

Factory Audit Report

Client:		Report No.:ca200807001
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Factory Name:	
Factory Address:	
Supplier Name:	
Audit Date:	July 09 2008

Comment:

The factory is professional in producing wafer valves, highly professional, production equipments and test equipment can all meet production capacity and quality control requirements, it has a relatively high market share in wafer valves market, doing OEM productions for many local big valve companies , and enjoy relatively high popularity, the entire product appearance and workmanship is relatively good.

The factory's quality management system is still relatively weak, although it has the ISO9000 certificate, but the quality management system's operation is not very standardized, and is lack of the relative documents and records.

The factory's scale is relatively small, but beginning from June because of the big increase in the output value and tax revenue, it has been upgraded from Yongjia County level of enterprise to Zhejiang Province level of enterprise. It is already in the search for a new plant, meanwhile the factory is applying for the related CE and API certification.

Follow up Action

No#	Recommended Corrective Actions	Committed Deadline
1.	The ISO9000 should be operation more shandardized and have record.	N/A

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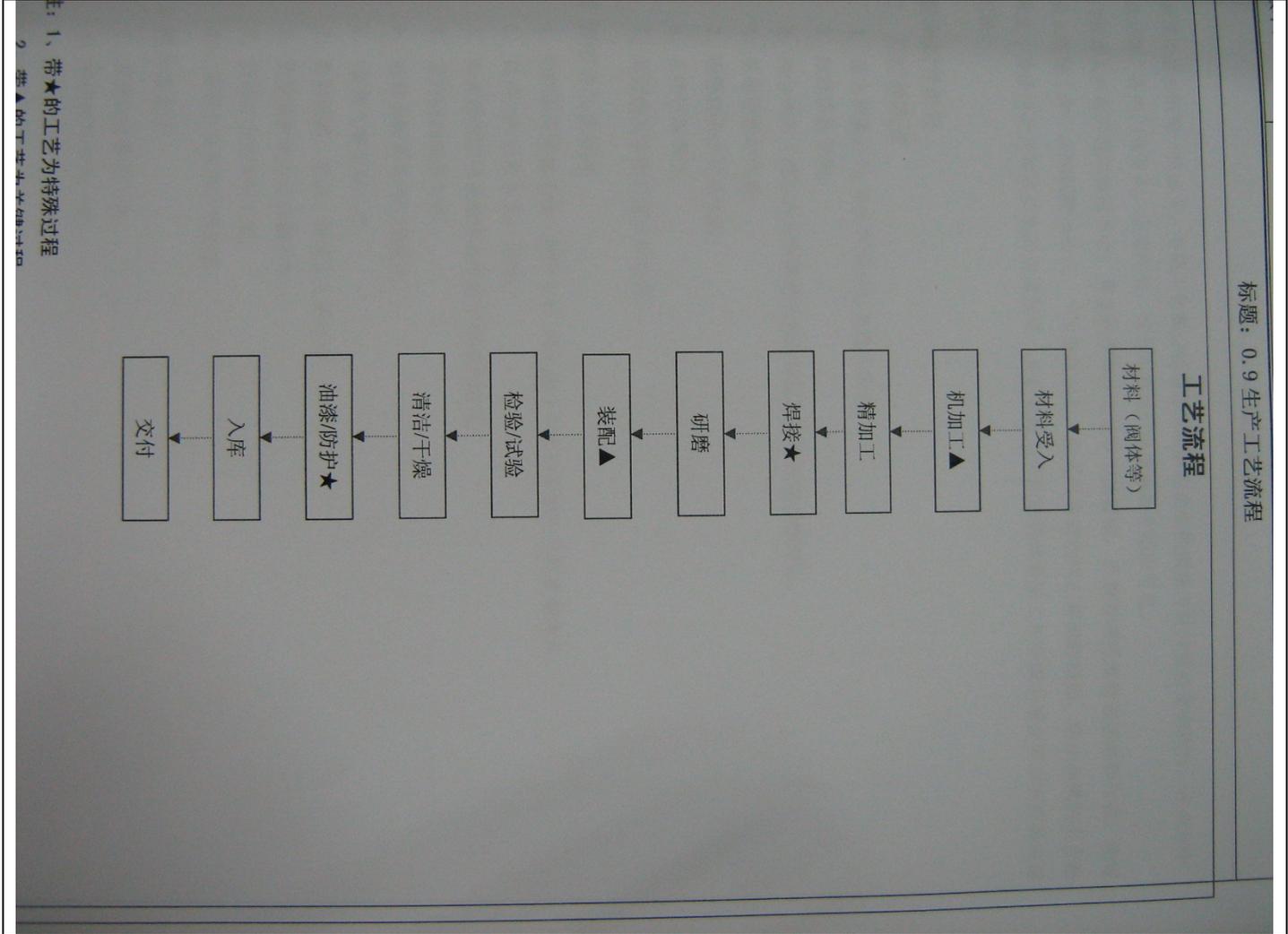
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Part 1 Factory Profile

		Findings or Comments	
Name of Audited Factory	Zhejiang naibang valve co.,LTD		
Address	27# jianshen road,tangtou industrial zone,oubei town,yongjia county,wenzhou		
Legal Status	Private Owned		
Date of Foundation	June 22 2000		
Business Licence	330323000015659		
Contact Person	Xiaoxiao lin		
Tel / Fax / E-mail	0577-67996985	0577-67996987	nbvalves@163.com
Main Products	Wafer-type check valve		
Production Capacity	12000pcs /year		
Manufacturing Floors (S.Q. Meters): 800m ²			
Employees Details	Male	Female	Sub-total
Production line workers	35	0	35
Engineering Staff	2	0	2
Quality Control Staff	3	0	3
Administration Staff	1	1	2
Sales Staff	0	4	4
Others	4	0	4
Sub-total	45	5	Grand Total: 50

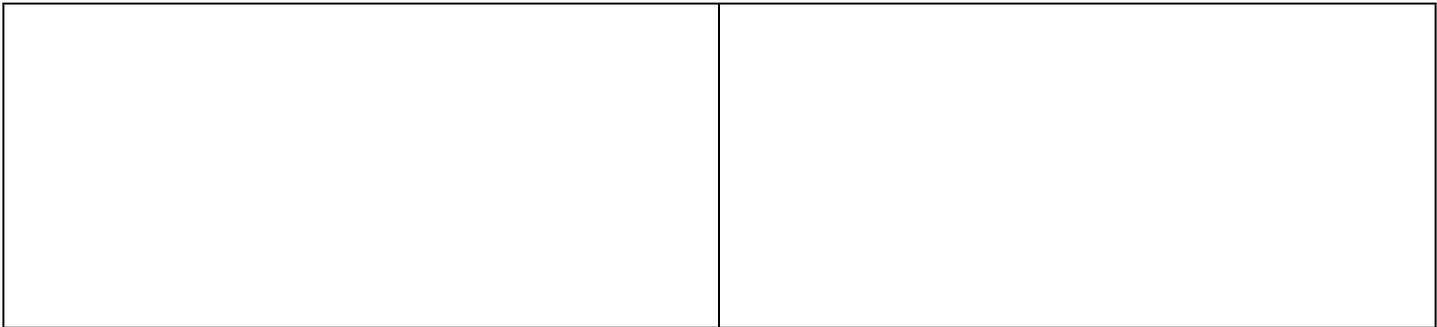
Main Subcontractors / Raw Material Suppliers	Material/component	Country of Origin / Location
	Alloy	Shanghai
	Alloy	Shanghai
	Cast	qingtian

Production Flow Chart



Purchasing raw material → IQC inspection → Trimming of Die cast parts
→Machining→Polishing→Assembly→Testing→Cleanness/drying→P
ainting→Packing → Delivery

Photos (factory outlook/each floor/workshop/producing line/Business & export license):	
Factory gate	Address label
	
Exterior view of workshop	Office
Office	Office



Business certificate for factory
(Valid date: to 2010)

Tax Register Certificate for factory



ISO 9000 Certificate for factory

ISO9000 Certificate for one of the suppliers

Production lines



Trimming of die casting parts



Machining



Machining



Surface polishing



Factory Floor



Painting



Assembly line



Testing of small size products(80-300mm)

N/A



Testing of large size products(300-600)

n/a

Part 2 Factory Facilities / Machinery Condition

Machinery Condition			
No.	Description	Yes/No	Comment
1	Is maintenance carried out on production equipments and are there any records?	NO	
2	Are work instructions / procedures provided at appropriate locations?	NO	
3	Is machinery in good condition?	YES	
4	Does the factory possess a maintenance team to support production?	YES	
5	Does each machine have a record/log hung on it?	NO	

Machinery detail information

			
Name:	Polishing machine	Name:	Machine tool
Description:	Made in China	Description:	Made in China
Qty:	5	Qty:	2
Comment:	In good condition	Comment:	In good condition
			
Name:	Machine tool (cw61125B)	Name:	Machine (CD6150A)
Description:	Made in China	Description:	Made in China
Qty:	1	Qty:	6
Comment:	In good condition	Comment:	In good condition



Name:	Machine tool(M7130)
Description:	Made in China
Qty:	1
Comment:	In good condition

Name:	Welding machine
Description:	Made in China
Qty:	3
Comment:	In good condition



Name:	Machine tool(X5030A)
Description:	Made in China
Qty:	1
Comment:	In good condition

Name:	Machine tool
Description:	Made in China
Qty:	1
Comment:	In good condition



Name:	Machine tool
Description:	Made in China
Qty:	20
Comment:	In good condition

Name:	Testing machine
Description:	Made in China
Qty:	1
Comment:	In good condition

		N/A	
Name:	Machine for making label and marking	Name:	N/A
Description:	Made in China	Description:	N/A
Qty:	1	Qty:	N/A
Comment:	In good condition	Comment:	N/A

Housekeeping and Cleanliness condition

No.	Description	Yes/No	Comment
1	Is the storage well organized?	NO	
2	Does the capacity of the warehouse meet the maximum production capacity?	NO	
3	Is the factory clean?	NO	
4	Are samples well kept and in good condition?	YES	

Pictures



Raw material storage - Die cast part



Raw material storage - Accessories



Semi-Product storage



Final Product storage

	<p style="text-align: center;">N/A</p>
Welding work station	N/A

Electric power supply			
No.	Description	Yes/No	Comment
1	Is there stable electric power supply in the area?	Yes	
2	Any self-supplied electric power generator?	Yes	

Pictures	
	<p style="text-align: center;">N/A</p>
Generator	N/A

Delivery/Loading conditions

No.	Description	Yes/No	Comment
1	Any trucks owned by the factory?	Yes	1 truck
2	Any shipping ports / airports nearby?	Yes	Ningbo
3	Is there enough space for 2 or 3 containers to be loaded at the same time?	No	

Pictures



Packaging Area



Delivery area

Part 3 Production Capacity

Production Capacity			
No.	Description	Yes/No	Comment
1	Can the machinery quantity meet the order volume?	Yes	
2	Can the worker quantity meet the order volume?	Yes	
3	Can the warehouse meet the order volume?	No	Too small

Capacity Checking				
Main process	Machine Name	Number Of Machines		Capacity per week
Trimming	By hand	20		250pcs per week
Surface Polishing	Polishing machine	5		250pcs per week
Machining	Machine tool	12		250pcs per week
Painting	By hand	1		250pcs per week
Assembly	By Hand	0		250pcs per week
Testing	Testing machine	1		250pcs per week
Overall capacity (equate to minimum capacity)				250pcs per week
Comment	n/a			

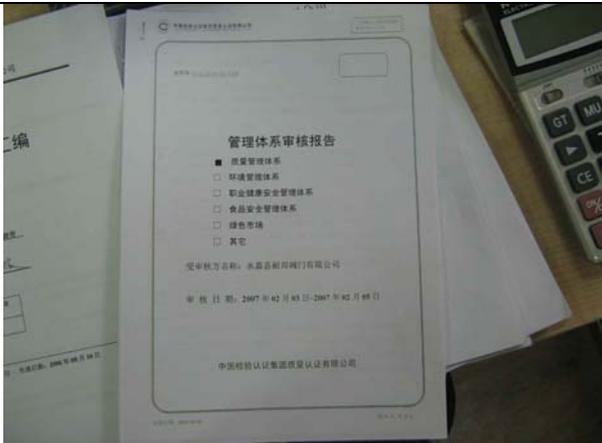
Part 4 Quality Assurance System

General Description			
No.	Description	Yes/No	Comment
1	Is there a complete quality control plan available in writing?	yes	
2	Is the factory ISO 9000 registered?	yes	
3	Is there an independent Q.C. manager or supervisory level person to head the Q.C.functions?	No	
4	Are quality meetings held with records?	No	Hold quality meeting not periodically and have no records.
5	Are there adequate documented internal training programs provided for all quality control personnel?	No	Not adequate training to quality control personnel
6	Are customers' and approved internal specifications properly filed and easily accessible?	Yes	
7	Any quality system certificates available? (with certification company details and dates)	Yes	ISO 9001:2000
8	Any sampling methods applied to conduct random product inspection?	Yes	But not followed strictly
9	Is workmanship standards / acceptance level provided for checking?	No	
10	Have testing equipments been calibrated and with calibration date noted?	Yes	

Incoming Material Control			
No.	Description	Yes/No	Comment
1	Incoming QC available? (how many? day shift/night shift)	Yes	1 worker, day shift
2	Are written inspection/ testing instructions available? Adequate enough? QCs fully followed up?	No	Not followed strictly
3	Are inspection status and results clearly marked / identified? Are inspection results recorded?	No	
4	What actions are taken if non-conforming materials are found? Are the procedures followed?	No	Will return to supplier to rework
5	Are storage facilities and handing methods appropriate?	No	
6	Is there outgoing inspection records from supplier for each lot?	Yes	
7	Are there certificates from material suppliers if applicable?	Yes	

Manufacturing Process Control			
No.	Description	Yes/No	Comment
1	Is final QC available? How many inspectors?	Yes	1 QC inspector and the test worker will also assist quality control
2	Is there a procedure to conduct random product inspection after final packaging ?	No	
3	Are inspection status and results clearly marked / identified?	No	Found no label or marking to show status of products
4	Are test and inspection results recorded and maintained for analysis and future quality control?	No	Found no non-conforming records in inspection report, only have some simple statistical sheet

Client Complaint Control :factory said there were never have complaint.			
No.	Description	Yes/No	Comment
1	Is any clear procedure for handling customer's complaint?		
2	Are corrective & preventive actions mechanism established and implemented effectively?		
3	Are corrective actions documented and followed up?		

Pictures (Control of non-conforming product/WI/ inspection criteria used on site/quality system certificate)	
	
ISO 9001:2000 certificate	Quality manual and procedure document

永嘉县研固门业有限公司

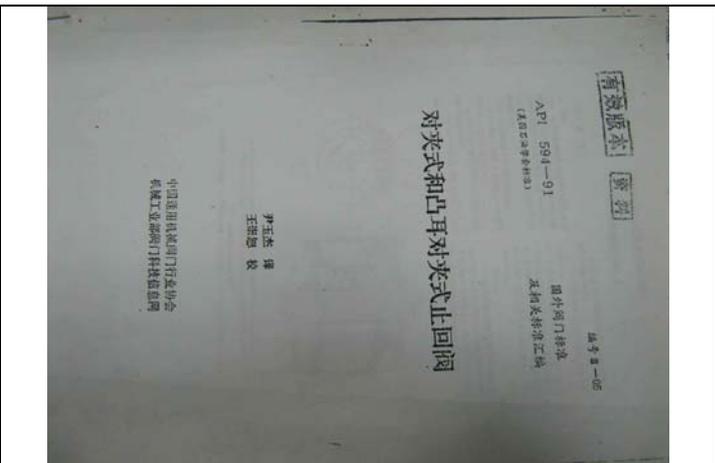
设备保养计划

编号: 4
日期: 2017.7.1

设备编号	设备名称	产地	保养人数	保养周期	月 份												备注	
					1	2	3	4	5	6	7	8	9	10	11	12		
2016-01	挂链板	江苏	范林	一年														✓
2016-02	"	江苏	"	"														✓
2016-03	取料机	文登	"	"														✓
2016-04	取料机	文登	"	"														✓
2016-05	取料机	文登	"	"														✓
2016-06	"	文登	"	"														✓
2016-07	斗轮机	杭州	"	"														✓
2016-08	斗轮机	杭州	"	"														✓
2016-09	斗轮机	杭州	"	"														✓
2016-10	斗轮机	杭州	"	"														✓
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2016-12	斗轮机	杭州	"	"														✓

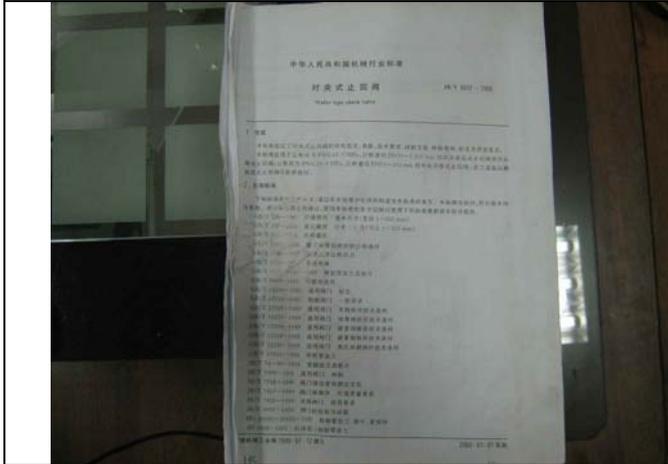
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QB-3-001



Example Equipment maintenance record

Example American API598 standard for pressure test



N/A

Example Chinese GB standard for pressure test

N/A



Coating thickness test



Coating thickness test



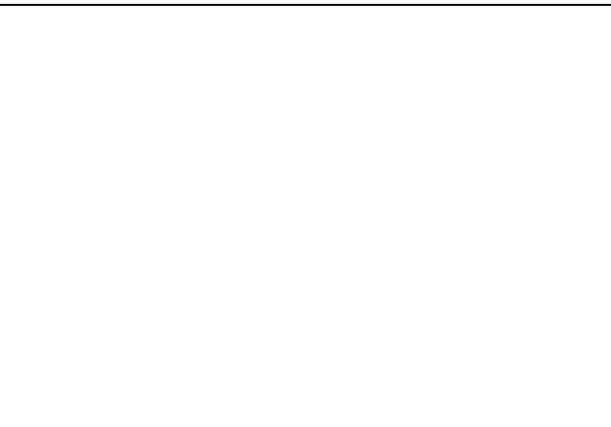
Torque test



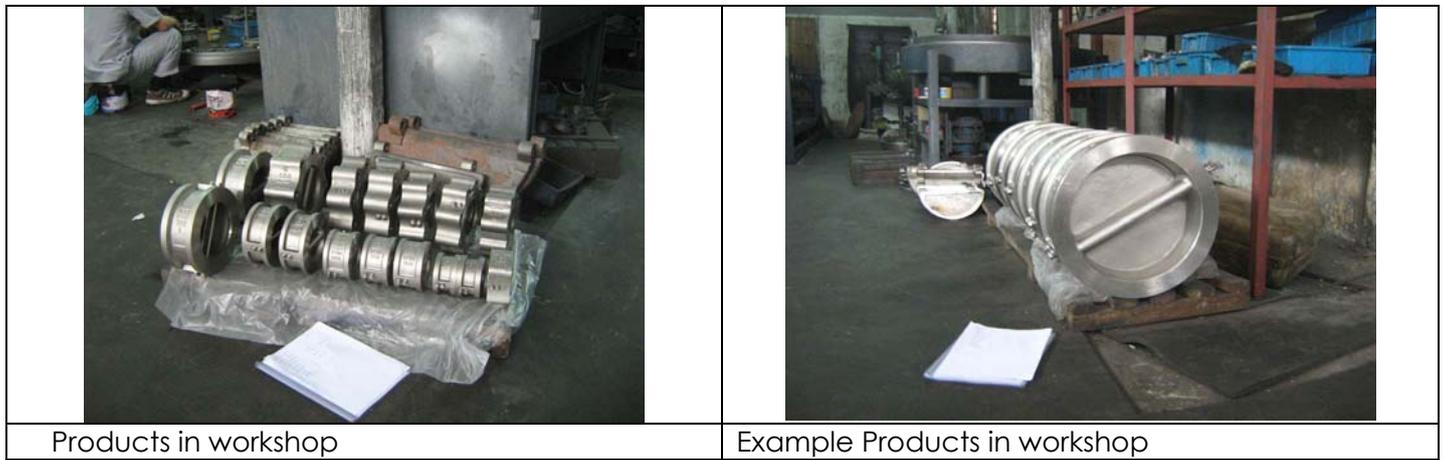
Example hardness test



Measuring equipments



Samples in show room



Part 5 Special instructions from client

No.	Description	Yes/No	Comment
1	What size and type valves can they make?		1200mm WAFER-TYPE CHECK VALVE
2	What international standards they can make to?		API ,GB
3	Production schedules?	NO	
4	Accreditations, client list, projects	YES	
5	Does the factory belong to any group of companies? Is yes, what is the name of the group?	NO	
6	Any export experience? If yes, where to?	yes	Spain

- End of Report -