



10 STEP QUALITY PROCESS

Spring Water: 10 Step Quality Process

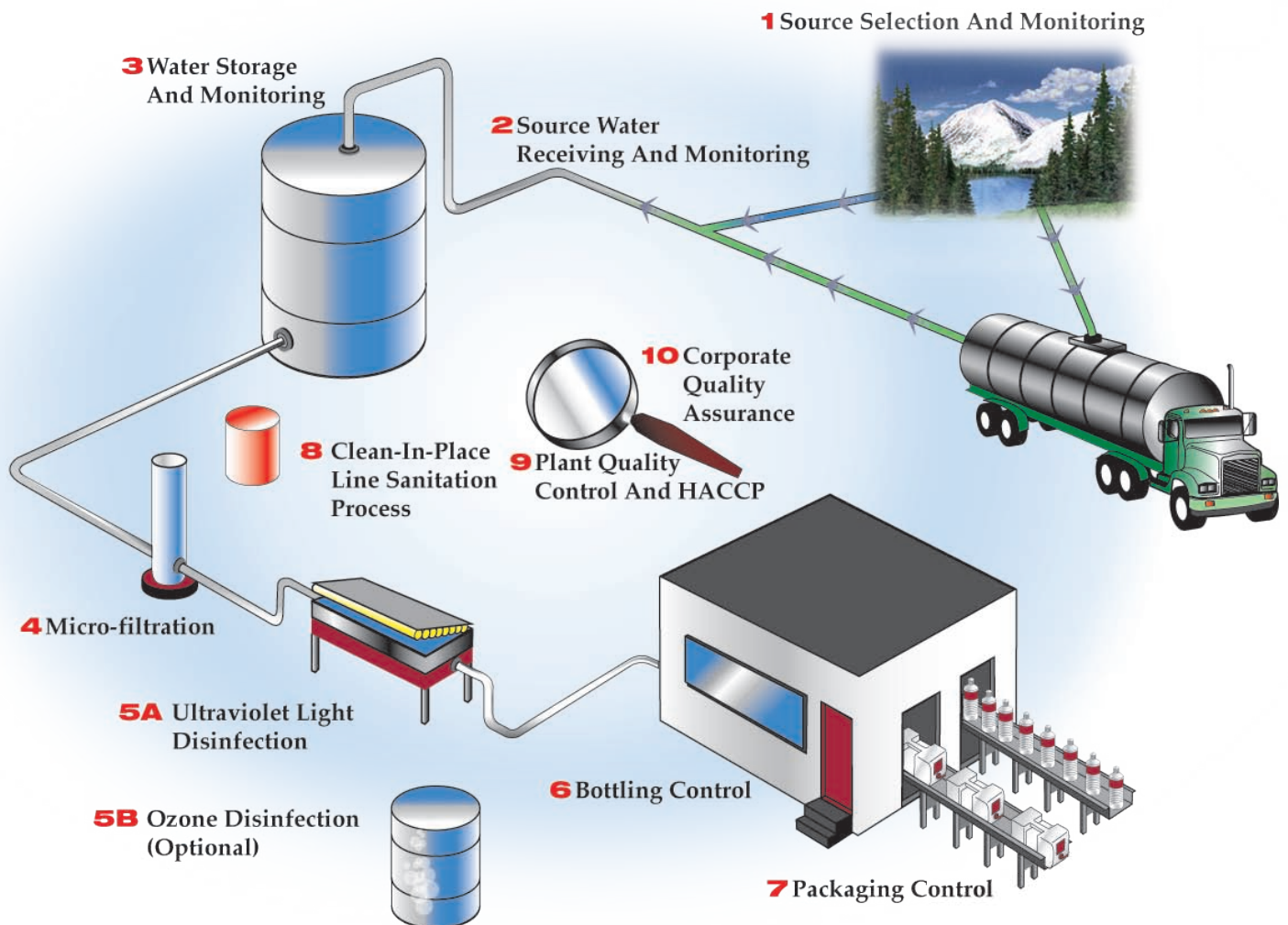
1 Source Selection and Monitoring

- Our spring water sources are natural springs, which come from aquifers.
- Spring selection is made on the basis of natural composition and freedom from contamination, availability and taste.
- In-house and trained, geologists and hydrogeologists, monitor springs regularly at the source.
 - Only sustainable sources, which meet our stringent requirements for quality and environmental harmony, are utilized.
 - Spring water is collected using state-of-the-art equipment to prevent chances of contamination and safeguard the water's natural characteristics.



2 Source Water Receiving and Monitoring

- Spring water is transported from the natural spring either by food-grade pipelines or through delivery in sanitary stainless steel tankers, direct to our plants.
- Trained Quality Assurance personnel at each plant take daily samples of incoming spring water and test for signs of contamination.
- Monitoring of the spring water collection and receiving process is performed regularly.
- One-micron filters remove sand or other particles, which may happen to be present.



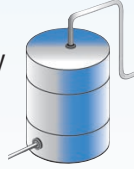


NORTH AMERICA

10 STEP QUALITY PROCESS

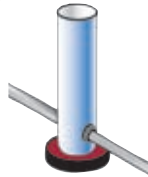
3 Water Storage and Monitoring

- Spring water is temporarily held in food-grade storage tanks upon initial receipt at the plant.
- Here, the water is further tested for conformance to specifications.



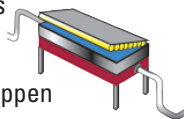
4 Micro-filtration

- Specialized two-stage advanced micro-filters, designed specifically for our process, filter the raw spring water.
- These filters are pharmaceutical grade and are designed to remove particles as small as 0.2 micron in diameter.



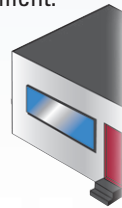
5 Ultraviolet Light/Ozone Disinfection

- A.** This process follows micro-filtration and is designed to destroy bacteria which may happen to be present.
- B.** The combined effects of micro-filtration and ultraviolet light/ozone disinfection provide added assurance of product safety.



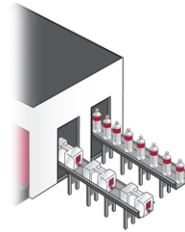
6 Bottling Control

- Bottling is conducted under very controlled conditions using state-of-the-art equipment.
- The spring water is monitored during the filling and capping process to prevent contamination from the environment.
- Each bottle is given a specific code that identifies the plant location, bottling line and time produced.
- Each plant maintains bottling specifications and control.



7 Packaging Control

- Packaging is conducted using the latest in modern equipment.
- Bottles, caps and labels are carefully controlled and monitored by lot.
- Most bottles are manufactured on-site for quality control.
- Packaging materials not meeting internal standards are rejected.



8 Clean-In-Place (C.I.P.) Sanitation Process

- Line sanitation practices include advanced internal pipe and equipment cleaning methods, called C.I.P.
- This automated cleaning process recirculates detergent and sanitizing solutions at the precise temperatures and time to ensure total control and maximum effectiveness of the line sanitation process.



9 Plant Quality Control and HACCP* Program

- Each plant has a fully staffed Quality Assurance Department and Laboratory that maintain the plant Quality Control processes.
- Water, packaging materials and plant processes are carefully monitored to ensure they meet company specifications and standards.

*Hazard Analysis Critical Control Point



10 Corporate Quality Assurance Program

- National Testing Laboratory is equipped with state-of-the-art testing machinery and staffed with degreed, experienced personnel.
- Comparative analyses are performed on products in accordance with State and Federal regulatory standards.
- Independent from the plant Quality Control and Quality Assurance Departments, the Corporate Quality Assurance program sets company-wide standards, specifications and monitors plant quality programs.