IFS Food
Version 6.1

Final Audit Report

Audited company: Encebe Vleeswaren B.V.

Date of audit: 07/10/2019 till 10/10/2019

Name and address of certification body
LRQA France SAS Tour Swiss Life 1
Boulevard Vivier Merle
69443 Lyon cedex 03 France

Accreditation number of the certification body
COFRAC 05-0069

IFS Food
Version 6.1, November 2017

Audit Overview

Audit details			
Lead Auditor: *Co-auditor:* *Trainee(s):*		*Date/time of current audit:* 07/10/2019 (09:15-17:00) 08/10/2019 (08:30-17:15) 10/10/2019 (08:40-16:45)	*Date of previous audit:* 11/10/2018 CB and auditor of previous audit: LRQA France SAS -
Name and address of the company (or headquarter): **Vion N.V. N.V.** Boseind 15 5281 RM Boxtel Netherlands		*Name and address of the audited site:* **Encebe Vleeswaren B.V.** Boseind 10 5280 AB Boxtel Netherlands	
		EAN Code/ UCC Global Location Number: COID:	8713279000252 55703
Phone: (+31) 062260 6187	*Fax:*	*Phone:* (+31) 88 9953124	*Fax:* (+31) 411 658799

Scope of audit	
Producing (cutting, slicing, mincing, blending, fermenting, pasteurising, sterilising, marinating) and packing (modified atmosphere, chilled, frozen, canned) of meat products of beef, pork and poultry in consumer and bulk packaging.	
Product scope(s):	1
Technology scope(s):	A, B, C, D, E, F

Scopes and processing steps												
		1	2	3	4	5	6	7	8	9	10	11
A	P1	☑	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
B	P2	☑	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
C	P3	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
C	P4	☑	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
C	P5	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
D	P6	☑	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
D	P7	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
E	P8	☑	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
E	P9	☑	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
E	P10	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
F	P11	☑	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
F	P12	☑	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
F	P13	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐

* The explanation of the product scopes and processing steps are listed separately

Scope explanation	
Scope	**Scope description**
1	Red and white meat, poultry and meat products
2	Fish and fish products
3	Egg and egg products
4	Dairy products
5	Fruit and vegetables
6	*Grain products, cereals, industrial bakery and pastry, confectionary, snacks*
7	Combined Products
8	Beverages
9	Oils and fats
10	Dry products, other ingredients and supplements
11	Pet food

Processing step explanation	
Processing step	**Processing step description**
P1	Sterilisation (e.g. cans)
P2	Thermal pasteurisation, UHT/ aseptic filling; hot filling; Other pasteurisation techniques e.g. high pressure pasteurisation, microwave
P3	Irradiation of food
P4	Preserving: Salting, marinating, sugaring, acidifying/ pickling, curing, smoking, etc. Fermentation/ acidification
P5	Evaporation/ dehydration, vacuum filtration, freeze drying, microfiltration (less than 10 µ mesh size)
P6	Freezing (at least –18 °C) including storage. Quick freezing, Cooling, chilling processes and respective cool storing
P7	Antimicrobial dipping/ spraying, fumigation
P8	Packing MAP, Packing under vacuum
P9	Processes to prevent product contamination esp. microbiological contamination, by means of high hygiene control and/or specific infrastructure during handling, treatment and/or processing e.g. clean room technology, „white room", controlled working room temperature for food safety purpose, disinfection after cleaning, positive air pressure systems (like filtration below 10µm)
P10	Specific separation techniques: e.g. filtration like reverse osmoses, use of active charcoal
P11	Cooking, baking, bottling, filling of viscous products, brewing, fermentation (e.g. wine), drying, frying, roasting, extrusion, churning
P12	Coating, breading, battering, cutting, slicing, dicing, dismembering, mixing/blending, stuffing, slaughtering, sorting, manipulation, packaging. Storing under controlled conditions (atmosphere) except temperature
P13	Distillation, purification, steaming, damping, hydrogenating, milling

Audit participants					
Name:	**Position:**	**Opening meeting**	**Documenta-tion review**	**Site assessment (Audit)**	**Closing meeting**
	Supply chain / Operations manager	☑	☑	☐	☑
	Production leader	☑	☐	☑	☑
	QA manager	☑	☑	☑	☑
	HR manager	☑	☑	☐	☑
	Department manager Encebe 2	☐	☐	☑	☑
	Sourcing manager Ingredients	☐	☑	☐	☐
	Employee service desk	☐	☑	☐	☐
	Department manager Encebe 1	☐	☐	☑	☑
	Specification control	☐	☑	☐	☐
	Product development	☐	☑	☐	☐
	Assisting foreman Industrial	☐	☐	☑	☐
	Foreman Expedition	☐	☐	☑	☐
	Production/QC officer	☐	☑	☐	☐
	Operator slicing	☐	☐	☑	☐
	Operator rokerij	☐	☐	☑	☐
	Foreman warehouse	☐	☐	☑	☐
	Assisting foreman zouterij	☐	☐	☑	☐
	Assisting foreman Expedition (packaging)	☐	☐	☑	☐
	Assisting foreman packaging	☐	☐	☑	☐
	Assisstant Maintenance manager	☐	☑	☑	☐
	Supply chain manager	☑	☐	☐	☑
	QA officer	☐	☑	☐	☐
	QA employee (interim)	☑	☑	☐	☑
	Commercial manager	☐	☐	☐	☑

Audit participants					
Name:	**Position:**	**Opening meeting**	**Documenta-tion review**	**Site assessment (Audit)**	**Closing meeting**
	Employee zouterij	☐	☐	☑	☐
	Employee bulk packaging	☐	☐	☑	☐
	Receipt meat	☐	☐	☑	☐
	Employee expedition	☐	☐	☑	☐
	Employee cutterij	☐	☐	☑	☐
	Employee cutterij	☐	☐	☑	☐
	Employee stopperij	☐	☐	☑	☐
	Warehouse employee	☐	☐	☑	☐
	Maintenance officer	☐	☑	☑	☐

Final result of audit	
As a result of the audit performed from 07/10/2019 till 10/10/2019, „LRQA France SAS" found that the processing activities of **Encebe Vleeswaren B.V.** for the above mentioned scope of audit comply with the requirements set out in the IFS Food 6.1, Version 6.1, **at Higher Level**, with a score of 97.74%.	**Next audit between 24/08/2020 and 02/11/2020**

Company profile

Product groups and products per group produced in the company:

Product Scope 1
Others - Meat products: fermented, cured, pasteurised and sterilised.

Encebe Vleeswaren BV is a middle-sized producer of meats preparations and meat products and is part of the Vion Food Group. The company is located in Boxtel at the same location as the slaughterhouse of Vion Boxtel (part of facility VION Boxtel).
The registration numbers of the company by authorities: EG 61 NL
(which is also the number of the slaughtering house)

COID: 55703

The company is producing and selling ca. 300 different final products divided into several product groups of meats and sausages: meat preparations, cooked (smoked) sausages, sterilized products and fermented sausages. Products are produced by the own production process. The production quantity is approximately 165 tons per week. The site is certificated for: BRC 7 Food, IKB 'Beter Leven Kenmerk', SKAL (Organic), COC (chain of custody) and ISO 9001 (as part of a multi-site ISO). Main selling market is the industrial market and a minor part at the retail (supermarkets). The strategy is focused at growth in the industrial market, for which an assortment tailor-made product is produced, and growth in the retail market of sliced ready to eat meat products.
The year of construction of the plant: 1934

Investments 2018 - 2019:
Investments 2018: Vacuum filling machine with metal detector, first phase CSB, new cold store, new cutter, bridge between Vion and Encebe, relocation Office, change of the walking route staff, displacement industrial (reduce the size high care area), on various places new walls (to reduce the size of High care area), new smoke-cabinets, new high care entrance, replacement of warehouse (to reduce the size of the high care area).
Investments 2019: Vacuum filling machine and a New cutter.

There were no issues with authorities since last visit.

Name and contact data (phone/ fax/ e-mail) of contact person (emergency/ withdrawal/ recall).

Product groups and products per group
(Product scope 1 "Red and white meat, poultry and meat products"):
Cooked (smoked) sausages, fermented sausages and sterilized meat products of beef, pork and poultry.

Complete view of the company's processes - technology scopes:
(P1, P2, P4, P6, P9, P11 & P12):
Producing (cutting, slicing, mincing, blending, fermenting, pasteurizing, sterilizing, marinating) and packing (modified atmosphere, chilled, frozen, canned) of meat products of beef, pork and poultry in consumer and bulk packaging.

No traded products applicable: NA

Employees: Full time Part time and average o flex workers = Total
most in a one shift operation (except smoking and slicing department: 2 shifts).

No seasonal workers.

No subcontracted processes

No subcontracted plants.

Site area of the plant in m2: 10.000 m2

This visit was a combined with the certificate renewal visit with BRC8 Food audit.
An audit program of this audit was made and agreed with the company before the audit.
No reasons for decreasing audit time: NA.

The integrity program was discussed during the opening meeting.

No deviations encountered regarding the use of the IFS logo.

Other certificates held by the company: BRC Food, ISO9001, CoC/CBL, Organic, "Beter Leven Keurmerk".

Reviewer

Audit data	
Outsourced processes and/or products	
Outsourced processes and/or products:	no
Additional audit data	
Total number of employees:	
Name and contact data (phone, fax, email...) of the contact person in case of emergency:	
Site area of the plant in square meters:	10000

Explanations regarding the audit report

Evaluation of requirements		
Result	**Explanation**	**Points**
A	Full compliance	20 points
B (deviation)	Almost full compliance	15 points
KO requirement scored with a B	Almost full compliance	15 points
C (deviation)	Small part of the requirement has been implemented	5 points
D (deviation)	Requirement has not been implemented	-20 points
Major	When there is a substantial failure to meet the requirements of the Standard, which includes food safety and/or the legal requirements of the production and destination countries. A major can also be given when the identified non-conformity can lead to a serious health hazard. A major can be given to any requirement which is not defined as KO.	15% of the possible total amount of points is subtracted
KO requirement scored with a D	The KO requirement has not been implemented	50 % of the possible total amount of points is subtracted
N/A	Not applicable Requirement not applicable for a company	N/A requirements will be excluded from the final scoring

Scoring and awarding of certificates				
Audit result	**Status**	**Action company**	**Report form**	**Certificate**
At least 1 KO scored with D	Not approved	Actions and new initial audit to be agreed upon	Report gives status	No
> 1 Major and/or total score < 75%	Not approved	Actions and new initial audit to be agreed upon	Report gives status	No
Max 1 Major and total score ≥ 75%	Not approved unless further actions taken and validated after follow-up audit	Send completed action plan within 2 weeks of receiving the preliminarily report. Follow-up audit max. 6 months after the audit date	Report including action plan gives status	Certificate at foundation level, if the Major non-conformity is finally solved as controlled during the follow-up audit
Total score is ≥ 75 % and < 95%	Approved at foundation IFS Food level after receipt of the action plan	Send completed action plan within 2 weeks of receiving the preliminarily report.	Report including action plan gives status	Yes, certificate at foundation level, 12 months validity
Total score is ≥ 95 %	Approved at higher IFS Food level after receipt of the action plan	Send completed action plan within 2 weeks of receiving the preliminarily report.	Report including action plan gives status	Yes, certificate at higher level, 12 months validity

IFS Food
Version 6.1, November 2017

Audit report

Result:
The processing activities of company „Encebe Vleeswaren B.V." met the requirements of the IFS Food, Version 6.1.

The company passed with a score of 97.74% at:

Higher Level

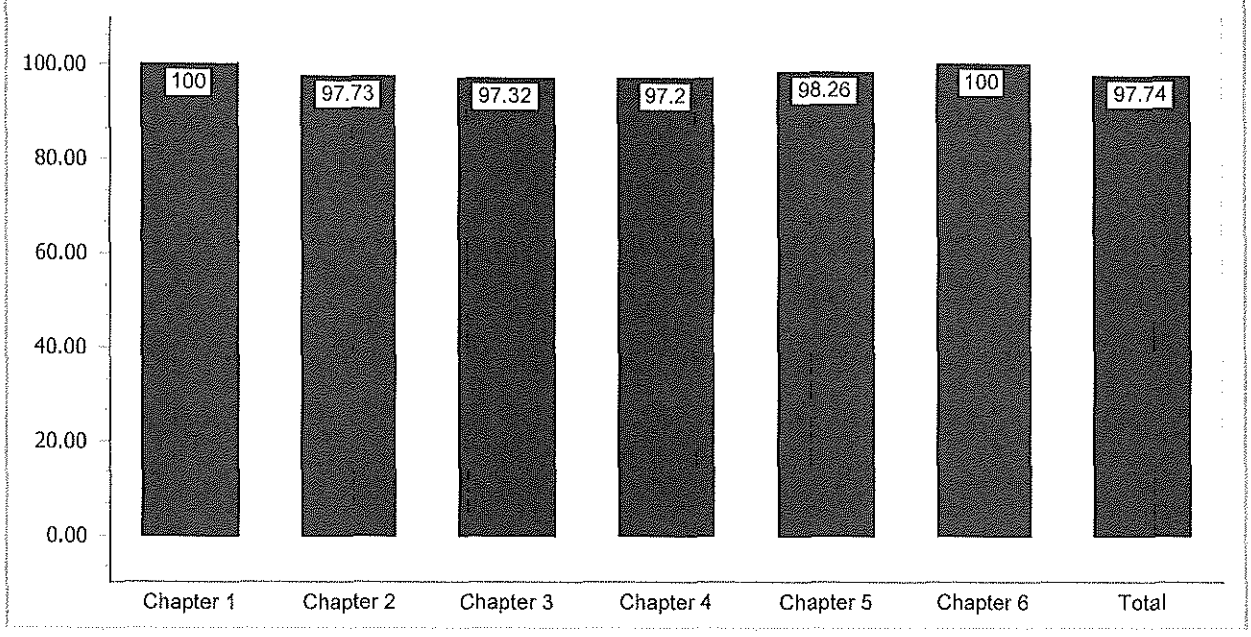
97.74 %

Date of renewal audit: between the 24/08/2020 and the 02/11/2020.

Summary:						
	Chapter 1 Senior management responsibility	Chapter 2 Quality and Food safety management system	Chapter 3 Resource management	Chapter 4 Planning and production process	Chapter 5 Measurements, analyses, improvements	Chapter 6 Food defense
KO	0	0	0	0	0	0
Majors	0	0	0	0	0	0
A	22	32	27	129	42	6
B	0	0	0	0	0	0
C	0	1	1	5	1	0
D	0	0	0	0	0	0
N/A	0	0	0	11	2	2

Observations regarding KO's and Majors:
na

General summary table for all chapters:



Overall summary of the audit:

Chapter 1
Official approval EG-61-NL of the Food and Consumer Product Safety Authority
A VION Food Group policy is in place, and this is translated for the site, signed by the site manager. Objectives are described by using the X-matrix structure with responsibilities for all department managers, e.g. Safety, People, Quantity Delivery, Cost. MT consists of the General Manager and other managers.
Quarterly management review takes place. Seen management review reviewing July 2018- June 2019 (July 2019), signed by most senior manager and discussed in the MT. All relevant items are addressed, and the results of internal and external audits were seen. KPI's are defined and MT evaluates the KPI's weekly during MT meetings.
No food safety issues since last visit.
Management improvement plans are managed by using a PDCA board. During audit PDCA board were seen, so the company was able to demonstrate an adequate communication system. System of escalating actions and aspects is: MMM – Huddles - Tier 1, Tier 2 (Local MT), Tier 3 (BU MT). If items occur to discuss HACCP it is added to the agenda of the weekly MT meetings. Monthly HACCP-team meetings take place. Improvements in organization are demonstrable.
Chapter 2:
A HACCP system is in place. All required aspects are addressed. Preventive measures are defined into CP's and 9 CCP's. The local HACCP system ("Procesbeheersplan" 30-10-2017) was developed by a multi-disciplinary HACCP team, namely General Manager, QA Manager, QA/QC Officer, "Bedrijfsleider" and TD coordinator. All team member's shows enough and the right experience and knowledge.
The PRP is present in the HACCP system.
The HACCP system has full management commitment and is an integral part of the company's Quality Management System (QMS). The HACCP was found to be well documented and effective.
Full product description including microbiological limits and shelf life is in place. The intended use (B to B / Consumer Products) of the product by the customer has been clearly defined.
Each identified hazard was reviewed and given a risk rating to define the severity (1 – 3) and likeliness (1 – 3) of a hazard occurring. The risks (R >=3) have been defined from the hazards with adoption of a decision tree: Risk < 3 = PRP, Risk 3 or 4 = CP, Risk 6 or 9 = CCP.
However, 1 deviation on chapter 2 see action list
CCP' s which are determined, including critical limits, according to P-NCB-NL-10027 dd 04-10-2019:
- CCP 1. Temperature control of (returned) fresh pork meat / beef at reception (≤7°C)
- CCP 2. Temperature control of (returned) animal by-products/organs at reception (≤3°C)

- CCP 3. Temperature control of separated meat at reception (≤2°C)
- CCP 4. NO2 in brine (absence or presence by indicator paper)
- CCP 5. Temperature control of heat-treated meat products sterilization (2,45 hours at 106°C)
- CCP 6. pH after fermentation process (pH≤5,3 within 45 hours)
- CCP 7. Temperature control of heat-treated meat products pasteurization (P70>3 minutes)
- CCP 8a. Temperature control of minced meat at dispatch (≤2°C) (former CP)
- CCP 8b. Temperature control of meat preparations at dispatch (≤4°C) (former CP)
- CCP 9. Temperature control of chicken meat at reception (≤4°C)

Corrective actions are clearly defined according to the CCP overview. The CCP's were demonstrated, including a well recording during the audit, including corrective actions. Verification during the year is demonstrable. Several reports seen (quarterly review) and HACCP verification is part of the annual Management Review (seen 03-07-2019, reflecting Q3/2018 - Q2/2019).
Chapter 3:
Required human resources are managed in good order.
Written instructions for personnel (e.g. work- and personal hygiene instructions) are in place, communicated and implemented.
The need of training is identified yearly. Training programs are demonstrable and evaluated.
CCP training is organized, records seen for receiving and production employees, on knowledge concerning training on topic CCP's and food safety.
There is a special training for Food Defence.
Training effectiveness is monitored (exam).
There were suitable changing rooms for staff. The rooms are sited to production. Separation in work wear and personal clothing/items is arranged. But see DEVIATION for workwear maintenance. Staff facilities are designed and operated to minimize the risk of contamination. Staff facilities are suitable for the operation. Suitable hand washing facilities with suitable warm water, liquid soap, single use towels, taps with hand-free operation and clear advisory sign to prompt hand-washing.
High-care area, personnel entered area via a specially designated changing facility with arrangements to ensure that protective clothing will not be contaminated before entry to the high-care area. The changing complies with the requirements. Well-designed canteen separated smoking area. Well controlled facilities. No external catering.
However, 1 deviation on chapter 3 see action list
The infrastructure facilities comply with the standard, the buildings and grounds are well maintained.
Chapter 4:
Specifications for raw materials, packaging materials, cleaning agents and finished products are available through and managed by the involved departments. Specifications are reviewed internally to ensure they are correct and up to date.
Product- or process development is part of the QMS (MDM). Documented product design and development procedure exists ("Procedure Product ontwikkeling"). A development / validation protocol is available. Claims made about Organic status / non GMO / Good Farming Star. Procedures and working instructions are available and in practice correct implemented to comply with the claim(s) standard. No remarks.
The Gateway (5 steps) system guarantees that all relevant departments as QA, Production etc. are involved where required in the R&D projects.
Allergen policy is part of the product development process and changes are discussed in the HACCP team.
The purchase of raw material, additives and packaging, some maintenance suppliers and services, is organized and managed by HQ. All supplied material is reviewed by the HACCP system for the required hazards.
Product packaging complies with the requirements.
The premises, grounds and buildings are suitable for the operation. The factory environment meets the IFS requirements. All walls, floors, ceilings, piping, lightning and ventilation is smooth and cleanable. Structures are designed to minimize risk of contamination. Lighting is covered and fly killer lights and windows are protected. Drainage is suitable and sloped with gutters. If condensation appears strict orders and instructions apply on removal. But see DEVIATIONs for condens
Cleaning is done by subcontractor in the evening / at night when production has stopped.
Cleaning schedules of are available and cover equipment, plant, buildings and services (with daily / weekly / monthly cleaning frequencies).
Low frequent cleaning schedule (ceilings, walls above 2,5m, evaporators) is executed on demand.
Socks controlled by maintenance department.
The effectiveness of the cleaning and disinfection process is followed by daily hygiene audits (pre-

SSOP) and monthly by QA HON inspections. Swabs for pathogenic bacteria like Listeria are taken. Waste is handled properly.
Dispatch and release of products is based upon general handling procedures. Checks are recorded. Temperature control is applicable during storage, loading and transport of the products. Product is loaded in covered bays. All transport and storage is subcontracted following P-NLFOOD-10038. VION Food (central office) is contract owner. The content of the contract complies with the requirements. VION reviews the performance of these transport companies (e.g.
Equipment is maintained and on the planned maintenance system. Maintenance is also outsourced to established companies within the food and meat business. Registrations to confirm that the preventive maintenance or preventive controls have been carried out as planned are in place. Inspections on building and constructions are done monthly by QA & TD.
But see DEVIATION for damaged doors where water was leaking

Pest control is contracted to : (central) for rodents (rats and mice) and insects (cockroaches and flying insects); frequency of control is 8 x / year; maintenance of EFK is 1 x / year. And assessment on the Pest control system and a Pest risk inventory 1x / year (Frequency of the in-depth pest control survey is risk based and accepted). All documentation is present in the contract map of (digital). Up to date site plans (are available to show the location of rodent baits, mouse traps, crawling and flying insect control units. Constructional action points are solved. Only Non-Tox is used.
A central Vion procedure "Product voedsel Fraude" for Food Fraud has been set up (including planning for yearly review). An assessment for Encebe according to Vion procedure has been performed . No special control measures are identified.
However, 5 deviations on chapter 4 see action list
Chapter 5:
Monitoring of the processes was demonstrated (QMS, Food safety, Legal requirements). During the visit control of CCP's is checked. Calibration data of relevant measuring devices (in process control) were available. Calibration is organized by the maintenance department and the QA department (external services). According procedure all measuring devices must be calibrated. All measuring devices for calibration are listed.
Quantity control for packaging was demonstrated. Related weighing equipment (scales applied) were calibrated. Product analysis is performed at an external laboratory (microbiological, physical and chemical analysis).
Product release is organized.
Management of non-conforming product, incidents, product withdrawal and product
Recall procedure is present. Combined Recall and traceability test is done yearly.
Vion Food has an internal audit team which visits all VION Food locations. They are trained and harmonized by Headquarters in Boxtel. Also follow up, recording and planning is arranged centrally. Inspections are; QA Hygiene inspections (HON) monthly, QA glass inspections 4x/year, Building inspections monthly, Agar/ Swab monitoring program on e.g. Listeria and daily prior production inspections (Pre-SSOP). All listed items are checked, records seen and trended for analytic results.
However, 1 deviations on chapter 5 see action list
Chapter 6:
A Food defense assessment is made for this factory. Personnel and visitors are registered and instructed. The production location is situated at an industrial area. The outside area is paved and fenced with gates. No outside storage of materials, equipment, packaging.
All entrances are restricted. All personnel and visitors enter the building through the main or office entrance. No other entrances are available, all secured. Personnel register their entrance by tagging. Visitors have to sign in, after reading the hygiene rules and comply with health instructions. Visitors are only allowed in the building together with the contacted employee. External maintenance workers sign a form "Procedure Reglement Externe monteurs" concerning personal and safety instructions.
All docking trucks and trailers are registered.
All employees, also temporary employees, are identified by checking their ID and BSN.
Food defense is part of the management review.

Description of follow up of corrective actions from the previous audit:
The Action Plan of 2018 was discussed. The deviations reported were closed.

Chapter 1: Senior management responsibility

Summary of all Chapter 1 deviations and non-conformities found:

Nr.	Reference	IFS requirements	Evaluation	Explanation

No non-conformities found.

Chapter 2: Quality and food safety management system

Summary of all Chapter 2 deviations and non-conformities found:

Nr.	Reference	IFS requirements	Evaluation	Explanation
1	2.2.3.5.1	A hazard analysis shall be available for all physical, chemical and biological hazards, including allergens, which may reasonably be expected.	C	The risk of contamination by air in the high care area is not demonstrable assessed in the risk assessment (30 Sep. 2019). (Motivation for C-Dev. Air is filtered and microbiological air monitoring plan show acceptable levels (<100 cfu/m3).

Chapter 3: Resource management

Summary of all Chapter 3 deviations and non-conformities found:

Nr.	Reference	IFS requirements	Evaluation	Explanation
1	3.2.2.1	Company procedures shall exist to ensure that all personnel, contractors and visitors are aware of the rules regarding the management of wearing and changing of protective clothing in specified areas in accordance with product requirements.	C	There is a maintenance jacket after the high care entrance without "high care" label. Maintenance trousers with a "high care" label are worn in and outside high care areas by maintenance personal. According to procedure "High Care" (3 Oct. 2019). Only "high care" labelled clothing are allowed in high care areas (and not outside those areas). Clean maintenance "high care" labelled maintenance clothing is stored unpacked and open (without any protection) in the maintenance shop.

Chapter 4: Planning and Production Process

Summary of all Chapter 4 deviations and non-conformities found:

Nr.	Reference	IFS requirements	Evaluation	Explanation
1	4.8.3	In case of microbiologically sensitive production areas, these shall be operated and monitored to ensure product safety is not compromised.	C	At the High care department there are water drops falling down from the doorpost between cooling departments "cel 149" and "cel 134".
2	4.9.6.1	Doors and gates shall be in good condition (e.g. no splintering parts, flaking paints or corrosion) and easy to clean.	C	From the top site of the door portal (between lactaat department and meat storage) water is leaking down. The doorpost is corroded at the top.
3	4.10.4	The effectiveness and safety of the cleaning and disinfection measures, based on hazard analysis and assessment of associated risks, shall be *verified and documented* according to a sampling schedule by using appropriate procedures. Resultant corrective actions shall be documented.	C	Around the fulling mouth (bottom site) of the ice machine (lactaat department) there is lime scale.
4	4.14.3	Raw materials, packaging, semi-processed and finished products shall be stored so as to minimise the risk of cross contamination.	C	In the warehouse ("ruimte 10") there is a role primary packaging material ("onder folie) which is not completely covered. The material for use in the high care packaging department.
5	4.17.4	The company shall ensure that all product equipment is in good condition without any negative influence on food safety.	C	In the High care packaging department there are two blue transport belts for packed products (line 1 and line 2) with cracks in the top surface.

Chapter 5: Measurements, analyses, improvements

Summary of all Chapter 5 deviations and non-conformities found:

Nr.	Reference	IFS requirements	Evaluation	Explanation
1	5.1.2	Internal audits of activities which are critical to food safety and product specifications shall be carried out at least once a year.	C	C-Deviation: The Food fraud plan is not demonstrable assessed in past year (seen internal audit reports from 14 May 2018 till 2019 ytd.) The audit frequencies are not demonstrable evaluated towards previous audit performances. There are detailed schedules of internal audit against documented procedures, carried out by trained independent staff (from the VION company). All departments are included in the plan. The audit is done twice a year. One unannounced and one announced audit by VION QA Mangers, trained and experienced. The audits have been carried out to schedule and are on food safety, product integrity, IOS9001 reported in several annexes. Corrective actions have been taken in a timely manner. Audits seen from Purchase by AQ Central, Announced 18-05-2018 & Unannounced 16-01-2017 (both including CCP control), executed by QA manager of Vion Retail Groenlo.

Chapter 6: Food defense

Summary of all Chapter 6 deviations and non-conformities found:

Nr.	Reference	IFS requirements	Evalua-tion	Explanation

No non-conformities found.

Report of the N/A evaluations

Nr.	Reference	IFS requirements	Evaluation	Explanation
1	4.7.3	Outdoor storage shall be kept to a minimum. Where goods are stored outside, hazard analysis and assessment of associated risks shall be undertaken in order to ensure that there is no risk of contamination or adverse effect on quality and food safety.	N/A	no outdoor storage of products or materials.
2	4.8.4	Laboratory facilities and in-process controls shall not affect the product safety.	N/A	no internal lab
3	4.9.9.2	Recycled water which is used in the process shall not pose a contamination risk. The water shall comply with applicable legal requirements for potable water; records of compliance testing shall be available.	N/A	no recycled water
4	4.9.9.4	Non-potable water shall be transported in separate, properly marked piping. Such piping shall not be connected to the drinking water system, or allow the possibility of reflux to contaminate potable water sources or the factory environment.	N/A	Non-potable water is not used
5	4.9.10.1	The quality of compressed air that comes in direct contact with food or primary packaging material shall be monitored based on hazard analysis and assessment of associated risks.	N/A	No direct contact
6	4.12.11	Based on hazard analysis and assessment of associated risks, preventive measures shall be in place for handling of glass packaging, glass containers or other kinds of containers in the production process (turn over, blow, rinse, etc.). After this process step there shall be no further risk of contamination.	N/A	No glass packaging

Nr.	Reference	IFS requirements	Evaluation	Explanation
7	4.19.2	Raw material specifications and delivery documents identifying products consisting of, being made from, or containing GMOs shall be available. The assurances concerning the GMO status of the raw materials shall be agreed by contract with the supplier or the relevant technical documents shall specify the GMO status. The company shall maintain a continuously updated listing of all GMO raw materials used at its premises, which also identifies all blends and formulas to which such GMO raw materials are added.	N/A	No GMO goods
8	4.19.3	There shall be adequate procedures to ensure that where products consisting of or containing GMOs are manufactured, contamination of non-GMO products is avoided. Adequate control measures shall be in place to avoid GMO cross contamination. The effectiveness of these procedures shall be monitored by testing.	N/A	No GMO goods
9	4.19.4	Finished products containing GMOs or labelled as not containing GMOs shall be declared in accordance with current legal requirements. Delivery documents shall include the corresponding reference to GMOs.	N/A	No GMO goods
10	4.19.5	Customer requirements concerning the GMO status of products shall be clearly implemented by the company.	N/A	No GMO goods
11	4.20.4	Where customers specifically require that products are "free from" certain substances or ingredients (e.g. gluten, pork, etc.), or that certain methods of treatment or production are excluded, verifiable procedures shall be in place.	N/A	No free from claims

Nr.	Reference	IFS requirements	Evaluation	Explanation
12	5.5.5	For purchased, already pre-packed products from third parties, there shall be evidence about the compliance with the legal requirements for nominal quantity.	N/A	No direct
13	5.6.3	Procedures shall exist which ensure the reliability of the internal analysis results on the basis of official recognised analysis methods. This shall be demonstrated by ring tests or other proficiency tests.	N/A	No internal analyses
14	6.1.3	If legislation makes registration or onsite inspections necessary, evidence shall be provided.	N/A	No export to USA
15	6.4.1	A documented procedure shall exist for managing external inspections and regulatory visits. Relevant personnel shall be trained to execute the procedure.	N/A	No export to USA

Detailed audit report

Nr.	Reference	IFS requirements	Evaluation	Explanation
1	1	Senior Management Responsibility		
2	1.1	Corporate policy/Corporate principles		
3	1.1.1	The senior management shall draw up and implement a corporate policy. This shall consider as a minimum: - customer focus - environmental responsibility - sustainability - ethics and personnel responsibility - product requirements (includes: product safety, quality, legality, process and specification). The corporate policy shall be communicated to all employees.	A	
4	1.1.2	The content of the corporate policy shall have been broken down into specific objectives for the related departments. The responsibility and the time scale for achievement shall be defined for each department of the company.	A	
5	1.1.3	From the corporate policy, the quality and food safety objectives shall be communicated to the employees in the respective departments and shall be effectively implemented.	A	
6	1.1.4	The senior management shall ensure that the achievement of all objectives is regularly reviewed, as a minimum at least once a year.	A	
7	1.1.5	All relevant information related to food safety and quality shall be communicated effectively and in a timely manner to the relevant personnel.	A	
8	1.2	Corporate structure		

Nr.	Reference	IFS requirements	Evaluation	Explanation
9	1.2.1	An organisation chart shall be available showing the structure of the company.	A	
10	1.2.2	Competences and responsibilities, including deputation of responsibility shall be clearly laid down.	A	
11	1.2.3	Job descriptions with clearly defined responsibilities shall exist and shall be applicable for employees whose work has an effect on product requirements.	A	
12	1.2.4 KO	KO n°1: The senior management shall ensure that employees are aware of their responsibilities related to food safety and quality and that mechanisms are in place to monitor the effectiveness of their operations. Such mechanisms shall be clearly identified and documented.	A	
13	1.2.5	Employees with influence on product requirements shall be aware of their responsibilities, and shall be able to demonstrate their understanding of their responsibilities.	A	
14	1.2.6	The company shall have an IFS representative nominated by senior management.	A	
15	1.2.7	The senior management shall provide sufficient and relevant resources to meet the product requirements.	A	
16	1.2.8	The department responsible for quality and food safety management shall have a direct reporting relationship to the senior management.	A	
17	1.2.9	The company shall ensure that all processes (documented and undocumented) are known by the relevant personnel and are applied consistently.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
18	1.2.10	The company shall have a system in place to ensure that it is kept informed of all relevant legislation on food safety and quality issues, scientific and technical developments and industry codes of practice.	A	
19	1.2.11	The company shall inform its customers, as soon as possible, of any issue related to product specification, in particular of all non-conformity (ies) identified by competent authorities related to products which could have, has or has had a defined impact on safety and/or legality of respective products. This could include, but are not limited to cautionary issues.	A	
20	1.3	Customer focus		
21	1.3.1	A documented procedure shall be in place to identify fundamental needs and expectations of customers.	A	
22	1.3.2	The results of this procedure shall be evaluated and considered to determine quality and food safety objectives.	A	
23	1.4	Management review		
24	1.4.1	Senior management shall ensure that the quality and food safety management systems are reviewed at least annually or more frequently if changes occur. Such reviews shall contain, at least, results of audits, customer feedbacks, process compliance and product conformity, status of preventive and corrective actions, follow up actions from previous management reviews, changes that could affect the food safety and quality management systems and recommendations for improvement.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
25	1.4.2	This review shall include the evaluation of measures for the control of the quality and food safety management system and for the continuous improvement process.	A	
26	1.4.3	The company shall identify and review regularly (e.g. by internal audits or on-site inspection) the infrastructure needed to achieve conformity to product requirements. This shall include, as a minimum, the following: - buildings - supply systems - machines and equipment - transport. The results of the review shall be considered, with due consideration to risk, for investment planning.	A	
27	1.4.4	The company shall identify and review regularly (e.g. by internal audits or on-site inspection) the work environment needed to achieve conformity to product requirements. This shall include, as a minimum the following: - staff facilities - environmental conditions - hygienic conditions - workplace design - external influences (e.g. noise, vibration). The results of the review shall be considered, with due consideration to risk for investment planning.	A	
28	2	Quality and Food Safety Management System		
29	2.1	Quality management		
30	2.1.1	Documentation requirements		
31	2.1.1.1	The system for food safety and quality management shall be documented and implemented, and shall be retained in one location (food safety and quality manual or electronic documented system).	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
32	2.1.1.2	A documented procedure shall exist for the control of documents and their amendments.	A	
33	2.1.1.3	All documents shall be clearly legible, unambiguous and comprehensive. They shall be available to relevant personnel at all times.	A	
34	2.1.1.4	All documents which are necessary for compliance with the product requirements shall be available in their latest version.	A	
35	2.1.1.5	The reason for any amendments to documents critical for the product requirements shall be recorded.	A	
36	2.1.2	Record keeping		
37	2.1.2.1	All relevant records necessary for the product requirements shall be complete, detailed and maintained and shall be available on request.	A	
38	2.1.2.2	Records shall be legible and genuine. They shall be maintained in a way that subsequent manipulation of records is prohibited.	A	
39	2.1.2.3	All records shall be kept in accordance with legal requirements and for a minimum of one year after the shelf life. For products which have no shelf life, the duration of record keeping shall be justified and this justification shall be documented.	A	
40	2.1.2.4	Any amendments to records shall only be carried out by authorised persons.	A	
41	2.1.2.5	Records shall be securely stored and easily accessible.	A	
42	2.2	Food safety Management		
43	2.2.1	HACCP system		

Nr.	Reference	IFS requirements	Evaluation	Explanation
44	2.2.1.1	The basis of the company's food safety control system shall be a fully implemented, systematic and comprehensive HACCP system, based upon the Codex Alimentarius principles. It shall take into account any legal requirements of the production and destination countries which may go beyond such principles. The HACCP system shall be implemented at each production site.	A	
45	2.2.1.2	The HACCP system shall cover all raw materials, products or product groups as well as every process from goods into dispatch, including product development and product packaging.	A	
46	2.2.1.3	The company shall ensure that the HACCP system is based upon scientific literature, or technical verified specifications relating to the manufactured products and procedures. This shall be maintained in line with new technical process development.	A	
47	2.2.1.4	HACCP system shall be reviewed and necessary changes shall be made when any modification is made in the product, process or any step.	A	
48	2.2.2	HACCP team		
49	2.2.2.1	Assemble HACCP team (CA Step 1) The HACCP team shall be multidisciplinary and include operational staff. Personnel appointed as HACCP team members shall have specific knowledge of HACCP, product and process knowledge and the associated hazards. Where competent knowledge is not available, external expert advice shall be obtained.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
50	2.2.2.2	*Those responsible for the* development and maintenance of the HACCP system shall have an internal team leader and shall have received adequate training in the application of the HACCP principles.	A	
51	2.2.2.3	The HACCP team shall have strong senior management support and shall be well known and established across the whole facility.	A	
52	2.2.3	HACCP analysis		
53	2.2.3.1	Describe product (CA Step 2) A full description of the product including all relevant information on product safety exists such as: - composition - physical, organoleptic, chemical and microbiological parameters - legal requirements for the food safety of the product - methods of treatment - packaging - durability (shelf life) - conditions for storage, method of transport and distribution.	A	
54	2.2.3.2	Identify intended use (CA Step 3) The intended use of the product shall be described in relation to the expected use of the product by the end consumer, *taking into account* vulnerable groups of consumers.	A	
55	2.2.3.3	Construct flow diagram (CA Step 4) A flow diagram shall exist for each product, or product group, and for all variations of the processes and sub-processes (including rework and reprocessing). The flow diagram shall be dated, and clearly identify each CCP with the number assigned to it. In the event of any changes the flow diagram shall be updated.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
56	2.2.3.4	On-site confirmation of the flow diagram (CA Step 5) The HACCP team shall verify the flow diagram, by on-site checks, at all operation stages. Amendments to the diagram shall be made, where appropriate.	A	
57	2.2.3.5	Conduct a hazard analysis for each step (CA Step 6 – Principle 1)		
58	2.2.3.5.1	A hazard analysis shall be available for all physical, chemical and biological hazards, including allergens, which may reasonably be expected.	C	The risk of contamination by air in the high care area is not demonstrable assessed in the risk assessment (30 Sep. 2019). (Motivation for C-Dev. Air is filtered and microbiological air monitoring plan show acceptable levels (<100 cfu/m3).
59	2.2.3.5.2	The hazard analysis shall consider the likely occurrence of hazards and severity of their adverse health effects.	A	
60	2.2.3.6	Determine critical control points (CA Step 7 – Principle 2)		
61	2.2.3.6.1	The determination of relevant critical control points (CCP's) shall be facilitated by the application of a decision tree or other tool(s), which demonstrates a logical reasoned approach.	A	
62	2.2.3.6.2	For all steps which are important for food safety, but which are not CCP's, the company shall implement and document control points (CP's) . Appropriate control measures shall be implemented.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
63	2.2.3.7	Establish critical limits for each CCP (CA Step 8 – Principle 3) For each CCP, the appropriate critical limits shall be defined and validated in order to clearly identify when a process is out of control.	A	In total 9 CCP's are determined ("Procedure Overzicht CCP's en CP's" 22-09-2017), including critical limits: CCP 1. Temperature control of (returned) fresh pork meat / beef at reception (≤7°C) CCP 2. Temperature control of (returned) animal by-products/organs at reception (≤3°C) CCP 3. Temperature control of separated meat at reception (≤2°C) CCP 4. NO2 in brine (absence or presence by indicator paper) CCP 5. Temperature control of heat-treated meat products sterilization (2,45 hours at 106°C) *CCP 6. pH after fermentation process (pH≤5,3* within 45 hours) CCP 7. Temperature control of heat-treated meat products pasteurization (P70>3 minutes) CCP 8a. Temperature control of minced meat at dispatch (≤2°C) (former CP) CCP 8b. Temperature control of meat preparations at dispatch (≤4°C) (former CP) CCP 9. Temperature control of chicken meat at reception (≤4°C)
64	2.2.3.8	Establish a monitoring system for each CCP (CA Step 9 – Principle 4)		
65	2.2.3.8.1 KO	KO N° 2: Specific monitoring procedures shall be established for each CCP to detect any loss of control at that CCP. Records of monitoring shall be maintained for a relevant period. Each defined CCP shall be under control. Monitoring and control of each CCP shall be demonstrated by records. The records shall specify the person responsible as well as the date and result of the monitoring activities.	A	Monitoring of the CCP's is demonstrable by trained workers. During the audit, the receiving employees show adequate control of (CCP 1,2,3& 9) temperature measuring at reception, records seen. The thermometers used were calibrated and used correctly. *Also for CCP's in processes (CCP 4, 5, 6 & 7)* employees show adequate control. Were relevant measuring equipment is calibrated. Registrations of checks are demonstrable.
66	2.2.3.8.2	The operative personnel in charge of the monitoring of CCP's shall have received specific training/instruction.	A	
67	2.2.3.8.3	Records of CCP's monitoring shall be checked.	A	
68	2.2.3.8.4	The CP's shall be monitored and this monitoring shall be recorded.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
69	2.2.3.9	Establish corrective actions (CA Step 10 – Principle 5) In the event that the monitoring indicates that a particular CCP or CP is not under control, adequate corrective actions shall be taken and documented. Such corrective actions shall also take into account any non-conforming products.	A	
70	2.2.3.10	Establish verification procedures (CA Step 11 – Principle 6) Procedures of verification shall be established to confirm that the HACCP system is effective. Verification of the HACCP system shall be performed at least once a year. Examples of verification activities include: - internal audits - analysis - sampling - evaluations - complaint by authorities and customers. The results of this verification shall be incorporated into the HACCP system.	A	
71	2.2.3.11	Establish documentation and record keeping (CA Step 12 – Principle 7) Documentation shall be available covering all processes, procedures, control measures and records. Documentation and record keeping shall be appropriate to the nature and size of the company.	A	
72	3	Resource Management		
73	3.1	Human resources management		
74	3.1.1	All personnel performing work that affects product safety, legality and quality shall have the required competence by education, work experience and/or training, commensurate with their role, based on hazard analysis and assessment of associated risks.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
75	3.2	Human resources		
76	3.2.1	Personnel hygiene		
77	3.2.1.1	There shall be documented requirements relating to personnel hygiene. These include, as a minimum, the following fields: - protective clothing - hand washing and disinfection - eating and drinking - smoking - actions to be taken in case of cuts or skin abrasions - fingernails, jewellery and personal belongings - hair and beards. The requirements shall be based on hazard analysis and assessment of associated risks in relation to product and process.	A	
78	3.2.1.2 KO	KO N° 3: The requirements for personnel hygiene shall be in place and applied by all relevant personnel, contractors and visitors.	A	
79	3.2.1.3	Compliance with personnel hygiene requirements shall be checked regularly.	A	
80	3.2.1.4	Visible jewellery (incl. piercing) and watches shall not be worn. Any exceptions shall have been comprehensively evaluated by hazard analysis and assessment of associated risks in relation to product and process. This shall be effectively managed.	A	
81	3.2.1.5	Cuts and skin abrasions shall be covered by a coloured plaster/bandage (different from the product colour) – containing a metal strip, where appropriate – and in case of hand injuries, in addition to a plaster/bandage, a single use glove shall be worn.	A	
82	3.2.2	Protective clothing for personnel, contractors and visitors		

Nr.	Reference	IFS requirements	Evaluation	Explanation
83	3.2.2.1	Company procedures shall exist to ensure that all personnel, contractors and visitors are aware of the rules regarding the management of wearing and changing of protective clothing in specified areas in accordance with product requirements.	C	There is a maintenance jacket after the high care entrance without "high care" label. Maintenance trousers with a "high care" label are worn in and outside high care areas by maintenance personal. According to procedure "High Care" (3 Oct. 2019). Only "high care" labelled clothing are allowed in high care areas (and not outside those areas). Clean maintenance "high care" labelled maintenance clothing is stored unpacked and open (without any protection) in the maintenance shop.
84	3.2.2.2	In work areas where wearing headgear and/or beard snood (coverings) is required, the hair shall be covered completely, so that product contamination is prevented.	A	
85	3.2.2.3	Clearly defined usage rules shall exist for work areas/activities where it is required to wear gloves (coloured differently from the product colour). Compliance with these rules shall be checked on a regular basis.	A	
86	3.2.2.4	Suitable protective clothing shall be available in sufficient quantity for each employee.	A	
87	3.2.2.5	All protective clothing shall be thoroughly and regularly laundered. Hazard analysis and assessment of associated risks, together with consideration given to the processes and products of the company shall determine if clothing shall be washed by a contract laundry, on site laundry or by the employee.	A	
88	3.2.2.6	Guidelines shall exist for laundering of protective clothing and a procedure shall be in place for checking its cleanliness.	A	
89	3.2.3	Procedures applicable to infectious diseases		

Nr.	Reference	IFS requirements	Evaluation	Explanation
90	3.2.3.1	There shall be written and communicated measures for personnel, contractors and visitors to declare any infectious disease which may have an impact on food safety. In case of declaration of infectious disease, actions shall be taken in order to minimize risk of contamination of products.	A	
91	3.3	Training and instruction		
92	3.3.1	The company shall implement documented training and/or instruction programs with respect to the product requirements and the training needs of the employees based on their job and shall include: - training contents - training frequency - employee's task - languages - qualified trainer/tutor - evaluation methodology.	A	
93	3.3.2	The documented training and/or instruction shall apply to all personnel, including seasonal and temporary workers and employees from external companies, employed in the respective work area. Upon employment, and before commencing work, they shall be trained in accordance with the documented training/instruction programs.	A	
94	3.3.3	Records shall be available of all training/instruction events, stating: - list of participants (this shall include their signature) - date - duration - contents of training - name of trainer/tutor. There shall be a procedure or program in place to prove the effectiveness of the training and/or instruction programs.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
95	3.3.4	The contents of training and/or instruction shall be reviewed and updated regularly and take into account company's specific issues, food safety, food related legal requirements and product/process modifications.	A	
96	3.4	Sanitary facilities, equipment for personnel hygiene and staff facilities		
97	3.4.1	The company shall provide staff facilities, which shall be proportional in size, equipped for the number of personnel and designed and operated so as to minimise food safety risks. Such facilities shall be kept in clean and good condition.	A	
98	3.4.2	The risk of product contamination by foreign material from staff facilities shall be evaluated and minimised. Consideration shall also be given to food brought to work by personnel and personal belongings.	A	
99	3.4.3	There shall be in place rules and facilities to ensure the correct management for personnel belongings and for food brought to work by personnel, food coming from dining room and from vending machines. The food shall only be stored and/or used in designated areas.	A	
100	3.4.4	The company shall provide suitable changing rooms for personnel, contractors and visitors. Where necessary, outdoor clothing and protective clothing shall be stored separately.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
101	3.4.5	Toilets shall not have direct access to an area where food products are handled. The toilets shall be equipped with adequate hand washing facilities. Sanitary facilities shall have adequate natural or mechanical ventilation. Mechanical airflow from a contaminated area to a clean area shall be avoided.	A	
102	3.4.6	Adequate hand hygiene facilities shall be provided at access points to and within production areas, as well as at staff facilities. Based on hazard analysis and assessment of associated risks, further areas (e.g. packaging area) shall be similarly equipped.	A	
103	3.4.7	Hand washing facilities shall provide as a minimum: - running potable water at an appropriate temperature - liquid soap - appropriate equipment for hand drying.	A	
104	3.4.8	Where highly perishable food products are handled, the following additional requirements regarding hand hygiene shall also be provided: - hand contact-free fittings - hand disinfection - adequate hygiene equipment - signage highlighting hand hygiene requirements - waste container with hand contact-free opening.	A	
105	3.4.9	Based on hazard analysis and assessment of associated risks, there shall be a program to control effectiveness of hand hygiene.	A	
106	3.4.10	Changing rooms shall be situated so that they allow direct access to the areas where food products are handled. Based on hazard analysis and assessment of associated risks, exceptions shall be justified and managed.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
107	3.4.11	Where the hazard analysis and assessment of associated risks show the necessity, cleaning facilities shall be available and used for boots, shoes and further protective clothing.	A	
108	4	Planning and Production Process		
109	4.1	Contract agreement		
110	4.1.1	The requirements which are defined between the contract partners shall be established, agreed upon and reviewed concerning their acceptability before a supply agreement is concluded. All clauses related to quality and food safety shall be known and communicated to each relevant department.	A	
111	4.1.2	Changes of existing contractual agreements shall be documented and communicated between the contract partners.	A	
112	4.2	Specifications and formulas		
113	4.2.1	Specifications		
114	4.2.1.1	Specifications shall be available and in place for all finished products. They shall be up to date, unambiguous and be in compliance with legal and customer requirements.	A	
115	4.2.1.2 KO	KO N° 4: Specifications shall be available and in place for all raw materials (raw materials/ingredients, additives, packaging materials, rework). Specifications shall be up to date, unambiguous and be in compliance with legal requirements and, if existing, with customer requirements.	A	Specifications for raw materials, ingredients, additives, packaging materials, final product have been checked during the IFS audit (as part of the vertical audit) seen: raw materials/ ingredients: Finished product "blk1 Schouderham gerookt" art nr. 301120 dd 24-06-2019 "FS Pees eind blauw" (pork) 13-02-2018. ' : (starch) " 02-05-2019. "Pekelmix" (brine mix) 12-04-2018. "Packaging material: Foil bag (incl. migration) 09-10-2018. Map gasses CO2 21-02-2018 & N2 14-08-2019

Nr.	Reference	IFS requirements	Evaluation	Explanation
116	4.2.1.3	Where required by customers, product specifications shall be formally agreed.	A	If necessary (retail brands), the final product specifications have been agreed upon with the customers. Such specifications are checked during the audit, e.g. "blk1 Schouderham gerookt" art nr. 301120 dd 24-06-2019. Seen costumers agreement / status on customers web portal
117	4.2.1.4	Specifications and/or their contents shall be provided in the relevant location and accessible to all relevant personnel.	A	
118	4.2.1.5	There shall be a procedure for the creation, the modification and approval of specifications for all parts of the process, which shall include the preliminary acceptance of the customer, if specifications have been agreed with customers.	A	
119	4.2.1.6	The specification control procedure shall include the update of finished product specification in case of any modification: - of raw material - of formula/recipe - of process with influence on the final products - of packaging with influence on the final products.	A	
120	4.2.2	Formula/recipes		
121	4.2.2.1 KO	KO N° 5: Where there are customer agreements in relation to the product formula/recipe and technological requirements, these shall be complied with.	A	Recipes and formulas are part of contracts and specifiations and/or Retail website portals. e.g. seen for "blk1 Schouderham gerookt" art nr. 301120 dd 24-06-2019 costumers agreement / status on customers web portal
122	4.3	Product development/Product modification/Modification of production processes		
123	4.3.1	A procedure for product development shall be in place which incorporates the hazard analysis principles, in accordance with the HACCP system.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
124	4.3.2	Product formulation, manufacturing processes, process parameters and the fulfilment of product requirements shall be established and shall have been assured by factory trials and product testing.	A	
125	4.3.3	Shelf life tests or adequate processes shall be carried out and consideration given to product formulation, packaging, manufacturing and declared conditions; "Use by" or "Best before" dates shall be established accordingly.	A	
126	4.3.4	When establishing and validating the shelf life of the product (including long shelf life product i.e. labelled with a "best before date"), the results of organoleptic tests shall also be taken into account.	A	
127	4.3.5	Product development shall consider the results of organoleptic assessments.	A	
128	4.3.6	A process shall be in place to ensure that labelling complies with current legislation of destination country and customer requirements.	A	
129	4.3.7	Recommendations for preparation and/or use of the food products shall be established. Where appropriate, customer requirements shall be included.	A	
130	4.3.8	The company shall demonstrate through studies and/or perform relevant tests in order to validate nutritional information or claims which are mentioned on labelling. This applies both for a new product and during all its period of sale.	A	
131	4.3.9	The progress and results of product development shall be properly recorded.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
132	4.3.10	The company shall ensure that in the event of changes to product formulation, including rework and packaging material, process characteristics are reviewed in order to assure that product requirements are complied with.	A	
133	4.4	Purchasing		
134	4.4.1	The company shall control purchasing processes to ensure that all externally sourced materials and services, which have an impact on food safety and quality, conform to requirements. Where a company chooses to outsource any process that may have an impact on food safety and quality, the company shall ensure control over such processes. Control of such outsourced processes shall be identified and documented within the food safety and quality management system.	A	
135	4.4.2	There shall be a procedure for approval and monitoring of suppliers (internal and external), outsourced production or part of it.	A	
136	4.4.3	The approval and monitoring procedure shall contain clear assessment criteria such as: audits, certificates of analysis, supplier reliability and complaints, as well as required performance standards.	A	
137	4.4.4	The results of suppliers' assessments shall be reviewed regularly and this review shall be based on hazard analysis and assessment of associated risks. There shall be records of the reviews and of the actions taken as a consequence of assessment.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
138	4.4.5	The purchased products shall be checked in accordance with the existing specifications and their authenticity, based on hazard analysis and assessment of associated risks. The schedule of these checks shall, as a minimum, take into account the following criteria; product requirements, supplier status (according to its assessment) and impact of the purchased products on the finished product. The origin shall be additionally checked, if mentioned in the specification.	A	
139	4.4.6	The purchased services shall be checked in accordance with the existing specifications. The schedule of these checks shall at least take into account the following items: service requirements, supplier status (according to its assessment) and impact of the service on the finished product.	A	
140	4.5	Product packaging		
141	4.5.1	Based on hazard analysis, assessment of associated risks and intended use, the company shall determine the key parameters for the packaging material.	A	Description of which kind of packaging material is used for the final products: plastic packaging like trays/scales with foil, sealed foil packs (consumer & BtoB), crates with innerbag etc. Casings to produce sausage is also seen as primary packaging.
142	4.5.2	Detailed specifications shall exist for all packaging materials which comply with the current relevant legislation.	A	
143	4.5.3	For all packaging material which could have an influence on products, certificates of conformity shall exist which comply with current legal requirements. In the event that no specific legal requirements are applicable, evidence shall be available to demonstrate that packaging material is suitable for use. This applies for packaging material which could have an influence on raw materials, semi-processed and finished products.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
144	4.5.4	Based on hazard analysis and assessment of associated risks, the company shall verify the suitability of the packaging material for each relevant product (e.g. organoleptic tests, storage tests, chemical analysis, migration tests).	A	
145	4.5.5	The company shall ensure that the packaging used corresponds to the product being packed. The use of correct packaging shall be regularly checked and checks shall be documented.	A	
146	4.5.6	Labelling information shall be legible indelible and shall comply with agreed customer product specifications. This shall be regularly checked and checks shall be documented.	A	
147	4.6	Factory location		
148	4.6.1	The company shall investigate to what extent the factory environment (e.g. ground, air) may have an adverse impact on product safety and product quality. Where it is established product safety and quality could be compromised, appropriate measures shall be established. The effectiveness of the established measures shall be periodically reviewed (*examples: extremely dusty air*, strong smells).	A	
149	4.7	Factory Exterior		
150	4.7.1	The factory exterior shall be maintained to be clean and tidy.	A	
151	4.7.2	All external areas of the factory shall be maintained in good condition. Where natural drainage is inadequate, a suitable drainage system shall be installed.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
152	4.7.3	Outdoor storage shall be kept to a minimum. Where goods are stored outside, hazard analysis and assessment of associated risks shall be undertaken in order to ensure that there is no risk of contamination or adverse effect on quality and food safety.	N/A	no outdoor storage of products or materials.
153	4.8	Plant layout and process flows		
154	4.8.1	Plans clearly describing internal flows of finished products, packaging materials, raw materials, waste, personnel, water, etc. shall be in place. A site map covering all buildings of the facility shall be available.	A	
155	4.8.2	The process flow, from receipt of goods to dispatch, shall be in place so that contamination of raw materials, packaging, semi-processed and finished products is avoided. The risk of cross-contamination shall be minimised through effective measures.	A	
156	4.8.3	In case of microbiologically sensitive production areas, these shall be operated and monitored to ensure product safety is not compromised.	C	At the High care department there are water drops falling down from the doorpost between cooling departments "cel 149" and "cel 134".
157	4.8.4	Laboratory facilities and in-process controls shall not affect the product safety.	N/A	no internal lab
158	4.9	Constructional requirements for production and storage areas		
159	4.9.1	Constructional requirements		
160	4.9.1.1	Rooms where food products are prepared, treated, processed and stored shall be designed and constructed so that food safety is ensured.	A	
161	4.9.2	Walls		

Nr.	Reference	IFS requirements	Evaluation	Explanation
162	4.9.2.1	Walls shall be designed and constructed to prevent the accumulation of dirt, to reduce condensation and mould growth, and to facilitate cleaning.	A	
163	4.9.2.2	The surfaces of walls shall be in a good condition and easy to clean; they shall be impervious and wear-resistant.	A	
164	4.9.2.3	The junctions between walls, floors and ceilings shall be designed to facilitate cleaning.	A	
165	4.9.3	Floors		
166	4.9.3.1	Floor covering shall be designed to meet production requirements and shall be in good condition and easy to clean. Surfaces shall be impervious and wear-resistant.	A	
167	4.9.3.2	The hygienic disposal of waste water shall be ensured. Drainage systems shall be easy to clean and designed to minimise the risk of product contamination (e.g. ingress of pests, etc.).	A	
168	4.9.3.3	Water or other liquids shall reach drainage without difficulties, using appropriate measures. Puddles shall be avoided.	A	
169	4.9.3.4	In food handling areas, machinery and piping shall be arranged so that waste water, if possible, goes directly into a drain.	A	
170	4.9.4	Ceilings/Overheads		
171	4.9.4.1	Ceilings (or, where no ceilings exist, the inside of roofs) and overhead fixtures (incl. piping, cableway, lamps etc.) shall be constructed to minimise the accumulation of dirt and shall not pose any risk of physical and/or microbiological contamination.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
172	4.9.4.2	Where false ceilings are used, an access to the void shall be provided in order to facilitate cleaning, maintenance and inspections for pest control.	A	
173	4.9.5	Windows and other openings		
174	4.9.5.1	Windows and other openings shall be designed and constructed to avoid the accumulation of dirt and shall be maintained in good condition.	A	
175	4.9.5.2	Where there is risk of contamination, windows and roof glazing shall remain closed and fixed during production.	A	
176	4.9.5.3	Where windows and roof glazing are designed to be opened for ventilation purposes, they shall be fitted with easily removable, good condition pest screens or other measures in order to avoid any contamination.	A	Windows and roof glazing are not designed to be opened.
177	4.9.5.4	In areas where unpackaged product is handled, windows shall be protected against breakage.	A	
178	4.9.6	Doors and gates		
179	4.9.6.1	Doors and gates shall be in good condition (e.g. no splintering parts, flaking paints or corrosion) and easy to clean.	C	From the top site of the door portal (between lactaat department and meat storage) water is leaking down. The doorpost is corroded at the top.
180	4.9.6.2	External doors and gates shall be constructed to prevent the ingress of pests; if possible, they shall be self-closing.	A	
181	4.9.7	Lighting		
182	4.9.7.1	All working areas shall have adequate lighting.	A	
183	4.9.7.2	All lighting equipment shall be protected by shatter proof covers and installed to minimise the risk of breakage.	A	
184	4.9.8	Air conditioning/Ventilation		

Nr.	Reference	IFS requirements	Evaluation	Explanation
185	4.9.8.1	Adequate natural and/or artificial ventilation shall exist in all areas.	A	
186	4.9.8.2	If ventilation equipments are installed, filters and other components which require cleaning or replacement shall be easily accessible.	A	
187	4.9.8.3	Air conditioning equipment and artificially generated airflow shall not lead to any product safety or quality risks.	A	
188	4.9.8.4	Dust extraction equipment shall be installed in areas where considerable amounts of dust are generated.	A	
189	4.9.9	Water supply		
190	4.9.9.1	Water which is used as ingredient in the production process, or for cleaning, shall be of potable quality and supplied in sufficient quantity; this also applies to steam and ice used within the production area. A supply of potable water shall be available at all times.	A	Water is used as an ingredient, for cleaning water and for the production of ice. (Steam is supplied from neighbour Vion). All water (incl steam and ice) used on site is potable water. Water is tested 2 times a year for E coli, Enterococcen and Total count. Results are within limits. Ice is tested 1 time a year for E coli, Enterococcen and Total count. Results are within limits. Quality is analysed by external accreditated lab
191	4.9.9.2	Recycled water which is used in the process shall not pose a contamination risk. The water shall comply with applicable legal requirements for potable water; records of compliance testing shall be available.	N/A	no recycled water
192	4.9.9.3	The quality of water, steam or ice shall be monitored following a risk based sampling plan.	A	
193	4.9.9.4	Non-potable water shall be transported in separate, properly marked piping. Such piping shall not be connected to the drinking water system, or allow the possibility of reflux to contaminate potable water sources or the factory environment.	N/A	Non-potable water is not used
194	4.9.10	Compressed air		

Nr.	Reference	IFS requirements	Evaluation	Explanation
195	4.9.10.1	The quality of compressed air that comes in direct contact with food or primary packaging material shall be monitored based on hazard analysis and assessment of associated risks.	N/A	No direct contact
196	4.9.10.2	Compressed air shall not pose a risk of contamination.	A	
197	4.10	Cleaning and disinfection		
198	4.10.1	Based on hazard analysis and assessment of associated risks, cleaning and disinfection schedules shall be available and implemented. These shall specify: - objectives - responsibilities - the products used and their instructions for use - the areas to be cleaned and/or disinfected - cleaning frequency - documentation requirements - hazard symbols (if necessary).	A	
199	4.10.2	Cleaning and disinfection schedules shall be implemented and documented.	A	
200	4.10.3	Only qualified personnel shall be allowed to undertake cleaning and disinfection. The personnel shall be trained and retrained to carry out the cleaning schedules.	A	
201	4.10.4	The effectiveness and safety of the cleaning and disinfection measures, based on hazard analysis and assessment of associated risks, shall be verified and documented according to a sampling schedule by using appropriate procedures. Resultant corrective actions shall be documented.	C	Around the fulling mouth (bottom site) of the ice machine (lactaat department) there is lime scale.
202	4.10.5	Cleaning and disinfection schedules shall be reviewed and modified, if necessary, in the event of a change to product, process or cleaning equipment.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
203	4.10.6	The intended use of cleaning utensils shall be clearly identified. Cleaning utensils shall be used in a way to avoid contamination.	A	
204	4.10.7	Current safety data sheets (SDS) and instructions for use shall be available for chemicals and cleaning agents. Personnel responsible for cleaning shall be able to demonstrate their knowledge of such instructions, which shall be always available on site.	A	
205	4.10.8	Cleaning chemicals shall be clearly labelled, used and stored appropriately, to avoid contamination.	A	
206	4.10.9	Cleaning activities shall be carried out in periods of non-production. If this is not possible, these operations shall be controlled as to not affect the product.	A	
207	4.10.10	Where a company hires a third -party service provider for cleaning and disinfection activities, all requirements specified within section 4.10 shall be clearly defined in the respective contract.	A	
208	4.11	Waste disposal		
209	4.11.1	A waste management procedure shall exist and shall be implemented to avoid cross contamination.	A	
210	4.11.2	All current legal requirements for waste disposal shall be met.	A	
211	4.11.3	Food waste and other waste shall be removed as quickly as possible from areas where food is handled. The accumulation of waste shall be avoided.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
212	4.11.4	Waste collection containers shall be clearly marked, suitably designed, in good state of repair, easy to clean, and where necessary disinfected.	A	
213	4.11.5	Waste collection rooms and containers (incl. compactors) shall be designed to be kept clean to minimise pest attraction.	A	
214	4.11.6	Waste shall be collected in separate containers in accordance with the intended means of disposal. Such waste shall be disposed by authorised third parties only. Records of waste disposal shall be kept by the company.	A	
215	4.12	Risk of foreign material, metal, broken glass and wood		
216	4.12.1 KO	KO N° 6 Based on hazard analysis and assessment of associated risks, procedures shall be in place to avoid contamination with foreign material. Contaminated products shall be treated as non-conforming products.	A	For the removal of potential foreign bodies metal detectors are in place at the end of each packaging line. Department "Worstmakerij" (0.8 mm Fe, 1.2 mm, non-Fe, and 2.4 mm SS), Department "Industrial" (2.0 mm Fe, 2.5 mm, non-Fe, 3.0 mm SS) Department "slice" (1.2 mm Fe, 2.4 mm non-Fe, and 3.2 mm SS), The metal detectors are tested 4x/day, including the end of production, by using test pieces according the accuracies described.
217	4.12.2	In all areas, e.g. handling of raw materias, processing, packing and storage, where hazard analysis and assessment of associated risks have identified the potential for product contamination, the use of wood shall be excluded. Where the use of wood cannot be avoided, the risk shall be controlled and the wood shall be in good order and clean.	A	
218	4.12.3	Where metal- and/or other foreign material detectors are required, they shall be installed to ensure maximum efficiency of detection, in order to avoid subsequent contamination. Detectors shall be subjected to regular maintenance to avoid malfunction.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
219	4.12.4	Potentially contaminated products shall be isolated. Access and actions for further handling or checking for these isolated products shall be carried out only by authorised personnel according to defined procedures. After this check, contaminated products shall be treated as non-conforming products.	A	
220	4.12.5	The appropriate accuracy of detectors shall be specified. Checks of proper function of detectors shall be carried out regularly. In case of malfunction or failure of a metal and/or foreign material detector, corrective actions shall be defined, implemented and documented.	A	
221	4.12.6	In cases where special equipment or methods are used to detect foreign material, these shall be properly validated and maintained.	A	
222	4.12.7	In all areas, e.g. handling of raw materials, processing, packing and storage, where hazard analysis and assessment of associated risks have identified a potential product contamination, the presence of glass and brittle material shall be excluded. Where the presence of glass or brittle plastic cannot be avoided, appropriate measures shall be in place to protect against breakage.	A	
223	4.12.8	All stationary objects made of or incorporating glass or brittle material present in areas of handling of raw materials, processing, packing and storage shall be listed in a specific register, including details of their exact location. An assessment of the condition of objects on the register shall be performed on a regular basis and recorded. Frequency of this check shall be justified by documents.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
224	4.12.9	Breakages of glass and brittle material shall be recorded. Exceptions shall be justified and documented.	A	
225	4.12.10	Procedures shall be in place describing the measures to be taken in case of breakage of glass and/or brittle material. Such measures shall include identifying the scope of goods to be isolated, specifying authorised personnel, cleaning the production environment and release of production line for continued production.	A	
226	4.12.11	Based on hazard analysis and assessment of associated risks, preventive measures shall be in place for handling of glass packaging, glass containers or other kinds of containers in the production process (turn over, blow, rinse, etc.). After this process step there shall be no further risk of contamination.	N/A	No glass packaging
227	4.12.12	Where visual inspection is used to detect foreign material, the employees shall be trained and operative change shall be performed at an appropriate frequency to maximise effectiveness of process.	A	
228	4.13	Pest monitoring/Pest control		

Nr.	Reference	IFS requirements	Evaluation	Explanation
229	4.13.1	The company shall have a pest control system in place which is in compliance with local legal requirements, taking into account, as a minimum: - the factory environment (*potential pests*) - site plan with area for application (bait map) - identification of the baits on site - responsibilities, in-house/external - used products/agents and their instructions for use and safety - the frequency of inspections. The pest control system shall be based on hazard analysis and assessment of associated risks.	A	Pest control is contracted to (central) for rodents (rats and mice) and insects (cockroaches and flying insects); frequency of control is 8 x / year; maintenance of EFK is 1 x / year. And assessment on the Pest control system and a Pest risk inventory 1x / year (Frequency of the in-depth pest control survey is risk based and accepted). All documentation is present in the contract map of (digital). Up to date site plans (are available to show the location of rodent baits, mouse traps, crawling and flying insect control units. Constructional action points are solved. Only Non-Tox is used. Trends over 2019 ytd. show no signs of rodent
230	4.13.2	The company shall have qualified and trained in-house staff and/or employ the services of a qualified external provider. Where an external provider is used, the activities required on site shall be specified in a written contract.	A	
231	4.13.3	Pest control inspections and resulting actions shall be documented. Implementation of actions shall be monitored and recorded.	A	
232	4.13.4	Baits, traps and insect *exterminators shall be* functioning, shall be in sufficient numbers and shall be placed in an appropriate position. They shall be constructed and positioned as not to cause any contamination risk.	A	
233	4.13.5	Incoming deliveries shall be checked on arrival for the presence of pests. Any infestation shall be documented and control measures taken.	A	
234	4.13.6	The effectiveness of the pest control shall be monitored with the help of regular trend analyses.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
235	4.14	Receipt of goods and storage		
236	4.14.1	All incoming goods, including packaging materials and labels, shall be checked for conformity against specifications and to a determined inspection plan. The inspection plan shall be risk based. Test results shall be documented.	A	
237	4.14.2	The storage conditions of raw materials, semi-processed and finished products as well as packaging shall in each case correspond to product requirements (e.g. refrigeration, protective covers) and shall not be detrimental to other products.	A	
238	4.14.3	Raw materials, packaging, semi-processed and finished products shall be stored so as to minimise the risk of cross contamination.	C	In the warehouse ("ruimte 10") there is a role primary packaging material ("onder folie ") which is not completely covered. The material for use in the high care packaging department.
239	4.14.4	Appropriate storage facilities shall be available for the management and storage of working materials, process aids, and additives. The personnel responsible for the management of storage facilities shall be trained.	A	
240	4.14.5	All products shall be clearly identified. Use of products shall be undertaken in accordance with the principles of First In/First Out and/or First Expired/First Out.	A	
241	4.14.6	Where a company hires a third -party storage service provider, the service provider shall be subject to IFS Logistics requirements. If the third party service provider is not certified to IFS Logistics, all relevant requirements equivalent to the company's own warehousing practices shall be fulfilled and this shall be clearly defined in the respective contract.	A	
242	4.15	Transport		

Nr.	Reference	IFS requirements	Evaluation	Explanation
243	4.15.1	Before loading transport vehicles, their condition (e.g. absence of strange smells, high dust load, adverse humidity, pests, mould) shall be checked and action taken, if necessary.	A	
244	4.15.2	Procedures to prevent contamination during transport shall be implemented (food/non-food/different categories of goods).	A	
245	4.15.3	Where goods must be transported at certain temperatures, before loading, the temperature inside the vehicle shall be checked and documented.	A	
246	4.15.4	Where goods must be transported at certain temperatures, maintaining the adequate range of temperatures during transport shall be ensured and documented.	A	
247	4.15.5	Adequate hygienic requirements for all transport vehicles and equipment used for loading/unloading (e.g. hoses of silo installations) shall exist. There shall be records of the measures taken.	A	
248	4.15.6	Loading and unloading areas shall have equipment in place to protect transported products from external influences.	A	
249	4.15.7	Where a company hires a third -party transport service provider, all the requirements specified within section 4.15 shall be clearly defined in the respective contract or the service provider shall be subject to IFS Logistics requirements.	A	
250	4.15.8	Security of transport vehicles shall be appropriately maintained.	A	
251	4.16	Maintenance and repair		

Nr.	Reference	IFS requirements	Evaluation	Explanation
252	4.16.1	An adequate system of maintenance shall be in place, maintained and documented, covering all critical equipment (incl. transport) for compliance with product requirements. This applies both for internal and external maintenance activities.	A	
253	4.16.2	Product requirements and prevention of contamination shall be ensured during and after maintenance and repair work. Records of maintenance and repair work and of corrective actions taken shall be kept.	A	
254	4.16.3	All materials used for maintenance and repair shall be fit for the intended use.	A	
255	4.16.4	Failures of plant and equipment (incl. transport) covered by the maintenance system shall be documented and reviewed with a view to adapting the maintenance system.	A	
256	4.16.5	Temporary repairs shall be carried out so that product requirements are not affected. Such work shall be documented and a short-term deadline set for eliminating the fault.	A	
257	4.16.6	Where a company hires a third -party maintenance and repair service provider, all the company specified requirements regarding material and equipment shall be clearly defined, documented and maintained.	A	
258	4.17	Equipment		
259	4.17.1	Equipment shall be suitably designed and specified for the intended use. Before commissioning, it shall be verified that the product requirements are complied with.	A	I

Nr.	Reference	IFS requirements	Evaluation	Explanation
260	4.17.2	For all equipment and tools with direct food contact, certificates of conformity shall exist which confirm compliance with current legal requirements. In case no specific legal requirements are applicable, evidence shall be available to demonstrate that all equipment and tools are suitable for use. This applies for all equipment and tools in direct contact with raw materials, semi-processed and finished products.	A	
261	4.17.3	Equipment shall be designed and located so that cleaning and maintenance operations can be effectively performed.	A	
262	4.17.4	The company shall ensure that all product equipment is in good condition without any negative influence on food safety.	C	In the High care packaging department there are two blue transport belts for packed products (line 1 and line 2) with cracks in the top surface.
263	4.17.5	The company shall ensure that in the event of changes to processing methods and equipment, process characteristics are reviewed in order to assure that product requirements are complied with.	A	
264	4.18	Traceability (including GMOs and allergens)		

Nr.	Reference	IFS requirements	Evaluation	Explanation
265	4.18.1 KO	KO N° 7: A traceability system shall be in place which enables the identification of product lots and their relation to batches of raw materials, packaging in direct contact with food, packaging intended or expected to be in direct contact with food. The traceability system shall incorporate all relevant receiving processing and distribution records. Traceability shall be ensured and documented until delivery to the customer.	A	A procedure defines how traceability is operated with the help of a computer system. The site's traceability system includes full traceability of raw materials, intermediate products and final products at all stages during food manufacturing and dispatch / transport. The system bases on input data at receiving stage, than labeling semi-products and control them. The site conducts minimal annual a traceability (combined with recall) test. The traces reconciled quantities of final products produced forward to dispatch to customer's addresses and to the raw material intake records and tests, mass balance conducted with traceability test complete. Traceability test dated 27-09-2019. The test lasted less than 4 hours. A product was chosen by the auditor for an onsite traceability test: "blk1 Schouderham gerookt" 175 g e art nr. 301120, production date 15-08-2019, Best before 12-09-2019. for customer A full review was available and showed the test to have been satisfactory. All demanded information could be shown, CCP's, hygiene control, raw materials with coding and specifications, start-up checks, product- and label controls, cleaning, specifications, packing materials and specification and label finished product. The traceability test of this case was carried out within 4 hours.
266	4.18.2	Downstream traceability records (from production sites to the customers) shall be available. The timeframe for producing these records for review shall be compliant with customer's requirements.	A	
267	4.18.3	Traceability shall be in place to identify the relationship between batches of final products and their labels.	A	
268	4.18.4	The traceability system shall be tested on a periodic basis - at least annually and each time traceability system changes. The test shall verify upstream and downstream traceability (from delivered products to raw materials, and vice versa), including quantity checking. Test results shall be recorded.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
269	4.18.5	Traceability shall be ensured at all stages, including work in progress, post treatment and rework.	A	
270	4.18.6	Labelling of semi-finished or finished product lots shall be made at the time when the goods are directly packed to ensure a clear traceability of goods. Where goods are labelled at a later time, the temporarily stored goods shall have been provided with a specific lot labelling. The shelf life (e.g. best before date) of the labelled goods shall be calculated from the original production batch.	A	
271	4.18.7	If required by customer, identified samples representative for the manufacturing lot shall be stored appropriately and kept until expiration of the "Use by" or "Best before date" of the finished product and if necessary for a determined period beyond this date.	A	
272	4.19	Genetically modified organisms (GMOs)		
273	4.19.1	For products being delivered to customers and/or countries with GMO requirements, the company shall have in place systems and procedures to allow the identification of products consisting of GMOs, containing GMOs or produced from GMOs, including food ingredients, additives and flavouring(s).	A	Is the company working with products consisting of GMOs, containing GMOs or produced from GMOs? : no NO GMO's materials are used. Checked raw material specifications.

Nr.	Reference	IFS requirements	Evaluation	Explanation
274	4.19.2	Raw material specifications and delivery documents identifying products consisting of, being made from, or containing GMOs shall be available. The assurances concerning the GMO status of the raw materials shall be agreed by contract with the supplier or the relevant technical documents shall specify the GMO status. The company shall maintain a continuously updated listing of all GMO raw materials used at its premises, which also identifies all blends and formulas to which such GMO raw materials are added.	N/A	No GMO goods
275	4.19.3	There shall be adequate procedures to ensure that where products consisting of or containing GMOs are manufactured, contamination of non-GMO products is avoided. Adequate control measures shall be in place to avoid GMO cross contamination. The effectiveness of these procedures shall be monitored by testing.	N/A	No GMO goods
276	4.19.4	Finished products containing GMOs or labelled as not containing GMOs shall be declared in accordance with current legal requirements. Delivery documents shall include the corresponding reference to GMOs.	N/A	No GMO goods
277	4.19.5	Customer requirements concerning the GMO status of products shall be clearly implemented by the company.	N/A	No GMO goods
278	4.20	Allergens and specific conditions of production		

Nr.	Reference	IFS requirements	Evaluation	Explanation
279	4.20.1	Raw material specifications identifying allergens requiring declaration that are relevant to the country of sale of the finished product shall be available. The company shall maintain a continuously up to date listing of all raw materials containing allergens used at its premises, which also identifies all blends and formulas to which such raw materials containing allergens are added.	A	Present allergens: EU Cereal grains / gluten (EU) Soy and products thereof (EU) Milk and products thereof (EU) Mustard and products thereof (EU) Sulfur dioxide and sulphite (EU) Allergens are managed by the company by separation in time and place. If allergens are present which can contaminate the product next in line measurements are taken. Products with the same allergens are planned together and new hand shoes, sleeves and aprons, the line will be cleaned dry. Allergens present on site are: Soya, Celery, Mustard, Gluten, Milk/Lactose, Sulphur dioxide and Sulphites.
280	4.20.2	Based on hazard analysis and assessment of associated risk, control measures shall be in place from receipt to dispatch, to ensure that cross contamination of products by allergens is minimised. Control measures shall be verified.	A	
281	4.20.3	Finished products containing allergens requiring declaration shall be declared in accordance with current legal requirements. For the adventitious or unintentional presence, the labelling of legally declared allergens and traces shall be based on hazard analysis and assessment of associated risks.	A	
282	4.20.4	Where customers specifically require that products are "free from" certain substances or ingredients (e.g. gluten, pork, etc.), or that certain methods of treatment or production are excluded, verifiable procedures shall be in place.	N/A	No free from claims
283	4.21	Food Fraud		

Nr.	Reference	IFS requirements	Evaluation	Explanation
284	4.21.1	A documented food fraud vulnerability assessment shall be undertaken on all raw materials, ingredients, packaging and outsourced processes, to determine the risk of fraudulent activity in relation to substitution, mislabelling, adulteration or counterfeiting. The criteria considered within the vulnerability assessment shall be defined.	A	Fraud-susceptible raw materials/products identified in the vulnerability assessment: Others organic and BLK meat The documented vulnerability assessment is made in conjunction with VION HQ as showed during supplier evaluation. P-NLFood-10211. In 2018 a central Vion procedure "Product voedsel Fraude" (latest version 05-08-2019) for Food Fraud has been set up (including planning for yearly review). An assessment for Encebe according to Vion procedure has been performed "Gevaren analyse Food Fraude voor grondstoffen en groepen" 05-08-2019. Evalution parameters are e.g. RASSF, Potential for fraud (dilution, replacement etc.), Chance to find/discover, Possible appearance on Vion's purchase market. No high-risk ingredients and meat where found. Besides Organic and BLK certification (and control measures), further no special control measures are identified. Meat BLK and Organic,
285	4.21.2	A documented food fraud mitigation plan shall be developed, with reference to the vulnerability assessment, and implemented to control any identified risk. The methods of control and monitoring shall be defined and implemented.	A	
286	4.21.3	In the event of increased risk, food fraud vulnerability assessment shall be reviewed. Otherwise all vulnerability assessments shall be reviewed at least annually. Control and monitoring requirements of the food fraud mitigation plan shall be reviewed and amended when applicable.	A	
287	5	Measurements, Analysis, Improvements		
288	5.1	Internal audits		

Nr.	Reference	IFS requirements	Evaluation	Explanation
289	5.1.1 KO	KO N° 8: Effective internal audits shall be conducted according to a defined agreed audit program and shall cover at least all requirements of the IFS Standard. Scope and frequency of internal audits shall be determined by hazard analysis and assessment of associated risks. This is also applicable for off-site storage locations owned or rented by the company.	A	
290	5.1.2	Internal audits of activities which are critical to food safety and product specifications shall be carried out at least once a year.	C	C-Deviation: The Food fraud plan is not demonstrable assessed in past year (seen internal audit reports from 14 May 2018 till 2019 ytd.) The audit frequencies are not demonstrable evaluated towards previous audit performances. There are detailed schedules of internal audit against documented procedures, carried out by trained independent staff (from the VION company). All departments are included in the plan. The audit is done twice a year. One unannounced and one announced audit by VION QA Mangers, trained and experienced. The audits have been carried out to schedule and are on food safety, product integrity, IOS9001 reported in several annexes. Corrective actions have been taken in a timely manner. Audits seen from Purchase by AQ Central, Announced 18-05-2018 & Unannounced 16-01-2017 (both including CCP control), executed by QA manager of Vion Retail Groenlo.
291	5.1.3	The auditors shall be competent and independent from the audited department.	A	
292	5.1.4	Audit results shall be communicated to the senior management and to responsible persons of concerned department. Necessary corrective actions and a schedule for implementation shall be determined and documented and communicated to every relevant person.	A	
293	5.1.5	It shall be documented how and when the corrective actions resulting from the internal audits shall be verified.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
294	5.2	Site factory inspections		
295	5.2.1	Factory inspections shall be planned and carried out (e.g. product control, hygiene, foreign material hazards, personnel hygiene and housekeeping). The frequency of inspections in every area (including outdoor areas) and every single activity shall be based on hazard analysis and assessment of associated risks and on the history of previous experience.	A	
296	5.3	Process validation and control		
297	5.3.1	The criteria for process validation and control shall be clearly defined.	A	
298	5.3.2	In circumstances where the control of process and working environment parameters (temperature, time, pressure, chemical properties etc.) is essential to ensure the product requirements, such parameters shall be monitored and recorded continuously and/or at appropriate intervals.	A	
299	5.3.3	All rework operations shall be validated, monitored and documented. These operations shall not affect the product requirements.	A	
300	5.3.4	There shall be appropriate procedures for prompt notification, recording and monitoring of equipment malfunction and process deviations.	A	
301	5.3.5	Process validation shall be performed using the collected data that is relevant for product safety and the processes. If substantial modifications occur, a revalidation shall be carried out.	A	
302	5.4	Calibration, adjustment and checking of measuring and monitoring devices		

Nr.	Reference	IFS requirements	Evaluation	Explanation
303	5.4.1	The company shall identify the measuring and monitoring devices required to ensure compliance with product requirements. These devices shall be recorded on a document and clearly identified.	A	
304	5.4.2	All measuring devices shall be checked, adjusted and calibrated, under a monitoring system, at specified intervals and in accordance with defined recognised standard/methods. The results of the checks, adjustments and calibrations shall be documented. Where necessary, corrective actions on devices and, if necessary, on process and products shall be carried out.	A	
305	5.4.3	All measuring devices shall be used exclusively for their defined purpose. Where the results of measurements indicate a malfunction, the device in question shall be immediately repaired or replaced.	A	
306	5.4.4	The calibration status of the measuring devices shall be clearly identified (labelling at the machine or on a list of test devices).	A	
307	5.5	Quantity checking (quantity control/filling quantities)		
308	5.5.1	The frequency and methodology of quantity checking shall be determined so that the legal requirements and customer specifications, or if appropriate, guidelines for nominal quantity are met.	A	Consumer products are packed under E weighing. Weights are controlled by checkweighers with rejectsystems. Registrations are checked and archived. For bulk packingaging the weights (no E) are printed on the labels. Weighers are in a calibration program.
309	5.5.2	A procedure shall exist to define compliance criteria for lot quantity checking. This procedure shall also, among others, take into consideration the tare, the density and other critical attributes.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
310	5.5.3	Checks shall be implemented and recorded, according to a sampling plan which ensures a proper representation of the manufacturing lot.	A	
311	5.5.4	Results of these checks shall be compliant with defined criteria for all products ready to be delivered.	A	
312	5.5.5	For purchased, already pre-packed products from third parties, there shall be evidence about the compliance with the legal requirements for nominal quantity.	N/A	No direct
313	5.5.6	If applicable, all equipment used for final checking shall be legally approved.	A	
314	5.6	Product analysis		

Nr.	Reference	IFS requirements	Evaluation	Explanation
315	5.6.1	There shall be procedures ensuring that all specified product requirements are met, including legal requirements and specifications. Microbiological, physical and chemical analysis required for that purpose shall be performed internally and/or subcontracted.	A	A sample scheme is set up as part of a microbiological monitoring program for product testing at production date and at end of shelf life conforms to Regulation 2073/2005/EC (Listeria, Salmonella) The frequency of monitoring and type of micro-organisms depends on the risk and the product group. Analyses are on Listeria, Salmonella, Stec, Entero's, Campylobacter, TPC. Pasteurized and packed products: every 4 weeks 3 microbiological analyses; Pasteurized and sliced products: 1 x / week 5 microbiological analyses; Fermented products: 1 x / week 5 microbiological analyses. All microbiological analyses are contracted to ISO 17025 accredited laboratory Results of TPC and pathogens are analysed and reported on a monthly basis (periodical report). Trend graphs are applied. Seen several COA's microbiological analyses (incl. pathogens; Listeria, Salmonell, Stec) on products; "Bio Acterham" 17-01-2019, "Gordon Blue ham" 08-03-2019 & "Paling worst" 01-04-2019 & "Snijworst" 31-01-2019. All results were within limits. Raw materials are checked visually and on temperature at receipt. Meat is analysed if new or new supplier (seen COA beef poulet 18-01-2019 on Listeria and Salmonella, both absent). Chicken meat is regularly analysed (seen COA chicken breast 18-01-2019 on Listeria and Salmonella, both absent) Product (organoleptic) test is conducted after each production batch and testing on pH, Aw is in place. There is a swabbing program on Listeria. Seen results over 2018 (2 exceeds of limit, corrective action was demonstrable).

Nr.	Reference	IFS requirements	Evaluation	Explanation
316	5.6.2	Analyses, which are relevant for food safety, shall preferably be performed by laboratories having appropriate accredited programs/methods (ISO 17025). If the analyses are performed by a factory internal or a laboratory not having appropriate accredited programs/methods, the results shall be verified on a regular basis by laboratories accredited on these programs/methods (ISO 17025).	A	
317	5.6.3	Procedures shall exist which ensure the reliability of the internal analysis results on the basis of official recognised analysis methods. This shall be demonstrated by ring tests or other proficiency tests.	N/A	No internal analyses
318	5.6.4	A test plan shall be drawn up for internal and external analysis, based on hazard analysis and assessment of associated risks, which covers raw materials, semi-processed and finished products as well as processing equipments and packaging materials, and where necessary environmental tests. The test results shall be documented.	A	
319	5.6.5	Results of analysis shall be evaluated promptly. Appropriate corrective measures shall be introduced for any unsatisfactory results. The analytical results shall be reviewed regularly in order to identify trends. Trends indicating potential unsatisfactory results shall be taken into consideration.	A	
320	5.6.6	Where internal analysis is undertaken, qualified and trained personnel shall be in place, as well as appropriate equipment and premises.	A	No internal analyses

Nr.	Reference	IFS requirements	Evaluation	Explanation
321	5.6.7	For verification of finished product quality, internal organoleptic tests shall be carried out regularly. These tests shall be in accordance with specifications and related to the impact on respective parameters of product *characteristic. The results of* these tests shall be documented.	A	no organoleptic tests needed
322	5.6.8	Based on hazard analysis, assessment of associated risks and on any internal or external information on product risks which may have an impact on food safety and/or quality (incl. adulteration and fraud), the *company shall update its* control plan and/or take any appropriate measure to control impact on finished products.	A	
323	5.7	Product quarantine (blocking/hold) and product release		
324	5.7.1	A procedure shall be in place, based on hazard analysis and *assessment of associated* risks, for the quarantine (blocking/hold) and release of all raw materials, semi-processed and finished products and packaging materials. The procedure shall ensure that only products and materials conforming to product requirements are processed and dispatched.	A	
325	5.8	Management of complaints from authorities and customers		

Nr.	Reference	IFS requirements	Evaluation	Explanation
326	5.8.1	A system shall be in place for the management of product complaints.	A	The procedure for complaint handling defines types of complaints and addresses requirements in terms of incident reporting as these are escalated to relevant personnel for action (corrective / preventive) and review as appropriate. Complaints can come from internal or customers and also complaints on suppliers are analysed. All complaints are trended, weekly reviewed by the site management team and monthly reported. The reduction of complaints and complaint costs is a topical subject and part of the X-matrix/KPI. KPI for customers complaints is 0,7% (was 0,8% till 2018) on total order rows. Overview of customer complaints Q3 2018 to Q3 2019 shows total of 90 complaints from customers with majority on packaging. Complaint level is slightly increasing (0,8% now, mainly caused by more stringent recording). Some complaints (18) on foreign body but no food safety issues. Trend shows incidents but no structural complaints. Good route cause analysis and corrective actions where demonstrable for all complaints. No complaints from the authorities.
327	5.8.2	All complaints shall be assessed by competent staff. Where it is justified appropriate actions shall be taken immediately, if necessary.	A	
328	5.8.3	Complaints shall be analysed with a view to implementing preventive actions which avoid the recurrence of the non-conformity.	A	
329	5.8.4	The results of complaint data analysis shall be made available to the relevant responsible persons and to the senior management.	A	
330	5.9	Management of incidents, product withdrawal, product recall		

Nr.	Reference	IFS requirements	Evaluation	Explanation
331	5.9.1	A documented procedure shall be defined for management of incidents and of potential emergency situations that impact food safety, legality and quality. This procedure shall be implemented and maintained. This includes as a minimum: the nomination and training of a crisis team, an alert contact list, sources of legal advice (if necessary), contacts availability, customer information, and a communication plan, including information to consumers.	A	
332	5.9.2 KO	KO N° 9: There shall be an effective procedure for the withdrawal and recall of all products, which ensures that involved customers are informed, as soon as possible. This procedure shall include a clear assignment of responsibilities.	A	How many recalls have been performed since the last audit : 0 How many withdrawals have been performed since the last audit : 0 There is a company's crisis and recall management procedure "procedure Crisis management" 03-05-2019 which covers the process which is applicable for all VION sites. The procedure for non-conforming product defines 'incidents' and addresses requirements in terms of incident reporting as these are escalated to relevant personnel for review and action as appropriate. Business continuity guaranteed by central procedures and emergency coordination protocol. The recall procedure is tested yearly (combined with a traceability test). Last test 27-09-2019 was about a fictional compliant about glass in pork belly. The recall report showed good control. There were no recalls or withdrawals since last audit.
333	5.9.3	Updated emergency contact details (such as names and phone numbers of suppliers, customers and competent authorities) shall be available. A person of the company, who has the authority to initiate the incident management process, shall be permanently available.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
334	5.9.4	The feasibility, effectiveness and timeliness of implementation of the withdrawal procedure shall be subject to regular internal testing, based on hazard analysis and assessment of associated risks but carried out at least once a year. This shall be carried out in a manner to ensure the effective implementation and operation of the procedure.	A	
335	5.10	Management of non-conformities and non-conforming products		
336	5.10.1	A procedure shall exist for the management of all non-conforming raw materials, semi -finished and finished products, processing equipment and packaging materials. This shall include, as a minimum: - isolation/quarantine procedures - hazard analysis and assessment of associated risks - identification (e.g. labelling) - decision about the further use (e.g. release, rework/post treatment, blocking, quarantine, rejection/disposal).	A	
337	5.10.2	The responsibilities for the management of non-conforming products shall be clearly identified. The procedure for the management of non-conforming products shall be understood by all relevant employees.	A	
338	5.10.3	Where non-conformities are present, immediate corrections shall be taken to ensure that product requirements are complied with.	A	
339	5.10.4	Out of specification, final packaged products or packaging materials, both related to private labels, shall not be placed in the market under the label concerned. Exceptions shall be agreed in writing with the contract partners.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
340	5.11	Corrective actions		
341	5.11.1	A procedure shall be in place for the recording and analysis of the non-conformities with the objective to avoid recurrences by preventive actions and/or corrective actions.	A	
342	5.11.2 KO	KO N° 10: Corrective actions shall be clearly formulated, documented and undertaken, as soon as possible to avoid further occurrence of non-conformity. The responsibilities and the timescales for corrective action shall be clearly defined. The documentation shall be securely stored, and easily accessible.	A	
343	5.11.3	The performance of the implemented corrective actions shall be documented and the effectiveness shall be checked.	A	
344	6	Food defense plan and external inspections		
345	6.1	Defense assessment		
346	6.1.1	Responsibilities for food defense shall be clearly defined. Those responsible shall be key staff or shall have access to the top management team. Sufficient knowledge in this area shall be demonstrated.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
347	6.1.2	A food defense hazard analysis and assessment of associated risks shall have been performed and documented. Based on this assessment, and based on the legal requirements, areas critical to security shall be identified. Food defense hazard analysis and assessment of associated risks shall be conducted annually or upon changes that affect food integrity. An appropriate alert system shall be defined and periodically tested for effectiveness.	A	
348	6.1.3	If legislation makes registration or onsite inspections necessary, evidence shall be provided.	N/A	No export to USA
349	6.2	Site Security		
350	6.2.1	Based on a hazard analysis and assessment of associated risks, identified areas critical to security shall be adequately protected to prevent unauthorized access. Access points shall be controlled.	A	
351	6.2.2	Procedures shall be in place to prevent tampering and/or allow identification of signs of tampering.	A	
352	6.3	Personnel & Visitor Security		
353	6.3.1	Visitor policy shall contain aspects of food defense plan. Delivery and loading staff in contact with the product shall be identified and shall respect the access rules of the company. Visitors and external service providers shall be identified in areas with product storage and shall be registered at the time of access. They should be informed about the site policies and their access controlled accordingly.	A	

Nr.	Reference	IFS requirements	Evaluation	Explanation
354	6.3.2	All employees shall be trained in food defense with respect to the product requirements and the training needs of the employees or when significant program changes occur. The training sessions shall be documented. Employee hiring and employment termination practices shall consider security aspects as permitted by law.	A	
355	6.4	External Inspections		
356	6.4.1	A documented procedure shall exist for managing external inspections and regulatory visits. Relevant personnel shall be trained to execute the procedure.	N/A	No export to USA