank, lug cap + lining, glass jar.

-bottle washing step was verified at monthly with method ST-QC-06 against AOAC 2000 and monitoring of microorganism e.g., TPC, staphylococcus, salmonella

-200 L plastic drum was test in migration on 10/08/2021

-Challenge product "Shiro Miso lot MI043/23, amount 256 box (1536 jars/), delivery to France, loading date 20/12/2023" refer to FMQC107 label checked and ink code checked by QC, weight and pack control checked during packing FMQC04, filtration checked FMQC44 on 01/12/2023, bottle washer FMPD43 with pressure and speed, FMQC60 heat cook, mixing record MI043/23 on 30/11/2023 refer to ferment tank (380 kgs), fermentation process FMPD81 "MI303", rice colking record, soy bean steam record FMPD86, ferment first date 08/11/2023, QC check finish ferment process, product checked before packing FMQC119 with pH/NaCl/moisture.

Steaming process was controlled as FM-PD-09 at 100-125 C at 30 minute on record 17/12/2023, roasted temperature at 315 C FM-PD-08, Koji process was maintained as FM-PD-37 and temperature controlled.

-Product was test at annual and result "PASS": Soy sauce on 01/10/2023, sauce product (sushi, teriyaki) on 09/11/2023, organic rice vinegar 07/03/2023 with EtOH, SO₂, vitamin C, miso product 17/06/2023 and Parameter; aflatoxin, heavy metal, As, Cd, Cu, Fe, Pb, Hg, Sn, Zn, synthetic color for miso product, APC, Bacillus, Clostridium, Coliform, EC, Salmonella, Staphylococcus, and YM, 3-MCPD was test on 01/09/2023, melamine on 01/09/2023, pesticide group on 09/05/2023, Sorbate and benzoate on 07/03/2023 result "ND"
Miso non-pasteurized test 17/06/2023 for APC, Bacillus, Clos, EC, Sal, Staph, YM

-Allergen was verified for soybean+wheat and soybean+rice >>> gluten 02/03/2023 "ND"

-COA product release by QC was maintained by QC and checking COA2312032 and COA2312074
With detail of color, NaCl, pH, TN, TPC, TSS, and YM which review and approved by QA manager.

-WI-RD-02 shelf-life was study at incubate 35 C and sampling; organic ponsu lime FM-RD-13 in 21/06/2023 for checking of temp, pH, color, Bx, %NaCl, TPC, YM and organoleptic test

-PT-test with third party and result "pass" ; APC on 24/05/2023 and protein 13/07/2023, %salt 27/07/2023

Calibration

-equipment list and calibration plan FM-EN-32

-Check plan FM-QC-07 and during the site inspection and seen the evidence of calibrated tag.

-Result FM-QC-64 for inhouse verification

-FM-QC-64 for equipment in inhouse laboratory and seen the certificate and acceptance criteria then checked; thermometer at fermentor 08/05/2023, wheat roaster 07/07/2023, thermometer at koji room 29/09/22, pressure

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gauge at cooker-in 11/04/2023, thermometer at cooker B2 21/11/2023, magnetic on 06/01/2023, pasteurization thermometer set #1 and thermo- graph recorder#1 on 17/05/22, pasteurization thermometer set #2 and thermo- graph recorder#2 on 30/05/22, dial thermometer at bottle washer 12 head 24/05/23, thermosensor at miso process 02/02/23, thermometer at alcohol evaporator 08/08/23,

PRPs verified

-Water and daily check for pH and chlorine and seen the weekly micro test FM-QC-88 (coliform, EC) and test on 13/05/2023 including steam test on 13/05/2023.

-WI-GR-08 Glass and plastic was control and seen the record for filling room FM-GR-54 at bulidng B2, moromi area, filling area, KOJI area, vinegar production area, squeezing and filtration of sauce area for 01-15/08/2023, FM-QC-101 check glass control and potential before start production.

-WI-GR-09 Waste control and during factory inspection and then found that effectiveness.

-WI-GR-11 Cleaning program on dailt and seen cleaning record on 01-15/08/2023 at bulidng B2/B4/B5, moromi area, filling area, KOJI area, vinegar production area, squeezing and filtration of sauce area. Seen the bottle wasing step was verified at monthly with method and monitoring of microorganism e.g.TPC, staphylococcus, salmonella. Seen the partial CIP system on 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.

-WI-GR-07 Pest controls that effective handling sub-contractor and data trend analysed in every month and seen the contract with detail of method and chemical. Monthly report for service by supplier on 03/09, 26/09, 15/10 and 29/10

-WI-GR-06 Personal hygienea was checked weekly FM-GR-26 by QC as policy for personal hygiene in place and record and seen the record on 1-15/08/2023 for filling area, KOJI area, vinegar production area, squeezing and filtration of sauce area.

-WI-GR-10 Chemical control and chemical control procedure in place

-FM-QC-103 Environmental moitoring program was maintained at monthly for swab test for hand, utensil, filling machine at monthly FM-QC-32 and seen record 06/09, 05/10

Ait test was done at twice a month in filling area and seen record test TPC on 05/09 and 16/09, and 14/10 & 26/10

Product development

PM-RD-01

-Seen FM-RD-01 and properly design input by review by FSTL

-FM-RD-09 with detail design, specification benchmark, review capacity, legal applicale, hazard related product in FM-RD-36

-FM-RD-04 formula checked record and done by RD staff.

-FM-RD-12 process review by production.

-First lot and confirmation by RD, QC, PD with FM-RD-16

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-Shelf-life study was studied FM-RD-13 organic ponsu lime FM-RD-13 in 21/06/2023 for checking of temp, pH, color, Bx, %NaCl, TPC, YM and organicleptic test

Allergen controlled was maintained as PM-GR-25 and seen allergen list (soy bean, wheat, sesame) on SP-GR-124. Seen the lgal and regulatory for each country. Swab test for allergen verification on 10/04/2023 (wheat) and 08/04/2023 (sesame)

Label FM-QC-107, ink code checked by QC and manager and FM-QC-04 and label check at before and finish step with code, name, weight and label detail.

Review and conclusion of client performance trends since last certification/recertification (at recertification audit and last surveillance audit prior to recertification)

From last recertification the client was maintained the ISO 22000:2018 system with effectiveness that shown in KPI and management, etc.

Conclusions regarding risk assessment/risk treatment processes

Risk/ Opportunity

Risk and Opportunity including assessment criteria was defined in FM-GR-175 and last reviewed on 2/5/2023. Scoring monitoring established in QM-01, High 10-25 score for established action plan to manage in FM-GR-175

In this period there were high topic defined in FM-GR-175 such as

1. PM plan of machine, action plan by PM with MRP program, control spar part.
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 in next management review.

Previous action report result in management review last on 5/9/22 the result was not achieved target, action was maintain again on 2023.

Conclusions regarding context of the organization

Conclusions regarding context of the organization

Conclusion regarding context of the organization refer FM-GR-173: Interview the Top management and QMR last on 4/9/2023.

understanding the organization and context needs and expectation of interested parties. Seen the organization has implemented and maintained to determine external and internal issue that it is relevant to quality management system. Top management and QMR by determined internal and external issue and SWOT (Strong, weakness, opportunity and treat) detail in document as below ;

Determined in quality manual use analysis SWOT & TOWS Matrix in FM-GR-173. Update on 4/9/2023.

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Internal issue;

- Corporate Values, Employees, Owners, Shareholders

External issue;

- Customer, Marketing, Law, Technology, Environment

Conclusion regarding context of the organization: Interview the Top management and QMR understanding the organization and context needs and expectation of interested parties. Seen the organization has implemented and maintained to determine external and internal issue that it is relevant to quality management system. Top management and QMR by determined internal and external issue and SWOT (Strong, weakness, opportunity and treat) detail in document as below ;

Needs and Expectations of Interested parties : defined in FM-GR-174 update on 8/4/2022.

- Customer; Delivery on time, High quality of product.

- Employees; Salary, Safety environmental , Bonus , Safety equipment support.

- Government; needs Comply with laws

- Supplier; needs Order continual, High order, Comply with specification

Additional information/unresolved issues

None

Communication/Changes during the visit (if applicable)

None

References to appendices:

Audit plan

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

Yes

Have there been any changes to Scope?

Yes

Confirm scope wording as below

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 Headcount?

No

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Have there been any Address Changes?

No

Have there been any Sites Added / Removed?

No

Have there been any Other Changes?

No

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LEAD AUDITOR RECOMMENDATION

Lead Auditor Recommendation for ISO 22000:2018

The nonconformity(ies) identified do not jeopardize the certification of the management system. Continued certification is therefore recommended pending acceptance of the corrective action plans(s) for identified nonconformity(ies).

OTHER OR ADDITIONAL LEAD AUDITOR RECOMMENDATION

None

CLIENT ACKNOWLEDGEMENT

Client Representative Name and Mailing Address:	Prakaiwan Tepmanee prakaiwan4213@gmail.com 99/3 Moo 1, Chiangrai-Dongmada Road, Maekorn, Maung, Chiangrai 57000 Thailand
Acknowledged By:	Prakaiwan Tepmanee

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.