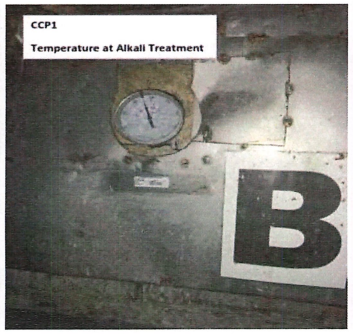
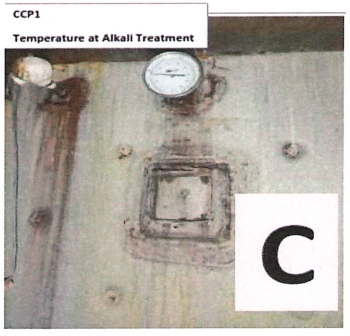
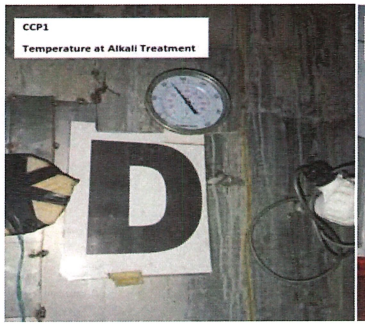
TBK MANUFACTURING CORPORATION	TBK MANUFACTURING CORPORATION Barangay 76, Hollywood, Nula-Tula,Tacloban City, 6500 Leyte, Philippines	Index No. : HM-2.0-2.6 Rev No. : 19 Date : 21 April 2022 Page : 01 of 1

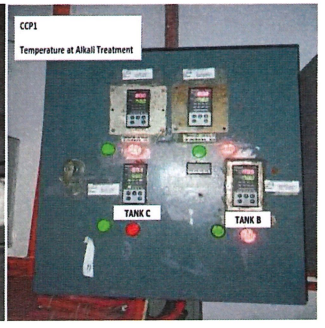
Section: 2
Subject: **CCP 1 (ALKALI TREATMENT) MONITORING PLAN**

Step/ Process	Control Measure	Critical Limit	Monitoring What, Where, How,When & Who	Corrective Action What & Who	Verification What & Who	Records	Validation (once/yr or when needed)
ALKALI COOK **Biological** ***a. Raw material*** *Pathogen contamination (E.coli* *survival of pathogens due to insufficient cooking temperature*	control of alkali concentration, temperature and time	cooking temp **Cottonii:** 75-85°C Time: 2-3hrs max %KOH=8-10% **Spinosum:** 55-65 °C Time: 1-2 hr max %KOH=4-5%	**What:** Alkali cooking temperature & conc. **Where & When:** Alkali temp gauge monitor every 15 min %KOH=every batch **How:** Manual & digital readings **Who:** Alkali Suvr. Lab Analyst	Adjust temperature or replace temp gauge Label as "NC" **Who:** Alkali Supervisor **%KOH (deviation)** Add addn'l KOH bags **Who:** Lab Analyst & Alkali Supvr.	random sampling of alkali solution by: Lab Analyst Verification of temp gauges by: Engg.	FM-OP-04 **Alkali Treatment** FM-OP-05 **Processing Timing Report** LB-LAB-23 **KOH Concentration** **FM-LQ-04.13** Temp Gauge Verification Report (Temp Gauge)	Random select 3 batches of Cottonii or Spinosum raw material batches and compare results of TPC and E.colion raw material inoculated with E.coli stock culture **By: Micro Analyst**









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Food Safety Team Leader

Approved by:

Technical Director

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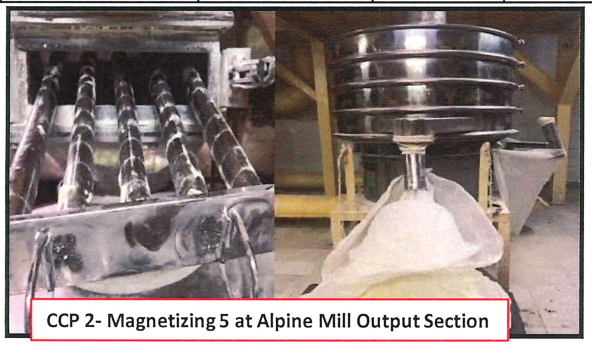
Section: 2
Subject: CCP 2 (MAGNETIZING 5 AT THE ALPINE MILL OUTPUT SECTION) MONITORING PLAN

Step/ Process	Control Measure	Critical Limit	Monitoring What, Where, How,When & Who	Corrective Action What & Who	Verification What & Who	Records	Validation (once/yr or when needed)
Magnetizing 5 at Alpine output section ***Physical*** ***Raw material*** *Metallic objects* *>remaining contaminants* unremoved from previous step	verification of magnet strength	**Fe:<=125 ppm ref.** customer email Apr 9,2021	**What:** Metal count determination of every batch **Where & When::** every batch of milled powder **How:** Analytical test **Who:** **Sampling by:** Milling Supervisor **Fe testing by:** **QC Analyst**	**Subject to further metal reduction until required Fe content is achieved or use in small amounts in finished blends.** **>Replace magnet if below 2000 gauss**	**Verify magnet strength** 2,000-4,000 gauss By: Alpine Mill Supvr.	Iron content (Alpine mill) **LB-LQ-19** Magnet Pull Strength (Manual Testing) **FM-EN-9.42** Magnet Pull Strength Testing (Gauss Meter) **FM-OP-23** Alpine Mill Magnet Metal Separator & Sieve Monitoring	**Introduce different metallic objects in a bag of powder and allow the powder to pass through the magnet.** **Target: 100% retrieval of all introduced metallic objects**



CCP 2- Magnetizing 5 at Alpine Mill Output Section

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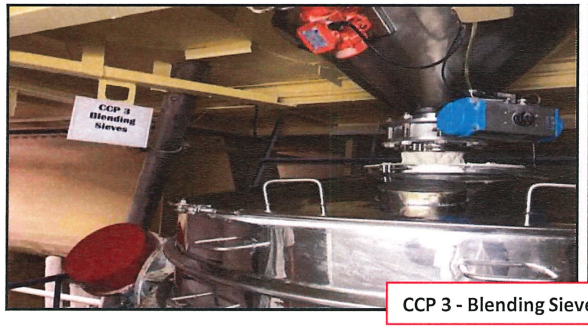
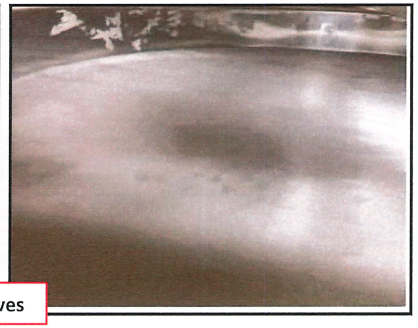
Section: 2
Subject: CCP 3 (SIEVING AT THE BLENDING SECTION) MONITORING PLAN

Step/ Process	Control Measure	Critical Limit	Monitoring What, Where, How,When & Who	Corrective Action What & Who	Verification What & Who	Records	Validation (once/yr or when needed)
Sieving 2 at the Blending output section ***Physical*** ***a. Raw material*** *Re-introduced and unremoved foreign matter and metallic object* *Re-introduced from other ingredients*	Checking of screen integrity	absence of any foreign matter	**What:** Sieve checking **Where & When::** 40,60 & 80 mesh screens, checking after every lot **How:** Visual and manual inspection of screens. **Who:** Blending Supervisor	1.Replace with new screen for 40,60,80 mesh or as required by: Blending Supervisor **2. Product:** Rework affected lot through new sieves.	1.Checking of screens through a microscope by QC Analyst every new arrival and every replacement 2. Testing for Dry particle size on every batch by QC Analyst	FM-OP-18 (Blending Operation) FM-OP-38 (Screen Monitoring of Ribbon/Double Con Blender & Pin Mill) **FM-OP-40** Product Rework Form	Introduce 5 foreign matters: strips of straws, metallic object,plastic strips, thread, paper strips and allow to pass through a standard sieve 40,60 & 80 mesh. Target: 100% retrieval of all introduced metallic object





CCP 3 - Blending Sieves

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Section: 2
Subject: **CCP 4 (METAL DETECTOR) MONITORING PLAN**

Step/ Process	Control Measure	Critical Limit	Monitoring What, Where, How,When & Who	Corrective Action What & Who	Verification What & Who	Records	Validation (once/yr or when needed)
Metal Detector ***Physical*** ***a. Raw material*** *metallic objects/ fragments, presence of metal fragments (ferrous, non-ferrous, stainless steel) from packaging and remaining from previous step*	verification of test pieces	**Test pieces:** Fe - 3.0 mm NFe - 3.5 mm SS304 - 3.5 mm	**What?** Efficiency of metal detector **Where & When?** >At the metal detector >Testing on every bag **How?** Conduct testing of all test pieces a. Test piece only b. Wet & Dry method **Who?** metal detector operator	1. Hold the product and label as"NC" or Nonconforming. 2. Re-work product by sieving thru 40,60 or 80m 3. Replace product with new blend. 4.Replace packaging if packaging is determined as the source.	Test all test pieces several times with and without a product on a per bag basis **Standard:** 100% pass	**FM-OP-25** Metal Detector Check Weigher **FM-MT-04** CPAR **LOGBOOK** Metal Detector Maintenance Record **FM-EN-05** Job Order	Introduce Fe, NFe, SS304 objects to a bag of powder and allow the powder to pass through the metal detector. **Acceptable:** 100% retrieval of all introduced pieces

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