Technical Audit Report 2021

Client	BabyOne Franchise- und Systemzentrale GmbH	QIMA Service No	R-Cloud-21233851
Supplier	Zhongshan BEAU TECH Baby Products Company Ltd	Auditor	Billy Chen
Factory	Zhongshan BEAU TECH Baby Products Company Ltd	Date	15-Dec-2021
Industry	Toys & Recreational items	Country	China

Factory Overall Score 8.84 of a possible 10

Audit Rating Green Approved

Ratings	Section Score	Theoretical Max	Score /10	Weight	Weighted Score
Quality Management System	45	/48	9.4	1	9.4
Resources Management	38	/42	9.05	3	27.15
Stock Management	48	/54	8.88	2	17.76
Incoming Material Inspection	19	/24	7.92	4	31.68
Production Process	47	/51	9.21	4	36.84
Packing and Quality Control before Shipment	22	/24	9.16	3	27.48
Measurement, Analysis and Improvement	34	/39	8.72	1	8.72
			Total	18	159.03

Valid until: 14-Dec-2022

Description of audited plant

1. The audited factory named "Zhongshan BEAU TECH Baby Products Company Ltd." Was located in No.37 Maohua Road, dongshen town, Zhongshan, Guangdong, China (The business license Chinese name and address: (中山市宝晟婴童用品有限公司 &广东省中山市东升镇茂华路37号第一幢).
2. There were one building, the factory rents one 6-storey building used as product workshops, warehouse and office. No dormitory, canteen and Kitchen were provided for employees.
3. The main products manufactured in the factory were various baby Products, such as Baby carriage. And the main production processes conducted in the factory were: Incoming inspection, Cutting, Template, Rivets, Sewing, Assembly, Inspection and Packing.
4. The factory has quality manual and quality procedure in place and ISO 9001:2015 Certificate.

Important remarks

1. Based on the document review, The factory has provided related external certificates for review during the audit, but two test equipment was not calibrated such as electronic scale used onsite.
2. As per the on-site observation, some materials in the raw material warehouse are stacked against the wall and the window, and the windows are covered with spider webs in many places.
3. As per the on-site observation, some semi-finished products were placed in the qualified area had no Identification label.
4. As per the on-site observation, some finished products in the finished goods warehouse are stacked against the wall and the window.
5. As per the on-site observation, some incoming material and Semi-finished products was placed mixed with the finished goods warehouse.
6. As per the on-site observation, some incoming materials placed in qualified area had no identification label and "Pass" label.
7. As per the on-site verification, there was no obvious floor marking in some production workshops. And the factory did not obey “5S” management
8. As per the on-site observation, the factory had set an area for non-conforming products in-process quality control. However, there was no label for the non-conforming products in the IPQC station.
9. The factory did not out of control conditions identified and brought back to control in timely manner or records for review.

Home Workers and Subcontractors

Is there any home workers used by factory? **No**
If yes, description: Nil

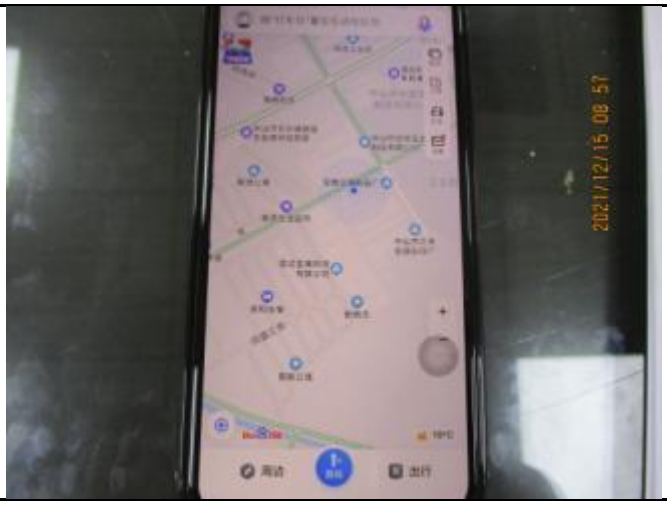
Is there any subcontractor used by factory? **Yes**
If yes, description:

1. Screen printing process
   Name: Rishen & Hongyuanxing
   Location: Zhongshan, Guangdong, Chian
   Contact: Mr.Hai & Mr. Zhu
   Tel: 86-15119104671 & 86-13527133960

2. Embroidery process
   Name: Jie Sheng
   Location: Zhongshan, Guangdong, China
   Contact: Mr. Kong
   Tel: 86-0760-22733620

Content

Number of days spent:		
		
Auditor 1: Mr. Billy Chen		Supervisor: Leo Cheung
Departure time from home / office	Arrival time at Factory	Departure time from Factory
6:20 AM	8:30 AM	16:00 PM

	
Map	GPS

	
Factory Gate	Factory name
	
Factory Building	Factory Building
	
Production Line - Warehouse	Production Line - Warehouse

	
Production Line - Cutting	Production Line - Template
	
Production Line -Sewing	Production Line - Sewing
	
Production Line - Rivets	Production Line -Assembly

Production Line - Packing

Production Line - Packing

Sample Room

Office

Manager

Licenses / Accreditations

Workers on site

Raw material in the factory

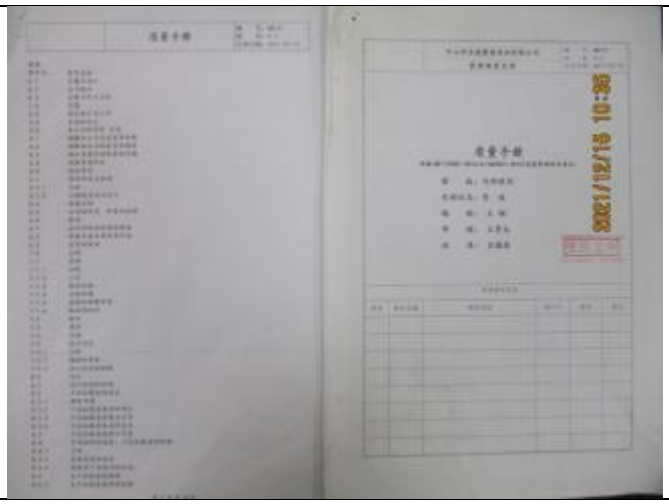
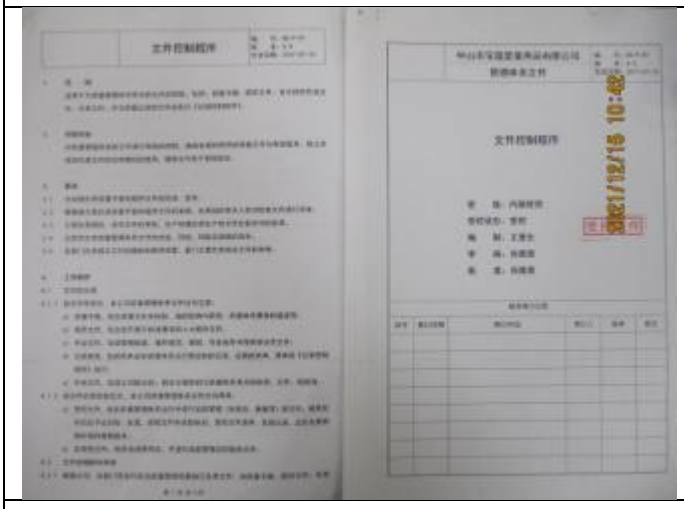
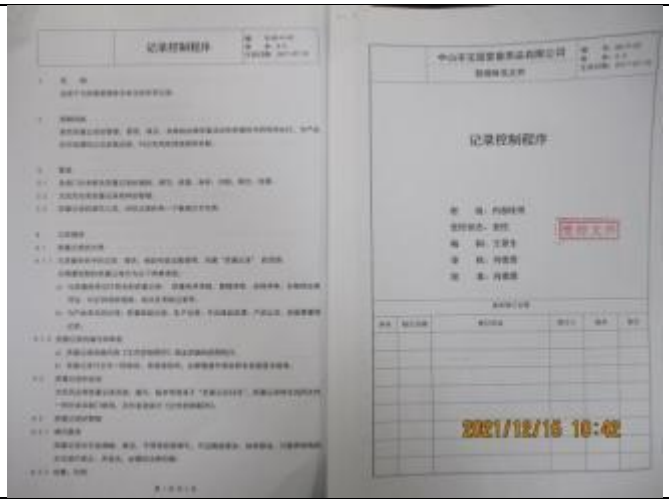
Final product

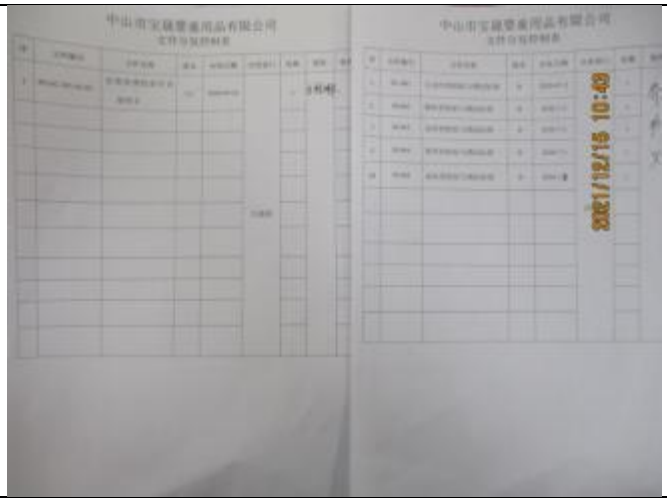
Part 1
Basic Factory Profile

Item			Finding	Comments
1	Date of formation		14-June-2016	Nil
2	Legal status		Limited Liability Company	Nil
3	Location		No.37 Maohua Road, dongshen town, Zhongshan, Guangdong, China	Nil
4	GPS Location		22.594'' N/S 113.314'' E/W	Nil
5	Area (m2)		9,700 m2	Nil
6	Owner		XiaoDeen	Nil
7	Total staff in the factory		150	Nil
8	Total office staff		15	Nil
9	Total Management staff		3	Nil
10	Number of workers		132	Nil
11	Factory Manager		Mr. XiaoDeen	Nil
12	Production Manager		Mr. Wang Jingsheng	Nil
13	Quality Manager		Mr. Yan Zhonghua	Nil
14	Main markets		Europe and America	Nil
15	Annual turnover		USD: 15,000,000	Nil
16	Business license		Date of issue: 9144200MA4UQLG10F	Nil
			Expiry date: long-time	
17	Factory Description	Workshop/Warehouse	Description	Size
		Warehouse	*N/A*	*4,000 m2*
		Office	N/A	2,000 m2
		Cutting	2 lines	300 m2
		Template	1 lines	200 m2
		Sewing	4 lines	1,000 m2
		Rivets	3 lines	5,00 m2
		Assembly and Packing	3 lines	1,700 m2
18	Products	Products	Quantity	Main clients/destination countries
		Baby carriage	*5,000 pcs/month*	*USA*
		Baby carriage	15,000 pcs / month	*Europe*

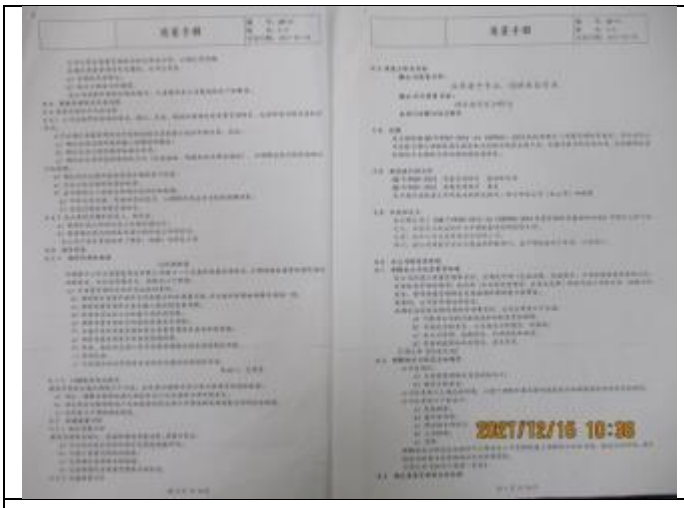
Part 2
Quality Management System

Quality Manual				
Questions		**Findings/Comments**	**Score**	
2.1	Does the factory have a quality manual, covering all the elements in current version of ISO9001?	Based on the document review and Management interview, the factory has quality manual and quality procedure in place. also ISO 9001:2015 certificates were provided for review. The document code was QM-01, version: A.0	3	/3
2.2	Is there a system to ensure that Quality Manual is regularly revised ?	Based on the document review, the document control procedure was established in the factory, and the Master list of documents with indication of established dates and revisions were provided for review.	3	/3
2.3	Is the document management system documented, to ensure documents affecting quality are controlled, managed, accessible and used in appropriate areas?	Based on the document review, Auditor sampling confirmed that all documents were controlled as requirements and related distribution records were provided for review during the audit.	3	/3
2.4	Is there a Master List of Documents with indication of established dates and revisions?	Based on the document review, the document control procedure was established in the factory, and the Master list of documents with indication of established dates and revisions were provided for review.	3	/3
2.5	Is documentation from customer available, and controlled so that only most current external documents are available?	Based on the document review, the documentation from customer and the list of external documentation were available for review.	3	/3
2.6	Is there a system in place to ensure that document change is applied and effective?	All documents were controlled as requirements, there a system in place to ensure that document change is applied and effective and related distribution records were provided for review during the audit.	3	/3
2.7	Is the document change system controlled using IT system?	Based on the document review and Management interview, the all-document change system controlled using IT system.	2	/3
Picture(s)				

	
ISO 9001:2015 certificates	Quality Manual
	
External documents list	Master List
	
Document control program	Record control procedure

Control of Records				
Questions		**Findings/Comments**	**Score**	
2.8	Are all records for topics affecting quality kept and with relevant information?	The written record control procedure was available, and the list of records was basically available.	3	/3
2.9	Are records clear, legible, stored in a way to prevent loss, and easily retrievable regardless of age?	Based on the document review, records basically clear, legible, and stored in a way to prevent loss.	3	/3
Picture(s)				
				
Document control records		Document control records		

Commitment to Quality, Quality Policy and Responsibility				
Questions		**Findings/Comments**	**Score**	
2.10	Is there a quality policy defined by factory (please describe).	Based on the document review, the Quality policy was defined in the quality manual. It is observed the Quality Policy which refers to: Quality comes from focus, innovation comes from profession.	3	/3
2.11	Are responsibilities of all employees that effect or assure quality been defined?	Responsibilities of all employees that effected or assured quality had been defined.	3	/3
2.12	Is the quality policy deployed and training implemented? Are employees aware of quality policy?	Based on the document review and Employees interview, the training on quality policy was implemented for all employees.	3	/3
Picture(s)				

	
Quality policy	Job Responsibilities
	
Training planning	Training records

Planning and Management Review

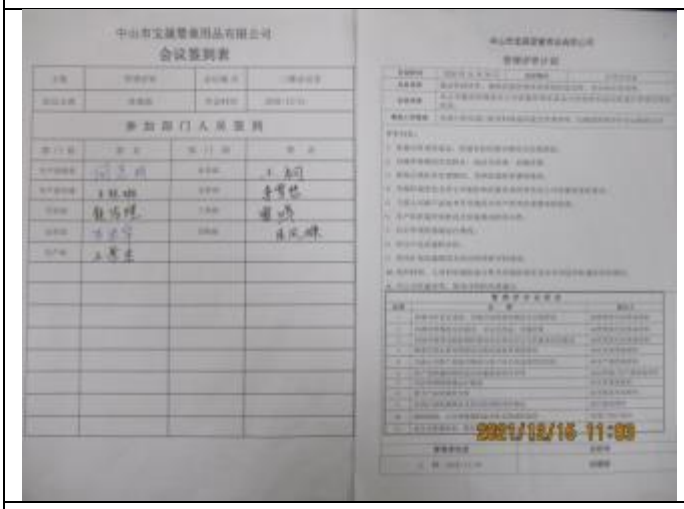
Questions		Findings/Comments	Score	
2.13	Are quality goals defined (yield improvement, defect rate,...)? Please describe.	Based on the document review, the factory has quality objectives were defined in quality manual. a. Customer satisfaction: above => 90%; b. On time delivery: above => 98%; c. Product pass rate: above => 98%; d. Customer compliant times: less than 1 times per month. were defined and review regularly.	3	/3
2.14	Are quality plans with defined schedules and actions to be taken available?	Based on the document review and Employees interview, the quality plans with defined schedules and actions to be taken are available.	3	/3
2.15	Is Management Review regularly planned, and including performance, customer issues?	The factory established management review procedure which defined that management review should be conducted at least annually, and management review should include performances,	2	/3

		objectives, and definition of corrective/preventive action plans etc. the latest one was conducted on 30-Nov-2020.		
2.16	Is Management Review including review of performance vs. objectives, and definition of corrective/preventive action plan?	Management Review included review of performance vs. objectives, and corrective/preventive action plan.	2	/3

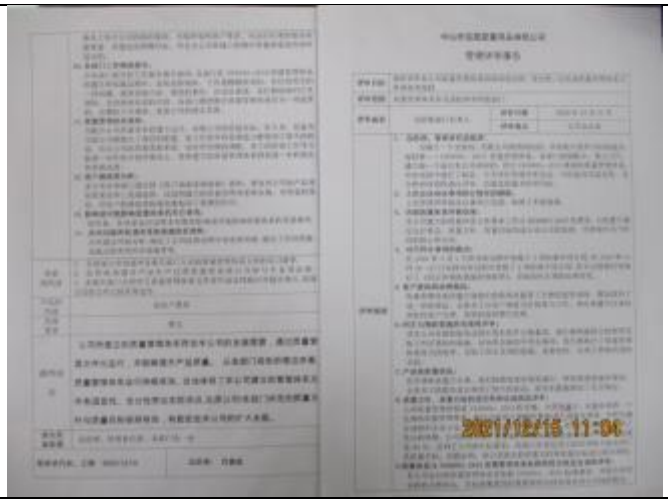
Picture(s)

Quality objectives

Quality objectives



Management Review planning



Management Review records

Special Remarks on this section

Nil

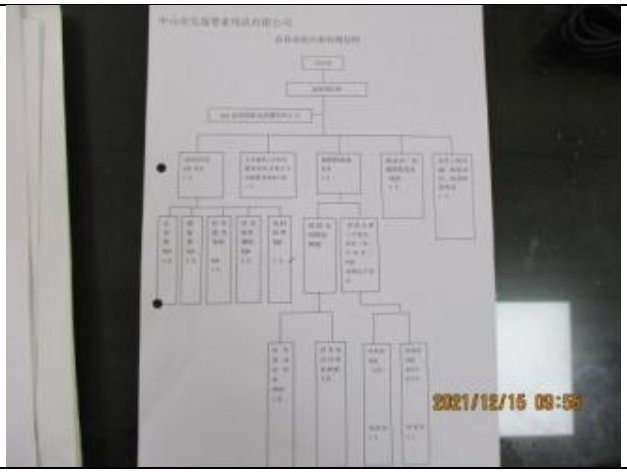
Actual Score	Theoretical Max
45	/48

Part 3
Resources Management

Human Resources				
Questions		**Findings/Comments**	**Score**	
3.1	Is there a clear Organizational structure, and organization chart in use?	As per the on-site observation, there was a clear organizational structure, and organization chart in use.	3	/3
3.2	Is there a training process in place to ensure that all workers receive training?	Based on the document review and Employee interview, there was a training process in place to ensure that all workers receive relevant training as per job description and Mechanical operation, etc.	3	/3
3.3	Are training recorded, with training records/certificates readily available for review?	The factory established employee training plan and conducted training as regular and training record readily available for review.	3	/3
3.4	Is there any regular assessment and re-training when necessary as part of training process?	There was regular assessment and re-training when necessary as part of training process.	2	/3

Picture(s)

organization chart



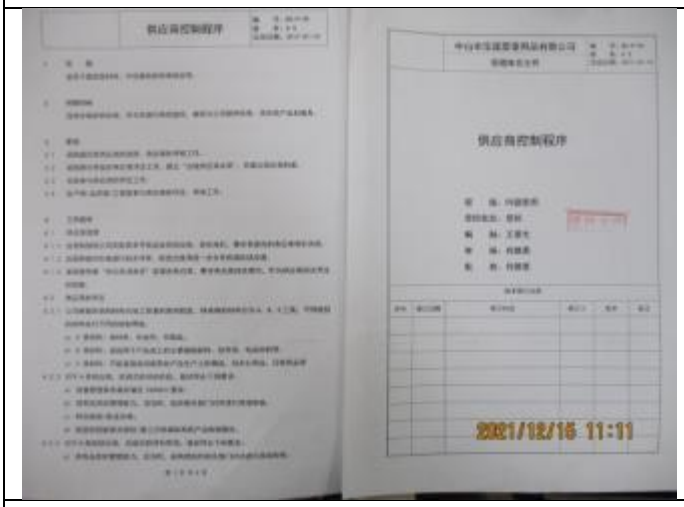
organization chart

Training planning

Training records

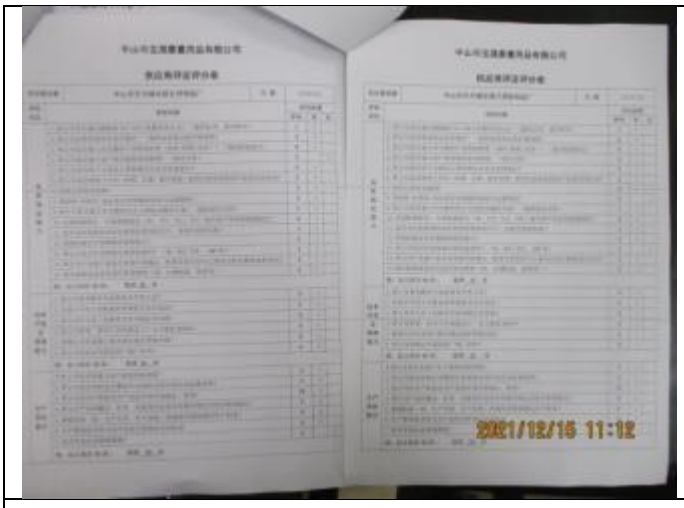
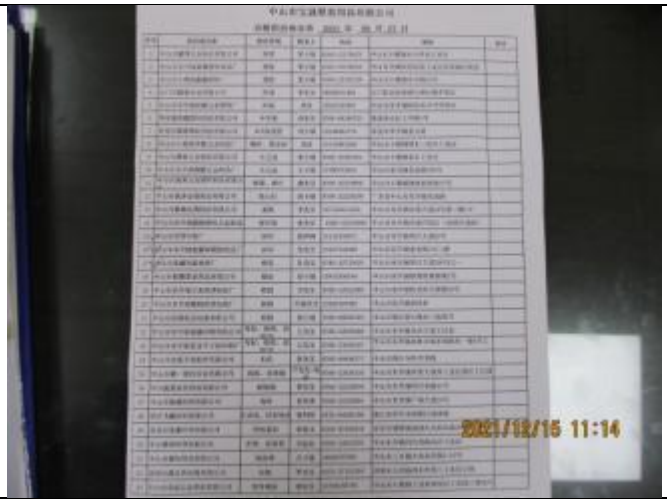
Purchasing				
Questions		**Findings/Comments**	**Score**	
3.5	Is there a defined supplier qualification system documented?	The factory established supplier management procedure and approved supplier list was also established in the factory.	3	/3
3.6	Is the selection/evaluation process for suppliers including regular audits of quality issues?	The factory established supplier annual audit plan and conducted it as requirements strictly. In other sides, the monthly quality issue audit was also conducted as each supplier's quality performance randomly.	3	/3
3.7	Are "Critical" components identified, and/or method to define "Key" suppliers in place?	The factory had a supplier assessment procedure and purchasing control procedure ensure all purchased inputs comply with all regulatory requirements and using A, B and C grade to define "Critical" components and "Key" suppliers identified for all suppliers.	3	/3
3.8	Is there a system defined to ensure that any change in suppliers/materials is communicated efficiently to customer?	There was system defined to ensure that any change in suppliers/materials was communicated efficiently to customer.	3	/3
3.9	Is there an evaluation system for suppliers, based on documented performance results (quality rate, delivery,...)?	The factory monitored the supplier's quality performance by Quarterly and updated the approved supplier list as supplier's performance.	3	/3
3.10	Is there evidence that suppliers are requested to provide evidence of corrective actions in case of failure?	The non-conforming products management procedure defined related requirements, confirmed by management interview, the main raw materials were Fabric, Hardware, plastic, packaging material, no incoming issue was occurred in IQC in the past, once occurred in later, the factory would require the supplier to raise prevent/corrective actions for it.	3	/3

Picture(s)



Supplier management select program

Supplier management select records

	
Supplier management select records	Quarterly evaluation record
	
Quarterly evaluation record	Supplier management list

Control of Monitoring and Measuring Devices				
Questions		**Findings/Comments**	**Score**	
3.11	Is there a process in place to register all gauges and measuring devices, including identification, last calibration date/due date, how to perform calibration?	The calibration management procedure was established in the factory and all gauges and measuring devices were included in calibration management list. Remark: the main measuring equipment was Steel tape, tension gauge, digital caliper, electronic scale, measuring ruler etc.	3	/3
3.12	Are all evidences of calibration available for gauges and measuring devices (external certificates, internal records)?	Based on the document review, The factory has provided related external certificates for review during the audit, but two test equipment was not calibrated such as electronic scale used onsite. 工厂提供相关的外部证书供审核期间审核。但现场使用的二台电子秤等测试设备没有校	1	/3

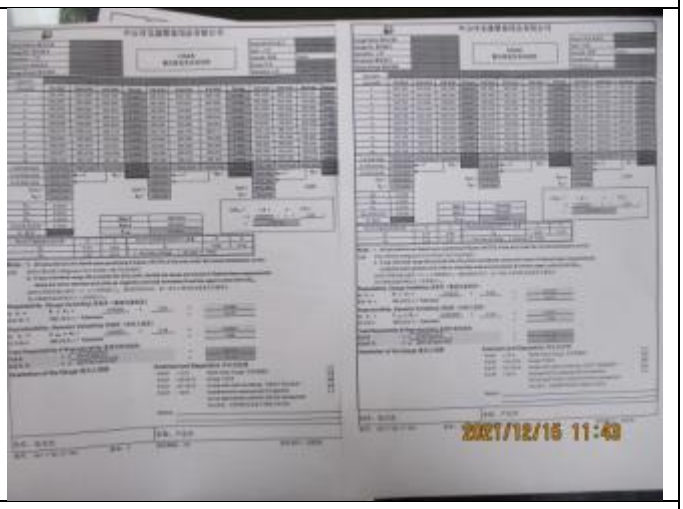
		准.		
3.13	If calibration performed internally, is there evidence (training certificates) that personnel in charge has relevant qualifications?	Based on the document review and Employee interview, all measuring equipment were calibrated by externally. it was not applicable.	N/A	/3
3.14	Are gauge R&R (repeatability and reproducibility) completed for all gauges on control plan?	Based on the document review, the factory has provided R&R (repeatability and reproducibility) control procedures and records for review.	3	/3
3.15	Is there an internal laboratory/QC room in the factory? Is it certified/accredited by a 3rd party?	There is an internal laboratory/QC room in the factory without certified/accredited by a 3rd party. and the product is baby Products, such as Baby carriage	2	/3

Picture(s)

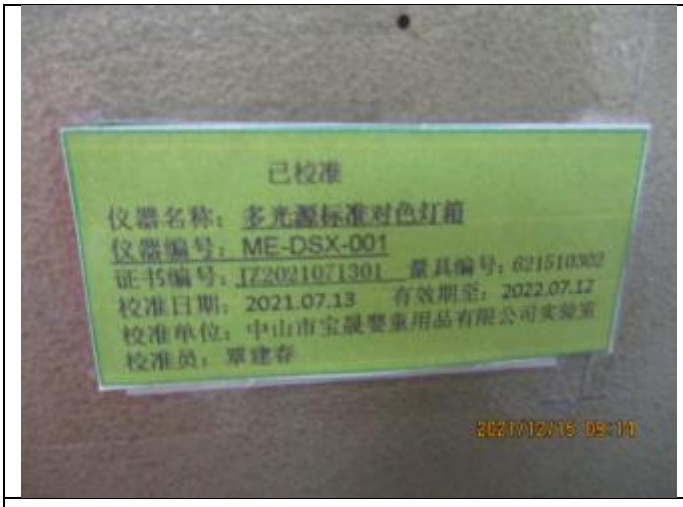
External calibration list

Calibration certificates

Calibrated label



R&R records

	
Calibrated label	No calibrated

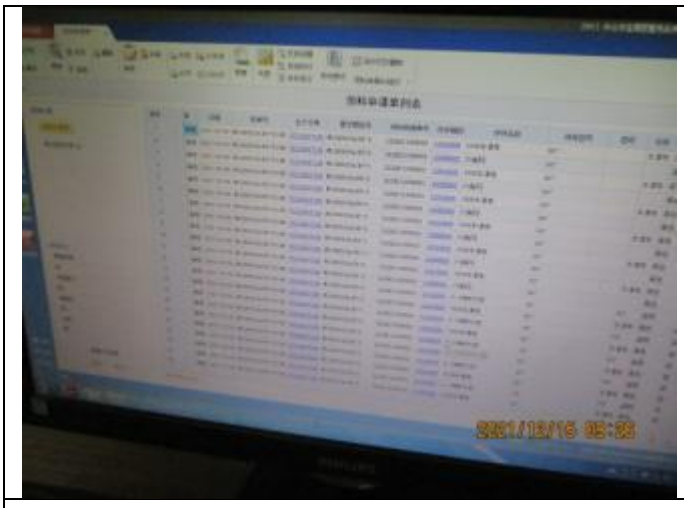
Special Remarks on this section

1. Based on the document review, The factory has provided related external certificates for review during the audit, but two test equipment was not calibrated such as electronic scale used onsite.

Actual Score	Theoretical Max
38	/42

Part 4
Stock Management

Incoming Materials Storage				
Questions		**Findings/Comments**	**Score**	
4.1	Is there a logistic method in used in the factory? Which one? (Kanban, FIFO…)	Based on the document review and employee interview, the factory has provided material in/out records and semi-product records for review.	3	/3
4.2	Is the stock management integrated to an ERP system?	As per the on-site observation, the stock management was integrated to an ERP system.	3	/3
4.3	Is storage capacity for incoming materials sufficient based on observation?	Confirmed by on-site observation, it was acceptable.	3	/3
4.4	Is there a reception area clearly marked and away from assembly line and stock area?	As per the on-site observation, there is a reception area clearly marked and away from assembly line and stock area.	3	/3
4.5	Are the materials and boxes in storage area in good conditions based on observation?	As per the on-site observation, some materials in the raw material warehouse are stacked against the wall and the window, and the windows are covered with spider webs in many places. 原料仓库里的一些材料靠墙和窗户堆放，窗户多处布满蜘蛛网.	1	/3
4.6	Is there any material needing special conditions of storage (temperature, humidity), and if yes, are the conditions controlled?	The electronic Hardware material was stored at warehouse with temperature and humidity controlling.	3	/3
Picture(s)				
				
Delivery record		Material in/out records		

	
ERP system	ERP system
	
stacked against the wall	spider webs

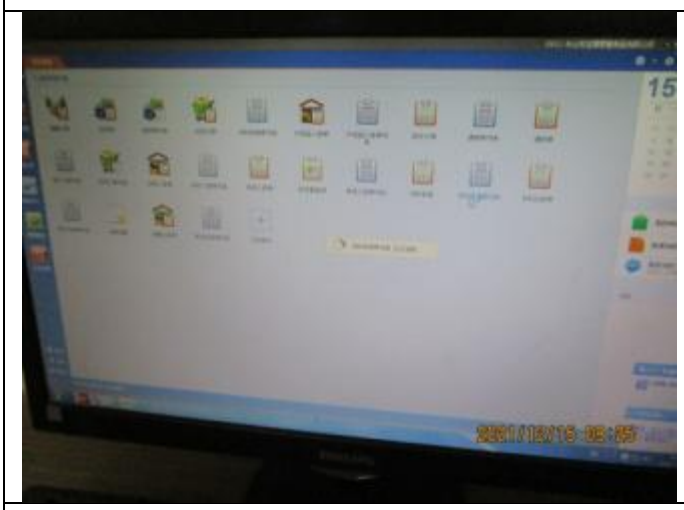
In-Process Storage				
Questions		**Findings/Comments**	**Score**	
4.7	Are the storage areas for semi-finished products and Non-compliant products clearly defined?	As per the on-site observation, the storage areas for semi-finished products and Non-compliant products are clearly defined.	3	/3
4.8	Is the size of workshops and storage areas sufficient based on observation?	Confirmed by on-site observation, it is acceptable.	3	/3
4.9	Does the system ensure traceability throughout the production process? Is production workshop managed linked to ERP?	Based on the document review, all records are recorded the purchase contract number and all production records were recorded the order number and customer's name, etc. Remark: The factory had used an ERP system or other IT system for production and warehouse.	3	/3
4.10	Is the identification system for semi-finished products well defined and implemented?	As per the on-site observation, some semi-finished products were placed in the qualified area had no Identification label. 一些合格区放置的半成品没有标识标签.	1	/3

4.11	Are the semi-finished products in storage area in good conditions based on observation?	As per the on-site observation, the semi-finished products in storage area are in good condition.	3	/3
4.12	Is there a special team dedicated to preparing kits and dispatching materials to assembly workshop?	As per the on-site observation and employee interview, there is a special team dedicated to preparing kits and dispatching materials to assembly workshop.	3	/3
4.13	Is the kitting and dispatching organized with an ERP system to ensure the relevant components are used for assembly? If not how the team is aware about when to feed the assembly with new parts?	As per the on-site observation and employee interview, the quality team provides drawings, ERP and production material records for new parts information to the assembly workshop.	3	/3
4.14	Is the kitting and dispatching process showing evidences of actions taken to improve speed and avoid mistakes from workers?	Based on the document review and Management interview, the factory has provided the dispatching process program and related records for review.	3	/3

Picture(s)

Production order planning

semi-finished products



ERP system

No Identification label

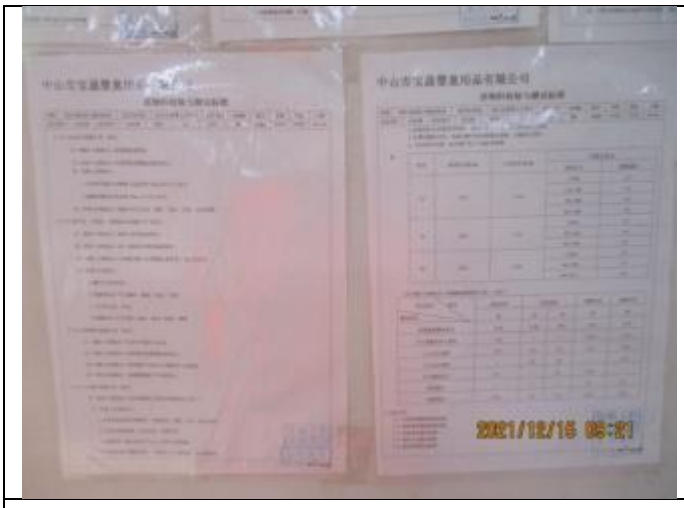
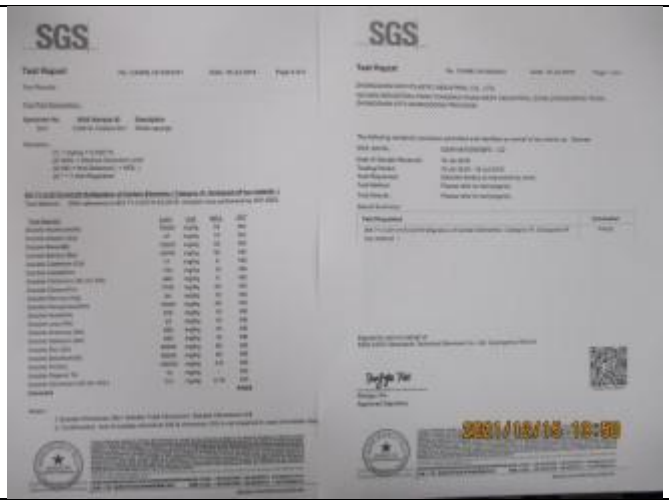
Finished Products				
Questions		**Findings/Comments**	**Score**	
4.15	Are the storage areas for finished products clearly defined?	As per the on-site observation, the storage areas for finished products is clearly defined.	3	/3
4.16	Is the size of storage area/warehouse for finished products sufficient based on observation?	As per the on-site observation, the size of the storage area/warehouse for finished products is sufficient.	3	/3
4.17	Are the conditions of storage controlled to ensure sufficient the products will not be deteriorated?	As per the on-site observation, some finished product in the finished goods warehouse are stacked against the wall and the window. 成品库内部分成品靠墙、靠窗堆放.	1	/3
4.18	Is there a sufficient number of loading decks, with relevant conditions of protections against rain and product deterioration during loading?	There is a sufficient number of loading decks, with relevant conditions of protection against rain and product deterioration during loading.	3	/3
Picture(s)				
				
Finished goods warehouse		stacked against the wall and the window		

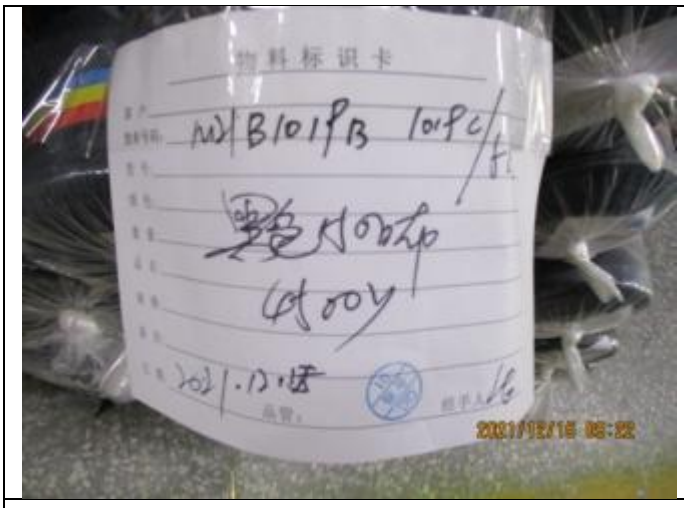
Special Remarks on this section
1. As per the on-site observation, some materials in the raw material warehouse are stacked against the wall and the window, and the windows are covered with spider webs in many places. 2. As per the on-site observation, some semi-finished products were placed in the qualified area had no Identification label. 3. As per the on-site observation, some finished products in the finished goods warehouse are stacked against the wall and the window.

Actual Score	Theoretical Max
48	/54

Part 5
Incoming Materials Inspection

Quality Control upon Reception				
Questions		**Findings/Comments**	**Score**	
5.1	Is the system for IQC (quality inspection upon reception) defined in written form, and included in standard operating procedures?	The factory established incoming inspection standards, the main inspection items and sampling plan and AQL- MIL-STD-105E Level II were defined in it.	3	/3
5.2	Is the scope of IQC, frequency, sampling method well defined and relevant?	There was a standard for IQC before delivery including sampling size, AQL and defect classification defined in the factory. AQL standard (AQL- MIL-STD-105E Level II , Critical 0/Major 1.0/Minor 2.5).	3	/3
5.3	Is there a QC room, separated from workshop, and clearly defined?	The factory has established a separated IQC area and three IQC employees were available.	3	/3
5.4	How many staff is dedicated to IQC? Are they suitably trained based on interview and observation?	Confirmed by employee interview and observation, the IQC employee was suitably trained and provided training records for review.	2	/3
5.5	Does factory keep records of incoming quality inspection? How? (Paper or Computer)	Based on the document review and Employee interview, the factory retained all IQC records by paper and computer.	3	/3
5.6	Is the system in case of non-compliance defined, and understood by IQC staff?	Confirmed by employee interview, it is acceptable.	3	/3
5.7	Is there an area for rejected parts? Is clearly defined and without mixed materials? If necessary, is it closed with controlled access?	As per the on-site observation, some incoming material and Semi-finished products was placed mixed with the finished goods warehouse. 一些进厂的来料品,半成品与成品仓库混合存放.	1	/3
5.8	Are parts correctly identified as pass or failed after QC inspection?	As per the on-site observation, some incoming materials placed in qualified area had no identification label and "Pass" label. 部分合格区的来料没有识别标签和“合格”标签.	1	/3
Picture(s)				
				
IQC inspection station		IQC inspection standard		

	
IQC inspection standard	IQC inspection records
	
IQC inspection records	Non-conforming records
	
IQC inspection records	Raw material test report

	
Inspection label for material	No identification label and "Pass" label
	
Mixed storage	

Special Remarks on this section
1. As per the on-site observation, some incoming material and Semi-finished products was placed mixed with the finished goods warehouse. 2. As per the on-site observation, some incoming materials placed in qualified area had no identification label and "Pass" label.

Actual Score	Theoretical Max
19	/24

Part 6
Production Process

Workshops Organization				
Questions		**Findings/Comments**	**Score**	
6.1	Are working instructions available for each machine?	Working instructions for each kind of machine and reference sample are available in production area during the audit day.	3	/3
6.2	Is the production planning defined and available in workshop?	The production planning is available in the production area during the audit day.	3	/3
6.3	Does factory follow production performance of each machine?	The factory has established machine maintenance plan and conducted maintenance monthly.	3	/3
6.4	Is workshop organization, cleanliness, and tidiness, optimized for performance (5S)?	As per the on-site verification, there was no obvious floor marking in some production workshops. And the factory did not obey "5S" management. 一些生产车间没有明显的地板标记,而且工厂没有服从"5S"管理	1	/3
6.5	Is machine daily maintenance status and condition identified clearly in workshop?	The factory has established machine maintenance plan and conducted maintenance monthly.	3	/3
6.6	Is there a defined process to set-up machines and start production? Who is responsible to give a green light to mass production? (Name and title)	The factory had the process to set-up machine and start production. Factory Production manager/ Wang Jingsheng was responsible to give a green light to mass production.	3	/3
6.7	Are variables of production defined clearly (temperature, speed...) and monitored during production?	As per the on-site observation, all variables of production defined clearly (temperature, speed...) and monitored during production.	3	/3

Picture(s)

Machine list

Maintenance planning

	
SOP	Maintenance records
	
SOP	No obvious floor marking

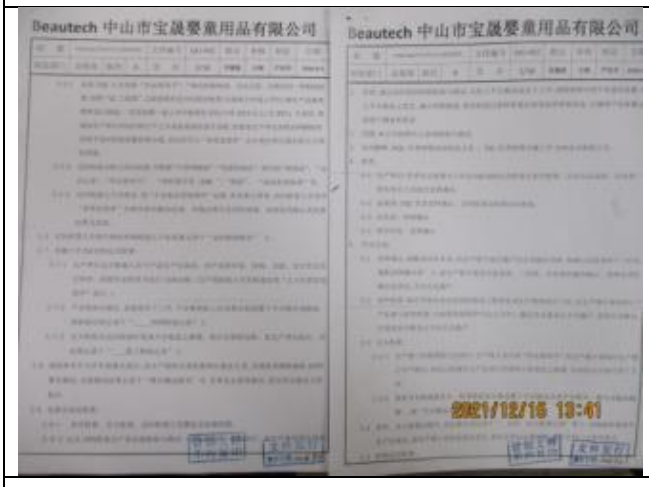
Quality Control during Production				
Questions		**Findings/Comments**	**Score**	
6.8	Is there a QC procedure for inspection before / during production written and available to relevant staff?	The factory established process inspection standards and arranged two QC to conduct process inspection (process routing inspection/first article inspection).	3	/3
6.9	How many QC staffs are there for in-line QC? Are they easily identified? What are the powers of the QC people toward the line in case of NCs found?	There were 6 in line QC staffs for 100% online inspection (e.g. function and visual) of all production steps. LQC staffs were easily identified with Work label.	3	/3
6.10	Is equipment necessary to perform quality control during production available on site and readily accessible to relevant staff?	As per the on-site observation, the factory equipped with all necessary equipment to perform quality control during production.	3	/3
6.11	Are first parts checked and validated before production? By who? Are the responsible not belonging to production team?	First parts were checked by technical supervisors and validated before production.	3	/3

6.12	Describe the frequency? (Every morning, twice a day, before each shift…) Define the tests that are done for the first parts to validate the mass production?	First parts would be checked for each lot before production and patrol inspection is conducted per 2 hours.	3	/3
6.13	Is there any random QC check during production? If yes, what is the frequency and sampling size used?	There were four QC would conduct the random checking per 2 hours, and at least 5 pieces would be selected during production.	3	/3
6.14	Are there records for all the above checks written and kept in factory?	The factory has provided all process inspection records for review and kept in factory.	3	/3
6.15	Are there steps of control for 100% of products during production? If applicable, are they well implemented?	There are steps of control for 100% of products during production and they are well implemented.	3	/3
6.16	In case of Non-compliance detected during production, is there a defined process defined and well understood?	In case of Non-compliance detected during production, there was a defined process of treatment, well understood.	3	/3
6.17	Are the Non-compliant products adequately separated, identified and disposed of?	As per the on-site observation, the factory had set an area for non-conforming products in-process quality control. However, there was no label for the non-conforming products in the IPQC station. 工厂设置了不合格品在制品质量控制区域。但是，发现一些巡检区对不合格品没有明确的标识.	1	/3

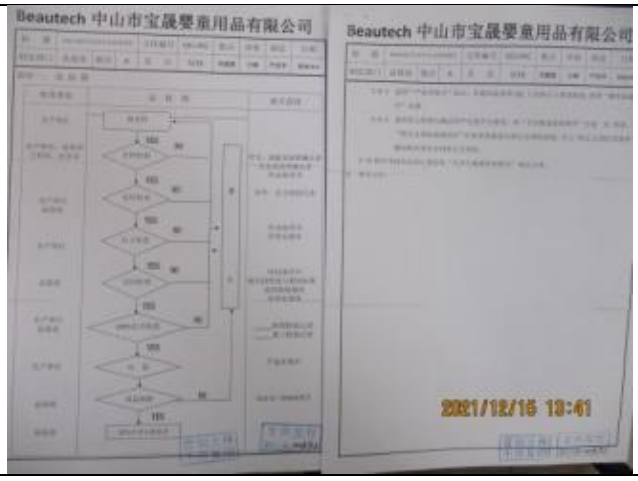
Picture(s)

IPQC inspection station

Reference sample



IPQC inspection standards



IPQC inspection standards

	
IPQC inspection records	IPQC inspection records
	
non-conforming products records	non-conforming products area
	
non-conforming products area	no label for the non-conforming products

Special Remarks on this section
1. As per the on-site verification, there was no obvious floor marking in some production workshops. And the factory did not obey “5S” management. 2.As per the on-site observation, the factory had set an area for non-conforming products in-process quality control. However, there was no label for the non-conforming products in the IPQC station.

Actual Score	Theoretical Max
47	/51

Part 7
Packing and Quality Control before Shipment

Packing Line Organization				
Questions		**Findings/Comments**	**Score**	
7.1	Are packing methods clearly defined to ensure product protection and instructions available?	As per the on-site observation, the packing methods were clearly defined to ensure product protection and instructions available.	2	/3
7.2	Is line organization, cleanliness, and tidiness, optimized for performance (5S) to ensure product cannot be deteriorated?	As per the on-site observation, all line organization, cleanliness, and tidiness is optimized for performance (5S) to ensure the product cannot be deteriorated.	2	/3
Picture(s)				
				
Packing instructions		Packing methods		

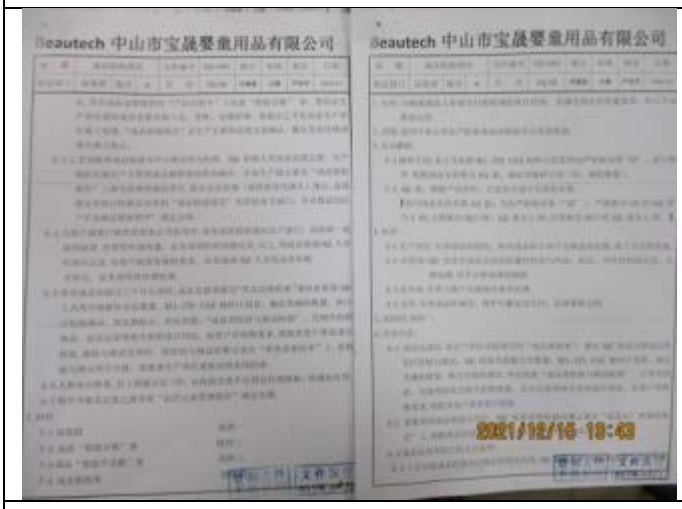
Quality Control Before shipment				
Questions		**Findings/Comments**	**Score**	
7.3	Is there a standard for final quality inspection before shipment defined in factory including sampling size, AQL, defect classification (Critical/Major/Minor)?	There was a standard for OQC before delivery including sampling size, AQL and defect classification defined in the factory. AQL standard (AQL- MIL-STD-105E Level II, Critical 0/Major 1.0/Minor 4.0).	3	/3
7.4	How many QC staffs are in charge of Final Quality Inspection? Are they in sufficient number, easily identified, and suitably trained based on interview and observation?	Four QCs were arranged to conduct finished goods inspection as OQC standards, and confirmed by interview, the QCs were trained well.	3	/3
7.5	Is necessary equipment to perform final inspection available in factory and readily available for relevant staff?	As per the on-site observation and employee interview, the factory equipped all necessary equipment to perform the final inspection and the OQC employees were trained well.	3	/3

7.6	Are records of final inspection kept and with enough information to be linked to the batch inspected and with enough information recorded?	The records of final inspection were kept and with enough information to be linked to the batch inspected and with enough information recorded.	3	/3
7.7	Is there a clearly defined process in case of fail final inspection? Will products be clearly identified and separated, and corrective actions taken?	The factory has established non-conforming products control procedure and established non-conforming products area in the production area, once nonconforming products were identified during production process, all of it were separated, identified immediately.	3	/3
7.8	Is factory using their own QC team? Who is responsible to approve final shipment quality? Is factory working with 3rd party company? If yes, which frequency?	The factory had their own QC team; factory manager Quality manager responsible to approve final shipment quality. The factory was working with 3rd party company in a regular frequency (factory would be working with 3rd party company in a regular frequency according to client 'requirement)	3	/3

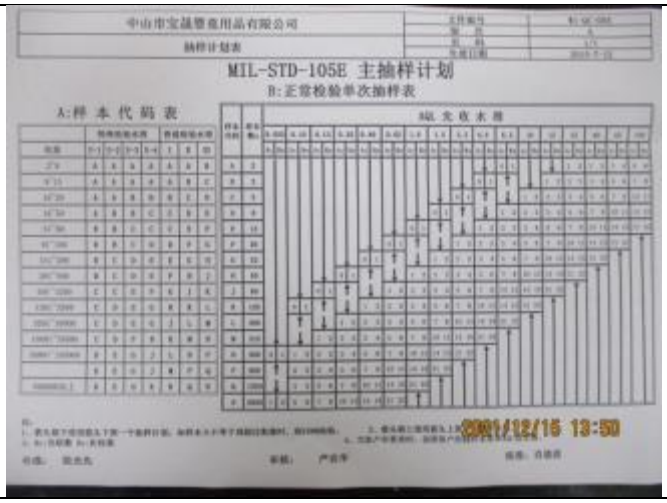
Picture(s)

OQC inspection station

Reference samples



FQC inspection standard



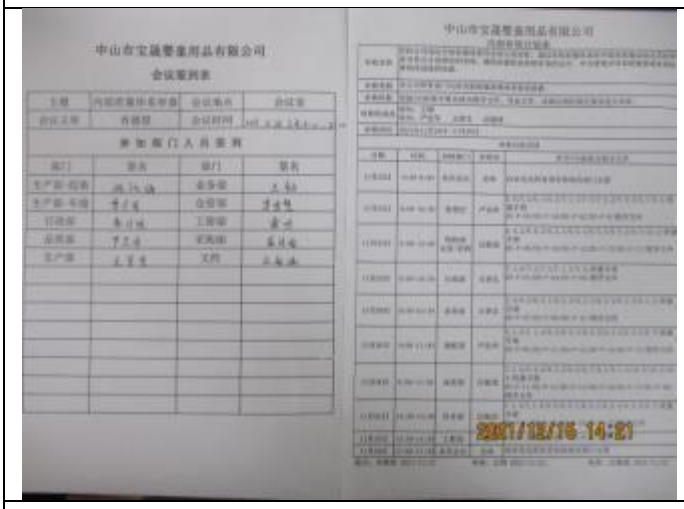
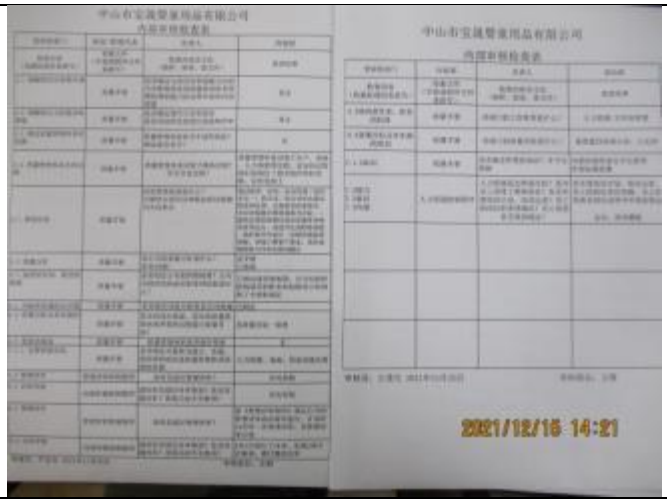
AQL inspection standard

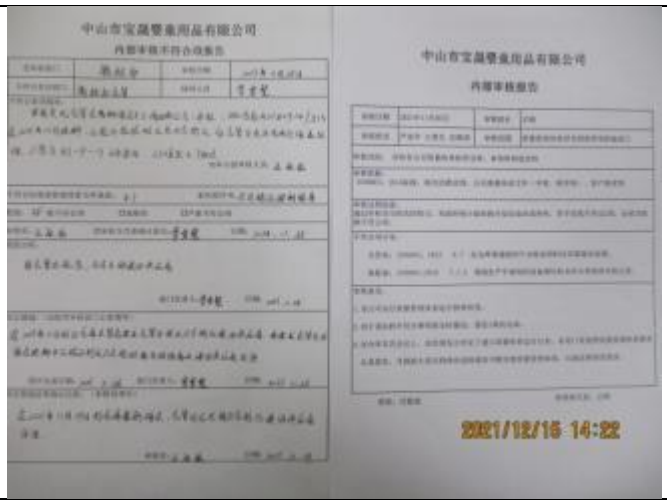
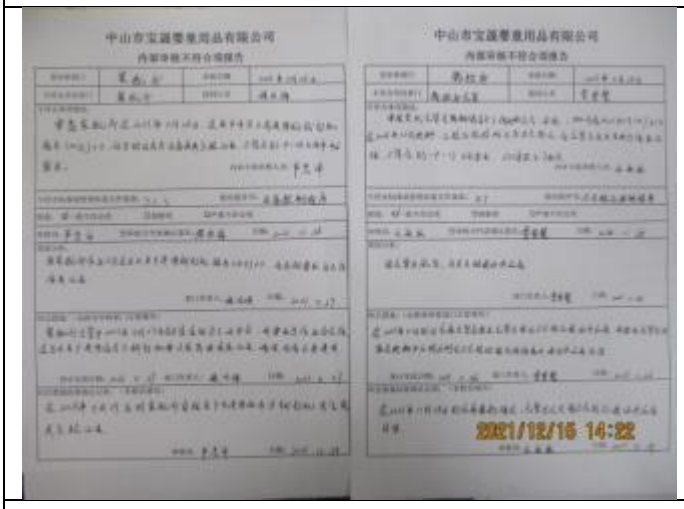
	
FQC inspection records	Non-conforming records
	
FQC inspection records	Inspection label
	
Test report	Test records

Special Remarks on this section
Nil

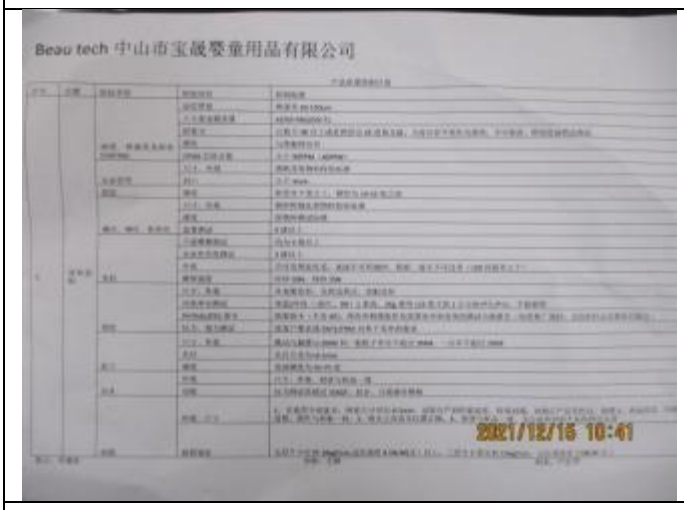
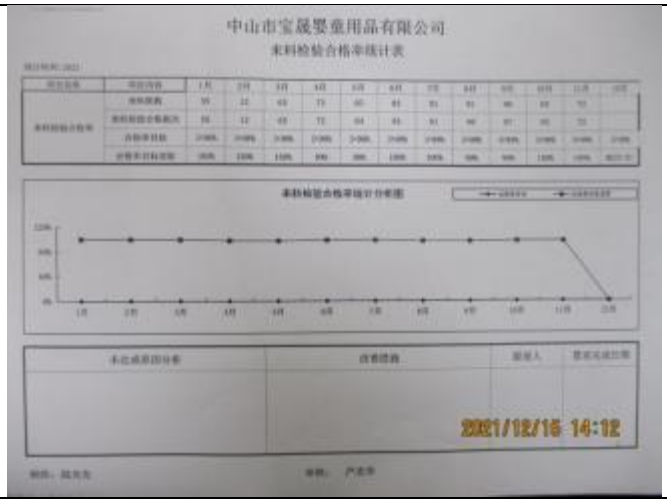
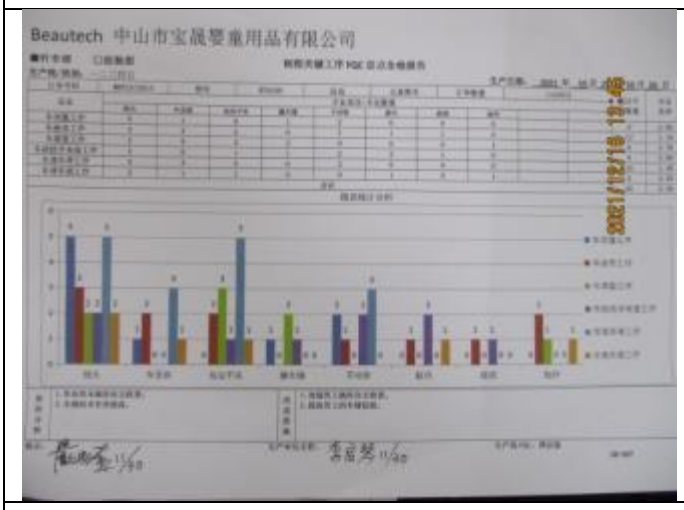
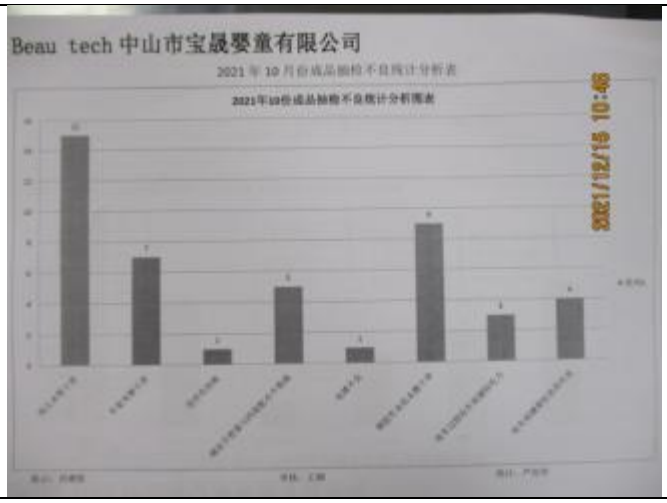
Actual Score	Theoretical Max
22	/24

Part 8
Measurement, Analysis and Improvement

Internal Audit				
Questions		**Findings/Comments**	**Score**	
8.1	Is there a documented internal audit process?	The factory has established an internal audit procedure and conducted an internal audit annually; the latest was conducted on 25 to 26-Nov-2021.	3	/3
8.2	Are internal audits performed at least once per year?	The factory has established an internal audit procedure and conducted an internal audit annually; the latest was conducted on 25 to 26-Nov-2021.	3	/3
8.3	Are internal audits recorded, and with proof that it has been performed according to plan, for whole process, and by auditors with relevant qualifications (certified)?	Based on the document review and employee interview, records showed internal audit were performed according to plan, and 2 internal auditors were available.	3	/3
8.4	Are issues found during internal audits addressed wit corrective actions, and efficiency reviewed and documented?	Corrective and preventive action records of issues found during internal audits were maintained.	3	/3
Picture(s)				
				
Internal audit planning		Internal audit checklist		

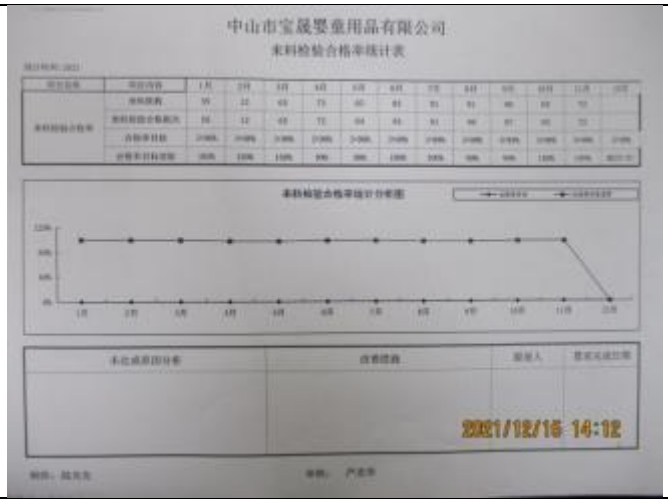
	
Internal audit checklist	Internal audit records
	
Internal audit records	Internal auditor

Monitoring and Measurement of Process				
Questions		**Findings/Comments**	**Score**	
8.5	Are there Statistical Process Control charts existing for all critical characteristics?	Based on the document review, there are Statistical Process Control charts existing for all critical characteristics.	3	/3
8.6	Are out of control conditions identified and brought back to control in timely manner?	The factory did not out of control conditions identified and brought back to control in timely manner or records for review. 工厂未发现失控情况并及时恢复控制或记录备查.	1	/3
8.7	Are there any Response Plan documented and readily available?	The factory provided related evidence for review during the audit.	3	/3
8.8	Is factory able to prove that Process Capability has been calculated using statistical analysis?	Based on the document review, the factory has Provided related Process Capability records for review.	3	/3
8.9	Does factory use Advanced Statistics to analyze data and define improvements?	The factory has provided related analyze data and define improvements records for review.	3	/3

Picture(s)	
	
Quality control planning	Quality analysis record
	
Quality analysis record	Quality analysis record

Data Management and Continuous Improvement

Questions		Findings/Comments	Score	
8.10	Does factory collect and analyze data for suppliers performance, product performance?	Based on the document review and Management interview, the factory has collected and analyzed data for suppliers performance, product performance records for review.	3	/3
8.11	Is there evidence that improvement efforts are documented and recorded?	Based on the document review, the factory provided related evidence for review during the audit.	3	/3
8.12	Are corrective and preventive actions documented and recorded?	The corrective and preventive actions are documented and recorded.	3	/3
Picture(s)				

	
Suppliers' performance records	Suppliers' performance records
	
Suppliers' performance records	Suppliers' performance records

Special Remarks on this section

1. The factory did not out of control conditions identified and brought back to control in timely manner or records for review.

Actual Score	Theoretical Max
34	/39

Part 9
Corrective Action Plan

Client	BabyOne Franchise- und Systemzentrale GmbH	QIMA Service No	R-Cloud-21233851
Supplier	Zhongshan BEAU TECH Baby Products Company Ltd	Auditor(s)	Mr. Billy Chen
Factory	Zhongshan BEAU TECH Baby Products Company Ltd	Date	15-Dec-2021
Industry	Toys & Recreational items	Country	China
Audit Type	Manufacturing Audit		

No.	Findings / Violations	Corrective action	Target completion date
1	Based on the document review, The factory has provided related external certificates for review during the audit, but two test equipment was not calibrated such as electronic scale used onsite. 工厂提供相关的外部证书供审核期间审核。 但现场使用的二台电子秤等测试设备没有校准.	All test equipment should be regularly calibrated.	14-Jan-2022
2	As per the on-site observation, some materials in the raw material warehouse are stacked against the wall and the window, and the windows are covered with spider webs in many places. 原料仓库里的一些材料靠墙和窗户堆放，窗户多处布满蜘蛛网.	All raw materials should be properly stored, and the storage warehouse should be in good conditions based on observation.	14-Jan-2022
3	As per the on-site observation, some semi-finished products were placed in the qualified area had no Identification label. 一些合格区放置的半成品没有标识标签.	The factory should set an area and for identified label for products storage area.	14-Jan-2022
4	As per the on-site observation, some finished product in the finished goods warehouse are stacked against the wall and the window. 成品库内部分成品靠墙、靠窗堆放.	The materials should be in storage area in good conditions based on observation.	14-Jan-2022
5	As per the on-site observation, some incoming material and Semi-finished products was placed mixed with the finished goods warehouse. 一些进厂的来料品,半成品与成品仓库混合存放.	The factory should place products as appointed area and set up rejected parts area.	14-Jan-2022
6	As per the on-site observation, some incoming materials placed in qualified area had no identification label and "Pass" label. 部分合格区的来料没有识别标签和“合格”标签.	The factory should be all material were placed in the qualified area had identification label.	14-Jan-2022
7	As per the on-site verification, there was no obvious floor marking in some production workshops. And the factory did not obey “5S” management. 一些生产车间没有明显的地板标记,而且工厂没有服从“5S”管理	The factory should ensure obvious floor making in the facility. And the facility should have 5S management.	14-Jan-2022

8	As per the on-site observation, the factory had set an area for non-conforming products in-process quality control. However, there was no label for the non-conforming products in the IPQC station. 工厂设置了不合格品在制品质量控制区域。 但是，发现一些制造巡检区对不合格品没有明确的标识.	The factory should set an area for non-conforming products storage. And ensure there are labels for the non-conforming products.	14-Jan-2022
9	The factory did not out of control conditions identified and brought back to control in timely manner or records for review. 工厂未发现失控情况并及时恢复控制或记录备查.	The factory should be provided out of control conditions identified and brought back to control in timely manner	14-Jan-2022

Factory Stamp & Site Representative Signature: Mr. Wang Gang / Manager

Date: 15-Dec-2021

Auditor Signature: Mr. Billy Chen

Date: 15-Dec-2021

IMPORTANT NOTES

THE ABOVE RESULT(S) REFLECT(S) QIMA LIMITED'S FINDINGS AT THE TIME AND PLACE OF AUDIT.
WITH REGARD TO THE RANDOM SAMPLE CHARACTER OF THE AUDIT, IT SHOULD BE NOTED THAT ADDITIONAL NONCONFORMITIES MAY EXIST, WHICH WERE NOT FOUND DURING THE AUDIT.
THE AUDITOR'S FINDINGS DO NOT RELIEVE THE AUDITEE OF ITS RESPONSIBILITY TO ENSURE THAT THE REQUIREMENTS OF THE STANDARD ARE FULFILLED AND CONSTANTLY ADHERED TO.

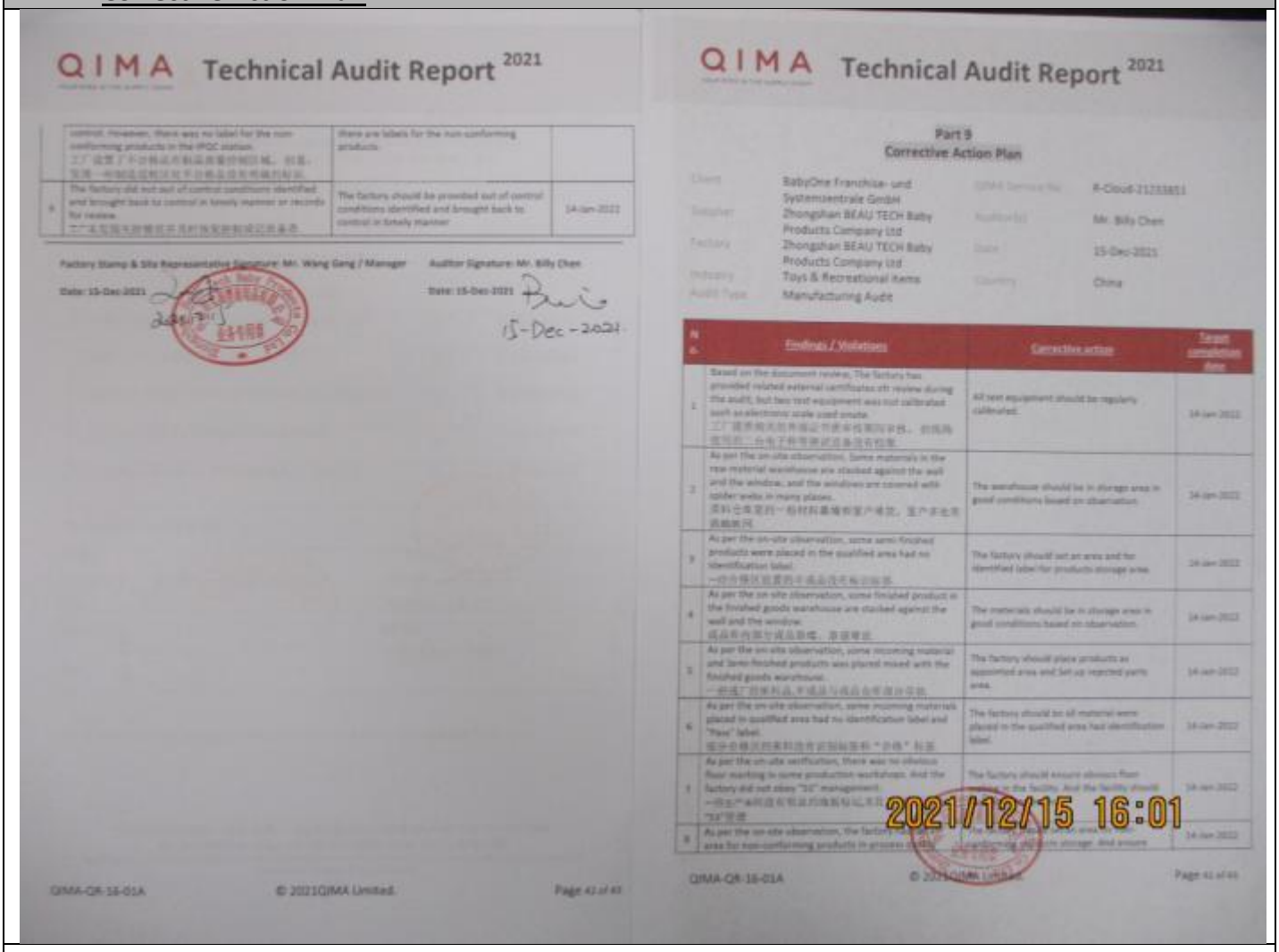
Factory Disclaimer

Original signature of the Factory Representative accepting QIMA policy including bribery issues.

Confirmation of Compliance with QIMA Code of Conduct

Original signature of the Factory Representative confirming that auditor respected QIMA Code of Conduct.

Corrective Action Plan



Original signature of the Factory Representative agreeing with the Audit Findings and Corrective Action Plandefined.

END