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AUDIT REPORT

File Information

File No.	:	P5-006131
File Status	:	Certified
File Sub Status	:	-
Licence No.	:	PC002467
Product	:	POLYETHYLENE (PE) PIPES FOR WATER SUPPLY
Standard	:	MS 1058-2 : 2023
Surveillance No.	:	2.2 of 2
Customer Code	:	03000126
Customer Name	:	HUP SOON PLASTIC INDUSTRIAL (M) SDN. BHD.
Customer Address	:	LOT PT 38820, PLOT 150 HALA PERUSAHAAN MENGLEMBU 9 31450, MENGLEMBU PERAK, MALAYSIA
Customer Representative	:	MS. SYARIFAH NOR SYAFEERA

Manufacturer Information

Manufacturer Name	:	HUP SOON PLASTIC INDUSTRIAL (M) SDN. BHD.			
Manufacturer Address	:	LOT PT 38820, PLOT 150 HALA PERUSAHAAN MENGLEMBU 9 31450, MENGLEMBU PERAK, MALAYSIA			
Manufacturer Representative	:	MS. SYARIFAH NOR SYAFEERA			
Job No.	:	J202607-0534			
Job Type	:	Surveillance	Date of Audit Report	:	15/07/2026
Job Auditor	:	MOHAMAD NURHIDAYAT BIN RAHMAT			
Job Start Date	:	15/07/2026	Job Start Time	:	10:00
Job End Date	:	15/07/2026	Job End Time	:	16:45

Product Audit Information

Item	Observations
Raw Materials (Storage area)	Black compound Supplier: Thai Polyethyelene Co. Ltd. Grade: H1000PC/ PE100 Lot no: out of stock Supplier: Borouge Grade: HE3490LS/ PE100 Lot no: 1325570 Supplier: Borouge Grade: HE3490LSH/ PE100 Lot no: out of stock Blue Compound Grade: H1000PBL Supplier: Thai Polyethylene Co. Ltd. Lot no: out of stock Grade: HE3494LSH Supplier: Borealis Lot no: 5230688
Production during audit	Process: Co - Extrusion process. No production for certified pipe during the audit, however machines were in good condition and ready for production. Verified similar production process in: a. machine 1: no production

	b. machine 2: no production c. machine 3: no production d. machine 4: no production e. machine 5: no production f. machine 6: no production g. machine 7: no production h. machine 8: 16mm tubing non-sirim
Raw materials (records)	1. HDPE black a. Grade: HE3490LS b. Designation/ lot no: PE100/ 1324409 c. Received date: 07/11/2025 d. Supplier: Borouge e. Verified COA from supplier i. MFR - 0.22g/10min (190ºC/ 5kg) ii. Density - 959kg/m3 iii. Carbon black content - 2.30% iv. Carbon black dispersion – 2.5 v. OIT – 42min vi. MC – 10ppm vii. Total volatiles – 210ppm 2. HDPE blue* a. Grade: HE3494 LSH b. Designation/ lot no: PE100/ 5230688 c. Received date: 30/06/2024 d. Supplier: Borealis e. Verified COA from supplier i. MFR - 0.3g/10min (190ºC/ 5kg) ii. Density – 951.4kg/m3 iii. OIT – 92min iv. MC – 10ppm v. Dispersion – 2.4 note *old stock
Finished product	Brand: HUP SOON Nominal diameter: DN32 and DN25 Nominal pressure: PN12.5 Color: Black with blue stripes
Records traceability	There was only 2 productions of certified pipes since last audit as below details: a. 10/06/2026 for DN25 PN12.5 b. 10/06/2026 for DN32 PN12.5

Marking Requirements

Marking Compliant : YES
Remark : -
Method of Marking : Hot-stamping on pipes, yellow colour

Record Observations

Record	Observations
Incoming	Based on Certificate of Analysis (C.O.A), mill certificate from supplier and internal inspection. All C.O.A, mill certificate and internal inspection records of raw materials well maintained in every incoming of HDPE black and blue.
In process	Records were maintained in every production running according to standard requirements and factory quality plan.
Final	Records were available and well maintained in every batch of pipes produced. Finished product tested accordingly to standard requirements and factory quality plan.
Customer complaint	System had been satisfactory established and records available. No complaint received.
Handling of product failure	Non compliance pipes will rejected and do cutting and crushing, and used for non-certified pipes.
Calibration	All equipment used for quality inspection within calibration status and all certificates available during audit.

Sampling, Testing and Results

Reference of Test Report

Report No.	Report Type	Report Date
2020PC0271	Type Test Report	20/05/2020
2020PC0591	Type Test Report	29/07/2020
2020PC0839	Type Test Report	12/10/2020
2025CE1401	Type Test Report	21/04/2025

Were sample selected?	YES
Remark	-

Laboratory

Laboratory	:	Factory Lab
Type of Test Conducted	:	OIT, Hydrostatic Pressure Test 80 @ 100hrs, Dimensions, Marking and Appearance
Purpose of Test	:	Routine at factory(witness test)
Quantity	:	1 length
Product	:	Nominal diameter: DN32 Nominal pressure: PN12.5 PE100
Selected From	:	Storage
Production Date/ Production Code/ Serial No.	:	10/06/2026
Result	:	OIT: > 40 mins Hydrostatic Pressure Test 80 @ 1000hrs: in progress Marking and Appearance: Satisfactory Dimensions: Pass

Corrective action for previous non-conformance(s)

1. to close NCR no MNH01/HS/070126 (calibration) accordingly.
Status: Rectified

Summary of current findings

2nd surveillance cycle 2026-2027 was done physically on 15/07/2026 in Menglembu, Ipoh.

Production area
No production of certified pipe during audit, however verified non-certified HDPE pipe in machine no:
a. machine 1: no production
b. machine 2: no production
c. machine 3: no production
d. machine 4: no production
e. machine 5: no production
f. machine 6: no production
g. machine 7: no production
h. machine 8: 16mm tubing non-sirim
It was found that no changes in term of production process flow. Raw materials were available in the storage area as well as the finished good.

Records audit
Manufacturer has maintained C.O.A for every batch of incoming raw material and verify in accordance with Company Specification. Online checking was also conducted according to the standard requirements and company specification. Finished product had been tested according to the standard requirements before deliver to the customer or for storage.

All equipment used were well maintained and within calibration period, certificates of calibration were well maintained and retrievable during the audit. Handling of failure product and customer compliant are satisfactory. There was no complain received since the last audit, however, the mechanism was well established. Handling of NC product were well recorded and classified for the next action. The pipes not complied with the standard requirements or company specification will be placed at Reject Area and will be crushed for recycle the materials for non-certified production.

Witnessed routine test on OIT, geometrical, hydrostatic pressure test, marking and appearance on pipe 32mm PN12.5 PE100 and 90mm PN10 PE100. All test comply according to the standard requirements however for hydrostatic pressure test, the test still in progress. Verified also that the manufacturer have competent personnel to conduct the entire routine test.

Overall findings
Company has maintained its capability to produce the product in accordance with the standard requirements and product certification requirements.

Changes required for continued certification

NIL

Other instructions

NIL

Recommendations

Recommendation for continue certification.

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End of Report