



Manufacturing Process

Moist Heat Packs

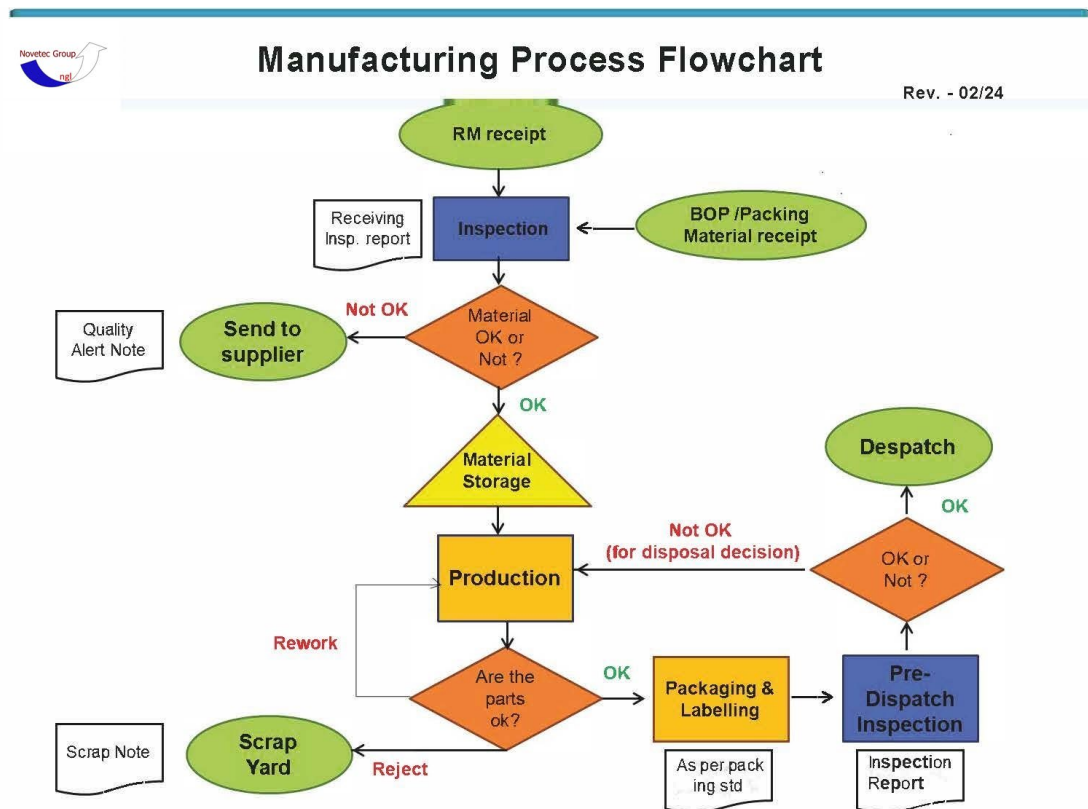
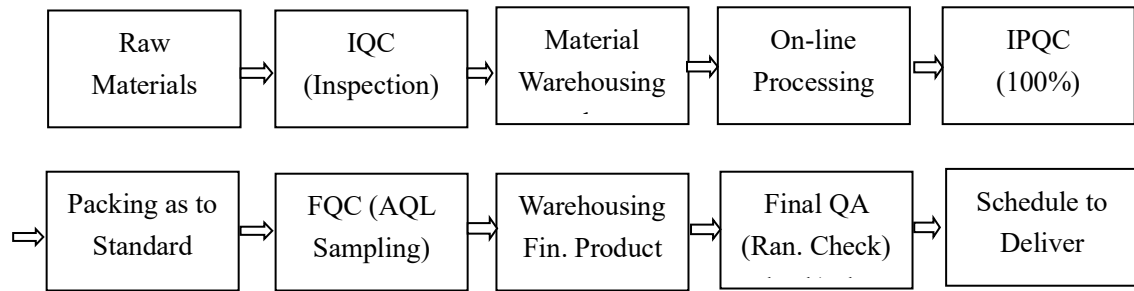
Plant: Linjiang (Holdings) Ltd.

Raw Materials and Functionality		
1	Fine combed cotton canvas as the exterior material	Because cotton is a natural product, it is soft and easy to stretch. It has ability to control moisture, insulate, and provide comfort. It is also weatherproof and a durable material. In particular, cotton has a high tensile strength, making it strong, durable and less likely to rip or tear. For more, cotton is hypoallergenic and does not irritate skin. It is therefore widely used in other medical products like bandages and gauze.
2	Bentonite clay as the filler	Formulated non-toxic biodegradable clay, a natural hydrocolloid filling.
3	How does Bentonite clay work Therapeutically? Hydration Process	While in its natural state, bentonite clay has negatively charged molecules. Most toxins and heavy metals have positively charged molecules. This allows the two to bind together easily and stay united while the toxin removal process happens. Bentonite clay essentially “seeks” toxins in the body to bind with because naturally any substance that has a missing ion (which gives it its “charge”) looks for oppositely charged types of substances that will make it complete. Upon binding, the clay is then able to help remove toxins, chemicals, impurities and “heavy metals” from the gut, skin and mouth.
4	Benefits	Digestive disturbances like acid reflux, constipation, bloating, gas, etc. Help with skin and allergy issues Help provide minerals for the body Help speed recovery from vomiting and diarrhea Detoxification In oral health preparations Externally for all types of skin problems and to speed healing

Manufacturing Process Flow

Key Process	Process Flow	Check Points / Criteria	Remarks
Receiving Order	Validate order quantity and relevant details	Check / prepare / ordering of all necessary materials / components	Alert suppliers on material quality and on time delivery.
Receiving Inspection	IQC Sampling Inspection	Check all materials as per BOM specs and requirements	Record issue, if any and to update / alert suppliers.
Processing	Threading check and tuning and calibration of sewing machines	Check all sewing materials and conditions conform to the requirements.	Any imperfection found, sort out and return to the beginning step, report and record.
	Sewing process for pouches	Sewing / stitching conform to specifications, stitching density (stitch per inch), alignment, stich quality	Any imperfection found, sort out and return to the beginning step, report and record.
	Filler testing preparation	Inspection / testing / sorting of bentonite filler to make sure product quality is up to the requirement	Any imperfection found, sort out and return to the beginning step, report and record.
	Calibration of the filler injection machines	Check / measure / calibration of the filler injection machine	Any misalignment found has to be calibrated, check and tested.
	Filler injection Process	Check and make sure the entire process up to the requirements.	Any imperfection found, sort out and return to the beginning step and report
	On line inspection	Random check / inspection throughout production process	Any imperfection found, sort out for analysis and corrective action planning and keep record.
Aesthetic Inspection	Full visual check and inspection	Intensive product inspection against defined specifications	Any imperfection found, sort out for analysis and corrective action planning and keep record.
Packing / Labeling	Check to make sure all packaging materials conform to export grade standard	Conduct Drop Test to make sure cartons are strong enough to get through transportation	Any quality issue found, sort out for analysis and for corrective action planning and keep record in file
QA Random Inspection	Conduct inspection based on AQL acceptable standard	Accordingly to AQL Sampling Plan Level I	If passed, keep record. For failure hold up for investigation.
Warehousing	Dispatch products to the finished product warehouse and to update record		Necessary for palletizing or floor loaded according to requirements

Processing Flow



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