



W.8.5.1 MONITORING AND MEASUREMENT OF PRODUCT (QMS & SQF)

REV.: G
DATE: 07/03/2025
OWNER: Quality Manager

(2.5.4.1/ 2.5.4.2/ 2.5.4.3/ 2.5.4.4/ 2.5.4.5/ 2.5.4.6/ 2.5.4.7/ 2.5.4.8) PRODUCT SAMPLING, INSPECTION AND ANALYSIS

The methods, responsibility, and criteria for sampling, inspecting and/or analyzing raw materials, finished food packaging and work in progress shall be documented and implemented. The methods applied shall ensure:

- Inspections and analyses are completed at regular intervals as required and to agreed specification and legal requirements, if any;
- Inspections are conducted to ensure raw materials, work in progress and finished product comply with the relevant specification, regulatory requirement, if any; and
- All analyses are conducted to industry recognized methods or alternative methods which are validated as equivalent to the industry recognized methods.

On-site personnel that conduct testing of finished product shall participate in an applicable proficiency testing program at least annually to ensure accuracy of results.

Where external laboratories are utilized to conduct input or product analysis, the laboratories shall be accredited to ISO 17025 or an equivalent national standard and shall be included on the site's contract service specifications register.

Where applicable, procedures shall also be in place for managing and verifying correct printing plates, anilox rollers, cylinders are used during printing.

Where required, procedures shall be in place for effective storage of printing plates, cylinders, and print blankets. Procedures for identifying print errors shall be documented and implemented.

Where applicable, a documented procedure shall be in place for the controlled disposal of trademarked or other printed food packaging products. Where a contracted disposal service is used, the disposal process shall be reviewed regularly to confirm compliance.

Product obtained for sampling and/or inspection shall be properly destroyed to prevent re-entry into the production process or sale to the customer.

Records of all inspections and analyses shall be maintained.

Each QC Auditor must visit in a daily manner their processes assigned and perform the following activities:

(2.3.2.5) RECEIVING

Verify with shipping personnel that all incoming material has been received correctly to ensure food safety is not compromised and the material is fit for its intended purpose, including certificates of conformance or certificate of analysis (when



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applicable); if rejected by any reason initiate DMR **F.10.2.1.2 DEFECTIVE MATERIAL REPORT** to the supplier.

FIRST PIECE SAMPLE AND DURING PRODUCTION SAMPLING

Is responsibility of the QC Auditor to visit their assigned processes (Printing, Cutting, Window, Gluing, Flat Pack) with regular frequency and perform the following activities:

1. Take the Job Ticket go to ERP look for the job ticket Read and follow the special instructions, if questions arise investigate with supervisor.
2. Open a QC Checklist and complete required inspection per QC checklist (ERP) for each job depending the case of First Piece or Sampling **F.9.2.2.2 FIRST PIECE/ SAMPLING ERP CHECKLIST**
3. If defective material is found it must be identified with a **F.10.2.1.1 REJECTED MATERIAL** label and communicated to proper supervisor.
4. QC auditor must select one case of Finish Goods from the skid after Make ready is completed to verify all product requirements are approved; this case will be stamped as "QCX-Case Approval."

BLUE TAG AT PRINTING

Printing operator sprayed BLUE if sections of the sheet are compromised with a printing defect, as well as filling proper information **F.8.5.2.1 WIP TAG**, and in their daily production report with the defect affecting the material.

QC auditor must add a laminated blue sheet for each load with blue sprayed and **F.8.5.2.3 BLUE TAG** at the end of each shift or JOB with the following sequence and details:

- Add a laminated blue tag to the sprayed loads.
- Assure all inches affected at properly sprayed.
- Add Problem, Positions affected, and Inches for all loads affected.
- Assure all inches affected at properly sprayed.
- When **F.8.5.2.3 BLUE TAG** is placed, share with the entire QC team for follow up.

SHIPPING

1. Randomly go to shipping warehouse and do a visual inspection on Finish Goods to be deliver during the day, if non-conformances are found **F.10.2.1.1 REJECTED MATERIAL** and communicate to proper supervisor.



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- Check all case labels are legible, correct part number, PO, Job Ticket and style.
- Check quantities (cases, pallets, loads) correspond to documented ones.
- Check material not damaged and good condition for shipment.

RANDOM INSPECTIONS DURING PRODUCTION

AERATOR

Is responsibility of the QC Auditor to visit the aerator process with regular frequency and perform the following activities:

1. Take two random printed sheets from the skid being worked from the operator.
2. Inspect them for Printing defects (Hickies, color variation, scumming, etc)
3. On ERP go to "Quality-> Testing Log" and document findings.
4. If defects found mark skid to be sorted and select another skid from same job, do Steps 1 thru 4.

REFERENCE OF DOCUMENTED INFORMATION

- **F.9.2.2.2 FIRST PIECE/ SAMPLING ERP CHECKLIST**
- **F.10.2.1.1 REJECTED MATERIAL**
- **F.10.2.1.2 DEFECTIVE MATERIAL REPORT**