

PRODUCTION PLANTS

VILA FLOR

In Sampaio, Vila Flor, in the heart of the Trás-os-Montes region, is located the HM-5 Bem-Saúde naturally carbonated mineral water concession and the respective factory where the FRIZE and BEM SAUDE brands are bottled.

The plant has a total filling capacity of 65,000 24cl bottles per hour and 50 million litres per year. Growth in production was accompanied by the drilling of boreholes to raise the volume of water necessary to keep pace with the growth of the FRIZE brand.

To ensure the highest levels of hygiene and quality in the production and management of the FRIZE brand, in 2003 ISO 9001:2008 Quality Management System certification was obtained for the Vila Flor plant.

The Vila Flor plant currently has 3 installed bottling lines which are as follows:

- 1 filling line for 0.25-litre TP glass containers with a capacity of 40,000 units per hour for the FRIZE Original and FRIZE Sabores brand;
- 1 filling line for TP glass containers of the following sizes:
 - 0.25l – 25,000 bottles per hour for the BEM SAUDE Original brand
 - 0.75l – 8,300 bottles per hour for the FRIZE Original brand
- 1 filling line for slim 0.25l aluminium cans with a capacity of 25,000 cans per hour for the FRIZE Original and FRIZE Sabores brand

GOUVEIA – CABEÇA DO VELHO

This production plant is located in the Serra da Estrela National Park at an altitude of around 1,200 metres.

The plant has been successively expanded and modernised in terms of industrial equipment, logistical efficiency, new bottling lines, new water capture licensing and laboratory facilities.

The plant currently has 4 installed bottling lines used to bottle SERRA DA ESTRELA MINERAL WATER which are as follows:

- 1 filling line for reusable glass containers (TR) of the following sizes:
 - 0.25l – 12,500 bottles per hour
 - 0.5l – 12,500 bottles per hour
 - 1l – 7,500 bottles per hour
- 1 filling line for PET containers of the following sizes
 - 0.33l – 19,500 units per hour
 - 0.5l – 17,500 units per hour
- 1 1.5-litre PET filling line with a capacity of 10,500 units per hour

- 1 6l-litre PET filling line with a capacity of 2,100 units per hour

The Gouveia – Cabeça do Velho plant has ISO 9001:2008 Quality Management System certification and a workforce of around 30 people.

POMBAL

SUMOL+COMPAL's Pombal production plant is located between Leiria and Coimbra and is responsible for producing the SUMOL, SEVEN UP, PEPSI, GUARANÁ ANTARCTICA and LIPTON ICE TEA brands. Its current output of liquid refreshment beverages exceeds 200 million litres per year out of a total of around 300 products.

Over recent years, the company has invested heavily in the plant with, notably, an expansion of the production facilities and installation of a Display pallet system with two palleting robots in the aim of equipping the plant with greater capacity and productive flexibility. One of the most important investments in terms of improving environmental performance was the installation of a waste water treatment facility to minimise the plant's environmental impact.

With a total footprint of around 70,000 m² and an installed capacity of 2 million litres per day, the Pombal plant currently has 10 operational filling lines and around 200 employees. The plant has ISO 9001 Quality Certification, ISO 14001 Environmental Management Systems Certification and EMAS III registration for the production of drinks. This was achieved with support from the "Economy" Operational Programme (EOP).

Attaining this certification is an important milestone for our company and our commitment to environmental management. We are the first company in the drinks sector in Portugal to obtain this recognition of excellence and transparency in environmental performance. Only 82 companies in Portugal have achieved EMAS registration to date.

ALMEIRIM

At its Almeirim plant, SUMOL+COMPAL produces juices, nectars, non-carbonated liquid refreshments, canned vegetables, tomato derivatives, tomato concentrate and fruit pulp. The plant underwent a major reorganisation and modernisation beginning in 1998 and was officially inaugurated on 7th July 2003. The investment, at over €43 million, was aimed at increasing production capacity associated with improved operability and greater quality, safety and hygiene, aspects which are intrinsic to the company's operations.

The plant has a total footprint of 40,000 m² and annual production which has grown from 75,000

to 160,000 tonnes per year. Total capacity stands at 250,000 tonnes per year. It currently has a workforce of roughly 300 people.

The plant currently has 18 production lines which are as follows:

- 9 aseptic carton filling lines
 - 5 20cl baseline carton lines: 38,000 units per hour
 - 1 33cl prisma carton line: 8,000 units per hour
 - 3 100cl prisma carton lines: 21,000 units per hour
- 2 aseptic PET filling lines
 - 1 PET 1 filling line: 14,000 units per hour
 - 1 PET 2 filling line: 24,000 units per hour
- 2 glass container filling lines
 - 1 33cl and 20cl glass container filling line: 50,000 units per hour
 - 1 20cl glass container filling line: 50,000 units per hour
- 1 canned vegetables filling line: 9,600 units per hour
- 2 fruit processing lines: 12 tonnes per hour
- 1 tomato concentrate processing line: 20 tonnes per hour
- 1 tomato concentrate squeeze tube filling line: 3,000 units per hour

This factory was one of the first in Portugal to obtain ISO 9002:1994 Quality Certification.

In 2008, the production and commercialisation of pasteurised fruit pulp in aseptic PET packaging was awarded BRC benchmark certification. Since then this has been extended and, from the beginning of 2016, all of the Almeirim plant has been certified.

BOM JESUS, ANGOLA

The SUMOL+COMPAL Angola plant is located in Bom Jesus, a commune in the municipality of Icolo and Bengo in the province of Bengo, 60 km from Luanda, the capital city.

Excellently located, the plant stands on the right bank of the Kwanza, the largest river in Angola.

The factory produces the SUMOL, COMPAL and BONGO brands and has current installed capacity of 781,440 litres per day.

It has 3 production lines:

- 2 aseptic carton packaging filling lines
- 1 can filling line

The workforce numbers around 200 employees and the plant is largely responsible for the development of the surrounding region.

SUMOL+COMPAL Angola produces 25 products locally that are market leaders in their respective segments.

BOANE, MOÇAMBIQUE

The SUMOL+COMPAL Mozambique plant in the Boane district is located roughly 35 km from the city of Maputo.

The factory acquired by SUMOL+COMPAL Mozambique is responsible for producing juices and nectars for the COMPAL and GUD brands and currently has a capacity of 30 million litres.

With a total footprint of 6,400 m², it currently has 4 aseptic carton filling lines:

- 4 aseptic carton packaging filling lines.

The factory, with a present workforce of roughly 75 employees, was one of the first plants in Mozambique to be awarded a Quality Certificate for its food safety management system based on the GFSI initiative, ISO/TS 22002 and SANS 10049