Audit Report Global Standard Food Safety Issue 9

1. Audit Summary			
Company name	Vion Enschede B.V.	Site code	1598805
Site name	Vion Enschede B.V.		
Scope of audit	Deboning and cutting to specification of beef. Curing and slicing of beef, bulk packed in dolavs or bags in crates, (consumer) vacuum packed in crates or boxes.		
Exclusions from scope	None		
Justification for exclusion	Non-applicable		
Audit start date	2025-12-16	Audit finish date	2025-12-18
Re-audit due date	2027-03-25	Head office	No

Additional modules included			
Modules	Result	Scope	Exclusions from Scope
Choose a module	Choose an item		
Choose a module	Choose an item		

2. Audit Results					
Audit result	Certificated	Audit grade	AA+	Audit programme	Unannounced - Voluntary
Previous audit grade	AA+		Previous audit date	2025-03-24	
Certificate issue date	2026-03-20		Certificate expiry date	2027-05-06	
Number of non-conformities			Fundamental	0	
			Critical	0	
			Major	0	

2. Audit Results

	Minor	2

3. Company Details

Site address	Het Lentfert 74 7547 SP Enschede		
Country	Netherlands +031534864444	Site telephone number	+031534864444
Commercial representative name		Email	
Technical representative name		Email	

4. Company Profile

Plant size (metres square)	<10K sq.m	No. of employees	51-500	No. of HACCP plans	1-3

Shift pattern	Dayshift, 1 shift from 07:00h to 16:00h, 5 days per week	
Seasonal site	No	
Seasonal opening times (Start/end date)	Click or tap to enter a date.	Click or tap to enter a date.
Other certificates held	Skal, IFS PIA, QS	
Outsourced processes	No	
Outsourced process description	n/a	
Regions exported to	Europe Choose a region Choose a region Choose a region Choose a region Choose a region	

4. Company Profile

Company registration number	NL 305 EG
Major changes since last BRCGS audit	No more marinating and tumbling, BRCGS category changed from 03 to 01 – raw red meat

Company Description

Vion Enschede B.V. is a site of Vion Food Group in which beef is cut and produced to specification for retail and industry. This beef plant is together with the one other Dutch beef plant, led by the German Vion Beef group. Vion Enschede is bought summer 2010 as a former cattle slaughterhouse, this is still there and maintained but close for operation. The production consists of two halls for production and several areas for storage. There is an area for receiving and dispatching hanging goods and an area for receiving and dispatching goods in bulk.

Vion HQ is based in Boxtel and provides support on several main processes such as sales, QA, Internal audits and contract management.

There is a small team leaded by the operation Director Beef with production manager, maintenance workers, a sales team, finance manager, QA manager and 2 QA/QC employees and HR manager supported by coaches.

Main activity is the deboning and packing of fresh beef for retail organizations and meat industry. Volume of production for Bio, Groenlo en is about 700 ton. B2B are the main customers (Western Europe).

There are 2 types of products (so 2 HACCP studies): Cutting to 1st slices meat products (technical parts, chilled bulk packed in crates or dolavs or most vacuum packed) and sliced (consumer) products (chilled packed in crates, vacuum packed in crates or boxes, skin packed). There are cutting lines and packaging lines.

On site (9500 m2) is app. m2 in use by factory and some m2 for offices, utilities, and maintenance. Of m2 not all is in use as the former slaughtering house is partly closed.

About employees of which about % permanent, including the ones in the offices. The production is organized from 7.00h till 16.00h basic in one shift and when needed this can be expanded to a 2-shift operation. In special situations shifted shifts are implemented as some employees start a bit later and work until about 19:00h (as example expedition, employee to manage dispatch).

The audit was performed unannounced, also for next year an unannounced audit will be planned.

5. Product Characteristics

Product categories	03 - Raw prepared products (meat and vegetarian) Category Category Category Category Category Category

5. Product Characteristics

	Category				
Finished product safety rationale	Chilling (temperature <7°C, <2°C), fresh / vacuum packing				
High care	No	High risk	No	Ambient high care	No
Justification for area	Appendix 2 applied. All products must undergo full cooking step prior to consumption.				
Allergens handled on site	None Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen Choose an allergen				
Product claims made e.g. IP, organic	Organic, Simmentaler				
Product recalls in last 12 months	No				
Products in production at the time of the audit	Beef pistols, hind legs, front legs, trimmings, cured beef, sliced beef, beef tongues, packed and labeled beef (crates, dolavs, boxes), bones, cat 1 and cat 3.				

6. Audit Duration Details

Total audit duration	20 man hours	Duration of production facility inspection	10 man hours
Reasons for deviation from typical or expected audit duration	n/a		

6. Audit Duration Details	
Combined audits	None
Next audit type selected	Unannounced - Voluntary

Present at audit

Note: the most senior operations manager on site should be listed first and be present at both opening & closing meetings (ref: clause 1.1.11)

Name	Job title	Opening meeting	Site inspection	Procedure review	Closing meeting
	QA manager	X	X	X	X
	QA Officer			X	X
	Operations manager	X	X		X
	Production manager	X	X		X
	Production manager		X		
	Supervisor production		X		
	Supervisor production		X		
	Supervisor production		X		
	Supervisor production		X		
	Working supervisor		X		
	Supervisor dispatch		X		
	Supervisor packaging		X		
	HR			X	
	HR				
	Maintenance manager		X	X	X
	Maintenance engineer		X	X	
	Employee warehouse non-food		X		
	Supervisor facilities / purchase		X		

	Chain director Beef			X	X
	Sales Manager			X	X
	HR Manager				X

GFSI Post Farm Gate Audit History			
Date	Scheme/Standard	Announced/Unannounced	Pass/Fail
18-01-2023	BRC Food v8	BRC Food v9	Pass
2024-03-21	BRC Food v9	announced	Pass
2025-04-26	BRC Food v9	unannounced	Pass
2025-12-18	BRC Food v9	unannounced	Pass

Document control			
CB Report number	RQA1032600 - 7465514		
Template name	F908 Food Safety Audit Report Template		
Standard issue	9	*Template issue date*	2022-12-16
Directory allocation	Food	*Version*	1.1

Non-Conformity Summary Sheet

Critical or Major Non-Conformities Against Fundamental Requirements			
Clause	Detail	Critical or Major	Re-audit date

Critical		
Clause	Detail	Re-audit date

Major						
Clause	Detail	Correction	Proposed preventive action plan	Root cause analysis	Date reviewed	Reviewed by

Minor						
Clause	Detail	Correction	Proposed preventive action plan	Root cause analysis	Date reviewed	Reviewed by
4.7.2	The evaporator in cold store 5 has peeling white paint directly above open products, posing a risk of product contamination.	This concerned an evaporator in the cold store above the hanging carcass parts. Parts that could potentially be contaminated were immediately removed. A temporary sign was placed on the wall stating that no carcass parts may be hung under the evaporator (see appendix). An order was then issued in to remove loose parts from the evaporator. This was taken care of by our technical department. Evidence seen: Pictures of the temporary sign on the wall.	Standard recording of evaporator checks in . Perform at least one annual inspection for visual defects. Responsible: maintenance manager Deadline: per Q2 2026 Evidence seen: Screenshot of the maintenance order in .	The cause can be traced back to some overdue maintenance. A request for quotation had already been sent to several suppliers for the deep cleaning of the evaporators. The final decision on who would carry out the work had not yet been made. Used method: 5 why	2026-01-06	

Minor						
		Agreed with correction and proposed action plan. Minor is closed.				
4.11.1	Several objects are not clean, e.g. the evaporator cutting room, under the unloading dock inbound, walls and controls next to the unloading dock inbound, backside weighing cabinets , weighing units and belts of the checkweighers, unused machine retail department.	None of the objects mentioned come into direct contact with products. This means there is no immediate risk of product contamination. Additional cleaning measures have been carried out to correct the identified deviations. Evidence seen: Pictures of clean objects Agreed with correction and proposed action plan. Minor is closed.	The daily schedule of employees takes into account the cleaning of various objects. A number of tasks have also been outsourced to an external cleaning company. An overview has been drawn up to clarify which objects are to be cleaned in-house. This overview is now used to manage the employees. Responsible: QA manager Deadline: 2026-02-28 Evidence seen: Cleaning schedule V8 2025-11-28	By conducting several interviews with the employees involved, we discovered why these areas were not being cleaned/maintained. It was not clear who was responsible for carrying out these cleaning tasks. It emerged that this should be done by our own employees, but that insufficient time was being allocated for this. Used method: 5 why	2026-01-06	

Comments on non-conformities
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Additional Modules / Head Office Non-Conformity Summary Sheet

Critical		
Clause	Detail	Re-audit date

Major						
Clause	Detail	Correction	Proposed preventive action plan	Root cause analysis	Date reviewed	Reviewed by

Minor						
Clause	Detail	Correction	Proposed preventive action plan	Root cause analysis	Date reviewed	Reviewed by

Audit team

Lead auditor		
Auditor number	**First name**	**Second name**
471275	Ine	van Deursen

Audit team				Attendance (YYYY/MM/DD, 24hr: MM)			Presence	
First name	Second name	Auditor number	Role	Audit Date	Start time	End time	Remote or physical	Professional recognition number
			Lead auditor	2025/12/16	08.30	17.00	Physical	
			Lead auditor	2025/12/17	08.30	17.00	Physical	
			Lead auditor	2025/12/18	08.30	12.30	Physical	

1. Senior management commitment

Policy
The site policy is documented in: **P-ENS-NL-10029 30-12-2024**
It is signed on 30-12-2024 by the person with overall responsibility for the site .
Commitment to continuously improve the site's food safety and quality culture is included.
Communication to staff: Displayed in key area (hallway to canteen and restrooms) on notice boards.

Product safety and quality culture plan
The level of culture at the site is identified by: introducing and implementing a plan for the development and continuing improvement of a food safety & quality culture. Culture aspects are clearly communicated through various channels (policy, induction program and TV screens in the canteen). The culture improvement plan of the site is documented in: **P-ENS-NL-10074.**

Activities undertaken, involving all sections of the site: personnel feedback, yearly tests by personnel, food safety training, whistleblowing policy, confidential advisor.
Success of the plan is measured through: monitoring of actions taken during (Vion Group) management meetings and annual HACCP training with test. Tier 1 boards show current performance and actions to the staff.
Plan is ongoing. During this audit, the implementation of this plan was also verified on the factory floor and all other departments that were audited. There is an open culture with open communication. Digitalise (QA) documents is ongoing

Date of last review of plan: **30/06/2025**
Frequency of reviews: 2x / year
Senior management were able to discuss the plan during this audit (spoken to , Chain director beef)

Food safety and legality objectives
Notable food safety and quality objectives include:

- Reduce staff absents to 5.5%. 2025 YTD: 6,4%.
- Perform at least 85% of preventive maintenance within the specified period. 2025 YTD: 89%.
- Increase in processed volume by 5%. 2025 till week 36: 10%.
- Optimising all product labels by adopting a uniform layout of all labels. 2025 YTD: MDM project ongoing.
- Optimising all product specifications to be available so that they are as uniform as possible, incl. photos. 2025 YTD: still ongoing. Seen specification beef tenderloin.
- Optimising the effectiveness of the product flow. More volume, fewer people. 2025 YTD: proposals have been made to Vion Group, but these have not yet been agreed upon.

Objectives are monitored **quarterly** by **QA manager.**

Key results or significant trends: the site is not meeting all established objectives / effectively progressing through its objectives, but these are identified and by the Vion improvement system allocated (VOS) to analyse and take measures if needed and when possible.

Management review
Frequency of management review meetings: quarterly. All required items are discussed.
Who typically attends the meeting: MT members (QA, purchase, production management, HR, maintenance, sales)

Date of last management review meeting: **01/10/2025**.
How minutes and actions are communicated to staff and recorded: senior management is present during most meetings. Management Review meetings are sufficiently provided with action lists with timescales, responsibilities and recording of status. For Tier meetings information is provided on white boards and visible for all employees.

Regular meetings
Routine meetings are held in which HR, sales, food safety and quality, maintenance, operations and projects are discussed. The structure is documented. How minutes and actions are communicated to staff and recorded: emerging actions are discussed in the huddle and Tier 1 meetings held with operatives daily and Tier 2 with management weekly and Tier 3 with Vion Group every 6 weeks.
Minute meetings reviewed: **12/08/2025**, **01/10/2025**

Since September 2025, there's an intensive project supervised by to optimise operational efficiency.

Previous nonconformities
All previous non-conformities have been closed out suitably.
Thorough root causes are identified through application of discussions. Preventive actions are effectively implemented to prevent re-occurrence. A CAPA excel list is maintained for external and internal audits.

Organisational structure, responsibilities, and management authority
The site organization structure is documented in: **P-ENS-NL-10020 07-08-2025**.

Management structure:
The senior management has appointed qualified employees for key functions (managed by HR). Responsibilities and competences are detailed in job descriptions. Employees in key functions and the members of the Incident Management Team are announced in the production site. Also, Members of the Food Safety Team are announced. Substitutes have been clearly appointed in **P-ENS-NL-10021 V13 06-07-2022**, in case of absence of the responsible person. Current structure and reporting are up to date.

Permanent expertise is provided by HQ Vion Boxtel and also expertise is shared with other Vion locations. The QA managers of all locations are part of the internal audit team and audit "each others" locations to support the internal audit programme.
Overall responsibility for the day-to-day management of the food safety system is with the Operations manager together with the Production managers, supported by the local QA manager.
No external expertise is used (consultant).

Reporting food safety issues
How food safety risks, concerns or non-conforming issues are reported by staff and resolved:
Feedback from personnel on factory floor demonstrates that staff is aware when, how, and to who report food safety issues to. The company keeps up to date with emerging issues, legislation, and good practice through branch organization (COV) and Vion Group.

A whistle blowing system is in place, document is available in 6 languages (P-food-10049). Anonymous concerns can be shared with the confidential advisor or by a special phone number, email or QR code. The Operations manager is responsible for monitoring and cascading this to the relevant stakeholders across the site. No issues reported since last audit.

The following supporting evidence was reviewed:
NVWA latest system audit 16-09-2024 (no issues, no report).

Details of non-applicable clauses with justification	
Clause/Section Ref	Justification
-	

2. The Food Safety Plan – HACCP

There is one HACCP manual described as the: **P-ENS-NL-10006.**

HACCP Team
The food safety team is detailed in: **P-ENS-NL-10006 04-03-2025.** The team leader is well qualified and experienced. Seen QA training evidence 15-02-2024 by for 1 day. The team is multidisciplinary, experienced, and knowledgeable in their fields with required level of food safety training. The HACCP Team is led by the Quality Manager who has more than 20 years' experience in the food industry and trained in HACCP. The other members all had appropriate training and experience. Training records were sampled. Seen training evidence 22-04-2024 by trainer for 4 hours. Refresher training every 2 years.

4x / year HACCP team meeting. Last HACCP team meeting on 15-09-2025 (minutes seen).

Scope of HACCP
The HACCP system scope is documented in: **P-VION-10000 15-09-2025**. It covers relevant processes and all products on site.
Vulnerable groups have been identified. Product is suitable for regular consumer groups.
Product descriptions are detailed in: **P- VION-10000**. Relevant information is described and information on food safety is included.
The scope accurately reflects all products on site.

Process flow diagram
Record key process steps/operations to manufacture products within the scope of certification:
P-ENS-NL-10005 20-01-2025

Record date and reason of last verification: **15/09/2025**. Fixed agenda item during the HACCP team meeting. Flow-diagrams are maintained and digital authorized as verified by members of the HACCP team. All were reviewed during the HACCP review. Last review Q3 2025.

Hazard analysis
HARA is based on comprehensive information sources**.** A Vion central PRP and CCP plan is the basis for the local HACCP plan. Severity vs likelihood is considered. The hazards are part of this document, categorised in microbiological hazards (especially pathogens, therefore in- and outbound temperatures are CCPs), chemical and physical hazards. There are no allergens on site.

CPs, limits and controls
CCPs details:

#	CCP	Control measure	Critical limit	Monitoring frequency

1	Reception of (parts of) carcasses.	Temperature measurement of the meat.	Chilled (parts of) carcasses / hanging meat: T ≤ 7°C core (CCP 1a)	At least 5 products spread across every batch.
2	Reception of additional purchased meat.	Temperature measurement of the meat.	Bulk meat (dolavs / crates): •T ≤ 7°C core (CCP 2a) •T ≤ 6°C vacuum → surface temp (CCP 2b) Organs: •T ≤ 3°C core (CCP 2c) •T ≤ 2°C vacuum → surface temp (CCP 2d)	At least 5 products spread across every batch.
3	Dispatch temperature of products.	Temperature measurement of the meat.	Chilled (parts of) carcasses / hanging meat and bulk meat (dolavs / crates): •T ≤ 7°C core (CCP 3a) •T ≤ 6°C vacuum → surface temp (CCP 3b) Organs: •T ≤ 3°C core (CCP 3c) •T ≤ 2°C vacuum → surface temp (CCP 3d) Meat preparations: •T ≤ 4°C core (CCP 3e) •T ≤ 3°C vacuum → surface temp (CCP 3f)	At least 5 products spread across every batch.

PRP's / CP's have been identified in: **P-ENS-NL10011 20-10-2025**. Control measures have been defined. This includes e.g.:

1. Packaging / label control (EAN code verification)
2. Incoming goods (visual, pH and temperature)
3. Cleaning and disinfection (Pre SSOP checks)
4. % fat trimmings by X-ray
5. Weight control
6. Metal detection
7. Traceability
8. Pestcontrol
9. Personal hygiene
10. Hygiene / GMP
11. Area temperature monitoring
12. Water and air quality
13. Hygienic handling after contamination of products (e.g. cleaning / handling fallen meat)

Examples of corrective actions:
Actions when monitoring level exceed acceptable limits are documented within the HACCP plan, recorded and investigated. Based on live demonstrations and records checked during this audit all CCPs are in control conform the work instructions.

Validation, verification and review:
The company has effectively validated and verified the HACCP/Food Safety Plan, including the critical limits, control measures and CP specific for controlling food safety hazards. Validation of the CCP is done

at central level, report is part of the central management system ( ). Procedures of verification have been established.

Procedures include: performing internal audits, review of records where acceptable limits have been exceeded, review of complaints (by enforcement authorities or customers), review of incidents (of product withdrawal or recall).
Documentation and record keeping is verified.
Results of verification/validation are recorded and communicated to the HACCP food safety team.
Validation was sampled for the CCPs.

Frequency of planned HACCP system review (at least annually): quarterly
Date of last review: 10/01/2025
Completed by: HACCP team members
Reason for completion: HACCP verification

The following supporting evidence was reviewed:
PowerPoint presentation HACCP training
During site tour:

- F-ENS-NL-10018 V11 14-03-2025 “checklijst aankoop bouten”
- F-ENS-NL-10003 V9 03-06-2024 “CCP temperatuur ontvangst bouten” (live demonstration 2,9°C and 2,3°C)
- F-ENS-NL-10005 V8 03-06-2024 “Opstartcontrole”

Details of non-applicable clauses with justification	
Clause/Section Ref	Justification
-	

3. Food safety and quality management system

3.1 Food safety and quality manual, 3.2 Document control, 3.3 Record completion and maintenance

Food safety and quality manual
The Food Safety & Quality Manual with department specific work instructions are available on the network ( ) and at point of use as demonstrated throughout the audit. All procedures and work instructions are in Dutch and when necessary in other languages and pictures and pictograms to support the employees understanding the information provided. When staff is not having an appropriate level of English or Dutch Language skills, interpreters are available should they be required. Documentation seen is up to date. Only QA can make the changes into the system. Changes are indicated in the procedures, clearly marked. Changes are also kept by the QMS system.

All documents seen during the audit were complying.

Record completion and maintenance
Records are in good condition and retrievable electronically or on site. Records retained 3 years (max shelf life fresh (vacuum) is 35 days).

The following supporting evidence was reviewed:
Documents in the QMS (digital) and on site during the onsite tour and the trace test, digital and on paper.

3.4 Internal audits

The following document(s) define the process: P-VION-10011 2024-11-19, all included in Q planning
The audits generally follow BRCGS guidelines and clause structures.

Internal audits are conducted: 4 x year. The programme includes at least four different audit dates spread throughout the year and is risk-based, considering any previous audit findings.

Internal audits are performed by: internal auditors provided from Vion HQ and QA managers of other Vion sites (intercompany) to maintain independency).

Auditor competency has been demonstrated through: training records, sufficient knowledge of the products and processes and experience.

Internal audits are reported in: a Word format.
Objective evidence of compliance and non-compliance are reported. The audit criteria are clearly referenced. Findings are included in a central log, monitored for follow-up, and evaluated in management meetings. Follow-up actions include immediate correction, root cause analyses and corrective action. Responsibilities and timescales for verification/closure of findings have been defined.

Internal audit reports reviewed during this audit: min 4 audits per year: **14/07/2025** (unannounced).
The report reviewed details conformity as well as non-conformity. A few minor nonconformities have been raised with no trends identified. Root cause by discussion within HACCP team is included where required. All actions were closed within the due date. Audits contained a basic amount of detail.

A separate program of internal inspections of factory environment and processing equipment is undertaken monthly verification rounds QC together with operator.
This is reported in: for each specific inspection per department, a specific format, signed off by QC.
Inspections are performed by using a checklist with the audit topic included and a clear action list.
Performance is measured based on minors and major deviations. Actions in response to deviations are recorded, cascaded to team leaders for follow-up, and discussed in HACCP QA/QC meetings. Completion

of actions is verified upon the next inspection by QA/QC. Effectiveness of the system is discussed in the Management Review and also separate in the huddles and Tier 1 meetings

Hygiene Inspections reports reviewed during this audit: verification rounds (incl. glass / brittle plastic) sampled 16/12/2025
A few minor issues had been observed. Follow-up of actions is demonstrable with records.

Beside internal audits, around 6 client audits are performed on site per year. Results (actions) are reviewed, handled and followed up, also included in the MR report.

The following evidence was reviewed:
Internal audit planning 2025
Internal auditor , 5 days Lead Auditor training on 09-11-2007 by
Internal auditor , refresher training on 08-05-2025, also followed by
Excel action list internal and external audits
action list

3.5 Supplier and raw material approval and performance monitoring

3.5.1 Management of suppliers of raw material and packaging

Risk identification / risk assessment related to raw materials setup centrally by HQ in Boxtel resulting in product specifications specifying relevant aspects to quality and food safety (CP). As the meat suppliers are all within the Vion company, all approved suppliers. In case of incidental other suppliers, these are low risk (fresh meat). No high-risk food suppliers identified for this organization. All suppliers of packaging must be approved by Vion Group before they are allowed to deliver.

The company's raw material risk assessment, including primary packaging is documented in: List of approved transporters (S-MMI-10013) and List of approved cold stores in use by Vion (S-MMI-10199), yearly demonstrably reviewed by Vion HQ

All potential risks have been appropriately considered. No significant risks include for this site applicable. The risk assessment forms the basis for the raw materials acceptance and testing procedure and for the processes adopted for supplier approval and monitoring.

Reviewed during the audit according to the last updated evaluation All suppliers are evaluated: **yearly, last update 21/3/2025 over 2024.**
List examples of suppliers reviewed during this audit:

Initials supplier	Supplier of:	Method of assessment	Evidence seen
	Vacuum foil	Valid GFSI certificate and DoC	yes
	Transport	Valid GFSI certificate	yes
	Cold storage	Valid GFSI certificate	yes
	Beef	Valid GFSI certificate	yes

All suppliers are evaluated: annually
Suppliers are rated on micro results, complaints, integrity, certification. All suppliers graded satisfactory in the past year.

Suppliers, that are not audited or certificated, have been traceability tested on first approval and then at least every three years: **Not applicable.** This was seen for: n/a

For raw materials purchased from an agent, broker or wholesaler, is the identity of the last manufacturer, packer or consolidator of the material known: **Yes**

Traceability system is verified through: GFSI certification of the manufacturer.

Handling exceptions and absence of information is considered in the supplier approval procedure.

3.5.2 Raw material and packaging acceptance, monitoring and management procedures

Procedures for the acceptance of raw materials and primary packaging on receipt is in place and based on risk assessment (see 3.5.1). The meat is purchased by the companies site manager (and purchase manager) from approved suppliers (slaughterhouses) all over Europe.

Acceptance by intake checks: visual inspection by experienced employees, well known with carcasses and beef, CCP (temp check). Monitored during site audit day 1 reception of meat, CMR Vion Waldrainburg 180835 (carcasses parts) and as part of the vertical trace test.

Deliveries are visually checked for product integrity, labelling and cleanliness. Based on risk assessment, food safety hazards are controlled through COAs, internal analysis, etc.

The requirements to be met for acceptance is identified for all raw materials (including primary packaging). Parameters for acceptance and frequency of testing has been clearly defined, implemented, and reviewed.

The following evidence was reviewed:
F-ENS-NL-10018 V11 14-03-2025 “Checklist aankoop bouten” seen during site tour
F-ENS-NL-10003 V9 03-06-2024 “Temperatuur ontvangst bouten” seen during site tour
F-ENS-NL-10005 V8 03-06-2024 “Opstart controle” seen during site tour

3.5.3 Management of suppliers of services

The following services are used and assessed during this audit:

- Pest control,
- Maintenance for cooling system, metal detectors, compressors, x-ray, etc.
- Laundry services,
- Contracted cleaning,
- Transport, Distrifresh
- Off-site storage,
- Temporary employees

Approval and monitoring for ongoing performance are described in the company’s supplier approval procedure (referenced under 3.5.1). Service suppliers (based on risk assessment) are evaluated annually.

Contracts are in place that clearly define service expectations. Food safety aspects are appropriately addressed.

Many suppliers of services are long standing with a good history of supply and contained on the approved supplier list from initial approvals.

Quarterly management review (seen for Q4 last year) include performance of suppliers of services.

The following evidence was reviewed: see above

3.5.4 Management of Outsourced processing
Outsourced process steps to a third-party or undertaken at another site is: **not applicable** Products from the external cold storage come back to the company, but don't leave the truck to complete the order.

3.6 Specifications

Suitable specifications are maintained for all raw materials (including primary packaging) and finished products and were reviewed from the auditor traceability exercise.

Specifications are held electronically (MDM) and access is restricted to the compliance team.

Specifications include limits for relevant attributes (relevant chemical, microbiological, physical and allergens). Key data is included to meet customer and legal requirements and to assist the user in the safe usage of the product.

During the audit, several specifications were reviewed:

- Raw material: beef carcasses
- Finished product: beef tenderloin (spec 033015080 16-05-2022) and trimmings
- Packaging: vacuum foil
- Cleaning agent:
- Lubricant:

All were seen to be clear and accurate.

Formal agreement of customer branded products is verified through the system of the retailers (for instance GS1). Verified customer approval during the vertical traceability exercise. Only B2B (at the moment no supermarkets are client who receive prepacked products).

Frequency of review of specifications: at least every 3 years or if changes occur.

The following evidence was reviewed: P–ENS-NL-10027 Management of specifications

3.7 Corrective and preventive actions

A documented system is used to manage corrective and preventive actions on the shopfloor.
Identified issues are logged in: the site central CAPA list, which is an Excel overview, list for internal / external audits and hygiene inspections.
For complaints another system is used. In this action list the responsible for completing / closing the non-conformity is monitored for reporting the status of progress. Seen action list which was ongoing reviewed and adjusted. Corrective actions and preventive action system is up to date. On the huddle white boards, open actions are written and closed when corrective action is implemented (daily morning meetings). Corrective and preventive actions are discussed during the Tier 1-2 -3 meetings.

During this audit, several samples were taken to verify effectiveness of corrective and preventive actions. Thorough root cause analysis is performed depending on level of deviation and action required.

This approach is applied for: internal audits findings, nonconformities raised by external audit bodies, non-conformities raised during SSOP checks and inspections and complaints and found to be suitable and effective. It meets the expectations of the BRCGS standard (i.e., section 3.7)

The following evidence was reviewed:
(maintenance department) / internal / external audit action list / complaint records / pest control actions / white boards during site tour

3.8 Control of non-conforming product

Control of non-conforming product is detailed in: **P-ENS-NL-10024 complaints handling** and in P-ENS-NL-10004. All fallen meat incidents have to be reported on the SSOP-checklists. Non-conforming products

are categorised to Cat 1 and Cat 3 material and collected by Rendac. Blocked products are accompanied by red form F-ENS-NL-10021 “Blokkade Vion” V3.

After recording a complaint or incident, a RCA is performed, corrective and preventive actions are defined and handled. Categories are used, like food safety, quality and order related issues, this way easy trend analyses could made.

Raw materials and (semi)finished products are checked regularly during the process stages.

Corrective and preventive actions are described in several work instructions (see previous section). Clear process which is well understood by staff that was interviewed during the audit.

Non-conforming products are physically labelled and put on hold. There is no segregated section in the warehouse for non-conforming products and returned goods, but products are clearly marked with a red block form.

Responsibilities regarding release of products on hold lies with product management together with QA and follows a clear decision-making process.

Records are kept of decisions made and where product is destroyed for food safety reasons.

Example seen of non-conforming product incident: **none.**

The following evidence was reviewed:
Complaint log 2025 YTD including root causes and preventive actions.
MR minutes were seen, discussed during the 3 monthly meeting and per incident with involved team.
Complaints are below max. KPI.

3.9 Traceability

The traceability process is documented in: **P-Food-10015**

Traceability through the process:
Traceability system operates through ERP computer system and paperwork enables trace of raw materials and packaging from supplier through processes to packing and dispatch. Incoming goods are entered into the ERP system and labelled. Basically, the whole batch is transported from the cold storage to the production facilities and do not return. Replacements recorded based on scanning. In case of distributing recipients from the pallets to the production facility this will be entered manually into the system. Recording of batch information raw materials, packaging materials, rework batches or pallets to be re-used on the production record sheets (as reviewed for vertical audit).

Traceability marking on products:
Codes are printed on all raw materials, intermediate / semi-processed products, part-used materials, finished products and materials pending investigation which enables retrieval of all required data.

Traceability test details company:
Frequency: min. annually
Last test conducted: **31/03/2025**
Results are retained as documented information and reports include all relevant information and data (including mass balance information). Traceability is achieved within 4 hours.

Vertical audit details:
Finished product: **Beef tenderloin (vacuum), art. 28777, batch**
Raw materials: **Beef pistola, received 18/09/2025**
Printed packaging and labels: **White label 90 x 90 cm, printed based on ERP system**
Production / packing date: **19/09/2025**

Quantities reconciled: Total kg raw material and traced kg finished product (beef tenderloin).

Key documentation reviewed including process control and quality control documentation:
A vertical audit list is used during the audit, with the following info: mass balance (traceability), production flow (procedures, flow charts, HACCP plan, inspections), specifications, GFSI certificates and approved suppliers, measurement and analyses.

Summary traceability and vertical audit:
Tracing (forwards / backwards) including packaging was possible within 3 hours. Rework is not used. No product in stock, all sold. Seen product specifications of all raw materials and finished product, receipt records, food compliance certificate is verified. Fully traceable one-step-up and one-step-down the system, including packaging. There were no issues found during the product traceability and all documents showed control over the system for food safety by the organisation. Food contact materials legalization is fully implemented. The company's traceability system is found to be effective.

3.10 Complaint-handling

Complaint-handling is documented in: **P-NL-Food-10054**

Follow-up of complaints is managed through: Excel list manged by Sales and QA. Complaints are handled and investigations are completed by the site. Corrective actions are carried out promptly and effectively. All complaints were deemed as justified following investigations.

After recording a complaint or incident, a RCA is performed, corrective and preventive actions are defined and handled. Categories are used, like food safety, quality and order related issues, this way easy trend analyses could made.

Product complaints:
2022: 4,7 complaints per week (all kind of complaints)
2023: 3,2 complaints per week (all kind of complaints)
2024: 0,9 complaints per week (all kind of complaints)
2025: 1,1 complaints per week (based on 14 complaints in Q3). Seen complaint overview 2025 (responsibility, description, category, email addresses, RCA, preventive action, closing date). AAA rated. The goal is to handle the complaint and inform the customer within two days of receiving all the information about the complaint.

Top 3 complaint reasons:
1. Weight
2. Foreign body complaints (metal, plastic, other)
3. Labelling

A trend analysis is maintained and documented and discussed in management meetings (including the management review (KPI)).

There has been no significant increase in a complaint.

The following complaint samples were taken:
- Complaint of small piece of metal, solved 26-06-2025
- Complaint of part of a paper label in beef trimmings, solved 07-01-2025

3.11 Management of incidents, product withdrawal and product recall

The company has procedures in place to report and effectively manage incidents and potential emergency situations that impact food safety, authenticity, legality, or quality.

Contingency plans have been considered, including the need to withdraw or recall products.

There is a documented product withdrawal and product recall procedure: **P-VION-10015**

The recall procedure identifies those who are to be notified (including CB, LRQA) in the event of an incident where product safety or legality is in question. There is a recall plan which is supported by a recall checklist. Mobile phone numbers for the senior management team are available for out of hour's emergencies. Recalls are categorised as critical (food safety, allergens, FBs, health, pest, and legislation) and non-critical (quality, coding and packaging).

LRQA is referenced as contact, indicating that incidents/withdrawal/recalls shall be reported via the website within 3 days of the event.

No withdrawals / recalls occurred since the previous visit.

Date of last incident management procedures test: **31/03/2025**
Type of test completed: recall

Mass balance information is included in the report. Traceability is achieved within 3 hours. Successful test conducted. No improvements have been required as result of the outcome.

The following evidence was seen:
Report of conducted test. No issues.

Details of non-applicable clauses with justification	
Clause/Section Ref	Justification
3.5.4	Outsourced process steps to a third-party or undertaken at another site

4. Site standards

4.1 External standards

Plant located in an industrial area in a rural environment.

Site boundaries are clearly identified. Premises is partly fenced off with security gate access to the facility and supervision of all visits incl. transport by a porter on site between 04:00h and 23:00h, outside these hours the main port is locked, then the site fully fenced.

Types of buildings include: production facility, storage building, offices, and maintenance workshop.

Site security:
Unauthorised access is prevented by use of ID badges access. Visitors / contractors must register at the security building. Several cameras are installed.

Truck drivers are not permitted to enter the dispatch area, warehouses or production areas, with the exception of the canteen. The company is always guiding the visitors / contractors while visiting the production areas.

Good condition of constructions noted. No risks have been identified related to the external environment. Site area is properly maintained.

4.2 Site security and food defence

The individuals or team completing threat assessments and food defence plans have the appropriate knowledge**.** The Team is also the site HACCP team. Awareness training was seen for team members and in-depth training for .

There is no legal requirement for specific training.

Food defence risk assessment is documented and based on TACCP: **P-NL-FOOD-10007**

A general risk assessment has been provided by Vion Group, which focuses on Vion Enschede. Risk score calculation based on impact and likelihood of occurrence. The threat assessment includes both internal and external threats. The site has established a documented food defence plan covering assess points and controls.

Examples of threats that have been determined: **unauthorized visitors,**

Appropriate control measures are developed and implemented: Site boundaries are well defined and security (external facility provider) is in place with checks for visitors, contractors and truck drivers. There are separate storage areas for cleaning chemicals, lubricants and waste. There are two secure entrances for pedestrians and one for vehicles.

Product en process integrity (TACCP study) review was used as input for the Management Review.

Access is via key coded doors and combination locks. There is an electric gate that can be used outside of normal operating hours. Security training is included for all staff as part of the HACCP induction to site.

Raw material storage areas are controlled and internal. No external intake points.

The following evidence was reviewed:
P-ENS-NL-20051 V1, last annual review 29-09-2025
Visitors brochure with plan, hygiene and safety rules

4.3 Layout, product flow and segregation

A lay out map with flow of processes and movement of personnel is present, including zoning. This is documented in “Overzichtstekening Vion Enschede” and in the visitors brochure**.**

Production risk zones (based on BRCGS Annex 2):

- Open product areas: low risk
- Enclosed product areas: warehouses and cold storages
- Non-product areas: canteens, offices, warehouse non-food

Contractors and visitors, including drivers are informed of the requirements for the areas they are visiting through hygiene rules, in a folder with hygiene and safety rules and zoning incl. personal protection to wear in which area. Personnel flows, material flows, services and equipment are placed such as to minimise the risk of product contamination. No high risk, high care or ambient high care production.

Premises allows sufficient working space and capacity to work in a proper way. There were no temporary constructions noticed during this audit. Also, there was no modernisation work in progress during this audit. There is a site plan for the plant. The routing for the removal of waste products is also demonstrably stated.

The following evidence was reviewed:
Brochure “Welkom bij Vion Enschede”
“Overzichtstekening Vion Enschede”

4.4 Building fabric, raw material handling, preparation, processing, packing and storage areas

Building materials were in good condition. Smooth cement floors, walls, and ceilings from metal cladding.

Condition of building was acceptable. No deteriorated doors or gaps evident. No suspended ceilings. Drainage, where provided, designed and maintained to minimise risk of product contamination and not compromise product safety. Machinery piping goes directly to the drains.

There are elevated walkways, access steps or mezzanine floors that are adjacent or above open product, but good control was seen. Ventilation controls in place to ensure good air flow.

No windows could be opened in the processing areas, glass is protected. Sufficient lightning available. Some lights in warehouse non-food are from non-breakable plastic. Nevertheless these will be replaced with covered led lights.

Doors in good condition, external doors are well fitted and kept closed when not in use.

The washing of equipment is done separated from production. Plastic strip curtains present, clean and maintained.

4.5 Utilities – water, ice, air and other gases

Water is used as: for cleaning purposes.

Source(s) of water supply:
- Municipal/city (cleaning, handwashing)
- In-house treated (only magnet softened)
- Storage or holding tanks (water used for cleaning purposes only (T > 60°C). This water is warmed up by rest heat generated by cooling equipment

Only potable water is used.

Microbiological or chemical testing is undertaken: 3x / year. 1x / year an analysis report is downloaded from (water supplier).
Water testing is completed via compliance checks and microbiology via an accredited external laboratory.

A water system distribution schematic diagram is available, including holding tanks.

Sampling points include: sampling points are changing and include canteen, hand washing and cleaning water.

Gas used in packaging: **No**
Compressed air used: **Yes**

Purpose of compressed air use: air pistol (product contact), control of machines and equipment and packing machines ( )
In direct product contact: **Yes**
Filtered at point of use (when in direct contact): **Yes**

Checks are done on filter replacement as part of the preventive maintenance program. Filter air pistol is from ISO 12500-1 oil aerosol filter, specification seen. Last filter change 14-11-2024 by .

No steam or other gases are in contact with products.

The following evidence was reviewed:
- Annual inspection report compressor, incl. filter change 17-09-2025
- Lab report 22-09-2025: 11 water samples (cutting area, canteen, production area, clothing area, first aid area, etc.). All results below the maximum limit.
- Water plan “Bedrijfswater t.b.v. reiniging productie”

4.6 Equipment

Key production and product-handling equipment include: **transport belts, metal detectors, x-ray (fat trimmings), check weighers, scales, scanners, vacuum packers, labelling machines, slicers, pallet trucks, hanging meat chain and hooks, evaporators, etc.**

Equipment is suitable and designed for the intended purpose; mostly stainless-steel construction. Conveyor belts are food grade.

Line equipment is sourced through: procurement, specified, tested, and commissioned before use.

Equipment which is in direct contact with food is suitable for food contact and meets legal requirements where applicable.

Purchase specifications are in place to ensure new equipment meet legislative requirements and is suitable for food contact where appropriate.

There is a procedure for moving static equipment detailing preventing potential risks to food safety and equipment integrity. Equipment that is not in use is always taken into the cleaning schedule when it stays in the production area.

Mobile equipment and battery-charging equipment is in use, potential risk to the product is prevented by means of separate storage and up to date maintenance.

The following evidence was reviewed:
- “Procedure beheersing metaal”
- Inspection cooling system by 30-09-2025
- Monthly alarm test cooling system (vriescel) 03-11-2025 and planning of which areas are tested which month.
- Calibration PT1000 by 23-01-2025
- DoC high density polyethyleen 06-03-2024

4.7 Maintenance

Preventive maintenance
Maintenance management system:

Frequency of main checks: depends on type of maintenance and equipment, based on risks / usage and status of equipment.
Notable equipment include: cooling equipment last check was performed 30-09-2025

Preventative maintenance covers all plant, processing equipment and mobile equipment.
Contractor services are used for: , cooling equipment / evaporators, metal detectors x-ray, compressors, pallet trucks.

Plans are downloaded along with relevant job sheets. Once completed they are put into the system.

Samples seen and completed to schedule:

- Cooling maintanance 30-09-2025
- Metal detector 01-07-2025
- X-ray Eagle 25-02-2025
- Pallet trucks annual maintenance by
- Multivac inspection and folow-up planning 03-12-2025 (offer seen)

Inspection of equipment condition
Inspections for damage and wear are completed for: conveyor belt condition and other equipment on daily basis, is part of SSOP. Maintenance engineer is “walking” his round in the morning before startup, to see and hear if all equipment is running ok. Daily meeting at 09:00h.

Minor NC: The evaporator in cold store 5 has peeling white paint directly above open products, posing a risk of product contamination.

Temporary maintenance was not detected.
Specific attention is given to energy savings such as heat recovery and reuse, water saving, reduction of gas and electricity consumption.

Temporary maintenance was not seen during the audit. In the daily SSOP a remark can be placed.

Handover
Suitable handover processes were in place after maintenance work to eliminate foreign matter risks generated signed off by technician, responsible engineer, supervisor, production manager on F-ENS-NL-10028 V3 03-09-2024 “Onderhoud tijdens werkzaamheden”. Acceptance of line start up signed off by line manager on SSOP form. Seen F-ENS-NL-10028 and SSOP forms of 30-10-2025.

Lubricants
Range of food grade lubricants used: spray, spray, grease . MSDS with compliance to NSF H1 and Allergen Declaration seen.

Overall cleanliness engineering workshop
The workshop was well maintained, not directly connected with the production areas. Entry via “regular entry with food brushes and hand wash equipment. There is also a dedicated rest room, changing room and wand wash present.

4.8 Staff facilities

Changing facilities
Designated changing facilities for staff in place that are appropriately sited. Sloped lockers observed for storage of outdoor clothing, and a separate area for protective clothing.

Workwear is externally laundered to a defined process and brought to site in a separate bag. Captive site shoes are stored in the work-wear locker when not in use.

Handwashing
Hands-free operable handwash facilities located in lobby area at entrance to production, equipped with an adequate supply of water delivered at a suitable temperature, soap and drying facilities. Advisory signs for prompt handwashing are displayed above the sinks.

Toilets
Toilets provided do not open directly into production or packing areas. Adequate hand-washing facilities are provided within toilets conform 4.8.5.

Catering facilities
Two rest room areas for food storage and eating; catering facility in place. Fresh meals are cooked on daily basis. No (white) working jackets are allowed to prevent contamination risks. Good controlled.

4.9 Chemical and physical product contamination control: raw material handling, preparation, processing, packing and storage areas

4.9.1 Chemical control

An approved list of chemicals is available and documented in:

Chemical containers including cleaning chemicals are clearly labelled and separately stored in secured compounds.

Safety Data Sheets / specifications are available, and samples have been taken: seen
and

All chemicals as sampled are suitable for the intended application.

Waste handling and spillage control is effectively managed.

4.9.2 Metal control

The following type of sharp metal equipment is used: knives (meat knives, Stanley and fish). No snap-off blades used.

Examples were seen on the factory inspection and observed to be in a satisfactory condition.

Knife check performed by operation management, also included in SSOP. Tool available to check the size of the meat knives.

Condition and integrity are monitored: by QA/QC on monthly hygiene audits; see section 3.4.4 for details.

Staples, paper clips and drawing pins are not used in open production areas. Observed bags and boxes were glued or stitched.

4.9.3 Glass, brittle plastic, ceramics and similar materials

Monitoring of glass / brittle, plastic and ceramic items is done through glass inspections 4x / year.
Records were seen for: 08-12-2025. Seen P-ENS-NL-10015 “Procedure beheersmaatregelen metaal, hard kunststof en glas”.

Besides these quarterly audits, inventory is checked daily (SSOP) and extra checks are performed by QC.

Last round performed and recorded on record**:** F-ENS-NL-10031 V15 “Form glass and hard plastic register”.

No glass incidents to date took place since the last audit. Staff is well trained in process and mock incidents which were part of the training (training is repeated at least once per two years).

Windows are protected against breakage with foil.

4.9.4 Products packed into glass or other brittle containers

Products are not packed into glass/brittle containers.

4.9.5 Wood

Wood is allowed (and present) in packing areas, only at the site of enclosed products and not near open product areas.

Wooden pallets used were observed to be in good condition.

Some packaging may be delivered on wooden pallets but re packed so no wooden pallet is used in the near of open product.

4.9.6 Other physical contaminants

Describe any other specific controls on physical contamination such as packaging:
De boxing and debagging procedures include controls for physical contamination. When packing material is brought in, the to use amount is temporary stored in yellow crates, to avoid contamination risk. Working stock plastic foil in production is put on a stainless steel rack.

Management of portable handheld equipment:
Metal detectable pens are in use and mobile phones only by management used. Testing equipment is situated in a separate area away from production of open products. All checked on daily basis by SSOP rounds and extra rounds by QC.

Other types of control for contamination not covered in section 4.9 are not required.

4.10 Foreign-body detection and removal equipment

4.10.1 Selection and operation of foreign-body detection and removal equipment

Metal detection (products) and X-ray (to determine fat%) applied. Also visual inspection is applicable, as employees are trained to detect FB’s such as small pieces of bones / tendons and e.g. plastic pieces.

The sensitivity of control measures is appropriate as determined through validation study.

No other types of foreign body contamination removal are used.

Escalation procedure in place in case of breakdown incidents. Detected foreign materials are evaluated and analysed by QA.

4.10.2 Filters and sieves

No filters or sieves used.

4.10.3 Metal detectors and X-ray equipment
Detection equipment (metal detection) is installed as result of the risk analysis and is controlled as CP, recorded on F-ENS-NL-10023 in cutting department and on F-ENS-NL-10036 in vacuum pack department for retail. Based upon risk analysis metal detector devices are placed in the cutting department, also in the sorting and labelling department. After these departments, meat can be sliced and packed, and there are also two metal detector devices in the packing department. The X-ray (Eagle) device is behind the detector in the cutting department, but only for fat% measurement. No removal or detection of foreign bodies with the X-ray. Metal detection is arranged as a system with an alarm and a belt stop at the production lines. The sensitivity of control measures is appropriate as determined through validation study. Tests are done with 3 types testing sticks in the cutting department: Fe 10,0mm, Non Fe 7,1mm and STS 9,0mm, and in the packing department: Fe 4,0mm, Non Fe 4,0mm and STS 5,7mm. The testing procedure is found to be suitable. No history of failed (metal) tests recorded. Correct operation was observed in line with the work instruction. Corrective actions are clearly defined in the CP control plan. Data is maintained in documentation. The sensibility of the detector is justified. An automatic belt stop and red light system is in place Monitoring frequency: beginning and end of the day and every hour. Metal detection (CP) was tested during this audit. Correct operation was observed in line with the work instruction. Escalation procedure in place in case of breakdown incidents. In case of detection of foreign body contamination, the material is analysed by QA/QC **The following evidence was reviewed:** “Form metal detection retail”
4.10.4 Magnets
Magnets are not used.
4.10.5 Optical sorting equipment
Optical sorting equipment is not used.
4.10.6 Container cleanliness – glass jars, cans and other rigid containers
No containers are in use. No products packed into glass/brittle containers.
4.10.7 Other foreign-body detection and removal equipment
Other types of control for foreign-body detection equipment not covered in section 4.10 are not required.
4.11 Housekeeping and hygiene
Cleaning is performed by: external company on a daily basis. Documented cleaning and disinfection procedures are in place and maintained for the building, plant and all equipment. Examples cleaning procedures seen included: **P-ENS-NL-10031**

Periodic cleaning activities ”dieptereiniging” are included and managed by QA and main contact . 1x / week Acid cleaning as scheduled in the “werkschema”. Good contact and regular meetings with a dedicated contact person of . This contact is working for more than 25 years on this location.

Cleaning methods described are found to be suitable.

Cleaning records were reviewed in both the traceability exercise and on the factory inspection with no issues noted. Cleaning records detail the cleaning requirements stipulated in clause 4.11.2.

Cleaning is monitored through: daily start up check by Pre-SSOPS per production / area and monthly agar TPC.

Limits of acceptable and unacceptable cleaning performance is defined for food contact surfaces and processing equipment: In general good performances were seen. In case agar TPC is 3 or 4 a resampling is performed.

Areas visited on the factory inspection were not all observed to be clean and tidy. **Minor NC**: Several objects are not clean, e.g. the evaporator cutting room, under the unloading dock inbound, walls and controls next to the unloading dock inbound, backside weighing cabinets , weighing units and belts of the checkweighers, unused machine retail department.

No specific cleaning operations seen during the audit.

The following evidence was reviewed:
- Results agar TPC 25-11-2025 and 10-12-2025
- Results cleaning chemical residue ( ) control 04-03-2025
- F-ENS-NL-10062 “Pre-SSOP opstartcontrole inpak 1 + 2” recorded on paper and mobile phone on 17-12-2025.

4.11.7 Cleaning in place (CIP)

CIP is not applicable.

4.11.8 Environmental monitoring

The environmental monitoring programme is detailed in: micro planning, F-ENS-NL-10086
The programme is risk-based and includes frequency of testing, organisms to be included, typical sampling areas and procedures for out of specification results.

The programme monitors for:
- Monthly Listeria swabs: 5x cutting area and 10x retail area
- Agar TPC verification cleaning 1x / 2 weeks retail area and the other week deboning area (crates included)
- Water samples 3x / year: sampling plan random
- Air samples 4x / year 6 samples (TVC, Entero’s, yeasts / moulds)

Comment on the results of environmental monitoring programme:
Agar TPC results and trend seen for 2025 YTD. No issues found. Listeria swab results 2025 YTD seen. 2x positive results on “keerwielen”. Resampled after cleaning and for monitoring monthly 5 extra Listeria SPP swabs of the specific object. Close and direct communication with representative employee of on site (good and direct communication, short lines).

A clear review and trend analysis is in place. Key data and performance are provided as input to the management review (no issues).

The programme is found to be suitable and effective.

The level of environmental monitoring performed is commensurate with the final product risk.

The following evidence was reviewed:
- Results agar TPC 25-11-2025 and 10-12-2025
- Results Listeria swabs 2025 YTD
- Lab report 22-09-2025: 11 water samples (cutting area, canteen, production area, clothing area, first aid area, etc.). All results below the maximum limit.

4.12 Waste and waste disposal

Waste is categorized in: **cat. 1, bones, cat. 3, paper / carton, plastic, sewage sludge and rest waste (canteen / offices)**
All waste containers were identified with contents. Cat. 1 specific in grey crates, cat. 3 in blue crates. Bone collection is situated indoor in special area, this way no birds nuisance.

The factory was seen to be clean and tidy with waste well controlled and no evidence of spillages were observed. There are limited open product areas.

Waste removal is contracted to:
Trademarked waste materials are: not present
Licensed waste removal was sampled for:
Records of destruction are being retained.

4.13 Management of surplus food and products for animal feed

Materials transferred to the animal feed chain: No

Category 3 material declared unfit for human consumption, retrieved by Rendac which is specialized in the destruction of this type of animal by-products. Trade documents according to Regulation 1069/2009/EC. A register is kept, and legal requirements are met, e.g. separate refrigerated storage and clear identification.

4.14 Pest management

Pest control is contracted to .
The scope is detailed as: rodents, crawling insects, flying insects and visual inspection point

No internal pest controller applicable.

No presence of infestation during the last certificated period or observed during the BRCGS audit.

Routine visits per year: 8x / year
Content of routine inspection: 8x inspections, 4x flying insects, 1x lamp change
In-depth inspections performed: 1x / year PRI performed on 29-01-2025 by and 1x / year quality inspection on 06-11-2025 by
Sampled regular visit reports: 05-12-2025 by
Frequency is suitable.

Documentation was well maintained and visit reports fully completed with actions closed in a timely fashion.

The following evidence was reviewed on dashboard:
Plan with bait points
Inspection and PRI reports
Trend analyses 2025 YTD
Certificate “bestrijdingstechnicus” , 31-12-2021 (exp. 31-12-2026)
Certificate PRI , 09-01-2022

4.15 Storage facilities

Storage spaces are maintained in hygienic conditions. Waste materials and chemicals are stored separately.

Temperature controlled storage is required, and this is monitored continuously through a central system with alarms when out of set limits. This is not required for ambient stable raw materials and packing materials incl. clean empty crates.

No allergens on site.

Chemicals and (raw) materials are stored separately from finished products. Only electric powdered fork-lift trucks are operated.

Only small stocks of materials are kept on site and stock rotation is via the ERP system managed. FIFO usage when possible, but as the shelf life is short and most products are produced based on client orders, FIFO or FEFO is not always applicable.

Delivery / storage record sheets are in place for each raw material & packaging item and are kept at their storage location; seen within the traceability exercise with no issues noted.

No outside storage.

The following evidence was reviewed:
Monthly alarm test cooling system (vriescel) 03-11-2025 and planning of which areas are tested which month.

4.16 Dispatch and transport

The transport of finished goods is all outsourced to external service providers. There are no company vehicles.

An overview is maintained in the site approved supplier list.
Verified GFSI certification of: **(cold storage) and Distrifresh (transport)**

Temperature checks and hygiene monitoring controls are in place for: unloading raw materials and loading finished product (identified CCPs, see chapter 2), all recorded per batch.

Vehicles back directly onto loading bays, which are closed with shutter doors when not in use.

The following evidence was reviewed:
Records of evidence were reviewed during the factory inspection during the audit and through the auditors’ vertical audit.

Details of non-applicable clauses with justification	
Clause/Section Ref	Justification
4.10.2	No filters and sieves applied
4.10.4	No magnets applied to control / prevent product contamination. Method not suitable for this sector.
4.10.5	No optical sorting
4.10.6	No packaging in glass jars, cans and other rigid containers.
4.10.7	No other foreign-body detection and removal equipment
4.11.7	No CIP cleaning applied.
4.13.x	No customer-branded surplus food.
4.13.3	No surplus food and products for animal feed
4.15.5	No outside storage

5. Product control

5.1 Product design/development

The product design / development procedures are clearly detailed in: **P-ENS-NL-10070 "Procedure aanvraag nieuw of gewijzigd product" V1 en P-ENS-NL-10047 "Procedure proefperiode".**

No specific product development, mostly minor product adjustments of products / labels / pack performance or portion size, on request of customers.

There is a process of defining the product brief and agreeing the brief with external customers. HACCP review after first trial and sign off, sample agreement, trail review and customer sign off. Since 2024, there are no new retail products developed in Enschede (most production for retail is now done Vion Groenlo)

HACCP team involvement and agreement on customer requirements:
Communication with PD based at Vion Groenlo retail is performed by QC (HACCP team member) HACCP reviews are held quarterly and include HACCP assessments made by the HACCP team leader The HACCP team also consider any amendments to standard processes.

The QA manager (HACCP Team Leader) reviews process specifications and together with sales department agrees / discusses information areas with customers before final agreements are made.

Trials:
Trials are agreed between the QC / Sales contact, Product Development Manager and customers, this is all customized (depending on type of development).

Shelf-life validation:
Shelf-life trials follow documented protocols that reflect appropriate conditions. The process is the same for existing products: 2x / year (1x refined parts and 1x trimmings) micro and sensory. Limit TVC < 7 log and Entero's < 5 log.

The following evidence was reviewed:
Shelf-life test bovenbil, 17-02-2025 (pack date): 5 samples tested on kill + 4 days (pack date), + 5 weeks and + 6 weeks. All results under the max. limit.

Shelf-life test trimmings, 29-08-2025 (pack date): 5 samples. Conclusion: shelf life of 14 days is maintained.

5.2 Product labelling

The following documentation describes the process: P-ENS-NL-10039 Labelling procedure

Day batches are created for geelhaar, fat, nerves and tendons. All other beef which is only portioned and packed, the original batches stay on the final label incl. the shelf life, depending on the day of deboning. However the label says "pack date" which is eventually the deboning date. The method of shelf life date defining is all laid down in specification system and interpretation.

Legislation in countries of sale:
Labelling product for EU-market following EU-legislation and any additional customer requirement. No markets outside EU for products produced at Vion Enschede. In storage areas are no none-labelled goods allowed.

Seen several right labelling of B2B products.

Artwork approval & accuracy of information:
The artwork approval and legality of customers' labels is the responsibility of the customer – they are supplied to site by the customer. QA / QC will still review the label contents.

No allergens used on site.

Cooking instruction validation procedures: Cooking instructions are not applicable, only B2B raw beef.

5.3 Management of allergens

No allergens handled on site.

5.4 Product authenticity, claims and chain of custody

Product authenticity is detailed in: Risk matrix Food Fraud P-ENS-NL-10057 and P-ENS-NL-10041

Knowledge of the Team

The food defence and fraud team are also the site HACCP team. The team leader has completed relevant training (see evidence section below). The use of raw material and supplier risk assessments demonstrated knowledge of the principle of vulnerability assessment.

The vulnerability assessment covers all the mandatory requirements in section 5.4 of the BRCGS standard.

Examples raw materials, risk level and mitigating controls:
Significant vulnerabilities have been determined. Examples include:
Bio material <50 low risk. No high risk identified (> 100)

Appropriate mitigation measures are developed and implemented, which include:
GFSI certification suppliers of raw material, packaging and services.

Review of the vulnerability plan is programmed to be reviewed annually, included in yearly MR.
Date of the last review is done in the Management Review: 01/10/2025

Claims:
Simmentaler beef: site is IFS PIA certified
Organic: Annual Skal audit (BIO) took place, no issues

The following evidence was reviewed:
Training Integrity Manager, : Food Defence, product / process integrity on 22-04-2024
Training Integrity Manager, : Central Vion Group integrity procedure on 11-10-2024
Skal certificate

5.5 Product packaging

The packaging materials for finished products are: bulk packed in dolavs, bags in crates, (consumer) vacuum packed in crates or boxes.

Suitable packing procedures and materials are in place with relevant (food contact suitability / migration) specifications. The packing suppliers are GFSI certified which was checked for .

Specification and declarations of conformity seen for the packaging used in the traceability test.

The following evidence was reviewed:
product information and data sheet No 23-685 09-05-2023
food contact compliance declaration No 25-01 26-03-2025

5.6 Product inspection, on-site product testing and laboratory analysis

The testing programme is outlined in: **P-ENS-NL-10067** based on P-Food-10008 (limits) and P-Food-10009 (frequency) created and maintained by HQ.

A plan of analysis is available and systematically followed. Product samples are taken from production at the line.

External analysis via **ISO 17025 accredited** ( ).
Product monitoring based on Regulation 2073/2005/EU laid down in procedure P-FOOD-10008. Both food safety criteria and process hygiene criteria set by legislation are translated to the monitoring program as reviewed based on sampling.

Types of tests and frequency:
Carcasses, per 10 deliveries 5 samples
Parts (veredelde delen), weekly 5 samples (TPC, Entero's, Salmonella, Listeria)
Trimmings, weekly 5 samples, process control
Shelf life 2x / year, 1x trimmings and 1x parts (veredelde delen)

Environmental: see 4.11

Results are shared with departments and management, also included in MR. Out of specification laboratory results follow a defined escalation route managed by QA / QC. If the trend for a new supplier of carcasses is continuous (first 5 deliveries) too high, the supplier is not accepted

Summarise test result outcomes / trends and actions taken: no issues.

The most recent shelf-life validation was seen for the: bovenbil and trimmings.

Confirm process and frequency of shelf-life testing verification: **see evidence**
Most recent shelf-life verification: **see evidence**

No onsite laboratories

The following evidence was reviewed:
- Shelf-life test bovenbil, 17-02-2025 (pack date): 5 samples tested on kill + 4 days (pack date), + 5 weeks and + 6 weeks. All results under the max. limit.
- Shelf-life test trimmings, 29-08-2025 (pack date): 5 samples. Conclusion: shelf life of 14 days is maintained.
- Trend analysis carcasses. Every 10th delivery is sampled. New suppliers sampling of first 5 trucks, if okay than approved supplier. Quarterly reviewed by QA manager.
- Trend analysis dressed cuts beef TPC and Entero's 2025 YTD
- Trend analysis trimmings beef TPC and Entero's 2025 YTD
- Q3 QA review micro results

5.7 Product release

No specific positive release.

5.8 Pet food and animal feed

No pet food produced.

5.9 Animal primary conversion

No animal primary conversion.

Details of non-applicable clauses with justification	
Clause/Section Ref	Justification

5.6.5	No laboratory on site.
5.8	No pet food.
5.9	No Animal primary conversion.

6. Process control

6.1 Control of operations

Process control was evaluated in all process steps incl. packing and change over.

Assessed during the onsite audit:

- Unloading and reception of (hanging) parts of carcasses, incl. raw material control, CCP temperature check
- Deboning of meat
- Cutting, slicing, portioning of meat
- Determine fat% of trimmings by the eagle (x-ray)
- Deboned beef, metal detection, vacuum packing, B2B labelling and packing in crates / boxes
- Managing of packing material
- Managing of bones, cat. 1 and cat. 3 material
- Managing of clean arrived crates and used dirty crates
- Storage of chilled meat (packed in crates, boxes, dolavs)
- Slicing and portioning of meat
- Label check with specifications and customer requests
- Label print check
- Weight checks
- CP metal detection check on deboned beef and retail products
- PRE-SSOP and SSOP checks
- Control checks before loading on temperature (CCP) and trucks
- Non-food warehouse
- Chemical storage (for cleaning purposes)
- Maintenance work shop
- Outside area

Documented procedures and work instructions are in place that ensure consistent product is produced and packed.

There are dedicated logs for each process which include traceability, process steps, process parameters such as times, temperatures and volumes, quality testing and results, set up approval (release) and packing.

The product is subject to CCP and CP checks and these were seen (see details below at evidence).

No out of scope products are handled.

The following evidence was reviewed:

- Change over during site tour in deboning area and in packing area.

- Demonstration CCP temperature checks recorded on: for CCP1 F-ENS-NL-10003 V9 03-06-2024 “CCP temperatuur ontvangst bouten”, for CCP2 F-ENS-NL-10016 V16 27-03-2025 and for CCP3 “CCP temperature check expeditie”
- F-ENS-NL-10022 V4 “Ingangscontrole non-food”.
- Process controls were evaluated in all process steps including packing and change over (deboning and packing) during site tour

6.2 Labelling and pack control

There is a clear process and line clearance check for labelling and removal of labelling from the line at a product change over.

Records of checks were sampled from previous days and from the vertical audit trail.

At the time of the production assessment there were two change overs on the lines so this could be witnessed. If a change over is done in the cutting department, a big empty space on the line is made between batches and a colourd piece of hard plastic is placed between the batches as marking. This was noticed during the tour.

Verification of labels is 4 eye principle and bar code scanning. There is no online verification equipment for the correct label.

The process for back label printing was looked at with checks on bar code and best before date undertaken and recorded.

The following evidence was reviewed:
- F-ENS-NL-1006 V7 12-05-2025 “Controle etiketten retail” of flat iron on 17-12-2025
- Seen product label and box label of tenderloin during vertical trace.

6.3 Quantity, weight, volume and number control

Weight control is on real product weights for packaged retail products as seen on the factory inspection and within the trace exercise and satisfactory.

No bulk quantities are sold.

Manual ( ) and online ( ) check weighers are used for real product weight.

The following evidence was reviewed:
- Seen demonstration label check during site tour on 17-12-2025. Registration on F-ENS-NL-10094 V5 18-06-2024 “Controle weegschalen inpak”
- Calibration of scales, checks on amounts and weight during site tour and vertical trace test.

6.4 Calibration and control of measuring and monitoring devices

There is a clear schedule of calibration for all equipment. The records of calibration were checked for:
- Metal detector S/N C240899164 01-07-2025 by (calibration, inspection, preventive maintenance)
- Metal detector S/N 84293 01-07-2025 by calibration, inspection, preventive maintenance)
- Internal calibration recorded on F-ENS-NL-10020 V3 “Kalibratie thermometers”
    - Thermometer reception S/N 19729079 12-08-2025
    - Thermometer dispatch S/N 15236739 12-08-2025

- Thermometer dispatch S/N 15338994 12-08-2025
- Reference thermometer S/N 15338993 19-12-2025 by
- Floor scales dispatch S/N 3106609 30-11-2024
- Scale packing area S/N 3106599P 18-10-2025 by
- Scale packing area S/N 3106601P 18-10-2025 by
- X-ray (Eagle) 25-02-2025 by

Clear records of calibration were seen within defined limits for all the equipment sampled.

Details of non-applicable clauses with justification	
Clause/Section Ref	Justification
6.2.4	No on-line verification equipment used.

7. Personnel

7.1 Training: raw material handling, preparation, processing, packing and storage areas

Induction training is required for all new employees and includes a short site tour, film, the company hygiene rules, site policy, general product safety and quality aspects and a “introductietoets” (seen). There is a yearly refresher training for inductions in place. New employees are accompanied by a “social buddy”. After 2 weeks an evaluation between the new employee and HR takes place.

Training needs for personnel engaged in activities related to product safety, quality and legality are further defined in the “personeelsmatrix” (seen).
Employee training is defined in a documented procedure. For operators there are records of sign off against key tasks.

At this visit, 8 operators were sampled (see evidence). Clear competency records and refresher training records were seen. End-of-year meetings are scheduled with employees

Records are maintained in personnel files and in an Excel-sheet (seen overview 2025 YTD).

The following evidence was reviewed:

- Handling fallen meat, 12-04-2021
- Onboarding and work instructions reception, 10-12-2025
- Onboarding and work instructions “ontvliezen”, 12-11-2025 and 19-11-2025
- Metal detection, 28-06-2025
- Metal detection, 03-02-2025
- Hygiene refresher training, 13-01-2025
- CCP dispatch temperature, 09-01-2025
- CCP intake temperature, 13-01-2025
- “Training Pre-SSOP en SSOP”
- “Training label controle diverse punten in productie”

7.2 Personal hygiene: raw material handling, preparation, processing, packing and storage areas
Hygiene policy is clearly communicated as part of induction programme and displayed on the wall in key areas. All requirements of the Standard are addressed. No deviations from the policy were observed during the audit. Blue, metal detectable plasters are provided in the first aid box. Visitors are required to complete a questionnaire prior to entrance and a brochure is given with the plan, hygiene and safety rules. Adequate facilities in place. Handwashing takes place at entry of the production area and warehouse area. No issues observed regarding handwashing stations. Staff hygiene canteens and consumption areas are segregated from production areas. Hygienic conditions are maintained. No issues observed during the audit. Changing rooms are located close to production facilities and found to be clean and tidy. Personal items stored in lockers. Double sided lockers for personal and company issued clothing. Staff changes into workwear on site. Toilets are accessible from the locker rooms, segregated from production. Designated smoking area available outside of the main buildings. **The following evidence was reviewed:** Good practice observed during the site tours.
7.3 Medical screening
Staff medical screening is limited under national privacy law. Reporting of illness and injuries which might cause a risk to product safety must be reported according to the company hygiene rules. Visitors need to sign the visitor's log and therewith declare adherence to the company rules. **The following evidence was reviewed:** Brochure at entrance "Welkom bij Vion Enschede"
7.4 Protective clothing: employees or visitors to production areas
Work wear of personnel includes suitable, protective clothing (including hair / beard nets) that provides adequate coverage. Clothing has no external pockets above waste or sewn-on buttons. Gloves used in production processes. White coats, white boots and hair / beard nets available for visitors. Laundering of clothing is outsourced to a contracted and specialised laundry . Before entering the canteen or smoking area, plastic sleeves, aprons, gloves and white coats must be removed. In cold areas, balaclavas and thermos clothing is allowed under the protective clothing. Segregation of clean and dirty clothing is effectively managed; there is a dedicated closed bin for dirty clothing. Clean clothing is provided in a dedicated locker by the laundry service provider. Free provided every day.

Details of non-applicable clauses with justification	
Clause/Section Ref	Justification

8. Production risk zones – high risk, high care and ambient high care production risk zones
8.1 Layout product flow and segregation in high-risk, high-care and ambient high-care zones
Not applicable
8.2 Building fabric in high-risk and high-care zones
Not applicable
8.3 Equipment and maintenance in high-risk and high-care zones
Not applicable
8.4 Staff facilities for high-risk and high-care zones
Not applicable
8.5 Housekeeping and hygiene in the high-risk high-care zones
Not applicable
8.6 Waste/Waste disposal in high risk, high care zones
Not applicable
8.7 Protective clothing in the high-risk high-care zones
Not applicable

Details of non-applicable clauses with justification	
Clause/Section Ref	Justification

9. Requirements for traded products
9.1 The food safety plan - HACCP
Not applicable
9.2 Approval and performance monitoring of manufacturers/packers of traded food products
Not applicable
9.3 Specifications
Not applicable
9.4 Product inspection and laboratory testing
Not applicable
9.5 Product legality
Not applicable
9.6 Traceability
Not applicable

Module 11: Meat Supply Chain Assurance	
Scope	Click or tap here to enter text.
11.1 Traceability	
Click or tap here to enter text.	
11.2 Approval of meat supply chain	
Click or tap here to enter text.	
11.3 Raw material receipt and inspection	

Click or tap here to enter text.
11.4 Management of cross-contamination between species
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11.5 Product testing
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11.6 Training
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Module 13: Meeting FSMA Requirements for Food – July 2022
Preventive Controls for Human Food: 21 CFR Part 117 (Clauses 13.1.1 – 13.1.33)
Click or tap here to enter text.
Preventive Controls for Animal Food: 21 CFR Part 507 (Clause 13.2.1)
Click or tap here to enter text.
Food Defence: 21 Part 121 (Clauses 13.3.1 – 13.3.11)
Click or tap here to enter text.
Sanitary Transportation: 21 CFR Part 1 Subpart 0 (Clauses 13.4.1 – 13.4.9)
Click or tap here to enter text.
Produce Safety: 21 Part 112 (Clauses 13.5.1 – 13.5.18)
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14.1 Additional Specifier Requirements
14.1 Traceability
Click or tap here to enter text.
14.2 Environmental Monitoring
Click or tap here to enter text.
14.3 Product inspection and laboratory testing
Click or tap here to enter text.
14.4 Protective clothing: Employees or visitors to production areas
Click or tap here to enter text.