Global Red Meat Standard

Edition 5, version 5.0
versus version 4.2

Section III: Scheme requirements

The requirements have been colour coded to indicate those requirements relating to practice of production and processes and those relating to documentation and records as well as those relating to animal welfare.

	Main focus of audit shall be on practice of production and processes. Audit may include verification of the audit results by records and documentation.
	Main focus of audit shall be on documentation and records. Audit may include verification by auditing practice in the production.
	Main focus of audit shall be on animal welfare observed in practice. Audit may include verification of the audit results by records and documentation.
	Main focus of audit shall be on documentation and records in relation to the animal welfare. Audit may include verification of the audit results by auditing animal welfare practice.

1. Management System

1.1	Management responsibility and commitment	Version 4.2
1.1.1	The company shall establish a management system for quality, food safety and animal welfare. The management system shall be documented, implemented, maintained and continually improved. **(K)**	The company shall establish a documented quality management system. The quality management system shall be in accordance with the requirement in this standard.
1.1.2	The company shall identify the processes needed to ensure product safety and quality. The management system shall measure, monitor and analyse the processes and implement actions necessary to achieve planned objectives and continuous improvement.	The company shall identify and control procedures necessary to apply the quality management system throughout relevant areas of the company's activities.
1.1.3	Senior management shall ensure that all necessary resources and information in a timely manner are available to support the operation and monitoring of the processes and to ensure implementation, maintenance and improvement of the management system. Senior management shall establish a clear organisational structure, which defines and documents the job functions, responsibilities and reporting relationships for staff with management responsibility for activities which could affect product safety and quality. Documented job descriptions shall be available for all employees with management responsibility.	Top management shall ensure that all necessary resources are available. Documented job descriptions shall be available for personnel and replacement employees with management responsibility.
1.1.4	All personnel shall have responsibility to report nonconformities and potential risk related to quality and product safety to identified persons with management responsibility.	Identical
1.1.5	Senior management shall provide evidence of commitment to the development and implementation of the management system and to continually improving its effectiveness especially by communicating to the organisation the importance of meeting the requirements relating to quality, food safety and animal welfare.	New

1.1.6	The company shall have in place a Hazard Analysis and Critical Control Point system (HACCP) to demonstrate food safety management. Senior management shall appoint a team leader who, irrespective of other responsibilities, shall have the responsibility and authority to manage a HACCP team and report to management on the effectiveness and suitability of the food safety management system.	The company's food safety control shall be based on Codex Alimentarius HACCP principles and include relevant bacteriological, chemical and physical hazards.

1.2	**Food safety policy**	**Version 4.2**
1.2.1	Senior management shall establish a clear, concise and documented food safety policy and ensure that the policy is appropriate to the role of the company in the food chain, conforms to legal requirements and agreed product safety requirements of customers.	Top management shall establish a documented quality policy. The quality policy shall include: The obligation to produce products in compliance with legislation; the obligation to produce products in accordance with agreed customer requirements; and the extent of food safety control.
1.2.2	Management shall ensure that the food safety policy is understood, communicated and implemented at all levels throughout the company.	Identical
1.2.3	Management shall ensure that relevant measurable food safety objectives are monitored to validate safety of the products (section 1.7)	Identical
1.2.4	The company shall have in place defined requirements for the procurement of slaughter animals regarding control of prohibited substances such as hormones, antibiotics, medicines, heavy metals and pesticides.	New

1.3	Quality policy	Version 4.2
1.3.1	Senior management shall establish a documented quality policy. The quality policy shall include the obligation to produce products in compliance with legislation and in accordance with agreed customer requirements.	Identical
1.3.2	Management shall ensure that the quality policy is understood, communicated and implemented at all levels throughout the company.	Identical
1.3.3	Management shall ensure that relevant measurable quality objectives are monitored (section 1.7).	Identical

1.4	Environment and Working Environment Policies	Version 4.2
1.4.1	Management shall establish environmental objectives. Relevant measurable objectives shall be monitored to ensure that the environmental activities are in accordance with both legislation and company requirements, including a continuous effort to reduce the external environmental impact of the production.	Identical
1.4.2	The company shall demonstrate activities to reduce or minimise the external environmental impact. The environmental impact shall be reviewed annually and be part of the management review (section 1.7) in order to improve sustainability of the production.	Identical
1.4.3	The company shall be responsible for worker health and safety. This responsibility shall be established in an internal work safety organisation. Internal assessment of the workplaces shall be carried out at least every 3 years.	Identical

1.5	Internal audit	Version 4.2
1.5.1	The company shall have a documented internal audit system in place to cover the scope of the management system and all elements of this standard. Internal audits shall be based on the past performance of the activity and its significance in relation to quality, animal welfare and food safety.	Identical
1.5.2	Trained and independent auditors shall make at least one internal audit every 12 months to ensure that the management system conforms and complies with the requirements of this standard. Nonconformities and corrective actions shall be documented.	Identical

1.6	Verification and improvement of the Management System	Version 4.2
1.6.1	Management shall analyse the results of verification activities, especially the results of internal and external audits and results of inspections by authorities to confirm that the overall performance of the management system meets the requirements of this standard and the objectives of the company. This analysis is an input to the management review (section1.7).	New
1.6.2	Management shall ensure that the management system is continually updated by evaluating the management system at planned intervals. System updating activities shall be recorded and reported as input to the management review (section 1.7). The management system, especially the HACCP system and food safety related processes shall be reviewed in the event of any change that may impact food safety. Such a review shall evaluate the need for changes to the food safety system, including the food safety policy and food safety objectives.	Identical

1.7	Review of the Management System	Version 4.2
1.7.1	Senior management shall establish a practice for an annual review of the Management System to ensure that procedures, production processes and resources are adequate and that the system in place is still fit for purpose and continually improved.	Identical
1.7.2	The review shall at least include an evaluation of: Food safety policy and objectives (section 1.2) Quality policy and objectives (section 1.3) Environmental impact and objectives (section 1.4) HACCP system (section 4.5) Food fraud mitigation plan (section 3.1.9) Food defence plan (section 3.1.11) Audit results (section 1.6) Inspections by authorities (section 1.6) Recall procedures (section 2.10.7) Traceability system (section 2.9.11) Performance of suppliers (section 2.11.15) Cleaning performance (section 7.10.5) Consistency of supply (section 2.7.3) Complaints and customer satisfaction (section 2.8.3 and 2.7.3) Measures taken to improve animal welfare (section 6.1.3) Training activities (section 9.2.6) Updating of the management system (section 1.6 and 3.1.3) The result of the review shall be documented and include updated policies and objectives and required improvements of the management system. Management shall communicate information concerning development, implementation and updating of the management system throughout the organisation.	Identical

2. Quality System

2.1	General Requirements	Version 4.2
2.1.2	The scope of the quality system shall include all products and processes relevant to the certified production site. The company shall establish control and monitoring activities to ensure compliance with the requirement in this standard and customer requirements (section 2.3). Any agreed exclusions shall be indicated on the certificate.	Identical

2.2	Legislation	Version 4.2
2.2.1	The company shall ensure that both national and relevant international legislation in export markets are known and complied with. This includes all processes and operations having an effect on food safety and legislation in the country of manufacturing as well as the country of known destination for the products.	Identical

2.3	Customer Requirements	Version 4.2
2.3.1	The company shall ensure that customer requirements are known and that agreed requirements are complied with.	Identical
2.3.2	The company shall ensure that specific requirements agreed with individual customers regarding traceability and risk assessment of the supply chain are complied with.	New

2.4	Product specifications	Version 4.2
2.4.1	Specifications with a description of product characteristics shall be available for finished products.	Identical
2.4.2	Shelf life shall be established from data, experience, analyses or validated predictive models.	Identical

2.4.3	Shelf life data shall be available for pre-packed products.	Identical
2.4.4	Shelf life guidelines for bulk products shall be available for customers.	Identical
2.4.5	Specifications for packaging and shipping shall be available.	Identical
2.4.6	Procedures must be in place to secure correct labelling of products. Finished product shall be labelled according to the applicable food regulations in the country of intended sale. Finished products intentionally or potentially containing allergenic materials shall be labelled according to the allergen labelling regulations in the country of manufacture and/or the country of destination.	New

2.5	**Nonconforming products**	**Version 4.2**
2.5.1	All handling, disposal and control of nonconforming products shall be defined in documented procedures, including determination (root cause analysis) and implementation of corrective action in the event of any significant nonconformity. Records of actions shall be kept together with justification of the action taken. In case of systematic deviations, documented improvement activities shall be initiated.	Identical
2.5.2	Products that do not comply with product specifications or do not conform to the monitoring results shall be identified.	Identical
2.5.3	The company shall prepare and implement appropriate product hold and release procedures for nonconforming products.	Identical
2.5.4	An appointed member of staff shall assess nonconforming products. If appropriate, the customer shall be involved in the assessment.	Identical

2.6	Product Development	Version 4.2
2.6.1	A procedure for the implementation of new products and processes or changes of existing products and processes shall be in place.	Identical
2.6.2	Product formulation, manufacturing processes and the fulfilment of product specification shall have been ensured by factory trials and product evaluation.	Identical
2.6.3	The product and processes shall be incorporated in the HACCP-system before production of final products (intended for sale) takes place.	Identical

2.7	Sales	Version 4.2
2.7.1	When an order is placed, the execution of that order shall be incorporated into production planning according to agreed order.	Identical
2.7.2	Customers shall be notified of any changes made to the agreed order.	Identical
2.7.3	The consistency of supply and levels of customer satisfaction shall be regularly monitored. The results of this monitoring shall be included in the management review (section 1.7).	Identical

2.8	Complaints procedures	Version 4.2
2.8.1	The company shall have a procedure for handling complaints and complaints data to control and correct shortcomings in quality and product safety. The customer shall be informed on the result of the handling of the claim.	Identical
2.8.2	Complaints shall be assessed by an appointed member of staff.	Identical

2.8.3	Management shall evaluate complaint data to identify any problem related to the management system and to identify possibilities of improvement. This evaluation shall be included in the management review (section 1.7).	Identical

2.9	**Traceability**	**Version 4.2**
2.9.1	The slaughterhouse shall maintain a traceability system, enabling tracing and tracking of products to a group of primary producers. **(K)**	Identical
2.9.2	All slaughter animals delivered shall be identified with a unique supplier number. Alternatively, another method for securing traceability to the supplier shall be implemented.	Identical
2.9.3	All carcases shall be identified by a slaughter number, which can be traced to a supplier number and the time of delivery.	Identical
2.9.4	The company shall maintain a traceability system enabling tracing and tracking (one step forward and one step backwards) of ingredients, packaging, nets or similar material in direct contact with food at batch level.	New
2.9.5	The company shall establish, implement and maintain appropriate procedures and systems to ensure identification of in-process material, final product and packaging throughout the production process.	Identical
2.9.6	The company shall establish, implement and maintain appropriate procedures and systems to ensure a record of purchaser and delivery destination for all meat products.	New
2.9.7	Finished products shall be marked with an identification (establishment) number and a lot or date mark.	Identical

2.9.8	Where the product has a specific provenance claim it shall be possible to verify the source of the provenance claim; either through verification of the traceability system or verification of the methods of identification used at the production site.	New
2.9.9	Traceability of all edible parts of the carcass shall be maintained until the carcass is deemed fit for human consumption, which includes blood for human consumption.	Identical
2.9.10	An annual test and evaluation of the traceability system shall be carried out and documented. This evaluation shall be included in the management review (section 1.7).	Identical

2.10	**Product Withdrawal and Recall procedures**	**Version 4.2**
2.10.1	The company shall have a documented procedure for handling, reporting and assessment of incidents, which leads to a product withdrawal or recall.	Identical (except specific requirement for the procedure to be documented).
2.10.2	The company shall appoint a Crisis Group responsible for dealing with incidents, which may lead to a product withdrawal or recall. The group shall be contactable all the time (24 hours a day).	Identical
2.10.3	Any affected products shall be traced, located and identified both internally and externally.	Identical
2.10.4	In the event of a product recall, the authorities shall be informed in due time.	Identical
2.10.5	In the event of a product recall, the Certification Body issuing the current certificate for the site against GRMS shall be informed within three working days of the decision to issue a recall.	Identical
2.10.6	Any course of action taken, which has led to a product withdrawal or recall, shall be documented.	Identical

2.10.7	An annual test and evaluation of product withdrawal and recall procedures shall be carried out and documented. This evaluation shall be included in the management review (section 1.7).	Identical

2.11	**Purchasing**	**Version 4.2**
2.11.1	The company shall establish, implement and maintain appropriate procedures and systems to ensure an identification of any outsourced production, inputs or services related to food safety.	New
2.11.2	Documented specifications shall be available for all products, materials and services purchased or provided which have an effect on quality or product safety. A defined specification review process shall be in place.	New
2.11.3	A catalogue of meat suppliers to the production site shall be available and it shall be registered which species are delivered by each supplier. Suppliers of raw/fresh meat shall be certified by a GFSI approved standard. If suppliers of raw/fresh meat are not meeting this requirement, specific requirements for raw/fresh meat purchase shall be defined and documented.	New
2.11.4	The origin of all slaughter animals shall be known. **(K)**	Identical
2.11.5	Production of slaughter animals shall be in accordance with a Good Agricultural Practice programme, which for pig production shall include a risk based surveillance programme for Salmonella.	Identical
2.11.6	Suppliers of slaughter animals shall receive continuous feedback on quality aspects and health status of their animals.	Identical
2.11.7	Ingredients, packaging and other materials shall be purchased from approved suppliers in compliance with purchasing specifications. A catalogue of approved suppliers shall be available.	Identical

2.11.8	Use of non-approved suppliers shall be acceptable on a specific delivery provided that the facility of the supplier has been assessed and the supply meets the specification. Any use of non-approved suppliers shall be subject to specific criteria that apply to the specific delivery and traceability shall be ensured.	New
2.11.9	Contracts shall be in place for hauliers, external storage facilities, pest controllers, cleaning contractors and laundry suppliers.	Identical
2.11.10	Transport of meat and meat products shall be subject to specific requirements regarding hygiene and temperature.	Identical
2.11.11	Any process equipment, materials or packaging that come into contact with the meat shall be approved or certified for use in the production of food for human consumption.	Identical
2.11.12	Approval of suppliers shall be based on a documented risk assessment. Special attention should be placed on evaluating risk of fraud. Externally sourced materials and services, which have an effect on food safety shall be identified and conform to food safety requirements, including food fraud mitigation plan requirements.	New
2.11.13	Quality requirements to the supplier shall be based on company requirements and experience with the particular supplier.	Identical
2.11.14	The performance of suppliers shall be continually reviewed. The results of evaluations, investigations and follow up actions shall be recorded. The need for supplier audits shall be based on experience of the product or service and risk assessment. This evaluation shall be included in the management review (section 1.7).	Identical

2.12	Control of documentation and records	Version 4.2
2.12.1	All documents in the management system shall be comprehensive and approved.	Identical
2.12.2	All documents in the management system shall be controlled and uniquely identified including relevant documents of external origin.	Identical
2.12.3	All documents in the management system shall be updated whenever necessary.	Identical
2.12.4	Documents shall be securely stored and readily accessible when needed. Documents shall be accessible at relevant points throughout the company, and remain legible and readily identifiable.	Identical
2.12.5	Unintended use of obsolete documents shall be prevented. Obsolete documents shall be identified as such and kept for a minimum of 3 years.	Keeping time 2 years
2.12.6	Records shall be kept for a defined time (minimum 1 year) in accordance with the shelf life of the products. A back-up system with defined frequencies shall be in place for electronic records. All records shall be properly kept to avoid loss and changes.	Identical
2.12.7	Only authorised personnel may alter records. Original records shall not be deleted.	Identical
2.12.8	The person recording or altering records shall sign and date the alteration in question. A password is required for electronic recording.	Identical

3. Food safety system

3.1	General requirements	Version 4.2
3.1.1	The scope of the food safety system shall include all products and processes relevant to the certified production site. The company shall establish, implement and maintain documented and detailed procedures and instructions for all processes and operations having an effect on food safety. Any agreed exclusions shall be indicated on the certificate.	Identical
3.1.2	The company shall evaluate and update the food safety system to ensure that the system reflects the activities of the company and incorporates the most recent information on the food safety hazards subject to control (section 4). The evaluation shall be included in the management review (section 1.7).	Identical
3.1.3	Where the company chooses to outsource any process that may affect product safety or end product conformity, the company shall ensure control over such processes. Control of such outsourced processes shall be documented within the management system.	New
3.1.4	The company shall have a documented procedure to ensure that any product, which does not conform to food safety requirements, is clearly identified and controlled to prevent unintended use or delivery.	Products that do not comply with product specifications or do not conform to the monitoring results shall be identified
3.1.5	The company shall have procedures to manage potential emergency situations and accidents that can impact food safety, including fire and disruptions of water and energy supplies.	Identical
3.1.6	Procedures shall be in place to manage unforeseen hazards (sabotage, vandalism, natural disasters etc.).	Identical
3.1.7	Procedures shall be in place to control the risk of allergens. This shall include risk assessment of allergen cross contact and implemented controls to reduce or eliminate the risk of cross contact. Risk assessment of allergens shall be included in the Hazard Analysis.	New

3.1.8	The company shall make a documented food fraud vulnerability assessment and identify and address food fraud vulnerabilities related to public health risk in a Food Fraud Mitigation Plan.	New
3.1.9	The company shall have a documented Food Fraud Mitigation Plan in place to mitigate the public health risks from the identified food fraud vulnerabilities. The Food Fraud Mitigation Plan shall be supported by the management system (section 1.7).	New
3.1.10	The company shall perform a documented assessment of threats related to food safety. The identified issues shall be addressed in a Food Defence Plan that specifies the measures the company has implemented to mitigate the public health risks from the identified food defence threats.	New
3.1.11	The company shall have a documented Food Defence Plan in place to minimize the identified threats. The Food Defence Plan shall be supported by the management system (section 1.7).	New
3.1.12	The company shall communicate appropriate information throughout the food chain regarding safety issues related to its products, in particular in relation to product information, contracts and order handling.	New

4. HACCP System

4.1	General Requirements	Version 4.2
4.1.1	Food safety control shall be based on Codex Alimentarius HACCP principles and include relevant bacteriological, chemical and physical hazards, including allergens. The system shall be systematic, comprehensive and thorough. The system shall include PRP (prerequisite programme).	Identical
4.1.2	The scope of the HACCP system shall be defined per product or product category and per process line or process-location. Hazards relevant to food safety shall be controlled in critical control points (CCP) and/or by PRP measures.	Identical
4.1.3	Current risk assessments from industry organisations or other similar sources shall form the scientific and/or technical foundation. The HACCP system shall be capable of accommodating change, such as advances in equipment design, processing procedures or technological developments.	Identical

4.2	HACCP team	Version 4.2
4.2.1	The management shall create a HACCP team consisting of representatives from management, and from departments responsible for production, quality, food safety and engineering. The HACCP team shall ensure that representatives with relevant knowledge are included in the team when required.	Identical
4.2.2	The HACCP team leader shall possess competent HACCP knowledge.	Identical
4.2.3	The HACCP team members shall receive training in the HACCP principles.	Identical

4.2.4	The HACCP team shall establish the requirements for HACCP and PRP control. The quality department participates whenever required.	Identical
4.2.5	The HACCP team shall document meetings in protocols or minutes.	Identical

4.3	**Hazard Analysis**	**Version 4.2**
4.3.1	A hazard analysis shall be carried out for all processes/product lines or product/product category and should be based on the following elements: **(K)** - Description of materials and products, including meat, ingredients, packaging specifications, product specifications, working instructions and packing instructions - Identification of intended use of the product, including consideration of consumers particularly susceptible to certain food hazards - Flow diagrams for processes, including returned products and re-work if relevant - Identification and assessment of severity of consequences and likelihood of occurrence for all known bacteriological, chemical and physical hazards	Identical
4.3.2	The HACCP team shall verify the accuracy of the flow diagrams used in the hazard analysis by on-site audit at least annually. The verification shall be documented.	Identical
4.3.3	The company shall ensure that allergenic ingredients are known and that the risk of cross contamination is assessed.	Identical

4.4	Control of Critical Control Points (CCPs)	Version 4.2
4.4.1	Relevant hazards shall be controlled in CCPs, which shall be identified using a systematic method. The control of CCPs shall be documented in a HACCP plan.	Identical
4.4.2	Each CCP shall include a definition of method and frequency of monitoring, identification of personnel responsible for monitoring and a definition of records to be kept.	Identical
4.4.3	Control measures shall be in place for all relevant hazards to prevent or eliminate the risk or reduce it to an acceptable level.	Identical
4.4.4	Relevant parameters shall be selected for monitoring every CCP and these must be capable of demonstrating the conformity of the control measure.	Identical
4.4.5	A critical limit shall be established for monitoring parameters to ensure hazards are eliminated or reduced to an acceptable level.	Identical
4.4.6	For each CCP, specific corrective actions shall be in place, which come into force when the monitoring system shows results exceeding the critical level. The person responsible for corrective action shall be identified.	Identical
4.4.7	Corrective actions shall be recorded, including actions taken for products produced during the deviation, according to requirement in section 2.5. **(K)**	Identical

4.5	Maintaining the HACCP system	Version 4.2
4.5.1	The company shall determine verification and validation activities. Documented activities shall ensure the function of the control measures and that the extent of monitoring is appropriate and adequate. The results of the activities shall be recorded. The HACCP system shall also be reviewed in the event of any change that could impact food safety.	Identical
4.5.2	The HACCP system shall be re-assessed annually to ensure that the system is appropriate and adequate. The HACCP team shall evaluate relevant aspects, including improvements that may have an influence on food safety. The results of the evaluation shall be recorded. The evaluation shall be included in the management review (section 1.7).	Identical

5. Production site standards

5.1	Access	Version 4.2
5.1.1	The company shall maintain controlled access to prevent unauthorised entry.	Identical

5.2	External Areas	Version 4.2
5.2.1	The factory area shall be clearly identified, and it must be located and maintained to prevent contamination from the environment and enable the production of safe products.	The factory area shall be clearly identified.
5.2.2	The surface of external areas shall be consolidated and properly drained.	Identical
5.2.3	Vegetation on external areas shall be kept to a minimum and clear from the buildings. Vegetation must not provide a habitat for rodents.	Identical
5.2.4	External areas shall be kept tidy to minimise the risk of pests.	Identical

5.3	Staff facilities	Version 4.2
5.3.1	The company shall provide changing facilities with lockers, showers and toilets.	Identical
5.3.2	Smoking and eating is prohibited outside designated areas.	Identical
5.3.3	The company canteen facilities shall have a self-assessment programme.	Identical
5.3.4	The company shall provide temperature monitored refrigerators for storing lunch boxes.	Identical
5.3.5	Staff facilities shall be designed and operated so as to minimise food safety risks. Canteens and staff facilities shall be kept clean and tidy.	Canteens and staff facilities shall be kept clean and tidy

5.4	Buildings, facilities and process equipment	Version 4.2
5.4.1	Buildings and facilities shall be suitable for the intended purpose. Production areas and process equipment shall not pose any risk of contamination and shall be maintained and easy to clean.	Fabrication of site, buildings and facilities shall be suitable for the intended purpose.
5.4.2	Equipment shall be suitably designed for the intended purpose and shall be used and stored so as to minimise food safety risk.	Production areas and process equipment shall not pose any risk of contamination and shall be easy to clean. Equipment shall be stored in a hygienic manner.
5.4.3	Plans showing the flow of materials, products, waste and human traffic through the company shall be available.	Identical
5.4.4	Facility design, construction, layout and product flow shall minimise the risk of product contamination.	New
5.4.5	Building plans showing water and waste pipes shall be available.	Identical

5.4.6	Water (including steam and ice) used shall be potable or approved by the authorities for the intended use, and subject to regular microbiological and chemical analysis.	Identical
5.4.7	The company shall perform planned maintenance for process equipment, buildings and external areas.	Identical
5.4.8	Production of high-risk products shall be in designated areas to prevent the risk of cross-contamination.	Identical
5.4.9	Safety measures shall be taken to avoid reflux in water pipes and access by rodents in waste pipes.	Identical
5.4.10	Adequate facilities for hand washing and hand disinfection shall be provided at the entrance to production area.	New
5.4.11	Opening windows in production and adjacent rooms shall be fitted with nets to avoid entrance of pests.	Identical
5.4.12	All doors shall be kept closed and, if necessary, secured to prevent access by pests.	Identical
5.4.13	Production rooms shall be kept tidy and clean.	Identical
5.4.14	Rooms and areas adjacent to production rooms, including the maintenance department, storage and depot rooms shall be kept tidy and clean.	Identical
5.4.15	Condensation shall not present a risk of contamination.	Identical

5.5	Foreign materials	Version 4.2
5.5.1	The company shall have a procedure in place for controlling relevant foreign materials.	Identical
5.5.2	The company shall have a documented procedure in case of glass or hard plastic breakages. Products affected by breakages shall be subject to non-conformance procedures in compliance with section 2.5.	Identical
5.5.3	Windows in production and storage rooms posing a risk of product contamination shall be secured against breakage.	Identical
5.5.4	Lights and flytraps posing a risk of product contamination shall be secured against breakage.	Identical
5.5.5	Glass and hard plastic posing a risk within production, storage and changing rooms shall be registered and checked regularly.	Identical

5.6	Pest Control	Version 4.2
5.6.1	An authorised contractor shall carry out relevant pest control. The frequency of inspections shall be determined by risk assessment. Clearly defined responsibilities shall be established between the contractor and site management.	An authorised contractor shall carry out relevant pest control
5.6.2	The position of baits and flycatchers shall be identified on building plans.	Identical
5.6.3	The activity and/or capture of insects and rodents shall be recorded. Identified lack in pest proofing shall be recorded and there shall be a documented follow up.	Identical

5.6.4	In the event of infestation, or evidence of indoor pest activity, immediate action shall be taken to identify products at risk and to stop infestation. Any affected products shall be subject to the non-conforming product procedure (section 2.5). Indoor pest activity and stop of activity must be documented.	New

5.7	**Waste**	**Version 4.2**
5.7.1	Waste (of animal origin) not approved for human consumption shall be stored in closed rooms/silos/containers.	Identical
5.7.2	Waste, plastic and cardboard shall be stored in closed containers and regularly collected by authorised contractors.	Identical
5.7.3	Waste (of animal origin) not approved for human consumption including Specified Risk Material (SRM) shall be categorised according to type of waste and regularly collected by authorised waste disposal contractors.	Identical

5.8	**Handling of products**	**Version 4.2**
5.8.1	The company shall prepare and implement appropriate product release procedures, including procedures for re-work in relation to nonconforming products.	New
5.8.2	Appropriate facilities and procedures shall be in place to control the risk of physical, chemical or biological contamination of product. Any handling of products shall not pose a contamination risk. This includes the use of processing aids.	Identical
5.8.3	Procedures shall be in place to ensure meat, ingredients and packaging materials are used in the correct sequence and within the allocated shelf life.	Identical

5.8.4	Procedures for handling of products (including rework) shall be in place whenever a specific labelling claim is made.	Identical
5.8.5	Handling and storage of products containing allergens (including rework) shall be carried out so as to prevent cross contamination.	Identical
5.8.6	A procedure must be in place to avoid cross contamination in case of handling of meat or meat derivate from different animal species in the production. The production site shall have a list of meat based raw materials showing the content of different meat species.	A procedure must be in place to avoid cross contamination in case of handling meat or meat derivate from different animal species in the production.
5.8.7	Where high-risk products are manufactured, procedures shall be in place to control meat, ingredients, equipment, packaging, environment and personnel to prevent product contamination **(K)**	Identical
5.8.8	Where high-risk products are manufactured, there shall be physical segregation between processing areas and other areas, especially including finished handling areas.	Identical
5.8.9	Received meat, ingredients and packaging materials shall be inspected for quality and hygiene deviations. The inspection shall be recorded.	Identical
5.8.10	Temperature for received chilled and frozen products shall be recorded.	Identical
5.8.11	All meat, ingredients and packaging materials not being in process shall be covered or stored to prevent contamination risks.	Identical
5.8.12	Packaging materials coming into contact with meat shall be covered when not in process to prevent contamination risks.	Identical
5.8.13	Transport packaging shall be kept away from areas with unpacked meat, meat products and ingredients or stored at a suitable distance to prevent contamination risks.	Identical
5.8.14	The identification of meat, ingredients and finished products shall be unique.	Identical

6 Animal welfare

6.1	Animal welfare – general requirements	Version 4.2
6.1.1	The company shall have a designated animal welfare officer who is trained to supervise all matters/conditions relating to the welfare of animals. The animal welfare officer shall report directly to the company's management.	Identical
6.1.2	Animals shall be spared any discomfort, pain or injury, fear or distress and have the ability to express normal behaviour during transport, intake, lairage and movement to killing. **(K)**	Animals shall be spared any avoidable pain, distress or suffering during their killing and related operations
6.1.3	The company shall keep records of the measures taken to improve animal welfare. Evaluation of these records shall be included in the management review (section 1.7).	The company shall keep records of the measures taken to improve animal welfare

6.2	Animal welfare – transport and unloading	Version 4.2
6.2.1	Slaughter pigs (excluding sows and boars) shall be delivered to the abattoir directly from the primary producer. Food chain information or equivalent must be available for all deliveries.	Slaughter pigs shall be delivered to the abattoir directly from the primary producer.
6.2.2	Only animals fit for transport must be transported.	Identical
6.2.3	For transport vehicles, a documented procedure shall be in place in case of a breakdown.	Identical
6.2.4	The company shall only use hauliers and vehicles approved for animal transport for delivery of animals for slaughter.	Identical
6.2.5	The company shall perform spot checks on deliveries of animals for slaughter to ensure that space requirements have been met.	Identical

6.2.6	Transport time shall be kept at a minimum. Transport time shall be recorded for each delivery and transport time shall not exceed 8 hours.	Identical
6.2.7	Animal welfare shall be inspected by an 'ante mortem' inspector during unloading and lairage. If an animal shows signs of disease or injury, a Veterinary Officer shall decide whether the animal should be killed immediately or transferred to a special sick pen.	Identical
6.2.8	Cleaning and disinfection of transport vehicles shall be monitored and documented via spot checks.	Identical

6.3	**Animal welfare – lairage, stunning and killing**	**Version 4.2**
6.3.1	Lairage facilities shall be designed, constructed and maintained, so as to safeguard the welfare of the animals at any given time. The ramp shall be flexible and the angle must be maximum 20 degrees. There shall be a sprinkler system in the lairage to be used in warm weather. The lairage must be well ventilated.	Lairage facilities shall be designed, constructed and maintained, so as to safeguard the welfare of the animals at any given time.
6.3.2	Maximum lairage capacity shall be defined.	Identical
6.3.3	Sick pens shall be available for immediate use upon arrival at the abattoir.	Identical
6.3.4	The company shall ensure that no animal for slaughter is slaughtered before a Veterinary Officer/Inspector has performed 'ante mortem' inspection and approved the animal for slaughter.	Identical
6.3.5	The company shall inspect animals in the lairage regularly. Animal welfare at unloading, in the lairage and during movement to stunning must be observed in daily spot checks, which must be documented.	The company shall inspect animals in the lairage regularly.

6.3.6	All animals for slaughter shall have access to fresh water. Animals kept in the lairage for more than 12 hours shall be fed.	Identical
6.3.7	Lactating cows shall be milked at intervals of no more than 12 hours.	Identical
6.3.8	No slaughter must be carried out without prior stunning of the animals	Identical
6.3.9	Handling of animals prior to slaughter shall not compromise animal welfare: - use of electric goads shall only be allowed when moving the animals into the final stunning area; - electric goads shall only be used on the rear of the animal, and when the animal can move forward; and - stunning and killing equipment shall be designed, built and maintained to prevent injury or lesions to the animals.	Identical
6.3.10	A documented procedure shall be in place to control the effectiveness of the stunning/killing equipment. This shall be performed as a documented spot check using two parameters, and include checking after stunning and after bleeding. Control and measures undertaken in the event of insufficient stunning/killing shall be recorded.	Identical
6.3.11	Stunning systems using stunning gas shall have alarms in place if the concentration of stunning gas should fall below a defined limit. The alarm must be regularly checked.	New
6.3.12	A back-up system for stunning animals shall be available in the stunning area.	Identical
6.3.13	Sticking shall be carried out in a continuous process and the animals shall remain fully unconscious until death from bleeding. Operators shall be trained in observing any signs of consciousness.	Identical
6.3.14	A maintenance programme shall be in place for the stunning/killing equipment. Maintenance carried out shall be recorded.	Identical

7. Process Management and Production Monitoring

7.1	General requirements	Version 4.2
7.1.1	Grading of carcases shall be based on an official method.	Identical
7.1.2	Process and work descriptions including packing requirements shall, where necessary, form the basis of all work undertaken.	Identical
7.1.3	The maximum time allowed from slaughter to start of the chilling process shall be defined. Time and temperature requirements for chilling of the carcass shall be defined.	New
7.1.4	Rooms that require cooling shall have a temperature control system and be fitted with an alarm system.	Identical
7.1.5	Sterilisation equipment including automated machinery shall be monitored. The monitoring must be documented.	Identical
7.1.6	Waste shall regularly be removed from the production process without posing a contamination risk.	Identical

7.2	Slaughter	Version 4.2
7.2.1	A procedure must be in place to avoid cross contamination in case of slaughter of different animal species at the same slaughter line.	Identical
7.2.2	An emergency procedure shall be in place in case of a breakdown on the slaughter line before the point of evisceration.	Identical
7.2.3	Faecal contamination shall be removed on the slaughter line. Alternatively, the carcass shall be dressed on a separate line.	Identical

7.2.4	The company shall ensure that an official Veterinarian Officer/Inspector inspects all parts of the slaughter animal (“post mortem inspection”) to ensure that it is fit for human consumption.	Identical
7.2.5	Health data of the individual animal shall be recorded at the slaughter line and informed to the animal supplier.	Identical
7.2.6	Knives and tools shall be sterilised between each carcass prior to approval of the carcass for human consumption (“post mortem inspection”).	Identical
7.2.7	The cooling and equalisation processes shall be defined, monitored and recorded.	Identical

7.3	**Primal cutting, deboning and packing**	**Version 4.2**
7.3.1	Prior to primal cutting, carcases shall be visually inspected for any slaughtering or hygienic deviations. Temperatures shall be recorded via spot checks. In case of hot or warm cutting and deboning a procedure shall be in place to ensure proper chilling of products.	Identical
7.3.2	The conformity of product shall be continuously ensured during the deboning process. Procedures shall be in place to avoid cross contamination with other species.	The conformity of product shall be continuously ensured during the deboning process.
7.3.3	Finished products shall be subject to a documented quality inspection, which in case of pre-packed products, shall include labelling, weight and count checks. The inspection of pre-packed products shall be recorded.	Identical
7.3.4	Where the control of packing parameters (vacuuming, packed under controlled atmosphere, leakers) is essential to ensure product safety and shelf-life, such parameters shall be monitored.	Identical
7.3.5	Before dispatch, product temperatures shall be checked and recorded in every shipment.	Identical

7.4	**Offal (fresh meat other than the carcase, including viscera and blood)**	**Version 4.2**
7.4.1	Offal shall originate from animals that have passed the official post-mortem inspection.	Identical
7.4.2	Offal shall be inspected for any slaughtering and hygiene deviations.	Identical
7.4.3	Where the control of process parameters (temperature, salting) is essential to ensure product quality and food safety, such parameters shall be monitored and recorded. Procedures shall be in place to avoid cross contamination with other species.	Where the control of process parameters (temperature, salting) is essential to ensure product quality and food safety, such parameters shall be monitored and recorded.
7.4.4	Offal shall where necessary be subject to an approval before release/dispatch. **(K)**	Identical
7.4.5	Finished products shall be subject to a documented quality inspection, which in case of pre-packed products, shall include labelling, weight and count checks. The inspection of pre-packed products shall be recorded.	Identical
7.4.6	Before dispatch of chilled or frozen products, product temperature shall be checked and recorded in every shipment. Alternatively, product temperature can be documented by temperature monitoring systems.	Before dispatch of chilled or frozen products, product temperature shall be checked and recorded in every shipment.

7.5	**Minced meat, meat preparations and meat products**	**Version 4.2**
7.5.1	Where control of process parameters is essential to ensure product quality and food safety, such parameters shall be monitored and recorded. **(K)**	Identical
7.5.2	Finished products shall be subject to a documented quality inspection, which in case of pre-packed products, shall include labelling, weight and count checks. The inspection of pre-packed products shall be recorded. Procedures shall be in place to avoid cross contamination with other species.	Finished products shall be subject to a documented quality inspection, which in case of pre-packed products, shall include labelling, weight and count checks. The inspection of pre-packed products shall be recorded.

7.5.3	Where the control of packing parameters (vacuuming, packed under controlled atmosphere, leakers) is essential to ensure product safety, such parameters shall be monitored.	Identical
7.5.4	Before dispatch, the temperature of products shall be checked and recorded for every shipment.	Identical

7.6	**Chilling and freezing storage**	**Version 4.2**
7.6.1	The chilling and freezing process shall be defined and monitored. Freezing processes shall be validated by temperature loggers measuring the temperature in the centre of products. For cartons on pallet the logger shall be placed in the centre of a carton placed at the middle of the pallet.	New
7.6.2	Temperature of chillers and freezers shall be defined and monitored on-line with temperature logging at least twice per hour. Records shall be kept for minimum 2 years.	Identical
7.6.3	An alarm shall be activated if the temperature exceeds a defined limit.	Identical
7.6.4	Temperature monitoring shall be assessed and approved on a daily basis.	Identical

7.7	**Product analyses**	**Version 4.2**
7.7.1	Laboratory analyses shall be carried out using recognised methods. Laboratories shall be part of documented inter-calibration (ring test) or hold an accreditation according to ISO/IEC 17025. Measurement values shall be expressed in SI-units. If specific sampling methods for a testing procedure are required by regulation or contract, such sampling methods shall be based on International Standards (ISO), whenever possible.	Laboratory analyses shall be carried out using recognised methods. Laboratories shall be part of documented inter-calibration (ring test) or hold an accreditation according to ISO/IEC 17025.

7.7.2	A risk based Salmonella surveillance programme shall be in place for slaughter animals (pigs). Producers shall receive continuous feedback on the Salmonella level.	Identical
7.7.3	A risk based Salmonella monitoring of carcases (pigs) shall be in place.	Identical
7.7.4	Slaughter hygiene shall be monitored continually via swab testing. The samples shall be analysed for at least total viable count and faecal bacteria.	Identical
7.7.5	The company shall perform random sampling for presence of residues in accordance with industry codes and/or surveillance programme.	Identical
7.7.6	The results of antibiotic and chemotherapeutic analysis shall be available.	Identical
7.7.7	A risk based Trichinella surveillance program shall be in place for slaughter pigs and horses.	Identical
7.7.8	A risk based BSE surveillance programme shall be in place for cattle in accordance with national legislation and at least OIE requirements. **(K)**	Identical
7.7.9	A risk based TSE surveillance programme shall be in place for lamb, sheep and goat meat production in accordance with national legislation. **(K)**	Identical
7.7.10	Microbiological analysis of products shall be performed to monitor the production process.	Identical
7.7.11	Where validation of finished product attributes is required, chemical, microbiological or sensory tests shall be carried out in accordance with product specifications.	Identical
7.7.12	Where more species are handled test shall verify that contamination with other species do not occur.	New

7.8	Transport vehicles	Version 4.2
7.8.1	All containers and vehicles (including contracted out vehicles) used for the storage and transportation of meat, ingredients, packaging materials and products shall be suitable for the purpose and maintained in good repair and be clean.	New
7.8.2	Company vehicles and contracted transport vehicles shall be equipped with a temperature log for chilled/frozen products.	Identical
7.8.3	The hygiene standards of transport vehicles shall be monitored and recorded at delivery/dispatch.	Identical
7.8.4	For company and contracted transport vehicles, a documented procedure shall be in place in case of a breakdown in vehicles, equipment or chilling systems.	Identical

7.9	External storage	Version 4.2
7.9.1	Intake, storage and dispatch conditions shall be documented. Products shall be stored and transported under conditions, which minimise the potential for microbial, chemical or physical contamination.	Intake, storage and dispatch conditions shall be documented.
7.9.2	The external storage company shall be obliged to inform the company in case of refrigeration/freezing deviations. The company shall notify the customer if necessary.	Identical

7.10	Cleaning	Version 4.2
7.10.1	Cleaning shall be made according to documented standards. The cleaning programme shall include frequency and a description of cleaning and disinfection materials used.	The cleaning programme shall include frequency and a description of cleaning and disinfection materials used.
7.10.2	Cleaning shall be carried out according to contract or job descriptions and be maintained at all times and throughout all stages of production.	Cleaning shall be carried out according to contract or job descriptions.
7.10.3	Cleaning materials shall be suitable for their intended use and stored appropriately.	New
7.10.4	The cleaning shall be visually inspected and approved before start up. The inspection shall be recorded. Results from the inspection shall be communicated to the cleaning personnel and, if contracted out, to the cleaning company.	Identical
7.10.5	The cleaning standard shall be verified and recorded periodically based on a testing programme, including at least TVC and Enterobacteriacea. Results from the tests shall be communicated to the cleaning personnel and, if contracted out, to the cleaning company. The verification and evaluation of cleaning shall be included in the management review (section 1.7).	The cleaning standard shall be verified and recorded periodically based on a testing programme. Results from the tests shall be communicated to the cleaning personnel.

8. Monitoring equipment

8.1	Measuring devices	Version 4.2
8.1.1	The company shall determine types of measuring equipment including the accuracy necessary to ensure control and monitoring.	Identical
8.1.2	Measuring equipment shall be protected against damage.	Identical

8.1.3	Measuring equipment shall be clearly identified and the calibration status shall be known.	Identical

8.2	**Calibration**	**Version 4.2**
8.2.1	Measuring equipment shall be calibrated within the full range of the scope.	Identical
8.2.2	Measuring and monitoring devices shall be calibrated traceable to a recognised standard. Calibration results shall be recorded against a norm.	Identical
8.2.3	Only qualified staff may calibrate measuring equipment.	Identical
8.2.4	If measuring equipment falls out of calibration and the deviation has direct impact on quality or food safety, corrective actions shall be taken (section 2.5).	Identical

9. Personnel, External Labour and Visitors

9.1	**Hygiene regulations**	**Version 4.2**
9.1.1	Documented personal hygiene standards and hygiene regulations based on risk of product contamination shall be in place.	Identical
9.1.2	The company shall have procedures in place to ensure that all external labour follow the hygiene regulations.	Identical
9.1.3	All personnel shall address hygiene precautions, especially when they enter a higher hygienic level.	Identical

9.1.4	A documented procedure for health information shall be in place. If in accordance with national legislation medical screening procedures shall be in place to identify conditions impacting food safety. Employees are obliged to notify the management in the event of any illness, which may pose a risk to food safety.	Employees are obliged to notify the management in the event of any illness, which may pose a risk to food safety.
9.1.5	Before gaining access to production areas, visitors and external personnel shall provide information on their health status.	Identical
9.1.6	The company shall provide suitable and appropriate work clothing and protective clothing. Work clothing and protective clothing may not pose a risk of product contamination.	Identical
9.1.7	Outside stay in working clothes is prohibited.	Identical
9.1.8	Visitors and external personnel shall be dressed in appropriate clothing before entering production areas.	Identical

9.2	**Training**	**Version 4.2**
9.2.1	The company shall ensure that all employees are adequately trained, instructed and supervised in food safety principles and practices, commensurate with their activity.	New
9.2.2	New employees coming into contact with products shall be informed of the company's hygiene regulations. Employees shall complete a course on hygiene within the first 4 months of employment. This shall be documented.	Identical

9.2.3	When commencing a new work operation, the employee shall be trained and monitored until the employee is familiar with the working procedures. All training shall be documented.	Identical
9.2.4	Employees handling animals from unloading to sticking shall complete an animal welfare competence course and pass a test to get a competence certificate. Hauliers handling animals for slaughter shall complete an animal welfare training course from an acknowledged training institution.	Hauliers handling animals for slaughter shall complete an animal welfare training course from an acknowledged training institution.
9.2.5	Employees shall be offered relevant further training on an on-going basis.	Identical
9.2.6	The company shall identify needs for training and resources needed to implement planned training activities. Evaluation of effectiveness of training activities shall be included in the management review (section 1.7)	New