



Wuhu Pacific Plastic Co., Ltd

Food Safety Management System (ISO22000 & HACCP)

Company: Wuhu Pacific Plastic Co., Ltd

Applicable Product: Reusable Plastic Tableware

Applicable Standard: ISO 22000:2018, HACCP Verification Standard V1.0, GB 4806.7-2023

Document Purpose: This Food Safety Management System (FSMS) is formulated to standardize food safety control throughout the entire production chain, eliminate potential food safety hazards, ensure stable and compliant production of food-contact plastic products, and fully meet global food safety requirements for domestic sales and export business.

1. General Requirements

1.1 Objective

To establish, implement, maintain and continuously improve a systematic food safety management system based on ISO 22000 and HACCP principles. The system effectively identifies, evaluates and controls biological, chemical and physical food safety hazards in raw material procurement, production, disinfection, packaging, storage and transportation, ensuring that all finished reusable plastic tableware are safe, compliant and suitable for repeated food contact use.

1.2 Scope

This system covers all processes involved in the production of reusable plastic tableware of Wuhu Pacific Plastic Co., Ltd, including raw material acceptance, raw material storage, injection molding and trimming, assembly, disinfection treatment, finished product packaging, finished product storage, product delivery and after-sales

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traceability management.

1.3 Core Principles

1. Hazard analysis and risk-based prevention;
2. CCP (Critical Control Point) key monitoring and limit control;
3. Prerequisite Programs (GHP & OPRP) full-process guarantee;
4. Documented traceability and closed-loop correction;
5. Continuous improvement of food safety performance.

2. Food Safety Organization & Responsibility

The company sets up a professional **Food Safety Team** to ensure independent, effective and standardized food safety management.

2.1 Top Management (General Manager)

1. Formulate, approve and issue the company's food safety policy and HACCP management guidelines;
2. Guarantee human, material, equipment and technical resources required for FSMS operation;
3. Appoint the food safety team leader and confirm organizational structure and department responsibilities;
4. Conduct annual management review to ensure the suitability and effectiveness of the system;
5. Take full legal and managerial responsibility for company food safety incidents and non-compliant batches.

2.2 Food Safety Team Leader (Production Department)

1. Organize daily operation, supervision and implementation of ISO22000 and HACCP systems;
2. Complete process hazard identification, hazard evaluation, CCP and OPRP confirmation;



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3. Organize internal audit, system verification, staff food safety training;
4. Responsible for external communication, certification audit and customer food safety audit coordination;
5. Track corrective actions for food safety deviations and ensure closed-loop improvement.

2.3 Administration Department

1. Manage all food safety system documents, procedures and record archives;
2. Formulate annual food safety training plans and organize implementation and assessment;
3. Supervise workshop sanitation, personnel hygiene and environmental hygiene management.

2.4 Sales & Purchasing Department

1. Implement supplier food safety qualification audit and annual evaluation;
2. Collect raw material safety certificates, test reports and realize raw material safety traceability;
3. Handle customer food safety complaints, product feedback and product recall management;
4. Control transportation hygiene and prevent cross-contamination during delivery.

3. Food Safety Prerequisite Programs (GHP & Factory Hygiene)

The company strictly implements Good Hygiene Practices (GHP) to build a safe production environment and eliminate basic food safety risks.

3.1 Personnel Hygiene Management

All production and inspection personnel must comply with uniform hygiene management regulations: wearing clean working clothes, gloves and dust-proof



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equipment; prohibiting entry with infectious diseases; regular health check-ups; strictly prohibiting smoking, eating and littering in the production workshop.

3.2 Workshop & Environmental Hygiene

The production area is kept clean, dry and dust-free. Partition management of production area, storage area and waste area is implemented. Regular cleaning, disinfection and sanitation inspection are carried out to prevent dust, mildew and microbial contamination.

3.3 Pest Control & Anti-Pollution Management

Complete rodent-proof, insect-proof, dust-proof and foreign matter prevention facilities are installed in workshops and warehouses. Regular pest inspection and elimination are performed. Toxic, harmful and odorous substances are strictly prohibited from entering production and storage areas.

3.4 Equipment & Mold Hygiene Maintenance

Production equipment, molds and tools are cleaned and maintained regularly. Lubricants and auxiliary materials used in production must be non-toxic and food-contact safe to prevent chemical contamination and residual pollution.

4. Raw Material & Packaging Material Food Safety Control

All raw materials and packaging materials for food-contact products strictly comply with **GB 4806.7-2023** food safety standards to ensure zero safety hazards at the source.

4.1 Approved Raw Materials

PP resin, PC resin, ABS resin and food-grade color masterbatch are adopted. All raw materials feature stable physical and chemical properties, no harmful precipitation, and meet the limit requirements of total migration, potassium permanganate consumption and heavy metal residues.



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4.2 Incoming Food Safety Inspection

1. Each batch of raw materials must be accompanied by supplier certificate of conformity;
2. Suppliers shall provide annual third-party food safety full-item test reports;
3. The company conducts visual inspection and document verification for each incoming batch;
4. Any raw material with unqualified safety indicators or incomplete documents shall be rejected.

4.3 Material Storage Safety Control

Raw materials and packaging materials are stored in cool, dry and ventilated warehouses, away from high temperature, sunlight and moisture. Strict FIFO management is implemented to prevent material deterioration and secondary pollution.

5. Production Process Food Safety Hazard Control

According to HACCP hazard analysis results, the company carries out targeted control on physical, chemical and biological hazards in all production links.

5.1 Raw Material Acceptance (OPRP1 – Chemical Hazard Control)

Significant Hazard: Excessive heavy metal residue, excessive total migration, unqualified chemical precipitation.

Control Measures: Strictly review supplier qualification and annual third-party test reports; verify batch-by-batch safety documents; reject unqualified raw materials completely to prevent chemical hazards from entering production.

5.2 Storage Process (Physical & Biological Hazard Control)



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Significant Hazard: Insect contamination, dust foreign matter, mildew and microbial pollution.

Control Measures: Implement GHP standardized management, regular warehouse sanitation inspection, perfect pest control system, and isolated storage to avoid cross-contamination.

5.3 Injection Molding & Trimming Process

Hazard Risk: Equipment oil contamination, foreign matter mixing, process temperature abnormality leading to material deterioration.

Control Measures: Pre-production equipment cleaning; fixed injection molding process parameters; first article inspection + in-process patrol inspection; unified standardized management of leftover materials and waste materials.

5.4 Assembly & Disinfection Process

Hazard Risk: Manual secondary pollution, unclean surface and microbial residue.

Control Measures: Strict personnel hygiene management; full disinfection of finished products; isolation and elimination of defective products to ensure product surface cleanliness and food safety.

5.5 Packaging & Finished Product Storage

Hazard Risk: Dust contamination, foreign matter mixing, storage environment pollution.

Control Measures: Clean packaging environment; only qualified products are allowed to be packaged; finished products are stored in classified zones with complete protection measures to ensure food safety stability during storage period.

5.6 Delivery & Transportation Safety Control

Hazard Risk: Transportation vehicle pollution, package damage, mixed loading contamination.

Control Measures: Check vehicle sanitation before loading; strictly prohibit mixed transportation with toxic and harmful goods; implement closed loading and seal record



management.

6. Monitoring, Corrective Action & Verification System

6.1 Daily Monitoring Mechanism

Arrange special personnel to monitor OPRP key links daily, including raw material document verification, environmental hygiene inspection, process parameter supervision and finished product safety status inspection, and keep complete monitoring records.

6.2 Corrective Action for Safety Deviation

Once food safety deviation or potential hazard is found, immediately stop the corresponding operation, isolate suspicious products, analyze root causes, formulate and implement corrective measures, and resume production only after verification and confirmation.

6.3 System Verification & Internal Audit

The food safety team conducts regular internal audits and system verification every year, evaluates the effectiveness of hazard control measures, checks the completeness of records, and continuously optimizes system loopholes and process risks.

7. Product Safety Standards & Release Control

All reusable plastic tableware products of Wuhu Pacific Plastic Co., Ltd are released only after full compliance with food safety requirements:

1. Heavy metal (Pb) \leq 1mg/kg;
2. Potassium permanganate consumption \leq 10mg/kg;
3. Total migration, decolorization test and other chemical indicators fully meet national standards;



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4. No peculiar odor, no residue, no microbial contamination;
5. Complete product labels, traceable batches, valid shelf life (18 months).

8. Traceability & Emergency Management

8.1 Full Traceability System

Establish a one-to-one traceability system of raw material batch, production batch and delivery batch. All production, inspection and delivery records are archived completely to realize full-chain traceability of food safety.

8.2 Food Safety Emergency & Recall

In case of potential food safety risks or customer safety complaints, the company can immediately initiate product isolation, batch investigation and product recall procedures to control risks within the minimum range and ensure consumer safety.

9. Continuous Improvement

Based on internal audit results, customer feedback, supplier evaluation, test data and market supervision information, the company continuously optimizes food safety control processes, updates control standards, strengthens staff safety awareness, and ensures the long-term stability and effectiveness of ISO22000 and HACCP food safety management systems.

Issued by: Wuhu Pacific Plastic Co., Ltd

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