

Global Red Meat Standard



version 7 versus version 6.1
01-10-2025

Introduction (section I), audit protocol (section II) and certification programme management (section IV)

	Version 7	Version 6.1
Scope	Processes: Transport, lairage, slaughter, grading, evisceration, chilling, cutting, deboning, trimming, washing, curing, marinating, mincing, mixing, fermentation, smoking, drying, cooking, packing, packing in modified atmosphere, vacuum packing, freezing, freezing storage. Products: Fresh meat, meat products, meat preparations, mixed products and edible by-products.	Processes: Transport, Lairage, slaughter, grading, evisceration, chilling, cutting, deboning, trimming, washing, curing, marinating, mincing, mixing, fermentation, smoking, cooking, packing, packing in modified atmosphere, vacuum packing, freezing, freezing storage. Products: Fresh meat, meat products, meat preparations, mixed products and edible by-products.
Audit duration	The onsite audit duration is expected to be at least two days to assess an organisation's systems and premises against the GRMS and provide trust in the certification process. Reduction in the audit duration shall be justified based in e.g. if head office is audited, activities, products, scope, size of the production site, significant changes, food safety or animal welfare incidents and the results of previous audits. Typical minimum audit duration related to activities and scope are: Head office (separate audit): 0,5 day. Slaughterhouse without cutting and deboning: 1,5 days. Casing facility: 0,5 day	The audit duration is normally minimum 2 days for a production site including central office and reporting time. Typical audit duration (including central office and reporting) for different type of production: Slaughterhouse with cutting, deboning and casing: 2-3 days. Cutting and deboning facility: 1-2 days. Slaughterhouse and casing: 1-2 days. Meat processing: 1-2 days. Casing facility: 1 day.
Remote audit	GRMS audits are on-site audits, but it may be possible to include remote auditing activities as regards to auditing the management system, records and documentation. A part of the audit may be carried out remotely with the mutual agreement of the company and the Certification Body only if remote audit can be implemented without compromising the effectiveness of the audit. Remote audit activities shall be implemented in accordance with IAF MD4	GRMS audits are on-site audits, but it may be possible to include remote auditing activities as regards to auditing the management system, records and documentation. A part of the audit may be carried out remotely with the mutual agreement of the auditee and the Certification Body only if remote audit can be implemented without compromising the effectiveness of the audit. Remote audit activities shall be

	(current version). Remote audit activities shall be implemented within the audit scheduling window indicated on the certificate. The maximum time between the beginning of the remote audit activity and the end of all on-site activities shall not exceed 30 days to ensure effectiveness and integrity of the audit. If the time limit is extended to exceed 30 days, the CB shall make a risk assessment to ensure integrity of the audit. The time between the beginning and end of all audit activities included in the audit duration shall not be extended beyond 90 days.	implemented in accordance with IAF MD4 (current version). Remote audit activities shall be implemented within the audit scheduling window indicated on the certificate.
Guideline document	The auditor shall carry out the audit against the requirements stated in GRMS and may use the supplied guideline document.	The auditor shall carry out the audit against the requirements stated in GRMS using the supplied guideline document.
Audit report	The report may be based on the checklist and guideline and shall contain the following sections: executive summary including conclusions company references; date and name of the auditor; details of the scope and duration of the audit; summary for each section of the guideline reference to findings during the audit if relevant to corrective actions; summary of nonconformities, including clear and concise details for each nonconformity level achieved including the calculation resulting in the stated level; action plan stating all corrective action taken or to be taken in respect of all nonconformities shall be based on a root cause analysis and include the acceptance (verification) of the actions by the auditor.	The report shall contain the following sections: executive summary including conclusions on audit objectives; details of the scope and duration of the audit; summary of nonconformities, including clear and concise details for each nonconformity; level achieved including the calculation resulting in the stated level; an overview of all the requirements and the findings, motivations and references of the auditor; conclusions for each main process of the production site; the corrective action plan stating all action taken or to be taken in respect of all nonconformities shall be based on a root cause analysis and include the acceptance (verification) of the actions by the auditor.
Suspension	The Certification Body reserves the right to withdraw or suspend a certificate based on evidence that food safety or animal welfare on-site has been compromised. The Certification Body can only withdraw a certificate after a suspension or by request from the company.	The Certification Body reserves the right to withdraw or suspend a certificate based on evidence that food safety or animal welfare on-site has been compromised. This may include legal proceedings with respect to product safety or animal welfare and significant damage to the site.
Notification	If any circumstances change within the company that may affect the validity of continuing certification, the company must immediately notify the Certification Body. This may include:	If any circumstances change within the company that may affect the validity of continuing certification, the company must immediately notify the Certification Body.

	significant public food safety incidents and product recall; legal proceedings significant to product safety or animal welfare; significant damage to the site, e.g. natural disaster such as flood or damage by fire; change of ownership; and changes to scope during a certified period. The Certification Body shall in turn take appropriate steps to assess the situation and any implications for the certification and shall take appropriate action.	This may include: legal proceedings with respect to product safety, animal welfare or legality; product recall; significant damage to the site, e.g. natural disaster such as flood or damage by fire; change of ownership; and changes to scope during a certified period. The Certification Body shall in turn take appropriate steps to assess the situation and any implications for the certification and shall take appropriate action. The Certification Body may as appropriate: confirm the validity of certification; suspend certification pending further investigation; require further details of corrective action taken by the company; undertake a site visit to verify the control of processes and confirm continued certification; withdraw certification; or issue a new certificate with the new owner's details.
Accreditation	If accreditation is not granted within 12 months the contract with the Certification Body shall be terminated and potential actions reviewed. In case of accreditation towards a new version of GRMS, the deadline for granting accreditation is 6 months based on at least a desktop assessment with document review. In situations, where there is a delay, the Certification Body shall provide a plan for achieving accreditation to DAFC for approval.	If accreditation is not granted within 12 months the contract with the Certification Body shall be terminated and potential actions reviewed. In situations, where there is a delay, the Certification Body shall provide a plan for achieving accreditation to DAFC for approval.
Agreement CB and client	The Certification Body shall have a legally enforceable agreement for the provision of certification activities to its clients. The Certification Body shall ensure that the agreement includes: ISO/IEC 17065 requirements; DAFC shall be informed of any significant public food safety incidents, such as significant regulatory food safety non-conformities, and significant product recalls; Reports and audit results shall be available to DAFC for integrity monitoring and GFSI benchmarking procedure; If any circumstances change within the company that may affect the validity of	A contract shall be drawn up between the company and the Certification Body detailing the scope of the audit. The contract shall include the rights and obligations of both parties regarding use and maintenance of certificated level, certificate and certification mark, confidentiality and liability. The contract shall require that a copy of the audit report and any subsequent certificate or audit result shall be supplied to DAFC in agreed format. Audit reports provided to DAFC will be treated as confidential.

	continuing certification, the company must notify the Certification Body; Participation of Accreditation Bodies in audits etc.;	
Impartiality and rotation	Certification activities shall be undertaken impartially. The Certification Body shall be responsible for the impartiality of certification activities and shall not allow commercial, financial, or other pressures to compromise impartiality. The Certification Body shall require all staff involved with the certification process to sign a contract or agreement, which clearly commits them to complying with the rules of the organisation with reference to confidentiality and independence from commercial or personal interest, and to declaring any issues in relation to personal conflict of interest. Certification Bodies shall have rules for the appointment of auditors to audits ensuring impartiality, including rotation of auditors.	The Certification Body shall require all staff involved with the certification process to sign a contract or agreement, which clearly commits them to complying with the rules of the organisation with reference to confidentiality and independence from commercial or personal interest, and to declaring any issues in relation to personal conflicts of interest.
Maintaining auditor qualifications	The Certification Body shall have a documented programme to maintain auditor qualifications, which shall include at least 5 on site audits annually at different sites against GRMS. In specific situations where auditors may perform less than 5 GRMS audits yearly justification is needed from the Certification Body. Specific situations may be e.g. limited number of certificates, high auditor/site rate, auditor rotation. In such cases the Certification Body must ensure that GRMS auditor experience are kept up to date (e.g. GRMS audit history, assessment, technical review activity, training) and that the auditor carry out at least one annual onsite GRMS audit out of at least five onsite audits against GFSI-approved Certification Programme(s). If the requirements cannot be met by an auditor, a risk assessment shall be made by the Certification Body. DAFC will arrange a mandatory training to re-qualify the auditor. The re-qualification of the auditor shall include one witness audit against GRMS.	The Certification Body shall have a documented programme to maintain auditor qualifications, which shall include at least 5 on site audits annually at different sites against GFSI approved certification programmes. To ensure specific GRMS knowledge each auditor shall carry out additionally at least one on site audit annually against GRMS. In specific situations where the above-mentioned requirement cannot be met, DAFC will arrange a mandatory training to re-qualify the auditor. The re-qualification of the auditor shall include one witness audit against GRMS
Certificate template	(list products, animal type and processes included in the audit).	(list products and processes included in the audit).

Section III: GRMS 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 <u>on practice</u> of production and processes. Audit may include verification of the audit results by records and documentation.
	Main focus of audit shall be <u>on documentation and records</u> . Audit may include verification by auditing practice in the production.

1. Management System

1.1	Management responsibility and commitment	Version 6.1 (NC = no change) In case of changes the old version is shown.
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)	NC
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 continual improvement.	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.
1.1.3	The company 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. The company shall establish a clear organisational structure, which defines and documents the job functions, responsibilities and reporting relationships for employees with management responsibility for activities which could affect product safety and quality. Documented job descriptions shall be	NC

	available for all 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.	NC
1.1.5	The company 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.	NC
1.1.6	Senior management shall commit to and have in place a hazard and risk management system including prerequisite programmes to identify and control food safety hazards, including allergens. The 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 shall have in place a hazard and risk management system including prerequisite programmes to identify and control food safety hazards, including allergens. The company 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.
1.1.7	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. The animal welfare officer shall receive regular training at intervals of max. 3 years.	NC

1.2	Food safety policy	Version 6.1
1.2.1	The company 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.	NC
1.2.2	Senior management shall encourage a strong food safety culture. Elements of a food safety culture should include commitment,	The company shall encourage a food safety culture that supports the food safety policy. Management shall ensure that the

	leadership, accountability, clear and open communication, employee feedback, risk awareness, learning, training and resources. Management shall ensure that the food safety culture is continually improved and implemented at all levels throughout the organization. Employees shall be aware and act upon food safety related issues. Improvement of the food safety culture shall be included in the management review (section 1.7).	food safety culture is implemented at all levels throughout the company.
1.2.3	Management shall ensure that relevant measurable food safety objectives are assessed related to safety of the products including performance measurement on food safety related activities.	Management shall ensure that relevant measurable food safety objectives are monitored related to safety of the products (section 1.7)

1.3	Quality policy and animal welfare policies	Version 6.1
1.3.1	The company 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.	NC
1.3.2	Management shall ensure that the quality policy is understood, communicated and implemented at all levels throughout the company.	NC
1.3.3	Management shall ensure that relevant measurable quality objectives are monitored.	Management shall ensure that relevant measurable quality objectives are monitored (section 1.7).
1.3.4	The company shall establish a documented animal welfare policy. The animal welfare policy shall include the obligation to treat animals in compliance with legislation and in accordance with best practise.	NC
1.3.5	Management shall ensure that the animal welfare policy is understood, communicated and implemented at all levels throughout the company.	NC
1.3.6	Management shall ensure that defined animal welfare objectives are monitored.	The company shall keep records of measures taken to improve animal welfare. Evaluation of these records shall be included in the management review (section 1.7).

1.4	Environment and Working Environment Policies	Version 6.1
1.4.1	The company 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 an effort to reduce the external environmental impact of the production.	The company 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.
1.4.2	The company shall demonstrate activities to reduce or minimise the external environmental impact. The environmental impact shall be reviewed annually in order to improve sustainability of the production.	NC
1.4.3	The company shall identify and review (e.g. self-assessment using internal audits and on-site inspections) the company culture, including resources and work environment needed to ensure food safety, animal welfare and product quality.	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.

1.5	Internal audit and site inspection	Version 6.1
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.	NC
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.	NC
1.5.3 New Clause	Documented site inspections shall be risk-based and carried out to ensure that site environment, buildings, facilities and process equipment are maintained in a suitable condition to ensure food safety and food defence, as applicable to the activity of the site. Site inspections must also include product	

	flow/handling, housekeeping, hygiene awareness and practices as well as risk of foreign materials.	
1.6	Verification and improvement of the Management System	Version 6.1
1.6.1	Verification activities shall be documented and reviewed to identify trends. This includes results of internal and external audits and results of inspections by authorities. Actions shall be implemented to address unsatisfactory trends.	The company 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 (section 1.7).
1.6.2	The company shall ensure that the management system is continually improved by evaluating the management system at planned intervals.	The company 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.
1.6.3 (new clause)	The company shall have a documented change management procedure. 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.	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.
1.7	Review of the Management System	Version 6.1
1.7.1	The company 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.	NC

1.7.2	Management shall review all elements of the management system. The review shall actively consider the continuing suitability of the system including improvements. The review shall be documented and include at least: Verification activities, including internal audits and inspections by authorities (1.6.1) Updating of the management system (1.6.2 and 3.1.2) Food safety culture (1.2.2) Food safety policy and objectives (1.2.3) Quality policy and objectives (1.3.3) Animal welfare policy and objectives (1.3.4, 6.1.2) Company self-assessment (1.4.1 and 1.4.3) Site inspection reports (1.5.3) Trends in non-conformities (2.5.1) Consistency of supply, complaints and customer satisfaction (2.7.3 and 2.8.3) Traceability system (2.9.10) Recall procedures (2.10.7) Performance of suppliers (2.11.14) Food fraud mitigation plan (3.1.9) Food defence plan (3.1.11) HACCP system (4.5.2) Trends in microbiological and chemical monitoring, including cleaning (5.8.2, 7.7.4, 7.10.5) Training activities (9.2.5).	Management shall review all elements of the management system. The review shall at least include an evaluation of: Food safety policy and objectives (1.2.3) Quality policy and objectives (1.3.3) Environmental impact and objectives (1.4.1) Animal welfare policy and objectives (1.3.6) HACCP system (4.5.2) Food fraud mitigation plan (3.1.9) Food defence plan (3.1.11) Audit results (1.6.1) Inspections by authorities (1.6.1) Recall procedures (2.10.7) Traceability system (2.9.10) Performance of suppliers (2.11.14) Cleaning performance (7.10.5) Consistency of supply (2.7.3) Complaints and customer satisfaction (2.8.3 and 2.7.3) Training activities (9.2.6) Updating of the management system (1.6.2 and 3.1.2) The result of the review shall be documented and include updated policies and objectives and required improvements of the management system.
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2. Quality System

2.1	General Requirements	Version 6.1
2.1.1	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.	NC
2.2	Legislation	Version 6.1
2.2.1	The company shall ensure that national and relevant international legislation in export markets are known and complied with. This includes all relevant legislation in the country of	The company shall ensure that both national and relevant international legislation in export markets are known and complied with. This includes all relevant legislation in the country of

	manufacturing as well as the country of known destination for the products.	manufacturing as well as the country of known destination for the products.
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2.3	Customer Requirements	Version 6.1
2.3.1	The company shall ensure that customer requirements are known and that agreed requirements are complied with.	NC
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.	NC

2.4	Product specifications	Version 6.1
2.4.1	Specifications with a description of product characteristics shall be available for finished products.	NC
2.4.2	Shelf life shall be established from data, experience, analyses or validated predictive models.	NC
2.4.3	Shelf life data shall be available for pre-packed products.	NC
2.4.4	Shelf life guidelines for bulk products shall be available for customers.	NC
2.4.5	Specifications for packaging and shipping shall be available.	NC
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 destination.	NC
2.4.7 New Clause	Recommendations for preparation and/or use of food product instructions shall be established, when required as related to end consumer.	

2.4.8 New Clause	The company shall demonstrate calculations behind to validate nutritional information or claims which are declared on labelling.	
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2.5	Nonconforming products	Version 6.1
2.5.1	A procedure shall be in place for handling and control of non-conformities and nonconforming products. Relevant records of actions shall be kept. Procedures must include requirement for employees to be aware and report a potential non-conformity and/or non-conforming product. The procedure shall consider recording, trending and assessing of non-conformities and non-conforming products. Root cause analysis shall be used to prevent recurrence of non-conformities and ensure ongoing improvements.	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.
2.5.2	Products that do not comply with product specifications or do not conform to the monitoring results shall be identified, including returned non-conforming products. Identified non-conforming products shall be isolated. After assessment, non-conforming products shall be treated accordingly.	Products that do not comply with product specifications or do not conform to the monitoring results shall be identified.
2.5.3	The company shall prepare and implement appropriate product hold and release procedures for non-conforming products, to prevent accidental release. The procedures shall ensure that only raw materials, semi-finished and finished products, and packaging materials conforming to product requirements, are processed and dispatched.	The company shall prepare and implement appropriate product hold and release procedures for nonconforming products.
2.5.4	An appointed employee shall assess nonconforming products. If appropriate, the customer shall be involved in the assessment.	NC

2.6	Product Development	Version 6.1
2.6.1	A procedure for the implementation of new products and processes or changes of existing products and processes shall be in place.	NC
2.6.2	Product formulation, manufacturing processes and the fulfilment of product specification shall have been ensured by factory trials and product evaluation.	NC
2.6.3		

	The product and processes shall be incorporated in the HACCP-system before production of final products (intended for sale) takes place.	NC
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2.7	Sales	Version 6.1
2.7.1	When an order is placed, the execution of that order shall be incorporated into production planning according to agreed order.	NC
2.7.2	Customers shall be notified of any changes made to the agreed order.	NC

2.7.3	The consistency of supply and levels of customer satisfaction shall be regularly monitored and improved. Trends and improvements shall be included in the management review (section 1.7).	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).
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2.8	Complaints procedures	Version 6.1
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 complaint.	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.
2.8.2	Complaints shall be assessed by an appointed employee.	NC
2.8.3	Management shall evaluate complaint data to identify any problem related to the management system. Improvement activities shall be implemented accordingly.	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).
2.8.4 New Clause	A procedure for handling returns must be in place.	

2.9	Traceability	Version 6.1
2.9.1	The slaughterhouse shall maintain a traceability	NC

	system, enabling forward and backward tracing of products to a group of farmers. (K)	
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.	NC
2.9.3	All carcasses shall be identified by a slaughter number, which can be traced to a supplier number and the time of delivery.	NC
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.	NC
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.	NC
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.	NC
2.9.7	Finished products shall be marked with an identification (establishment) number and a lot and date mark. The identification number shall make it possible to identify the producer, production site and country of origin. The date mark shall indicate date of production or date of packing. The date mark may be used as a lot mark.	NC
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.	NC
2.9.9	Edible parts of the carcass (including blood for human consumption) shall be maintained traceable to the carcass until the carcass is deemed fit for human consumption.	NC
2.9.10	An annual test and evaluation of the traceability system shall be carried out and documented. The test shall demonstrate both forward and	An annual test and evaluation of the traceability system shall be carried out and documented. The test shall

	backward traceability. Internal traceability processes should be designed to enable the relevant information to be compiled within company defined time limits.	demonstrate both forward and backward traceability. The result of testing of the traceability system shall be included in the management review (1.7)
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2.10	Product Withdrawal and Recall procedures	Version 6.1
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.	NC
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). A procedure for Crisis Management must be defined, implemented and verified at regular intervals.	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).
2.10.3	Any affected products shall be traced, located and identified both internally and externally.	NC
2.10.4	In the event of a product recall, the authorities shall be informed in due time.	NC
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.	NC
2.10.6	Any course of action taken, which has led to a product withdrawal or recall, shall be documented.	NC
2.10.7	An annual test and evaluation of product withdrawal and recall procedures shall be carried out and documented.	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).

2.11	Purchasing	Version 6.1
2.11.1	The company shall define requirements and control conformity for externally sourced raw materials, semi-finished products, packaging materials, services.	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.
2.11.2	Documented specifications shall be available for all products, materials, utilities and services purchased or provided which may have an effect on quality or product safety. A defined specification review process shall be in place. Microbiological, physical, chemical and allergenic specifications used for food safety purposes shall be available when relevant.	Documented specifications shall be available for all products, materials, utilities and services purchased or provided which may have an effect on quality or product safety. A defined specification review process shall be in place.
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.	NC
2.11.4	The origin of all slaughter animals shall be known. (K)	NC
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.	NC
2.11.6	Suppliers of slaughter animals shall receive feedback on quality aspects and health status of their animals.	Suppliers of slaughter animals shall receive continuous feedback on quality aspects and health status of their animals.
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.	NC
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.	NC
2.11.9	Contracts shall be in place for hauliers, external storage facilities, pest controllers, cleaning contractors and laundry suppliers. This includes customer certification requirements for logistics service providers.	Contracts shall be in place for hauliers, external storage facilities, pest controllers, cleaning contractors and laundry suppliers.

2.11.10	Transport of meat and meat products shall be subject to specific requirements regarding hygiene and temperature and shall be transported under conditions which minimise the potential for microbial, chemical or physical contamination.	NC
2.11.11	Any process equipment, materials or packaging material that may come into contact with product must be suitable for use and in compliance with applicable regulations.	Any process equipment, materials or packaging that come into contact with meat shall be in compliance with applicable regulations as regards to use in the production of food for human consumption.
2.11.12	Approval of suppliers shall be based on defined assessment criteria. Attention should be placed on food safety, quality, animal welfare, and risk of fraud. Externally sourced materials and services, affecting food safety shall be identified and conform to food safety requirements, including food fraud mitigation plan requirements.	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, affecting food safety shall be identified and conform to food safety requirements, including food fraud mitigation plan requirements.
2.11.13	Quality requirements to the supplier shall be based on company requirements and experience with each supplier.	NC
2.11.14	The performance of suppliers shall be continually reviewed. The results of evaluations, investigations and improvements shall be recorded. The need for supplier audits shall be based on experience of the product or service and risk assessment.	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).

2.12	Control of documentation and records	Version 6.1
2.12.1	All documents in the management system shall be comprehensive and approved.	NC
2.12.2	All documents in the management system shall be controlled and uniquely identified including relevant documents of external origin.	NC
2.12.3	All documents in the management system shall be updated whenever necessary.	NC
2.12.4	Documents shall be securely stored and readily accessible when needed. Documents shall be accessible at relevant points throughout the	NC

	company and remain legible and readily identifiable.	
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.	NC
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 avoiding loss and changes.	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.
2.12.7	Only authorised personnel may alter records. Original records shall not be deleted.	NC
2.12.8	The person recording or altering records shall sign and date the alteration in question. A password is required for electronic recording.	NC

3. Food safety system

3.1	General requirements	Version 6.1
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 affecting food safety. Any agreed exclusions shall be indicated on the certificate.	NC
3.1.2	The company shall evaluate and improve 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.	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).
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.	NC

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.	NC
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.	NC
3.1.6	Procedures shall be in place to manage unforeseen hazards (sabotage, vandalism, natural disasters etc.).	NC
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. Appropriate guidelines and work instructions must be in place. Employees shall demonstrate awareness and responsibility on allergen risk in practice.	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.
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 using relevant knowledge and expertise.	The company shall make a documented food fraud vulnerability assessment and identify and address food fraud vulnerabilities related to public health risk.
3.1.9	The company shall develop, implement, verify, maintain and review a Food Fraud Plan on regular basis or when a new vulnerability is established. The Food Fraud Mitigation Plan shall specify the measures in place to mitigate the public health risks from the identified food fraud vulnerabilities.	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).
3.1.10	The company shall perform a documented assessment of Food Defence threats related to food safety using relevant knowledge and expertise.	The company shall perform a documented assessment of threats related to food safety.
3.1.11	The company shall develop, implement, verify, maintain and review a Food Defence Plan on regular basis or when a new threat is established. to minimize identified threats.	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).
3.1.12	The company shall communicate appropriate information throughout the food chain regarding safety issues related to its products, in	NC

	particular in relation to product information, contracts and order handling.	
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4. HACCP System

4.1	General Requirements	Version 6.1
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).	NC
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, including documented procedures and work instructions. The prerequisite programmes shall be designed, established and verified where possible, to support the application and implementation of the HACCP system.	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, including documented procedures and work instructions.
4.1.3	Appropriate knowledge and expertise for the development of an effective HACCP system shall be used. Risk assessments from industry organisations or other similar sources may 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 and take all relevant laws into consideration.	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.

4.2	HACCP team	Version 6.1
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.	NC
4.2.2	The HACCP team leader shall possess competent HACCP knowledge.	NC

4.2.3	The HACCP team members shall receive training in the HACCP principles.	NC
4.2.4	The HACCP team shall establish the requirements for HACCP and PRP control. The quality department participates whenever required.	NC
4.2.5	The HACCP team shall document meetings in protocols or minutes.	NC
4.3	Hazard Analysis	Version 6.1
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, rework and outsourced processes when relevant - Identification and assessment of severity of consequences and likelihood of occurrence for all known bacteriological, chemical and physical hazards.	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, rework - Identification and assessment of severity of consequences and likelihood of occurrence for all known bacteriological, chemical and physical hazards.
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.	NC
4.3.3	The company shall ensure that allergenic ingredients are known and that the risk of cross contamination is assessed.	NC

4.4	Control of Critical Control Points (CCPs)	Version 6.1
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.	NC

4.4.2	Each CCP shall include a definition of method and frequency of monitoring, identification of employees responsible for monitoring and a definition of records to be kept, including information on date, time and records shall be signed or initiated by the employee making the entry.	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.
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.	NC
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.	NC
4.4.5	A critical limit shall be established for monitoring parameters to ensure hazards are eliminated or reduced to an acceptable level.	NC
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.	NC
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)	NC

4.5	Maintaining the HACCP system	Version 6.1
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 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.
4.5.2	The HACCP system shall be re-assessed annually and in case of significant changes 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 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).
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5. Production site standards

5.1	Access	Version 6.1
5.1.1	The company shall define and maintain controlled access to prevent unauthorised entry, including lairage.	The company shall maintain controlled access to prevent unauthorised entry.
New clause 5.1.2	Access areas where a significant risk is identified shall be defined in the food defence plan, including external storage and intake points for products, raw materials and packaging. Employees shall demonstrate awareness of food defence procedures in practice.	

5.2	External Areas	Version 6.1
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.	NC
5.2.2	The surface of external areas shall be consolidated and properly drained.	NC
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.	NC
5.2.4	External areas shall be kept tidy to minimise the risk of pests.	NC

5.3	Staff facilities	Version 6.1
5.3.1	The company shall provide changing facilities with lockers, showers and toilets. Toilets shall neither have direct access nor pose contamination risks to areas where food products are handled. Toilets shall be equipped with adequate hand washing facilities.	The company shall provide changing facilities with lockers, showers and toilets.
5.3.2	Smoking and eating is prohibited outside designated areas.	NC

5.3.3	The company canteen facilities shall have a self-assessment programme.	NC
5.3.4	The company shall provide temperature monitored refrigerators for storing lunch boxes.	NC
5.3.5	Staff facilities shall be designed and operated to minimise food safety risks. Canteens and staff facilities shall be kept clean and tidy.	Staff facilities shall be designed and operated so as to minimise food safety risks. Canteens and staff facilities shall be kept clean and tidy.

5.4	Buildings, facilities and process equipment	Version 6.1
5.4.1	Buildings and facilities shall be suitable (designed, constructed and maintained) for the intended purpose. Production areas (e.g. floor, wall and ceiling) and process equipment shall not pose any risk of contamination and shall be maintained and clean. Water must be prevented from accumulating. Where goods are stored outside, it shall be ensured that there is no product contamination risk or adverse effect on food safety and quality.	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.
5.4.2	Equipment shall be suitably designed for the intended purpose. Equipment shall be designed, constructed, maintained, used and stored to minimise food safety risks.	Equipment shall be suitably designed for the intended purpose and shall be used and stored so as to minimise food safety risk.
5.4.3	Plans showing the flow of materials, products, waste and human traffic through the company shall be available.	NC
5.4.4	Facility design, construction, layout and product flow shall minimise the risk of product contamination. The flow of operations including the movement of personnel and the process flow of raw materials, packaging, rework and/or waste shall not compromise the safety of products.	Facility design, construction, layout and product flow shall minimise the risk of product contamination.
5.4.5	A plant overview of the facility shall be available, including water and waste pipes.	Building plans showing water and waste pipes shall be available.
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.	Water (including steam and ice) used shall be potable or approved by the authorities for the intended use, and subject to regular microbiological and

	The plant must have a tapping point plan in place and a risk-based sampling plan for analysing water quality.	chemical analysis.
5.4.7	The company shall perform planned maintenance for process equipment, buildings and external areas. A system of planned maintenance shall be in place for all items of equipment, which may be critical to product safety. Risk of failure and malfunction essential for food safety, shall be identified and included in the development of the maintenance plan.	The company shall perform planned maintenance for process equipment, buildings and external areas. A system of planned maintenance shall be in place for all items of equipment, which may be critical to product safety.
5.4.8	Production of high-risk products shall be in designated areas to prevent the risk of cross-contamination.	NC
5.4.9	Safety measures shall be taken to avoid reflux in water pipes and access by rodents in waste pipes.	NC
5.4.10	The production areas are entered through adequate facilities for hand washing and disinfection, and risk-based requirements for cleaning of shoes.	Adequate facilities for hand washing and hand disinfection shall be provided at the entrance to production area.
5.4.11	Opening windows in production and adjacent rooms shall be fitted with nets to avoid entrance of pests.	NC
5.4.12	All doors shall be kept closed and, if necessary, secured to prevent access by pests.	NC
5.4.13	Production rooms shall be kept tidy and clean.	NC
5.4.14	Rooms and areas adjacent to production rooms, including the maintenance department, storage and depot rooms shall be kept tidy and clean.	NC
5.4.15	Condensation shall not present a risk of contamination.	NC
5.4.16 New Clause	Suitable and sufficient lighting shall be provided for inspection and quality control activities.	
5.4.17 New Clause	Compressed air shall not pose a contamination risk. The compressed air that comes in direct or indirect contact with food or primary	

	packaging materials shall be controlled based on a risk assessment.	
5.4.18 New Clause	Temporary repairs shall be carried out not to compromise food safety and product quality.	
New clause 5.4.19	The storage conditions of raw materials, products and packaging materials shall be defined. Packaging material must be stored in designated area.	

5.5	Foreign materials	Version 6.1
5.5.1	The company shall have a procedure in place for identifying and controlling relevant foreign materials. Where visual inspection is used to detect foreign materials, the employees shall be trained and demonstrate their awareness in practice. Precautions shall be taken to minimise the risk of product contamination and if required, use of foreign material detectors.	The company shall have a procedure in place for controlling relevant foreign materials
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.	NC
5.5.3	Windows and other openings shall be designed and constructed to avoid the accumulation of dirt and shall be maintained in good condition. Where windows are designed to be opened for ventilation purposes, they shall be fitted with pest screens or other measures to avoid contamination. Windows in production and storage rooms posing a risk of product contamination shall be secured against breakage.	Windows in production and storage rooms posing a risk of product contamination shall be secured against breakage.
5.5.4	Lights and flytraps posing a risk of product contamination shall be secured against breakage.	NC
5.5.5	Glass, hard plastic and other brittle materials posing a risk within production, storage and changing rooms shall be registered and checked regularly.	NC
5.5.6 New Clause	Portable handheld equipment (mobile phones, tablets etc.) and stationery items (pens, pencils etc.) shall be managed to minimise the risk of product contamination.	

5.5.7 New Clause	There shall be a procedure for use and storage of metal cutting equipment. This shall include inspection for damage and the investigation of any lost items.	
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5.6	Pest Control	Version 6.1
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.	NC
5.6.2	The position of baits and flycatchers shall be identified on building plans.	NC
5.6.3	Pest control inspections and resulting actions shall be documented. Implementation of actions shall be monitored and recorded. Any infestation shall be documented, and control measures taken.	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.
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.	NC
5.6.5 New Clause	Incoming deliveries shall be inspected on arrival for the presence of pests.	
5.6.6 New Clause	Employees shall understand the signs of pest activity and be aware of the need to report any evidence of such activity.	
5.6.7 New Clause	The effectiveness of the pest control measures shall be evaluated, including trend analysis, to allow timely appropriate actions.	

5.7	Waste	Version 6.1
5.7.1	A procedure shall be in place for the collection, storage and disposal of waste material, including waste water and drainage ensuring they do not pose any food safety risks. Suitable precautions must be taken for the storage and	Waste (of animal origin) not approved for human consumption shall be stored in closed rooms/silos/containers.

	disposal of food waste and inedible by-products.	
5.7.2	Waste, plastic and cardboard shall be stored in closed containers and regularly collected by authorised contractors.	NC
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 stored in closed rooms/silos/containers and regularly collected by authorised waste disposal contractors.	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.

5.8	Handling of products	Version 6.1
5.8.1	The company shall prepare and implement appropriate product release procedures, including procedures for re-work in relation to nonconforming products.	NC
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, packaging materials, compressed air and gasses.	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 and packaging materials.
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 and stored under appropriate conditions. Employees must demonstrate awareness and responsibility related to storage management and take corrective actions in the event of failure.	Procedures shall be in place to ensure meat, ingredients and packaging materials are used in the correct sequence and within the allocated shelf life.
5.8.4	Procedures for handling of products shall be in place whenever a specific labelling claim is made. This includes mass balance tests as defined by the company.	Procedures for handling of products (including rework) shall be in place whenever a specific labelling claim is made.
5.8.5	Handling and storage of products containing allergens (including rework) shall be carried out so as to prevent cross contamination.	NC
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	NC

	a list of meat based raw materials showing the content of different meat species.	
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)	NC
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.	NC
5.8.9	Received meat, ingredients and packaging materials shall be inspected for quality and hygiene deviations. The inspection shall be recorded.	NC
5.8.10	Temperature for received chilled and frozen products shall be recorded.	NC
5.8.11	All meat, ingredients and packaging materials not being in process shall be covered or stored to prevent contamination risks.	NC
5.8.12	Packaging materials coming into contact with meat shall be covered when not in process to prevent contamination risks.	NC
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.	NC
5.8.14	The identification of meat, ingredients and finished products shall be unique.	NC
5.8.15 New Clause	All rework operations shall be adequate, monitored and documented. These operations shall not affect the food safety and product quality requirements. Traceability shall be maintained.	
5.8.16 New Clause	Procedures to maintain product safety and quality during storage shall be developed based on risk assessment, understood by relevant employees and practised accordingly.	
5.8.17 New	Ingredients must be stored under suitable storage conditions. Ingredients containing	

Clause	allergens must be stored in designated area and be included in the allergen control procedures.	
5.8.18 New Clause	The cold chain shall be controlled. A defined room temperature must be maintained. it must be ensured that the temperature of the products does not exceed the specified temperatures.	

6 Animal welfare

6.1	Animal welfare – general requirements	Version 6.1
6.1.1	Animals shall be spared any avoidable pain, mental distress or suffering during transport, lairage, killing and related activities. The slaughtering plant must take precautions to ensure that the animals do not suffer any unnecessary stress or are exposed to it. (K)	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)
6.1.2 New clause	The company shall monitor animal welfare using cameras. The company shall document where cameras are used by use of risk assessment. Data from cameras must be evaluated for continual improvement of the animal welfare.	
6.1.3 New clause	Employees and visitors in the lairage and stunning area must wear dark clothing.	
6.1.4 New clause	Noise from equipment within the lairage and stunning area must be minimised.	

6.2	Animal welfare – transport and unloading	Version 6.1
6.2.1	Slaughter pigs (excluding sows and boars) shall be delivered to the abattoir in a closed system from the primary producer. Food chain information or equivalent must be available for all deliveries.	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.
6.2.2	Only animals fit for transport must be transported and received.	Only animals fit for transport must be transported.
6.2.3	For transport vehicles, a documented procedure shall be in place in case of a breakdown.	NC

6.2.4	The company shall only use hauliers and vehicles approved for animal transport for delivery of animals for slaughter.	NC
6.2.5	The company shall perform spot checks on deliveries of animals for slaughter to ensure that space requirements have been met.	NC
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.	NC
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 observation pen.	NC
6.2.8	Cleaning and disinfection of transport vehicles shall be monitored and documented via spot checks.	NC
6.2.9	Care must be taken to ensure animal welfare during unloading. It is forbidden to hit or kick the animals, to apply pressure to sensitive parts of the body, to use mechanical gear, to use driving aids with pointed ends or sharp edges and to use electrical driving aids. It is forbidden to pull at an animal's head, ears, horns, legs, tail or coat. The ramp angle shall be flexible, and the angle must be maximum 20 degrees.	NC

6.3	Animal welfare – lairage, stunning and killing	Version 6.1
6.3.1	Lairage facilities shall be designed, constructed and maintained to safeguard the welfare of the animals at any given time. The temperature shall be between 5C and 35C. There shall be a sprinkler system (for pigs) in the lairage to be used in warm weather. Operating instructions for the sprinkler system must be present. The lairage must be well ventilated. Access to lairage must be restricted. Documented procedures shall be in place in case of a breakdown of sprinkler or ventilation system.	Lairage facilities shall be designed, constructed and maintained to safeguard the welfare of the animals at any given time. The temperature shall be between 5C and 35C. There shall be a sprinkler system (for pigs) in the lairage to be used in warm weather. Operating instructions for the sprinkler system must be present. The lairage must be well ventilated. Access to lairage must be restricted.
6.3.2		NC

	Maximum lairage capacity and minimum resting time shall be defined. Slaughtering and delivery time must be coordinated.	
6.3.3	Observation pens shall be available for immediate use upon arrival at the abattoir. 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.	NC
6.3.4	The animal welfare officer shall monitor animal welfare work of employees during stunning and sticking to ensure qualifications and training level has been achieved. Only trained and competent operators are authorised to kill animals. Operators shall be trained in observing any signs of consciousness.	NC
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.	NC
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.	NC
6.3.7	Lactating cows shall be milked at intervals of no more than 12 hours.	NC
6.3.8	No slaughter must be carried out without prior stunning of the animals.	NC
6.3.9	Care must be taken to ensure animal welfare prior to slaughter. The animals must be driven without rushing them. The employees shall drive the animals forwards in a calm flow of work. Driving tools may only be used in a considerate and compassionate manner: - use of electric goads is only allowed for slaughter pigs in emergency situations - electric goads shall only be allowed for sows and boars when moving the animals into the final stunning area and only 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.	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.

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.	NC
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.	NC
6.3.12	A back-up system for stunning animals shall be available in the stunning area.	NC
6.3.13	Sticking shall be carried out in a continuous process and the animals shall remain fully unconscious until death from bleeding. Sticking shall be performed immediately after stunning with a specified maximum duration time from stunning to sticking. The duration time shall depend on the type of animal and the stunning method. The decisive factor is that the animals shall remain fully unconscious.	NC
6.3.14	Start-up check of the stunning/killing equipment shall be implemented. A maintenance programme shall be in place for the stunning/killing equipment. Maintenance carried out shall be recorded.	NC

7. Process Management and Production Monitoring

7.1	General requirements	Version 6.1
7.1.1	Grading of carcasses shall be based on an official method.	NC
7.1.2	Process and work descriptions including packing requirements shall, where necessary, form the basis of all work undertaken. Employees must demonstrate awareness of process and work descriptions and act in case of equipment malfunction and process deviations.	Process and work descriptions including packing requirements shall, where necessary, form the basis of all work undertaken

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.	NC
7.1.4	Rooms that require cooling shall have a temperature control system and be fitted with an alarm system.	NC
7.1.5	Sterilisation equipment including automated machinery shall be monitored. The monitoring must be documented.	NC
7.1.6	Waste shall regularly be removed from the production process without posing a contamination risk.	NC
7.1.7 New Clause	Where the control of process and working environment parameters (temperature, time, pressure, chemical properties, etc.) are essential to ensure the food safety and product quality requirements, such parameters shall be monitored.	

7.2	Slaughter	Version 6.1
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.	NC
7.2.2	An emergency procedure shall be in place in case of a breakdown on the slaughter line before the point of evisceration.	NC
7.2.3	Faecal contamination shall be removed on the slaughter line. Alternatively, the carcass shall be dressed on a separate line.	NC
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.	NC
7.2.5	Data from post mortem inspection of the individual animal shall be recorded at the slaughter line. Relevant data must be entered into the company IT-system and informed to the animal supplier.	NC

7.2.6	Knives and tools shall be sterilised between each carcass prior to approval of the carcass for human consumption ("post mortem inspection").	NC
7.2.7	The cooling and equalisation processes shall be defined, monitored and recorded.	NC

7.3	Primal cutting, deboning and packing	Version 6.1
7.3.1	Prior to primal cutting, carcasses 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.	NC
7.3.2	The conformity of product shall be 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. Procedures shall be in place to avoid cross contamination with other species.
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.	NC
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.	NC
7.3.5	Before dispatch, product temperatures shall be checked and recorded in every shipment.	NC

7.4	Offal (fresh meat other than the carcase, including viscera and blood)	Version 6.1
7.4.1	Offal shall originate from animals that have passed the official post-mortem inspection.	NC
7.4.2	Offal shall be inspected for any slaughtering and hygiene deviations.	NC

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.	NC
7.4.4	Offal shall where necessary be subject to an approval before release/dispatch. (K)	NC
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.	NC
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.	NC
7.4.7	When blood is collected for human consumption, it must be ensured that a temperature of 3C is reached within a defined time interval as quickly as possible. Blood shall be subject to approval before release.	NC

7.5	Minced meat, meat preparations and meat products	Version 6.1
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)	NC
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.	NC
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.	NC
7.5.4	Before dispatch, the temperature of products	

	shall be checked and recorded for every shipment.	NC
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7.6	Chilling and freezing storage	Version 6.1
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.	NC
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.	NC
7.6.3	An alarm shall be activated if the temperature exceeds a defined limit.	NC
7.6.4	Temperature monitoring shall be assessed and approved on a daily basis.	NC

7.7	Process and Product analyses	Version 6.1
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.	NC
7.7.2	A risk-based Salmonella programme shall be in place for slaughter animals (pigs), including relevant feedback to producers.	A risk-based Salmonella surveillance programme shall be in place for slaughter animals (pigs). Producers shall receive continuous feedback on the Salmonella level.
7.7.3	A risk-based Salmonella monitoring of carcasses (pigs) shall be in place. A concept for the reduction of Salmonella contamination in the slaughtering process (a Salmonella reduction plan) must be drawn up in line with the HACCP principles and implemented in the abattoir.	NC

7.7.4	Slaughter hygiene shall be monitored continually via swab testing. The samples shall be analysed for at least total viable count, faecal bacteria and/or Enterobacteriaceae. The results shall be ongoingly reviewed to identify trends, and appropriate corrective actions taken.	Slaughter hygiene shall be monitored continually via swab testing. The samples shall be analysed for at least total viable count, faecal bacteria and/or Enterobacteriaceae. A trend analysis of results shall be implemented, and measures shall be taken in the event of unsatisfying results
7.7.5	The company shall perform random sampling for presence of residues in accordance with industry codes and/or surveillance programme.	NC
7.7.6	The results of antibiotic and chemotherapeutic analysis shall be available.	NC
7.7.7	A risk based Trichinella surveillance program shall be in place for slaughter pigs and horses.	NC
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)	NC
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)	NC
7.7.10	Microbiological analysis of products shall be performed to monitor the production process.	NC
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.	NC
Deleted		Where more species are handled test shall verify that contamination with other species do not occur.

7.8	Transport vehicles	Version 6.1
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 (designed, constructed) and maintained in good repair and be clean.	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.

7.8.2	Company vehicles and contracted transport vehicles shall be equipped with a temperature log for chilled/frozen products.	NC
7.8.3	The hygiene standards of transport vehicles that could impact food safety shall be monitored and recorded at delivery/dispatch.	The hygiene standards of transport vehicles shall be monitored and recorded at delivery/dispatch.
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.	NC

7.9	External storage	Version 6.1
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.	NC
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.	NC

7.10	Cleaning	Version 6.1
7.10.1	Procedures for housekeeping, cleaning and disinfection shall be established, implemented and maintained. Cleaning shall be made according to documented standards and shall not represent a food safety risk. The cleaning programme shall include frequency, and a description of cleaning and disinfection materials used.	Cleaning shall be made according to documented standards. 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 and throughout all stages of production.	Cleaning shall be carried out according to contract or job descriptions and be maintained at all times and throughout all stages of production.
7.10.3	Cleaning equipment and materials shall be suitable for their intended use, stored appropriately and access to chemicals shall be restricted.	Cleaning materials shall be suitable for their intended use and stored appropriately.

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.	NC
7.10.5	The effectiveness of the cleaning and disinfection shall be verified and include a risk-based environmental monitoring programme covering TVC and Enterobacteriaceae. The results of checks on cleaning, including visual, analytical and microbiological checks, shall be recorded and used to identify trends and be communicated to the personnel responsible for cleaning activities.	The cleaning standard shall be verified and recorded periodically based on a testing programme, including at least TVC and Enterobacteriaceae. 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).
7.10.6 New clause	Safety Data Sheets and instructions for use shall be available for chemicals. Personnel responsible for cleaning shall be able to demonstrate their understanding in practice.	

8. Monitoring equipment

8.1	Measuring devices	Version 6.1
8.1.1	The company shall identify measuring equipment and monitoring devices critical to ensure quality and product safety, including the accuracy necessary to ensure control and monitoring of critical parameters. Detection equipment shall be in place if needed based on a risk assessment.	The company shall identify measuring equipment and monitoring devices critical to ensure quality and product safety, including the accuracy necessary to ensure control and monitoring of critical parameters.
8.1.2	Measuring equipment shall be protected against damage.	NC
8.1.3	Measuring equipment shall be clearly identified and the calibration status shall be known.	NC

8.2	Calibration	Version 6.1
8.2.1	Measuring equipment shall be calibrated within the full range of the scope.	NC
8.2.2	Measuring and monitoring devices shall be calibrated traceable to a recognised standard.	NC

	Calibration results shall be recorded against a norm.	
8.2.3	Only qualified employees may calibrate measuring equipment.	NC
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).	NC

9. Personnel, External Labour and Visitors

9.1	Hygiene regulations	Version 6.1
9.1.1	Documented personal hygiene standards based on risk of product contamination shall be in place. Employees shall be aware of the hygiene standards and act upon food safety related issues. The following areas should be taken into consideration: • hair and beards • protective clothing and footwear • cleaning and disinfection of hands • eating, drinking and smoking • fingernails • personal belongings, including watches and jewellery (smooth wedding rings are accepted) • actions to be taken in case of cuts or skin abrasions.	Documented personal hygiene standards and hygiene regulations based on risk of product contamination shall be in place.
9.1.2	The company shall have procedures in place to ensure that all external labour follow the hygiene regulations.	NC
9.1.3	Employees shall address hygiene precautions. Different hygiene levels shall be addressed in the hygiene regulation.	All personnel shall address hygiene precautions, especially when they enter a higher hygienic level
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.	NC
9.1.5	Before gaining access to production areas, visitors and external personnel shall provide information on their health status.	NC

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. The following should be taken into consideration: - Proper use of clothing - Laundering conditions - Maintenance of clothing - Storing facilities for clothing and personal items	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.
9.1.7	Outside stay in working clothes is prohibited. Outdoor clothing shall be stored separately from production clothing.	Outside stay in working clothes is prohibited.
9.1.8	Visitors and external personnel shall be dressed in appropriate clothing before entering production areas.	NC

9.2	Training	Version 6.1
9.2.1	The company shall ensure that all employees (including temporary workers and subcontractors) are adequately trained and retrained as necessary, instructed and supervised in relevant food safety practices, commensurate with their activity. Records of training and retraining shall be available.	The company shall ensure that all employees are adequately trained, instructed and supervised in food safety principles and practices, commensurate with their activity.
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.	NC
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.	NC

9.2.4	Employees handling animals from unloading to sticking must be competent and receive ongoing training defined by the company. Hauliers handling animals for slaughter shall complete an animal welfare training course from an acknowledged training institution.	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.
Deleted clause		Employees shall be offered relevant further training on an on-going basis.
9.2.5	The company shall identify needs for training and instruction activities, including necessary resources. The contents of training and instruction shall be regularly evaluated and improved	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)