



The Healthy Hydration Company™

# 14 STEP QUALITY PROCESS

## Purified Water Enhanced With Minerals for Taste: 14 Step Quality Process

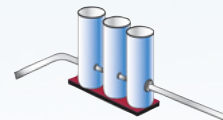
### 1 Source Receiving



- Water is carefully collected from the source, which may either be a well or municipal supply.
- Common method of receiving water is through stainless steel pipeline.
- Sample is taken from source weekly prior to internal processing.
- Microbiological and general chemistry testing performed on samples regularly.

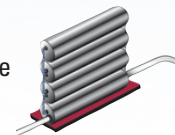
### 3 Pre-treatment

- Water softener used to reduce water hardness.



### 4 Demineralization Process

Demineralization is the use of cation and anion resin beds to remove minerals.

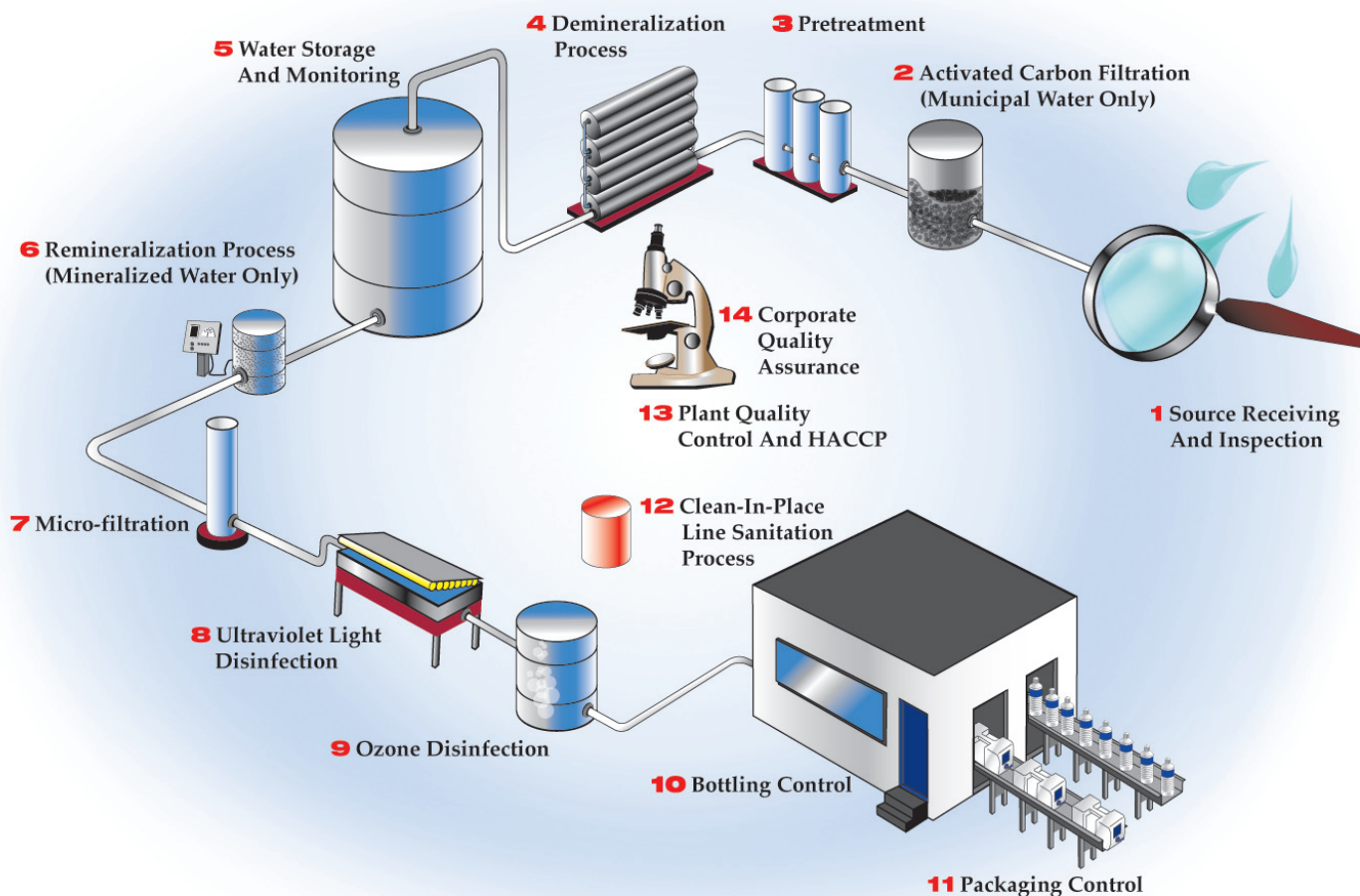
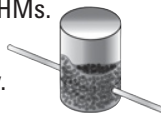


Either/or of the following would be used:

- Reverse Osmosis – Use of high-pressure pump and special membranes, called semi-permeable membranes, to reverse the natural phenomenon of osmosis.
- Distillation – A process that boils the water and collects the condensate for bottling.

### 2 Activated Carbon Filtration (Municipal Water Only)

- Removal of chlorine and THMs.
- Filtration process monitored and tested daily.



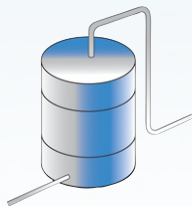


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## 5 Water Storage and Monitoring

- Water is received into storage tanks.
- Storage environment and water carefully monitored daily.



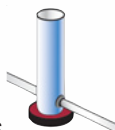
## 6 Remineralization (Mineralized Water Only)

- Minerals added for taste.



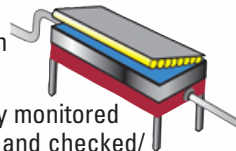
## 7 Micro-filtration

- Specialized two-stage advanced micro-filters, designed specifically for our process, filter the water.
- These filters are pharmaceutical grade and are designed to remove particles as small as 0.2 micron in diameter.
- Capable of removing microbiological contaminants.
- Filtration process monitored hourly and tested daily.



## 8 Ultraviolet Light Disinfection

- The combined effects of micro-filtration and ultraviolet light provide added assurance of product disinfection and safety.
- Process continually monitored by instrumentation and checked/monitored hourly.



## 9 Ozone Disinfection

- Highly reactive form of oxygen used to disinfect water.
- Process is monitored on an hourly basis.



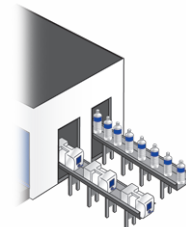
## 10 Bottling Control

- Bottling is conducted under very controlled conditions using state-of-the-art equipment.
- Each bottle is given a specific code that identifies the plant location, bottling line and time produced.
- Process monitored and tested continuously.
- Filling room and environment are of high sanitary conditions.



## 11 Packaging Control

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



## 12 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 affect total control and maximum effectiveness of the line sanitation process.



## 13 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



## 14 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.