



Wuhu Pacific Plastic Co., Ltd

Quality Control System for Reusable Plastic Tableware (Official External & Internal Audit Version)

This quality control system is established in accordance with **ISO22000:2018**, **HACCP (Hazard Analysis and Critical Control Point) system**, and the national standard **GB 4806.7-2023**. It applies to the full-process production and quality management of reusable plastic tableware manufactured by **Wuhu Pacific Plastic Co., Ltd**. The system covers supplier qualification management, raw material control, in-process production control, environmental and equipment hygiene management, personnel hygiene, finished product inspection, warehousing & transportation, and after-sales traceability. It is fully integrated with the company's existing HACCP food safety system to form a dual closed-loop management mechanism for **food safety + product quality**. This document is applicable to public disclosure, customer factory audits, on-site production implementation, and internal quality audits.

1. General Provisions

1.1 Purpose

To standardize the entire production quality activities of reusable plastic tableware of Wuhu Pacific Plastic Co., Ltd; to systematically identify, prevent and control physical defects, chemical hazards, hygiene contamination and process variations; to unify process quality standards, inspection specifications, operational guidelines and non-conformity handling procedures; to stably deliver qualified products that meet national standards, customer requirements and food safety specifications; and to realize controllable, traceable and continuously improvable quality management.

1.2 Scope of Application



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This system applies to the full-process quality control and management of reusable plastic tableware within the company's production scope, including **raw material procurement, incoming inspection, warehousing management, injection molding, trimming, assembly, disinfection, packaging, finished product storage, delivery and transportation, and after-sales traceability.**

1.3 System Principles

1. **Source Prevention:** Strictly control supplier access and raw material incoming quality to eliminate quality and safety risks at the source.
2. **Process Control:** Focus on process quality management and implement the "self-inspection, mutual-inspection and special-inspection" system.
3. **Risk linkage:** The quality system operates synchronously with the HACCP food safety system, ensuring unified identification and control of both quality risks and food safety hazards.
4. **Full Traceability:** Establish one-to-one correspondence among raw material batches, production batches, delivery batches and customer batches.
5. **Continuous Improvement:** Optimize quality standards and production processes based on inspection data, customer feedback, internal audits and corrective action mechanisms.

2. Quality Organization & Job Responsibilities

Based on the company's food safety team, a dedicated quality management team is established with clear authority and responsibility. All team members undertake dual responsibilities for product quality and food safety control.

2.1 Senior Management (General Manager)

1. Approve the company's quality policy, quality objectives, quality management regulations and annual quality plans.
2. Ensure sufficient human resources, equipment, testing conditions and training resources for the operation of the quality system.
3. Conduct management reviews and approve handling plans for major quality



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abnormalities and batch non-conforming products.

4. Take overall responsibility for the product quality and food safety of Wuhu Pacific Plastic Co., Ltd.

2.2 Production Department / Quality Team Leader

1. Lead the implementation of the quality control system and HACCP system, and oversee overall in-process quality control.
2. Organize process quality patrol inspections, monitor key process parameters, and manage on-site hygiene conditions.
3. Analyze quality abnormalities, implement corrective actions, judge rework or scrap disposal, and formulate preventive measures.
4. Verify process flow charts, conduct hazard analysis, ensure effective implementation of control points, and complete system internal audits and verification.

2.3 Administration Department

1. Manage, update and archive all quality system documents, forms and records.
2. Organize company-wide training and assessment on quality management, food safety and operational specifications.
3. Conduct regular compliance inspections on workshop environment, warehouse conditions and hygiene control.

2.4 Sales Department

1. Manage supplier qualification review, raw material document collection, and supplier quality evaluation.
2. Collect customer quality feedback and complaints, and lead after-sales quality problem handling.
3. Support product traceability, product recall simulation and quality risk early warning management.

3. Quality Standard Basis



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All product quality control activities of Wuhu Pacific Plastic Co., Ltd strictly comply with the following standards:

1. GB 4806.7-2023 National Food Safety Standard: Food Contact Plastic Materials and Products
2. ISO 22000:2018 Food Safety Management System Requirements
3. HACCP System Certification Requirements
4. In-house standards of Wuhu Pacific Plastic Co., Ltd including raw material inspection, injection molding process control, finished product inspection, packaging and transportation specifications

4. Full Process Quality Control Specifications

In accordance with the production process of Wuhu Pacific Plastic Co., Ltd: **Raw Material Acceptance** → **Warehousing** → **Injection Molding & Trimming** → **Assembly** → **Disinfection** → **Packaging** → **Finished Product Storage** → **Delivery**, standardized quality control is implemented for each process.

4.1 Raw Material Incoming Quality Control (Source Control & OPRP Key Control Point)

Controlled Materials: PP/PC/ABS resin, plastic color masterbatch, composite film and packaging bags

Potential Quality Risks: foreign object contamination, excessive heavy metals, excessive total migration, unqualified decolorization test, substandard additives

Control Measures:

1. **Supplier Access Control:** Only qualified suppliers with complete qualifications and valid annual test reports are approved for cooperation.
2. **Incoming Inspection:** Conduct package-by-package visual inspection to ensure no damage, no foreign impurities, no moisture and no peculiar odor.
3. **Document Verification:** Each batch must be accompanied by a certificate of conformity. Suppliers shall provide annual third-party full-item test reports covering heavy metals, total migration, potassium permanganate consumption and



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decolorization test.

4. Non-conformity Handling: Any raw material without valid test documents, abnormal indicators or poor appearance shall be **rejected directly and prohibited from warehousing**.

5. Annual Supplier Evaluation: Eliminate suppliers with unstable quality performance.

4.2 Warehouse Quality Control

Potential Quality Risks: pest contamination, dust pollution, moisture deterioration, cross-contamination, batch confusion

Control Measures:

1. Raw materials, packaging materials and finished products are stored in separate zones with clear identification of batch number, production date and quality status.
2. The warehouse is kept cool, dry, ventilated, away from direct sunlight and high temperature.
3. Strict pest control, dust prevention and anti-pollution measures are implemented. Storage with toxic, harmful or odorous articles is prohibited.
4. Adopt FIFO (First In First Out) principle and conduct regular inspections to prevent expired, moist or contaminated materials from being used in production.

4.3 Injection Molding & Trimming Process Control

Potential Quality Risks: defective molding, uneven thickness, burrs, notches, surface defects, oil contamination, parameter deviation

Control Measures:

1. Complete equipment and mold cleaning inspection before startup to avoid contamination by lubricants, rust inhibitors or foreign particles.
2. Strictly fix injection molding parameters including temperature, pressure, displacement and time; unauthorized parameter adjustment is prohibited.
3. **First Article Inspection System:** First article inspection is mandatory for each batch startup, mold change and material change; mass production is only allowed after confirmation of conformity.



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4. In-process patrol inspection is carried out to check product thickness, flatness, surface condition, no bubbles, no damage and no burrs.
5. Runner materials and leftover scraps are collected uniformly and disposed of through qualified recycling or scrapping to prevent defective materials from mixing into finished products.

4.4 Assembly & Disinfection Control

Potential Quality Risks: foreign substance mixing, assembly misalignment, unqualified hygiene status, secondary contamination

Control Measures:

1. All operators comply with personnel hygiene regulations and wear standardized working uniforms.
2. Each product is visually checked during assembly to prevent defective semi-finished products from flowing into the next process.
3. Finished products undergo standardized disinfection procedures to ensure full compliance with hygiene indicators.
4. Non-conforming semi-finished products are isolated and marked strictly to avoid mixing with qualified batches.

4.5 Finished Product Packaging Control

Potential Quality Risks: foreign substance contamination, non-standard packaging, quantity error, outer package damage and pollution

Control Measures:

1. Only fully inspected and qualified products are allowed to enter the packaging process.
2. The packaging environment is kept clean to prevent dust and foreign impurities from mixing in.
3. Products are packed in standard specifications with accurate quantity and neat arrangement.
4. Outer packaging is fully labeled with product name, batch number, production date, shelf life, specification and origin information.



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4.6 Finished Product Warehousing Control

Potential Quality Risks: batch confusion, moisture damage, contamination, expired products

Control Measures:

1. Re-inspection is conducted before warehousing; unqualified products are prohibited from entering the finished product warehouse.
2. Finished products are stored in divided zones with clear batch and status identification.
3. Maintain long-term warehouse hygiene and protection measures, and conduct regular inventory and shelf-life inspection.

4.7 Delivery & Transportation Quality Control

Potential Quality Risks: package breakage, product moisture, transportation contamination, mixed loading risks

Control Measures:

1. Check vehicle sanitation, dryness and cleanliness before loading.
2. Standardize loading and stacking methods to prevent product dumping and extrusion damage.
3. Monitor the whole loading process and record container seal numbers; mixed transportation with toxic or harmful goods is strictly forbidden.
4. Effective protection measures are adopted during transportation to avoid sunlight exposure, rain and contamination.

5. Final Finished Product Inspection Standards

All delivered products must fully comply with the following quality and safety standards before release:

- 1. Appearance Quality:** uniform thickness and color, smooth and clean surface, free of burrs, notches, breakages, holes, bubbles, scratches and embedded impurities.
- 2. Physical & Chemical Safety:** Lead (Pb) \leq 1mg/kg; Potassium permanganate



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consumption $\leq 10\text{mg/kg}$; total migration and decolorization test fully comply with GB 4806.7-2023.

3. Hygiene Indicators: No peculiar odor, no mildew, no pest contamination and no secondary pollution.

4. Packaging & Labeling: Intact packaging, complete labeling, traceable batch information and valid shelf life.

6. Quality Abnormity & Corrective Action System

Combined with the HACCP correction mechanism, a closed-loop management system for quality abnormalities is established:

- 1. Minor Abnormity** (slight appearance defects, irregular placement): On-site immediate correction by operators with self-inspection.
- 2. General Abnormity** (minor defective products, slight parameter deviation): Stop production for inspection, isolate non-conforming products, adjust process parameters and keep complete records.
- 3. Major Abnormity** (unqualified raw materials, excessive chemical indicators, batch defects, contamination risks): Immediately suspend production, isolate the entire batch, block delivery, and initiate review, rectification, root cause analysis and preventive action implementation.