Audit Report

Global Standard for Food Safety Issue 7: July 2015

1.Audit Summary			
Company name	Vion Groenlo B.V.	BRC Site Code	2074194
Site name	Vion Groenlo B.V,		
Scope of audit	The slaughtering of pigs and sows and the deboning, cutting to specification and packing in bulk packaging of pork, including Good Farming®-meat.		
Exclusions from scope	none		
Justification for exclusion	Not applicable		
Audit Finish Date	2016-01-12		
Re-audit due date	2017-01-18		

Voluntary modules included		
Modules	Result	Details
Choose a module	Choose an item	
Choose a module	Choose an item	

2. Audit Results					
Audit result	Certificated	Audit grade	AA	Audit type	Announced
Previous audit grade	A	Previous audit date	2015-01-13		

Number of non-conformities	Fundamental	0
	Critical	0
	Major	0
	Minor	5

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3.Company Details

Address	Vion Groenlo B.V. Den Sliem 8 7141 JH Groenlo		
Country	The Netherlands	Site Telephone Number	+31 544 476100
Commercial representative Name	Mrs	Email	@vionfood.com
Technical representative Name	Mr	Email	@vionfood.com

4.Company Profile

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

Subcontracted processes	No
Other certificates held	ISO9001, Chain-of-Custody, BLK, SKAL
Regions exported to	Asia North America Oceania Africa Europe Choose a region
Company registration number	NL 367
Major changes since last BRC audit	Due to the new strategy of Vion Food a transition process is running to transform Vion Groenlo to a Retail delivering plant. An investment project is running to extend the factory with a deboning plant and to enlarge the expedition areas.

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4.Company Profile

VION Groenlo B.V. is part of VION Food Group Nederland. Originally the location was an independent slaughterhouse. The location is slaughtering pigs and sows, and subsequent deboning and cutting to specification. Actual customers are industrial B-toB companies. Processed integration lines are welfare, IKB, good farming * and Bio origin. The company has a SKAL recognition. VION Groenlo is approved. The company has one HACCP study which is supported by a central VION study (VION HQ, located in Boxtel). Centrally organised processes are: purchasing, sales, logistics and transport. The location has about employees, working in 1 shift. The production volume is ca. pigs / sows / week. This will be expanded to pigs/sows per week in May 2016. The building is from 2002 and the surface is about 9700 m2. The products are packed in crates or cartons, big boxes or hanged on hooks or brackets

5.Product Characteristics

Product categories	01 - Raw red meat Category Category Category
Finished product safety rationale	Fresh pork meat (bulk, carcasses and cut to specification: further processing required), chilled (max. 7 degree), short shelf life, no presence of preservatives, packed at semi bulk level

High care **No** High risk **No** Ambient high care **No**

Justification for area	Production of fresh pork meat which undergo a full cooking 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
Product claims made e.g. IP, organic	Organic
Product recalls in last 12 Months	No

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5. Product Characteristics

Products in production at the time of the audit	Japan Ham meat, Procureur GF*, middles for plant Scherpenzeel

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6. Audit Duration Details

On-site duration	16 man hours	Duration of production facility inspection	10 man hours
Reasons for deviation from typical or expected audit duration	none		
Next audit type selected	Announced		

Audit Duration per day

Audit Days	Audit Dates	Audit Start Time	Audit Finish Time
1 (start date)	2016-01-11	08.30	17.00
2	2016-01-12	08.45	17.00

	Auditor (s) number(s)	Names and roles of others
Auditor Number		
Second Auditor Number	N/A	

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 1.1.9)

Name / Job Title	Opening Meeting	Site Inspection	Procedure Review	Closing Meeting
Plant Manager	x		x	x
Quality Manager	x	x	x	x
Ass QA manager		x	x	x
Production Manager				x
Manager expedition / facilities		x		x
		x		x

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Present at audit				
Manager cutting department		x		
Manager slaughtering department		x		

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Non-Conformity Summary Sheet

Critical or Major Non Conformities Against Fundamental Requirements				
No.	Clause	Details of non-conformity	Critical or Major?	Anticipated re-audit date

Critical			
No.	Clause	Details of non-conformity	Anticipated re-audit date

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Major							
No.	Clause	Details of non-conformity	Correction	Proposed preventive action plan (based on root cause analysis)	Evidence provided document, photograph, visit/other	Date reviewed	Reviewed by

Minor							
No.	Clause	Details of non-conformity	Correction	Proposed preventive action plan (based on root cause analysis)	Evidence provided document, photograph, visit/other	Date reviewed	Reviewed by
01	3.2.1.	At the facility department the used SSOP registration form was F-GRO-NL-10037, version 20.02.2014. The actual version in Quality online is version 22.12.2015. This department is using the	The old versions of the SSOP emballage forms were directly removed and the new version from 22-12-2015 is in use since 13-01-2016	The QA department is responsible for document changes in The modified version is send (via) to the manager of the concerned department for approval and only after that the	SSOP form about checking hard copy documents	2016-02-01 NC is closed and practise will be verified	

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		wrong version; the registration of the temperature of the water in the crate washing equipment was the new element and isn't recorded now.		document will be released. The department manager is responsible for the instructions of the employees and replacement of the hard copy documents. In this specific case not all employees were informed and the old documents weren't replaced. Action plan: - Reinstruction of employees of facility management about the new procedure - Verification of document control at shop floor after document changes is by the QA department will be introduced.		next BRC audit	

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02	3.3.1.	The verification of the SSOP records in the slaughtering department isn't demonstrable from the 27th of November until the 2nd of December 2015.	All SSOP forms were collect by the QA department which weren`t signed by the slaughtering department. All SSOP forms that has no signature, yet signed by the slaughtering department.	Rootcause: The teamleiders and the slaughterhouse manager were not fully aware that the SSOP checklists have to be signed every day (at the end of the day). Action plan: Clear instruction were performed by the Qality manager to the concerning employees (Slaughterhouse manager and teamleiders) in regard with completing the SSOP checklists. This matter will be daily verified by the Slaughterhouse manager and one time a week by the QA department.	Instruction SSOP: "verification SSOP-forms" and way of judging and signing the SSOP-forms.	2016-02-01 NC is fully closed	
03	3.6.4.	The specifications about the used -ink and cleaner and water treatment chemicals are all 3 dated 2008. No process of	The supplier was contacted and the specifications for these chemicals were reviewed, controlled and the most recent version were asked. No	Root cause: Not clear within de Maintenance department that this kind of	Inventory list of technical materials BOW	2016-02-01	

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		verification of the actual specification 1* 3 years demonstrable.	modifications were made on ink cleaner and water sinced 2008.	specification cannot be older than 3 years. Action plan: This issue was discussed within the Maintenance Department and clear instruction was giving by the QA department over the management of the chemical substances specifications. An inventory of all technical materials was done in order to check all specification and where necessary update them. This Inventory will be done once a year reviewed and adjusted by the maintenance manager.		NC is closed and practise will be verified next BRC audit	
04	4.7.4.	In conformity with the maintenance programme for the chopping equipment in the slaughtering line a logbook should be kept for the maintenance and repair	A change was made directly in the work order of the programm . Logbook deleted.	Rootcause: By mistake the Maintenance Department forgot to delete from the sentence about	Printscreen BOW 1. Work order chopping equipment 2. Daily Start	2016-02-01 NC is fully closed	

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		work related to this equipment. This logbook isn't used since 17th of April 2015.		'Logboek". Action plan: This issue is discussed within the Maintenance Department. The maintenance manager instructed all employees with regard of managing the work orders. The Logbook for the chopping equipment is no longer in used. Every day there is a start-up (work order) inserted in In this manner all information related to chopping equipment are registered and easy to trace back when needed. A logbook has no added value in this system anymore.	up order chopping equipmen		
05	4.11.5	The results of the agar samples of the BO storage, organ production area and several chilled storage areas aren't demonstrable for Q3 2015.	Case discussed within the Quality Department.	Rootcause: Because of a damage hard copy of the agar registration form a new one was printed and all the data was manually	Kopie agar list januari 2016	2016-02-01 NC is fully closed	

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				transcribed. Due to an administrative error during this process the agar results for the BO storage, organ production area and several chilled storage we're not registered for Q3 - 2015 For the Q1- 2016 the results from all the departments were registered. Action plan: This issue is discussed within the QA Department. Clear instruction were giving by the QA manager to the employee in charge with the agar sampling over extra verification of the changed or modified documents. Further on the Agar results will be minimally every month stored on a digital file. This will be checked by the QA manager and			

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				used as feedback for the cleaning company (beside de daily feedback for the positive samples).			

Comments on non-conformities

The company has done a root cause analyses about the 5 minor NC's and has taken appropriate corrective actions. 3 minors NC's are fully closed after the verification of the corrective actions and root cause analyses and defined corrective measurements. 2 minor NC's are closed and will be verified at practical implementation of the corrective measurements.

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Voluntary Modules Non-Conformity Summary Sheet

Critical			
No.	**Clause**	**Details of non-conformity**	**Anticipated re-audit date**

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Major							
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Minor

No.	Clause	Details of non-conformity	Correction	Proposed preventive action plan (based on root cause analysis)	Evidence provided document, photograph, visit/other	Date reviewed	Reviewed by

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Detailed Audit Report

Details of non-applicable clauses with justification	
Clause reference	Justification
3.5.4.	No outsourced processes
4.3.5, 4.3.6, 4.3.7, 4.4.4., 4.4.13, 4.8.4, 4.8.5, 7.4.4.	No high-risk, high-care or ambient high care based upon appendix 2 risk zone decision tree.
4.9.2.	No use of strongly scented or tain-forming materials
4.9.4.	No products packed into glass or other brittle containers
4.10.2	No use of filters and sieves
4.10.3.	No use of metal detectors
4.10.4.	No use of magnets
4.10.5	No use of optical sorting equipment
4.10.6	No use of container cleanliness euipment
4.11.7	No CIP cleaning
4.13	No production of animal feed
5.2.3.	No products with claims
5.2.4	No use of labels, prescribed by customers
5.3.	No allergens on site
6.2.4.	No use of in line vision equipment

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1. Senior management commitment

1.1 Senior management commitment and continual improvement

The quality policy is documented as P-GRO-NL-10044 and is authorized by the plant manager.
The site has ISO9001:2008 approval in a multisite certification with all VION Food Nederland plants, expiry date July 2018. The company is using the lean management principles to realise continual improvement (VOS 2.0 approach). The yearly management review was reflecting the period July 2014-June 2015. This review includes the HACCP verification. The corrective actions related to the previous visit have been evaluated and were closed effectively. The MR report is demonstrable discussed at MT level at 28th of October 2015.
In 2016 a quarterly management review report, based at KPI's, is introduced, in 2015 a monthly quality report was used for the information of the general management.
For setting the objectives, a system called X matrix is in use. Main objective for 2016 is the transformation to a 100% Retail supplier plant. Level of complaints is reduced last years and has a stable trend in 2015. Clear communication structure is part of it (daily huddles, weekly Tier 1 and Tier 2 and monthly MT meetings).
Minor NC's (3 NC's) from previous audit could be fully closed.

Due date is 18th of January 2016, so the audit is scheduled on time.

1.2 Organisational structure, responsibilities and management authority

The actual organisation chart is documented as P-GRO-NL-10117 (version 03.12.2015). This is combination chart for Vion Groenlo and Vion Retail, which is situated at the other site of the main road. The HR manager and maintenance manager are both working for both sites.
Replacement is clearly described.

2 The Food Safety Plan – HACCP

The HACCP system is implemented and maintained. A VION central PRP and CCP plan is the basis for the local HACCP plan.
Base for the local HACCP plan is the VION central HACCP-analysis. The output of the central HACCP Vion HACCP plan is processed in the local process management plan. The actual plan is dated P-GRO-NL-10074 December 2015. The HACCP system was developed by a multi-disciplinary team (plant manager, QA manager, production manager, maintenance manager and department managers).

A set of flow diagrams is part of the HACCP documentation, the steps are: receiving pigs, dirty and clean section of slaughter process, cooling, deboning and cutting, packing, storage and dispatch.
The flow diagram of the cutting process is verified, this is actual with the current situation.
The HACCP system is well established and has been carried out in accordance with Codex Alimentarius.
Each identified Hazard was reviewed and given a risk rating 1 to 9 (severity and likeliness of a hazard occurring = 3 x 3 matrix).
A decision tree is used.
Based at the actual HACCP plan the following CCP's apply with the critical limits:
CCP1: faecal contamination on carcass (0 contamination). Hourly, in line measurements.
CCP2: product temperatures at dispatch for meat (< 7 degree) sampling of every truck delivery
CCP3: product temperatures at dispatch for organs (< 3 degree) sampling of every truck delivery

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CCP4: product temperatures at dispatch for warm carcass (< 29,3 degree), sampling of every delivery (last year no warm carcasses are dispatched).
CCP5: purchase of and receiving returned organs < 3 degree) sampling of every truck delivery or return
CCP6: purchase of and receiving of returned meat < 7 degree) sampling of every truck delivery or return

Last formal HACCP verification covers July 2014- June 2015 and has been used as input for the overall management review of this period.
Verification outcome: CCP's are managed well. The daily process of CCP checks and preshipment procedures is organised good.
The prerequisite programme has resulted in 40 points of attention, which are controlled at daily base with the SSOP procedures.

The recent extension of the expedition areas is validated at the 6th of January by the group QA manager of the Vion HQ.

3. Food safety and quality management system

3.1 Food safety and quality manual

The documented Quality management system is managed by the QA department and available via . All key staff members have direct access.
Instructions of employees are done with text in multiple languages, instructions with photos and e-learning tools.

3.2 Documentation control

A general procedure is in place for document control. The QA manager is coordinating the authorisation steps in quality on line.
During the site audit an outdated document was in use for the SSOP control in the department facility management. The systematic for version management needs attention (minor NC 01).

3.3 Record completion and maintenance

Most records are hand written. Minimum retaining period is defined for 2 – 5 years. All electronic data are secured by daily back-ups.

A minor is raised for the verification of the SSOP checks in the slaughtering department, which wasn't demonstrable for 1 week in 2015 . (minor NC 02)

3.4 Internal audit

The interal audits within the Vion company are scheduled and coordinated by the central QA department. All internal auditors have followed an internal auditor refresher training in July 2015. is the internal auditor for Vion Groenlo, training record 09.07.2015 is seen.

Scheduling and reporting of internal audits is organised via the auditor-online tool. Audit frequency is 2x/year, 1 x announced and 1x unannounced.
Audit reports are seen of 11.05.2015 and 01.10.2015. The follow of the major and minor NC's is timely and demonstrable. Audit reports also contain information about conformity aspects.

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Hygiene and fabrication inspections are kept at a daily base with the SSOP checks. There's a monthly verification of the SSOP checks by the QA department. Records of this are verified for October 2015 and January 2016; no remarks.

3.5 Supplier and raw material approval and performance monitoring

3.5.1 Management of suppliers of raw materials and packaging

The purchase and delivery of pigs/sows is managed by VION Farming, located at the HQ in Boxtel. The intake of the pigs, including of the verification of relevant documents is a local responsibility. Close communication including reporting of defects and complaints was demonstrated. This is checked for the delivery of bio origin pigs, batch at the 23rd of October 2015 (vertical test); no remarks.
At the HQ of Vion in Boxtel there's also a central purchase department for non-food, food and services. The approval and assessment process of non-food suppliers and services is centrally managed with input of the several sites of Vion.
This is verified for , supplier of sow carcasses. This supplier is BRC approved. Due to the level of complaints, which has resulted in an inadequate assessment, a supplier audit is scheduled in Q1 2016.

3.5.2 Raw material and packaging acceptance and monitoring procedures

Incoming controls are performed for packaging materials and meat (saw carcasses from).
Process is verified for the incoming control at packaging materials (vacuum bags), delivered by at the 26th of November 2015. Records are verified; no remarks.

3.5.3 Management of suppliers of services

Approval and assessment of suppliers of services is the responsibility of the central purchasing department of Vion. The several plants are requested for input for the assessment process. For example transport audits are kept for the transport companies (reports 2015 and are seen).

3.5.4 Management of outsourced processing and packing

No outsourced processing and packing.

3.6 Specifications

The following specifications are sampled during the audit and vertical test:

- 36983 Ham meat 4 muscles Japan
- 47103 Mager met 80/20
- Meat pak paper (orange)
- water treatment
- -ink and cleaner

Specifications are made by the sales managers and authorised via a workflow based process. There's a narrow cooperation between the department managers of cutting departments and sales managers during the development of new specifications.

3 of the sampled specifications were dated 2008. A minor NC (03) is written for the review process of specification 1 x 3 years.

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3.7 Corrective and preventive actions

The principles of lean management are in use for the management of corrective and preventive actions. This is translated in VOS 2.0. Corrective actions are initiated via the team huddle communication structure. If not closed within the time frames actions are escalated towards the tier 1 level. A4 papers are in use for root cause analysis and defining corrective actions. For complex items a A3 approach is in use for the in depth root cause analysis.
This process is verified for the actual corrective actions related to the performance of the chopping equipment in the slaughtering line.

3.8 Control of non-conforming product

The procedure for non-conforming product is checked during the audit and records any incidents of non-conformity. For fallen meat a special procedure for tiding up is in place and at every department. During the audit the process of temporary blocked batches for Retail customers is seen. Good organised process. No recalls or withdrawals related to non-conforming products last year.

3.9 Traceability

The traceability of meat products is daily-based. For primary packaging materials the traceability is batch based.
During the audit a vertical audit kept for the product 47107, "mager met 80-20" bio origin, produced at 26.10.2015.
All relevant documents were available within 4 hours.
The following records and information is shown:

- Specification 47107
- Bio origin approval farmer , slaughterdate 13.10.2015
- Mass balance checks bio products 23.10.2015
- CCP records,
- SSOP records
- Traceability used primary packaging material
- Kalibration records used measuring equipment at 26.10.2015
- Result forward tracing
- Pre-SSOP records

Traceability tests are kept at a regular base, at least 1*/year. In 2015 2 tests are kept, reports are seen. The process has no rework flow.

3.10 Complaint handling

Complaints are send by sales to the complaint inbox email address of Vion Groenlo. All complaints are discussed in the tier 1 meetings. Corrective actions related to complaints are organised and coordinated by the responsible department managers.
Complaints including analysing reports and trend are part of the monthly quality reports and in 2016 of the quarterly management review report.

3.11 Management of incidents, product withdrawal and product recall

Vion Food group has 3 pork slaughtering plants in the Netherlands and ca 6 in Germany. In case of emergency situations the production will be transferred to another Vion plant.
The recall process is documented as P-VION-10015 Crisis manual and P-GRO-NL-10181 for the specific Groenlo situation.

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A recall test is kept at 26.02.2015, the report is seen. No corrective action needed after this test.
Vion Groenlo BV haven't had a product recall or withdrawal in 2015.
The certification body will be informed within 3 working days in case of a product recall.

3.12 Customer focus and communication

The sales department is centrally organised within Vion. No local sales managers.
the plant will become the dedicated producer of good farming star meat for retail customers of Vion. A project to intensify the awareness of the employees of Vion Groenlo BV to be a supplier of retail customers is running.

4. Site standards

4.1 External standards

The site is located at an industrial estate, close to Groenlo. This is in the east of the Netherlands. At the other site of the main road Vion Retail BV is located. This location is specialised in the production of consumer meat products, like hamburgers and minced meat for the retail market.

The plant is rebuilt in 2002, after a fire.

An investment project is running to enlarge the cutting facilities and storage areas for chilled products.

4.2 Security

The site is fully fenced. Entrance via barrier and porter.
Mandatory check in for each visitor.
Entrance for employees only possible with tags.
Site is EU approved (NL 367).

4.3 Layout, product flow and segregation

The production and storage zones have been defined and based upon a risk assessment all zones are "Low risk areas" (all meat products are sold to other industries or butcher's shops and do need a heat treatment before consumption).

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

The fabric and internal condition of the site was suitable and satisfactory for the processes. Walls, ceilings and floors were generally suitable. Daily check at fabrication aspects is part of the SSOP checks.
A separate building is in use for crate cleaning and storage of packaging materials. By cross over the street with crates including bags, the whole palled is sealed in, to prevent for cross contamination. A new disinfection tray is placed at entrance for disinfection wheels.
All areas are "low risk areas"

4.5 Utilities – water, ice, air and other gases

The company is using 100% water from main supply for process water and cleaning water. There's steam boiler equipment for the production of hot water.
Water samples are analysed 4x/year at microbiological aspects and 2x/year at Legionella.

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Results 2015 are verified: all results are in conformity with legal demands.

4.6 Equipment

Equipment used is made of SS or hard plastic. Equipment is bought from renowned producers of specialised equipment for the meat industry.
Used conveyer belts are food approved, the statement and specification of Bell tech is seen.
The actual situation of processing meat and chilling carcasses in the same area (expedition / cutting lines) isn't ideal. This will be solved in May 2016, when the new cutting equipment will be put in operation.

4.7 Maintenance

The company is using the software tool for the planning and registration of maintenance.

This is verified for the maintenance of the evisceration equipment of the slaughtering department. Main aspect of the maintenance of these equipment is the daily inspection and control during the start-up of the production process. Records of these are seen. In conformity with the maintenance programme, a log book should be kept about the maintenance works of the chop equipment. This wasn't done since 17th of April 2015, a minor NC is raised for this.

Hygiene clearance after maintenance work is the responsibility of the management of the several departments and is recorded at the SSOP list.

The engineering work shop is inspected during the site audit. Tidy organised work shop, the 5S approach is demonstrable. Lubricants are stored in a locker, which is locked. Only technician have keys. Food graded lubricants are in use for equipment, which have a direct contact with meat. Segregate storage, clearly labelling and list of chemicals (food and non-food approved) is seen.

4.8 Staff facilities

There are two separate staff facilities. One for the employees of the slaughter department and one for the pork cutting and expedition department. Both split in men and woman facilities. All employees have 2 lockers: 1 for work clothes and 1 for private clothes.
Canteen does only supply drinks and sandwiches.
The production and storage zones have been defined and based upon a risk assessment all zones are graded as "Low risk areas".
All entrances are equipped with hand free washing facilities, foot brushers and disinfection with hand pump.

4.9 Chemical and physical product contamination control

Raw material handling, preparation, processing, packing and storage areas

Control of chemicals on site was demonstrated. Separate (locked) storage facilities for e.g. cleaning chemicals and lubricating oil. This is also checked 2 -monthly during safety audits.
Knifes are provided by numbered sets in dedicated holders and checks on numbers at start and end of the day are daily this is recorded in the SSOP registration forms of the departments.
No application of glass or brittle packaging materials. Glass audits are performed monthly and daily in SSOP and Pre SSOP.

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Wood is not allowed in the production areas.

4.9.1 Chemical control

Control of chemicals on site was demonstrated. Separate (locked) storage facilities for e.g. cleaning chemicals and lubricating oil. This is also checked 2 -monthly during safety audits.

4.9.2 Metal control

Knifes are provided by numbered sets in dedicated holders and checks on numbers at start and end of the day are daily this is recorded in the SSOP registration forms of the departments.

4.9.3 Glass, brittle plastic, ceramics and similar materials

No application of glass or brittle packaging materials. Glass audits are performed monthly and daily in SSOP and Pre SSOP.
In 2015 there have been no glass breakage incidents.

4.9.4 Products packed into glass or other brittle containers

Not applicable

4.9.5 Wood

The use of wooden pallets is only allowed in the storage area of packaging materials. The production area is wood free.

4.10 Foreign-body detection and removal equipment

4.10.1 Foreign-body detection and removal equipment

At this site the semi-bulk products are produced. No consumer packed product are involved.
Based upon risk analysis no foreign body detection or removal equipment is applicable.
Crates and dolavs are in use (mostly including a bag (exception e.g. for fat).

At request of a customer of bio products, the company has 1 mobile metal detector, which is used during the production of bio products.

4.10.2 Filters and sieves

No use of filters and sieves

4.10.3 Metal detectors and X-ray equipment

A mobile metal detector is in use during the production of bio products for 1 customer.

The following test pieces are used:

- mm Fe
- mm non Fe
- mm SS

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Records of the use of the metal detector at 26.10.2015 are verified (vertical test). These were demonstrable. Metal catches are recorded at F-GRO-NL-10098.

In the new cutting area (running investment project) all lines will have metal detection equipment.

4.10.4 Magnets

No use of magnets, NA

4.10.5 Optical sorting equipment

NA, no optical sorting equipment in use

4.10.6 Container cleanliness – glass jars, cans and other rigid containers

NA, no container cleanliness in use.

4.11 Housekeeping and hygiene

The cleaning of the plant is outsourced to a contracted specialised cleaning company. Daily cleaning and disinfection of the whole plant < 2.5 m. Periodic cleaning (ceilings, walls > 2.5 m) is taken place at request and is coordinated by the QA manager. The actual cleaning schedule is verified: the extension of the expedition area is already added to the cleaning schedule.

Daily visual check at cleaning with pre-SSOP systematic. Weekly check at the disinfection process with agar samples and residue checks.

Daily cleaning of the staff facilities and outside terrain is carried out with the own facility services department. Employees are demonstrable trained in the use of cleaning chemicals at 12.03.2015 and 15.03.2015.

CIP is applicable at the blood tanks. But these tanks are owned and handled by the customer of the blood, this process is out of the scope of the BRC audit. The department manager daily checks if the CIP is working well.

The disinfection results of Q3 2015 were not complete, the results of the organ production process and several storage areas are missing (minor NC 04).

4.11.7 Cleaning in place (CIP)

NA, no CIP process.

4.12 Waste / waste disposal

A set of types of waste are defined. Correct collection and identification was seen. Legal handling of categorised meat (cat 2 and cat 3) is collected by a licensed company or feed application (/). Plastic etc is collected separately.

4.13 Management of surplus food and products for animal feed

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NA, in conformity with the legislation it's not allowed to give surplus food an animal feed destination.

4.14 Pest Control

Pest control is subcontracted to company (VION central contract).
Monitoring includes rodents, flying and crawling insects. Scheduled surveillances take place (8/year). In case of infestation extra visits are done and reported. At the moment no real problems (except some catches outside the building.
In-depth surveys are planned half yearly, based on risk assessment. Some infestation was reported. Corrective actions from the reports could be demonstrated.
In 2015 ca 160 recommendation points to improve te pest control programme are carried out.

4.15 Storage facilities

Packaging materials and crates/pallets are stored in a separated building.
Chilled storage facilities are limited, but will be extended after finalizing the running investment project.
All chilled storage areas are linked to a recording system, linked to an alarm reporting system.
This system is verified for the temperature course in the week of 20-26 October 2015 (vertical test), no issues with the temperature control in this week.
Stock rotation is based at FIFO principle.

4.16 Dispatch and transport

During the dispatch process a preshipment control is taken place to verify the CCP controls.
Transport is outsourced to contracted and specialised transport companies. Supplier approval and contract management is managed by the central purchasing department.
Local verification of the transport process by transport audits (agar check cleaniless, verification logger /temperature) and check of cleanliness before loading of each truck.
Reports of transport audits of and are seen.

5. Product control

5.1 Product design/development

Product design aspects are changes of snit recipes.
Process improvements are done based upon investment projects. Actual project is the improvement of the chopping process to improve the snit quality.
Shelf life trials are coordinated by the central QA department and is a continuous programme within Vion.

5.2 Product labelling

Vion Groenlo is producing single meat products. Labelling aspects are production date and land of origin. The English sows are labelled with the text born and bred in Engeland, due to the new legislation about labelling of origin.

5.3 Management of allergens

No allergens in use

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5.4 Product authenticity, claims and chain of custody

Vion Groenlo is producing bio, GF * and welfare pork meat. Chain of custody audits are kept 2x / year by an external certification body.
Mass balance checks are kept at a daily base.
During the audit the good farming star status of the British sow carcasses is verified. The Dutch authority of animal welfare has accepted the animal welfare system of the British supplier at 21.11.2014 as equivalent with the BLK demands in the Netherlands. The statement is seen.
The company has a SKAL recognition for the production of bio pork meat. Expiry date is 31.12.2016.

5.5 Product packaging

Packaging materials are stored separately from production materials and part used packaging is covered prior to returning to the storage area. Product contact liners applied are green, (organic), orange (good farming star), purple (Japan) or bleu (other) , depending on the IP of the product.
Based upon sampling the compliance with EU 1935/2004 was demonstrated.

5.6 Product inspection and laboratory testing

5.6.1 Product inspection and testing

Sub contracted analyses (microbiological) are carried out by a laboratory operating in accordance with ISO 17025 ( ). Swabs are done at the office of QA.
Trend analyses of swabs from carcasses do show good results within the limits (regarding to EU 2073/2005).
The sampling programme and schedule for 2016 is seen.

5.6.2 Laboratory testing

All microbiological analyses are carried out by the contracted external laboratory

5.7 Product release

Product release is based upon product temperature measurements (CCP) before dispatch. This is the preshipment process. 5 samples are taken from every batch. Checked during vertical audit and site tour.

6. Process control

6.1 Control of operations

Process control is based upon the HACCP study, legal and customer requirements. Documented start up checks (Pre SSOP) are seen. Measurement of fat of the meat, the weight, visual checks related to cutting specifications and the temperature are the most important items. All cooled areas are linked to a failure alarm.
Since May 2015 a product conformity check is introduced at a hourly base in the cutting department.

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6.2 Labelling and pack control

The labelling and pack control process of the production of products is verified. Each crate and each package is labelled with labels with product information and a color code. Employees are demonstrable instructed about this specific customer demand. For each batch the first and last label is stuck at a registration form, which is demonstrable verified by the shift leader of the expedition.

6.3 Quantity, weight, volume and number control

Quantity control is the responsibility of the expedition department, based at the orders of the customers. Only production and sales of variable weight products. A calibration programme for measuring equipment is seen. Yearly calibration of scales, verified for the balance of the expedition, used for meat, sold at hooks. (calibrated at 23.11.2015)

6.4 Calibration and control of measuring and monitoring devices

Calibration procedures ensure relevant equipment is identified and regularly calibrated.
Temperature devices (CCP related) and scales (legal issue) were sampled. Hand thermometers are calibrated at least two monthly (with melting ice) and yearly external. PT 100 of cellars are calibrated yearly (internal with calibrated thermometer). Balances are calibrated yearly (seen record of 23-11-2015 of 1 balance at expedition)

7. Personnel

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

There's a yearly training programme for all employees. Programme 2016 is seen, focus at management, HACCP and animal welfare training.
New (temporary) workers are trained prior work. The company is using e-learning training modules for the refresher training HACCP for employees.
The following training records are verified:

- HACCP refresher (15.12.2014), (12.11.2014) and T (15.12.2014)
- Animal welfare officer: (24.04.2014)
- CCP training: and (CCP 2 : 29.05.2015) and (CCP 1: 13.05.2015)

7.2 Personal hygiene: raw material handling, preparation, processing, packing and storage areas

All requirements and regulations about personal hygiene and raw material handling are documented in the house rules of Vion Food.
Visitors have an intake at the porter and have to fill in a questionnaire about their health and contact with livestock.

7.3 Medical screening

Medical screening of new employees and visitors is part of the intake process, when a person is entering the plant for the first time.

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7.4 Protective clothing: employees or visitors to production areas
All employees and visitors are wearing protective clothing and shoes or boots. Change of work clothes is at least daily. The wearing of a disposable hair cap is mandatory. The wearing of jewellery isn't allowed (zero tolerance policy). Laundering of protective clothing is done by a contracted professional laundry company. Gloves are worn, disposable gloves are changed each break. Safety gloves are washed each break.

Traded Goods Module

Scope

8.1 Approval and performance monitoring of manufacturers/packers of traded food products
8.2 Specifications
8.3 Product inspection and laboratory testing
8.4 Product legality
8.5 Traceability

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