

**Audit Report Global Standard Food Safety Issue 9**

1. Audit Summary			
Company name	Vion Tilburg BV	Site code	1886989
Site name	Vion Tilburg BV		
Scope of audit	The slaughtering of cattle and the deboning, cutting to specification and packing (foil or vacuum) of beef. The production and packing (foil, crate or drum) of slaughter by-products, semi-processed scalded stomachs.		
Exclusions from scope	none		
Justification for exclusion	na		
Audit start date	2026-04-22	Audit finish date	2026-04-24
Re-audit due date	2027-05-10	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 – mandatory 1 in 3 years
Previous audit grade	A		Previous audit date	2025-04-29	
Certificate issue date	2026-05-19		Certificate expiry date	2027-06-21	
Number of non-conformities			Fundamental	0	
			Critical	0	

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2. Audit Results		
	Major	0
	Minor	3

3. Company Details			
Site address	Enschotsestraat 28 5013 BD Tilburg		
Country	The Netherlands	Site telephone number	+31 (0) 13 462 08 00 345
Commercial representative name		Email	
Technical representative name		Email	

4. Company Profile					
Plant size (metres square)	10-25K sq.m	No. of employees	51-500	No. of HACCP plans	1-3
Shift pattern	1 shift, day operation				
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	ISO9001; Organic; IFS PIA; BLK				
Outsourced processes	No				
Outsourced process description	na				
Regions exported to	Europe Asia North America				

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**4. Company Profile**

	Choose a region Choose a region Choose a region
Company registration number	NL87EG
Major changes since last BRCGS audit	New construction for truck cleaning live stock.

**Company Description**

VION Tilburg B.V. is a cattle slaughterhouse and industrial butcher. It is one of the several sites of VION Food Netherlands which is a company with global presence. The location Tilburg is NVWA approved (NL 87 EG). VION Tilburg B.V. produces beef products and slaughter by-products and offal (organs, processing of stomachs (scalding) and the processing of first stage of natural casing (cleaning/ heating of bovine intestines)). The cattle is bought by VION Rundvee BV at the general mostly Dutch and Belgium market. Slaughter capacity is animals per day – per hour which is all done in 1 shift. At the moment animals are slaughtered per day.

The cutting department is supplied by pre-selected carcasses and very first cutting. The department includes about 3 main routes (forequarter, hindquarter and butcher handling). There are many equivalent activities (deboning, cutting to specification). Packing is at semi-bulk level (no consumer packed items). Trimmings are packed loose in crates/ dolavs or vacuum packed. The by-products are packed loose in crates/ dolavs or vacuum packed. The main customers are operating companies in the VION Food Group, retailers related processing within the Netherlands and Europe, Fast food producers, and business to business in Asia and Canada and almost all over the world. Some beef is sent to an external provider for freezing, packing and final storage (GFSI certificated). Some products from sister VION company in Enschede are cross docked in Tilburg.

The site is situated at an industrial area of the town Tilburg. The oldest part of the building is from 1920. In 2006 a new building for the cutting and packing departments has been constructed. In 2024 extension of staff facilities, storage of crates and primary packaging material, and creation of new offices. In 2025 stable is adjusted to best practice and state of the art stables for accepting cattle according to animal welfare requirements. Also, premises paving and porters house creating correct and logical flow for cattle carriers and meat carriers according to European law and a new washing area for the cattle trucks was built

VION Tilburg B.V. is certificated against ISO 9001 (multi-site certification) and holds SKAL approval (001997), IFS PIA declaration and certificate for trading of BLk2\* meat. At the moment the company employs approximately people (including subcontracted personnel about 50% mainly in operation). Production takes place in one shift. The surface is sq. meters and the used quality system is based on one HACCP-study.

This is an unannounced audit and the site tour started in 30 minutes after arrival.

[www.vionfoodgroup.com](http://www.vionfoodgroup.com).



5. Product Characteristics					
Product categories		01 - Raw red meat Category Category Category Category Category Category Category			
Finished product safety rationale		Cooled red meat and by-products/offal's. Beef intended for further raw processing is under a positive release regime.			
High care	No	High risk	No	Ambient high care	No
Justification for area		Appendix 2 is applied. In general beef and by-products are heated in one of the next stages of processing at the customer. Beef intended for further raw processing and consumption is under a positive release regime.			
Allergens handled on site		Milk 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		BLk, Organic/BIO			
Product recalls in last 12 months		No			
Products in production at the time of the audit		Different meat cuts, slaughtering of cattle			

6. Audit Duration Details			
Total audit duration	24 man hours	Duration of production facility inspection	12 man hours

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6. Audit Duration Details	
Reasons for deviation from typical or expected audit duration	None
Combined audits	None
Next audit type selected	Announced

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
	Plant manager	X		X	X
	Quality Manager	X	X	X	X
	Quality Manager	X	X	X	X
	QA employee		X		
	Financial manager			X	
	HR Manager			X	X
	Commercial Manager	X		X	
	Maintenance team leader		X	X	
	Expedition		X		
	Maintenance		X	X	
	Slaughtering team leader		X		
Employees	cutting department, slaughter department, stable; cattle reception, porter, cleaning, expedition and maintenance		X		

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GFSI Post Farm Gate Audit History			
Date	Scheme/Standard	Announced/Unannounced	Pass/Fail
2023-03-07	BRC	Announced	Pass
2024-04-10	BRC	Announced	Pass

Document control			
CB Report number	RQA9732086 job 6784860		
Template name	F908 Food Safety Audit Report Template		
Standard issue	9	Template issue date	2022-12-16
Directory allocation	Food	Version	1.1

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### 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

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Minor						
Clause	Detail	Correction	Proposed preventive action plan	Root cause analysis	Date reviewed	Reviewed by
4.4.1	Overdue maintenance on the cooling tunnel: peeling paint on the walls, loose sealant and a cracked floor.	<p>Repair by technical service carried out.</p> <p>Evidence seen: pictures of the repaired walls, sealant and floor.</p> <p>Agreed with correction and proposed action plan. Minor is closed.</p>	<p>Discuss within the HACCP team ( . ) how to prevent technical deficiencies reported during Pre-SSOP and SSOP checks from going unresolved by the technical service in a timely manner. Subsequently, initiate and document actions based on this to better monitor technical deficiencies within the framework of structural, timely, and complete resolution. Also training/instruction related department managers.</p> <p>Responsible: Manager maintenance / technical service.</p> <p>Repaired and checked 5-5-2026. Training relevant</p>	<p>Technical deficiencies have been reported by slaughterhouse and the "afsteek" departments on the corresponding Pré-SSOP and SSOP checklists of the respective departments. In the case of a deficiency, these are also reported to the technical service by phone. From the available data, it cannot be determined whether the deficiencies observed during the audit were previously reported substantively correctly to the technical service. Periodic technical meetings are held, attended by the site manager, production manager, QA manager, and technical service</p>	10-05-2026	



Minor					
			<p>staff by QA manager at 5-5-2026.</p> <p>Evidence seen: "F-TIL-NL-10116 training and instruction", training (Pre-) SSOP signed off by employees slaughter area, "afsteek" and technical service employees.</p>	<p>manager. Planning priorities are largely determined by the technical service manager.</p>	
4.7.4	<p>The maintenance service booklet was not signed off during weeks 35 to 37 2025.</p>	<p>Retroactive signing off of the actions carried out in weeks 35 to 37 of 2025 by maintenance manager.</p> <p>Evidence seen: pictures of signed off actions.</p> <p>Agreed with correction and proposed action plan. Minor is closed.</p>	<p>Refresher training for Technical Service employees and managers in other departments at VION Tilburg regarding Maintenance and Faults procedures P-TIL-NL-10130 and Workplace Protection in Unsafe Situations P-TIL-NL-10126. Checking and signing off the Technical Service technicians' "booklet" after food-safe delivery following a repair must be known to everyone and be carried out.</p>	<p>The related technician carried out work during this period and failed to have the workplace signed off for approval by the responsible department managers after the work was completed.</p>	10-05-2026

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Minor						
			<p>Responsible: Manager maintenance / technical service.</p> <p>Corrected and checked 5-5-2026. Training relevant staff by QA manager at 5-5-2026.</p> <p>Evidence seen: "F-TIL-NL-10116 RF training and instruction", signed off training.</p>			
4.9.3.2	<p>A crack in the window between the shooting area and the slaughterhouse is not listed in the checklist for glass/hard plastic, pre-SSOP and SSOP.</p>	<p>Urgently tape off to prevent possible product contamination and and repair carried out by technical department manager.</p> <p>Evidence seen: pictures of repaired window.</p> <p>Agreed with correction and proposed action plan. Minor is closed.</p>	<p>Refresher training by QA manager for responsible middle management accountable for inspections in this zone (stable and dirty slaughterhouse) at 5-5-2026.. This concerns Process Control (SSOP) P-TIL-NL-10119 and PRE-SSOP R&amp;D inspection procedures prior to production.</p> <p>Evidence seen: "F-TIL-NL-10116 RF training and instruction", signed off training.</p>	<p>Staff at the barn and slaughterhouse have (so far) NOT reported this (new) damage on the control lists available for this purpose. The reason is presumably insufficient knowledge of the procedures present in the quality manual. Because the glass round is conducted quarterly by the QA department (last on 3-2-2026), this deviation could not yet have been observed by the QA department.</p>	10-05-2026	

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**Comments on non-conformities**

Click or tap here to enter text.

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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

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**Audit team**

Lead auditor		
Auditor number	First name	Second name

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	2026-04-22	08:30	16:30	P	
			Lead auditor	2026-04-23	07:30	16:30	P	
			Lead auditor	2026-04-24	07:30	16.00	P	
			AUT	2026-04-22	08:30	16:30	P	
			AUT	2026-04-23	07:30	16:30	P	
			AUT	2026-04-24	07:30	16.00	P	

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## Detailed Audit Report

### 1. Senior management commitment

#### Policy

The site policy is documented in: Policy P-TIL-NL-10062, signed by \_\_\_\_\_, responsible for the site at Feb 10, 2025.

Commitment to continuously improve the site's food safety and quality culture are included.

Communication to staff: Displayed in key areas on notice boards and part of induction program new employees.

#### Product safety and quality culture plan

The level of culture at the site is identified. Objective KPI > 92,5%, where the standard requires 82,50 % and in 2025 80%. Culture aspects are clearly communicated through various channels (policy, induction program, annual newsletter). Through conversations, development of workers, personal training, etc. a total program is developed. Further: workshops, year-end meetings with personnel, food safety training, whistleblowing policy, sign up to business code of conduct.

The culture improvement plan is documented in: P-Food-10059 2024-07-04, v2, FSC, incl. animal welfare, prod, integrity, and FD, incl. goals in the management assessment plan. Seen report from July 1 – June 30, 2025 and Q4 2025, dated January 26, 2026.

Trainings are offered in 7 different languages, including for temporary workers.

Senior management were able to discuss the plan during this audit (spoken to Operational Manager).

#### Food safety and legality objectives

Notable food safety and quality objectives include:

- Agar checks: 0,55 (realized in 2025: 0,48).
- Cleaning plan: cooperation between Vion and \_\_\_\_\_. Completed.
- Cost and amount of returned goods decreased
- Number of food safety complaints number of product integrity complaints per 100,000 kg, with targets of 0,2
- New QA Manager (before end of 2026).
- Customer satisfaction score av. Min 7.6 and no score lower than 7 (in 2025: 6).

Objectives are monitored 4x per year by MT

Key results or significant trends: the site is meeting established objectives / effectively progressing through its objectives.

#### Management review

Frequency of management review meetings: 4x per year. Seen last report of Q4 2025, 26/01/26. All required items are discussed as these are fixed tabs in the excel sheet managed by HQ. EG on FSQC-plan, returns and complaints, microbiology, audits, and other topics.

Who typically attends the meeting: PT Production team of 8 persons

Date of last management review meeting: **21/01/2026**

How minutes and actions are communicated to staff and recorded: Senior management is present during most meetings. Meetings are sufficiently provided with action lists with timescales, responsibilities and recording of status.

#### Regular meetings

Routine meetings are held in which food safety, authenticity, legality, and quality issues are discussed.

The structure is documented. Daily meetings at 8 am for local MT, weekly MT/Haccp team at Tuesday 11 am, Wednesday with Maintenance and Vion-wide QA 4 times/year.

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The food safety team is detailed in: **P-TIL-NL-10219**. No changes in the team in 2026. Seen notes of Week 17 and 18, 2026.

The team leader is well qualified and experienced. The team is multidisciplinary, experienced, and knowledgeable in their fields with required level of food safety training. The HACCP Team is led by the 'Chair' Technical 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. Training records were sampled. HACCP team is integrated in Production team.

**Scope of HACCP**

The HACCP system scope is documented in: **P-VION-10000, V20**. 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. Document process control plan P-TIL-NL-10127, v23, March 26, 2026 is in place, identifying the CCP's, CP's and RP's.

**Processdiagram**

Record key process steps/operations to manufacture products within the scope of certification: Receipt of cattle, receipt of packing material, storage, slaughter, cutting, packing, storage and dispatch (see proof. Yearly verification of all process flows by methodology of authorisation and verification. The flow diagrams accurately reflect the production processes fully.

Record date and reason of last verification: **26/03/2026**

Flow-diagrams are maintained and signed as verified by members of the HACCP team; all were reviewed during the HACCP review.

**Hazard analysis**

HARA is based on comprehensive information sources.

Severity vs likelihood is considered.

Outline hazards considered specific to each process step:

- An assessment is made of microbiological (main risks Salmonella, STEC, Listeria), chemical (main risks heavy metals, pesticides, PFAS, PCB, dioxines, veterinary residu's, the allergen milk is acknowledged due to slaughtering of cows/presence of udder), radiological and physical (metal, plastic) risks for all steps in the production process, packing material

**CCPs, limits and controls (In F-TIL-NK-10042, V6, June 9, 2021).**

Provide CCPs / PRPs details:

#	CCP	Control measure	Critical limit	Monitoring frequency
1	Faecal contamination of carcasses, zero tolerance for visible faecal contamination just before the carcass cooling step. There is a daily verification of this CCP on the 5 last carcasses of the day. Monitoring is done at the end of the slaughter process	Visible detection faecal contamination	zero tolerance for visible faecal contamination just before the carcass cooling step	Formal monitoring is done on 5 carcasses at least 4 times per day.



2	Temperature control of cooled (vacuum) packed beef and by-products at dispatch (expedition). This is measured on every dispatch of product in the product reception / dispatch area	Thermometer	Core temperature of beef <7°C, intermediate surface contact temperature of vacuum-packed cooled beef <6°C, core temperature of animal by-products <3°C, surface contact temperature of vacuum-packed animal by-products <2°C	Every Dispatch, several (minimum 3) times
3	Temperature control of externally slaughtered cattle (carcasses/beef) of approved suppliers	Thermometer	Core temperature of beef <7°C intermediate surface contact temperature of vacuum-packed cooled beef <6°C, core temperature of animal by-products <3°C, surface contact temperature of vacuum-packed animal by-products <2°C.	every receipt.
4	Removal of spinal cord at the slaughter department	Visible detection on cutting the vertebral column	Zero tolerance for visible spinal cord or husks of spinal cord just before the carcass cooling step (In order to prevent BSE).	monitoring is done on 5 carcasses at least 4 times per day. There is a daily verification of this CCP on the 5 last carcasses of the day. Monitoring is done at the end of the slaughter process;
5	Transport and reception of partially chilled beef quarters conforming (EU) 2017/1981 with transport time of maximum of 6 hours.	Thermometer	Surface temperature <7°C, travel duration less as 6 hours	This is measured on every reception or dispatch of product in the product reception / dispatch area.

PRPs have been identified in: **P-TIL-NL-10127 Procesbeheersplan 26-03-2026**. Control measures have been defined. This includes approximately 30 OPRPs as condense control, knife and sharps management, metal detection, calibration of weight scales, traceability, packaging control.

**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. (NB CCP5 currently not in operation.)

**Validation, verification and review:**

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The company has effectively validated and verified the HACCP/Food Safety Plan, including the critical limits, control measures and PRPs specific for controlling food safety hazards. Procedures of verification have been established. Yearly the documents are reviewed. Seen latest changes in 2026.

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). Plan is made up by QA department at Vion Central and part of the audits are unannounced.

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.

**The following supporting evidence was reviewed:**

- P-TIL-NL-10127 Procesbeheersplan, v23 (26-3-2026).
- P-VION-10000, v20 CCP, CP and RP table.
- Flow docs:
  - F-TIL-NL-10083 cattle trucks/ washing site (2020-05-04)
  - F-TIL-NL-10027 slaughtering process (2022-08-31)
  - F-TIL-NL-10174 Organs processing (2013-11-09)
  - F-TIL-NL-10070 Testiness processing (2021-04-26)
  - F-TIL-NL-10087 Cutting (2020-05-13)
  - F-TIL-NL-10088 cutting back leg (2020-05-13)
  - F-TIL-NL-10089 cutting front leg (2020-05-13)
  - F-TIL-NL-10158 packing cut pieces (2020-05-13)
  - F-TIL-NL-10045 expedition / loading FP (2020-05-12)

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



**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 ( ) for whole Vion organization and at point of use as demonstrated throughout the audit. All procedures and work instructions are in Dutch. Training for workers is up to 7 languages or with pictures. 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 in a yellow colour.

All documents seen during the audit were complying.

There is also a manual of the HR management with documents and procedures concerning HR.

**Record completion and maintenance**

Records are in good condition and retrievable electronically or on site. Records retained as a minimum for the shelf life +3 year.

**The following supporting evidence was reviewed:**

- 
- for training records
- for Maintenance
- for slaughtering management

3.4 Internal audits

The following document(s) define the process: **P-VION-10011 Internal audits**, made up by QA Central, Feb 5, 2026. The audits generally follow BRCGS guidelines and clause structures.

Internal audits are conducted and completed. Actions are listed on a central list. Actions stay open till next audit. Audits are done by other QA deputies from other sites or HQ.

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

Internal audits are reported in fixed formats with annexes per scheme. BRC is annex 3 to the audit report. 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: **2026-02-25, 2026-03-10.**

The reports reviewed detail conformity as well as non-conformity.

A separate program of internal inspections of factory environment and processing equipment is undertaken daily by SSOP and Pre-SSOP. This is done by operators in the slaughterhouse.

This is reported in: a excel list PRE-SSOP and SSOP monitoring.

Inspections are performed by using a checklist which includes a clear action list. Performance is measured based on a scoring system and link to a KPI. Actions in response to deviations are recorded, cascaded to team leaders for follow-up, and discussed in production team meetings. Completion of actions is verified upon the next inspection. Effectiveness of the system is discussed in the Management Review.



The following evidence was reviewed:

- Procedure P-VION-10011 Internal audits including the planning
- Results of internal audits and inspections in the management review
- Internal audit reports dd **2026-02-25, 2026-3-10.**
- Pre SSOP and SSOP of April 22 and 24, 2026.
- Action list of findings in all audits

3.5 Supplier and raw material approval and performance monitoring

3.5.1 Management of suppliers of raw material and packaging

The company's risk assessment is documented in: **P-NLFOOD-1055**. Main supplier is Vion Rundvee, supplier of UBN's in 2025.

A slight number of slaughtered rinds are purchased from other slaughterhouses. This can be done for strategic reasons and/or there is not enough to run the slicing department. All suppliers are audited by Vion and need to have a GFSI certification. When this is done for customer , permission is required from this customer.

The risk assessment forms the basis for the raw materials acceptance and testing procedure and for the processes adopted for supplier approval and monitoring.

**List examples of suppliers reviewed during this audit:**

Name/Initials supplier	Supplier of:	Method of assessment	Evidence seen
	carcasses	IFS	Audit 2026
Vion Rundvee	Cattle	Audit	In house supplier for Vion

All suppliers are evaluated: Yearly

Suppliers are rated on quality, service, delivery, and complaints. All suppliers graded satisfactory in the past year.

Traceability system is verified through: GFSI certification of the manufacturer, I&R system of the Dutch Authorities on cattle management.

**The following supporting evidence was reviewed:**

- Review Vion Rundvee
- GFSI certificate



**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).

Deliveries are visually checked with authority of Dutch NVWA and the animal welfare officer. Other than cattle are accepted 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.

**3.5.3 Management of suppliers of services**

The following services are used:

- Pest control:
- Maintenance:
- Laundry services:
- Contracted cleaning;
- Temporary employees: Agency in house
- Laboratory:

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 organized by HQ April 2026.

Local yearly review of suppliers performed. Contracts are in place that clearly define service expectations. Food safety aspects are appropriately addressed.

Examples assessed during this audit:

- Contract with pest controller

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 reviews include performance of suppliers of services.

**3.5.4 Management of Outsourced processing**

Outsourced process steps to a third-party or undertaken at another site is: **not applicable**



**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 and access is restricted to the production 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: VKI for cattle and , delivered on 09-01-2026
- P-TIL-NL-10147 v3 Specification live stock
- Finished product specification art. 257 bovin 28% v3
- Customer specification 18-06-2024
- Product data sheet LDPE bag 90 mu, 14-01-2026

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

**3.7 Corrective and preventive actions**

Procedures are in place for handling and correcting issues identified in the food safety and quality management system. This is documented in: **P-TIL-NL-10229** Corrective and preventive actions and **P-TIL-NL-10088** Corrective and preventive actions

Identified issues are logged in: the site has 3 CAPA lists, depending on meeting group (MT, PT, QA) which are all Excel overviews.

During this audit, several samples were taken to verify effectiveness of corrective and preventive actions. Thorough root cause analysis is performed by the Production team. A correct solid system identified.

This approach is applied for: internal audits findings, nonconformities raised by external audit bodies, complaints, maintenance actions and actions from production teams and found to be suitable and effective. It meets the expectations of the BRCGS standard (i.e., section 3.7)

Timescales for completion are agreed upon and recorded. No issues noted regarding exceedance of due dates.

Actions and status of CAPA list are discussed during: HACCP meetings.

The following evidence was reviewed:

- Excel list with actions from audits
- Excel list with actions from Production team
- Excel list with actions from QA team about maintenance actions

**3.8 Control of non-conforming product**



Control of non-conforming product is detailed in: P-TIL-NL-10015. Handling of waste and categorised material

Cattle 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 segregated and discard according to defined categories Cat 1, Cat 3 and waste. There is a segregated section in the warehouse for returned and blocked goods. Responsibilities regarding release of products on hold lies with Dutch NVWA and also 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: slaughtering process in which segregation of categorised material is correctly applied.

The following evidence was reviewed:

- Area for returned goods in the storage cell
- Identification of bins for Cat 1, Cat 3 and general waste

### 3.9 Traceability

The traceability process is documented in: **P-TIL-NL-10087 Traceability and P-VION-10015**

Traceability through the process:

Traceability system operates through cattle identification per animal; application SQL is in place. Recording of batch information per batch of packaging materials, on the production record sheets (as reviewed for vertical audit).

Traceability marking on products:

LOT 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. ERP system Juun is used.

**Traceability test details company:**

Frequency: yearly

Last test conducted: **2025-10-06**

Product: animal with Dioxin noticed at customer

Lot code: na

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: art. 257 bovin 28% chilled, delivery date 2026-01-13, batch

Raw materials: Slaughtering dd 2025-03-20

Printed packaging and labels: print od identical label seen

Production/packing date: 2026-01-12

Quantities reconciled: 9988 kg

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Key documentation reviewed including process control and quality control documentation: Quantity control, pre-SSOP forms, SSOP-form, CCP1, 2 and 4 control, knife count forms, microbiological and chemical analysis results.

**Summary traceability and vertical audit:**

Fast tracing (forwards/backwards) including packaging was possible in the records/system. 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. Verified records of CCPs and CP's, delivery control checks, production checks, calibration and analyses were verified too. Time to perform the test was respected (08:22h – 10:58h). 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-TIL-NL-10229** Complaint-handling  
 Follow-up of complaints is managed through: Complaints are handled centrally using the system and complaints from B2B come in per mail and WhatsApp. Investigations are completed by the site. Corrective actions are carried out promptly and effectively. In total complaints in 2024-2025.

**Product complaints:**

In Q1 2026: food safety complaints and integrity complaints were filed. Integrity complaints relate mainly to one customer who received naked meat, transported to Spain where the weight was declined after arrival (which is a logical, natural process since the meat gets dryer).

Top 3 complaints: temperature too high; micro complaints and foreign material.

A GFL notification (to NVWA) was done because data of rind were not found. The animal was slaughtered and meat was kept separate. NVWA did not respond immediately.

2 warnings: 1. Faecal contamination at post mortum check (23/12/2025); 2. Empty truck washed and cleaned at Vion Tilburg with certificate was not clean enough. (23/2/2026).

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

There has been no significant increase in a complaint.

**The following complaint samples were taken:**

- Complaint overview in the management review 2024-2025.
- Seen follow up of complaints: Naked meat by Spanish customer.
- 2026 YTD FScomplaints 1Q 2026

**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** Crisis management, product withdrawal and product recall.

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.

This was notified to LRQA on: na  
Corrective actions found to be effective. na

Date of last incident management procedures test: 2025-10-06  
Type of test completed: all in one test: recall/withdrawal/incident.

Mass balance information is included in the report. Successful test conducted. One recommendation was defined (reminder for next year) to conduct the next test outside normal working hours.

**The following evidence was seen:**

- Evaluation report of the recall test dd 2025-10-06

Details of non-applicable clauses with justification	
Clause/Section Ref	Justification
3.5.4.	There is no outsourced processing
3.9.4.	No rework

**4. Site standards**

**4.1 External standards**

Plant located in an industrial area in a rural environment.

Site boundaries are clearly identified. Premises is fenced off with security gate access to the facility.

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

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**Site security:**

Unauthorised access is prevented by use of badges. Visitors/contractors must register at the security building and request for a badge. Many CCTV cameras are installed.

Supervision by porters. Truck drivers (cattle and other) need to report to the porter before they can enter premises and will be supervised by staff. The company is always guiding the visitors while visiting the production areas.

Water break tanks are in place and locked when not in use. This was checked during the audit outside tour. Access to these tanks is controlled through the site key plan.

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

The following evidence was reviewed:

- Badge system on entrance
- Reporting system on entrance
- Outside tour: all fenced and gated

#### 4.2 Site security and food defence

The 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.

There is no legal requirement for specific training.

Food defence risk assessment is documented and based on TACCP: **P-FOOD-10051 P-TIL-NL10105**

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 unauthorised visitors and personnel and temporary contractors.

Appropriate control measures are developed and implemented: CCTV cameras installed, badge system for visitors and temporary contractors.

Access is via key coded doors and keyed locks. There is a gate that can't be used for cars / trucks after 20:00h and during opening hours watched by porters. Security training is included for all staff as part of the HACCP induction to site.

Beef storage areas are controlled and key locked. No external intake points.

The procedure was assessed and as was described that Food fraud was verified during internal audit reports were assessed.

Following procedure P-TIL-NL10105 the annual check on the Food defence plan is performed by an internal audit. The reports of the internal audits performed during the last 12 months did show proof of the annual check on FD plan, procedure and implementation of measures.

Detail: proof was seen of some inspections performed incl. checks on FD measures.

**The following evidence was reviewed:**

- X-matrix Q3 2024 – Q2 2025 par. 1.3 Food Defence
- Key plan with numbers and sorts of keys available and handed out
- Daily opening and closing of beef storage cells on F-TIL-NL-10167

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**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 several maps. There are three large parts on the production site. The first part contains the live animal stable and slaughter part; the second part is the cooling of the carcasses and finally there is a cutting part in the plant. There is 1 slaughter line and carcasses are automatically transported to the cooling areas. From there on, there is 1 main cutting line to cut the carcasses into quarters. Once this is done, there are three possible finishing lines for technical pieces, one line for meat cuttings and some smaller machines for grease collection and some minor products. In the slaughter area, the intestines are sent to a specific area, where there is a cold and a warm cleaning line. In the cutting area, the offal is collected and sent to a specific area for further collection.

Production risk zones (based on BRCGS Annex 2):

- Open product areas: (all low-risk production zone identified due to processing of raw beef)
- Enclosed product areas: warehouses and storerooms
- Non-product areas: canteens, workshop, offices

Contractors and visitors, including drivers are informed of the requirements for the areas they are visiting through hygiene rules, placed on walls and to be signed in contract or during visit (visitors and contractors).

Premises allows sufficient working space and capacity to work in a proper way. In the production areas there were no temporary constructions noticed during this audit. There was construction work in progress during this audit as a new maintenance area and heating pump are build. 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:

- Map in welcoming leaflet at entrance with safety and hygiene rules.

**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 and internal drains. However, some overdue maintenance on the cooling tunnel: peeling paint on the walls, loose sealant and a cracked floor in damaged floors were seen. **Minor NC on 4.4.1.** No FS problems identified, good results seen on environmental monitoring.

Elevated walkways, access steps or mezzanine floors that are adjacent or above open product are present and accurate. Ventilation controls in place to ensure good air flow.

No glass, no windows could be opened in the processing areas.

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

Plastic strip curtains present.

The following evidence was reviewed:

- in general well managed conditions observed, some old part of building were maintained and kept in basic conditions.

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4.5 Utilities – water, ice, air and other gases

Water is used as: rinsing and cleaning, for ice production for cooling stomachs

Source(s) of water supply:

- Municipal/city (cleaning, handwashing)
- In-house treated (Yes. Descale system installed to prevent equipment damage)
- Storage or holding tanks (demi-water)

Only potable water is used.

Microbiological or chemical testing is undertaken: 2x per year.

Water testing is completed to ensure the requirements are met. Analysis reports for chemistry are completed from the water company “ ” via compliance checks and microbiology via an accredited external laboratory.

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

Sampling points include carcass rinsing water, canteen water, water for ice production. Tested for TVC 22°C, odour, colour, e. coli and enterococci.

Gas used in packaging: N

Compressed air used: Y

Purpose of compressed air use: blow up beef for easier cutting

In direct product contact: Y

Filtered at point of use (when in direct contact): Y

Checks are done on filter replacement as part of the preventive maintenance program. Filters are to 1 micron.

No steam or other gases are in contact with products.

**The following evidence was reviewed:**

- Analysis reports Q4 2025 and Q1 2026
- Lab report , drinking water canteen cutting area and slaughter area 11-03-2026
- Lab report , drinking water canteen cutting area and slaughter area 10-12-2025
- Lab report , ice 16-03-2026
- Lab report washing area trucks live stock on legionella 14-01-2026
- Maintenance department with detailed schematic overview of processing water (maintained by external company ).
- Tap points analysed 2x per year as indicated in procedure P-NLFOOD-10032

4.6 Equipment

Key production and product-handling equipment include stables with automated animal welfare state of the art cattle pushing system, slaughtering line, intestines line with stomach cleaning, chilling equipment, cutting lines with several meat equipment, packing lines with up to 8 vacuuming machines, fat% detector on X-ray, 4 metal detectors.

In 2026 the washing facility for the trucks, delivering the cattle was opened.

Equipment is suitable and designed for the intended purpose, mostly stainless-steel construction.

Line equipment is sourced through procurement, specified, tested, and commissioned before use. This is documented in SSOP and Pre-SSOP documents and demonstrated during tour.

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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.

Equipment is made of stainless steel. Conveyor belts are food grade. lines used for product transfer are registered as FDA compliant for food contact.

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. 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:**

- Watersystem maintenance by ;
- Pressured air used in carcasses;
- Logbook washing facility
- Validation of own cooling system, including calibration certificate of the data logger 9/12/2025) for serienumber (9950-063 and 1105-029) at -20, +20 and +40 degrees Celcius.

**4.7 Maintenance**

is used as maintenance system used for PPM work.

Frequency of main checks: weekly, monthly, quarterly, and bi-annual PMs are completed.

Notable equipment includes stables with automated animal welfare state of the art cattle pushing system, slaughtering line, intestines line with stomach cleaning, chilling equipment, cutting lines with several meat equipment, packing lines with up to 8 vacuuming machines, fat% detector on X-ray, 4 metal detectors.

Preventative maintenance covers all plant, processing equipment and mobile equipment.

Contractor services are used for: multiple activities including weighing scales and metal detectors.

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

Samples seen and completed to schedule.

Production reports incidents or issues by phone and/or records them on (Pre)SSOP document.

Inspection of equipment condition

Inspections for damage and wear are completed for: conveyor belt condition, daily checks on sterilisation water temperature >82°C.

Temporary maintenance: No temporary repairs observed.

Handover

Suitable handover processes were in place after maintenance work to eliminate foreign matter risks generated. On SSOP forms are the corrective maintenance activities reported. SSOP's are per department used. Handover of the maintained object/ situation is signed off in booklets which each maintenance worker has

However, the maintenance service booklet was not signed off during weeks 35 to 37 2025. **Minor NC on 4.7.4.**

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**Lubricants**

Range of food grade lubricants used of “ ”, NSF/H1, MSDS with compliance to NSF H1 and Allergen Declaration seen. Greasing plan was up to date (greasing on daily basis).

**Overall cleanliness engineering workshop**

The workshop was well maintained and away from the production, access via outside, no direct access into production areas. There is also a dedicated rest room, changing room and wand wash present.

**The following supporting evidence was seen:**

- system.
- Weeklist to be done for maintenance workers, including sign off and returning responsibility to production.
- Working permit external ( )
- Metaldetector check of serienumber 192394 and 147192.
- Balance check (no 3) by (every 6 months), latest check 26/2/26.
- Balance check B23 at expedition (WS18) at 9/3/26.
- Program for maintaining temperature in plant. Done by . Area E10: set temperature 6°C, after 60 minutes alarm when -1°C and Snijzaal (cutting area) set at 10 °C. Same alarm settings.
- PT100 checks (monthly). With thermometer from (certificate 25129302, 9/12/25).
- Monitoring sterilization water by return water. Temperature shall be 83°C. At slaughter area weekly checks.
- Pressured air in carcasses: change of filters: 13/10/25.
- Lubricant control: each Monday and recorded in SSOP.

**4.8 Staff facilities**

**Changing facilities**

Designated changing facilities for staff in place that are appropriately sited. Several areas with these facilities present. Most areas have sloped lockers for storage of outdoor clothing, and a separate area for protective clothing.

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

**Handwashing**

Several hygienic sluices with hands-free operable handwash facilities located 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**

Multiple rest room areas for food storage and eating; several catering facilities in place. There are also vendors for food and drink. Staff fridges were seen to be clean and maintained.

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

**4.9.1 Chemical control**

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An approved list of chemicals is available.

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: all cleaning chemicals supplied by \_\_\_\_\_, available in map in chemical storage area.

All chemicals as sampled are suitable for the intended application.

Waste handling and spillage control is effectively managed.

The following evidence was reviewed:

- F-TIL-NL-10100 form registration used cleaning chemicals 17-04-2026 / 24-04-2026
- Specification protect 1x/week disinfection
- Specification foam 1x/week cleaning
- Specification hypofoam for cleaning
- Specification for disinfection

**4.9.2 Metal control**

Several types of sharp metal equipment are used: knives, blades, saws. No snap-off blades used.

There is a knife regime and a procedure for guidance with daily counting and recording in place.

Condition and integrity are monitored: by daily hygiene inspections; see section 3.4.4 for details.

Staples, paper clips and drawing pins are not used in open production areas.

**4.9.3 Glass, brittle plastic, ceramics and similar materials**

P-TIL-NL-10054 Monitoring of glass/brittle, plastic and ceramic items is done 4x year during a specific glass inspection by QA. F-TIL-NL-10047 was seen for all areas on 03-02-2026 and 06-02-2026. Issues are mentioned in the Excel maintenance action list.

Besides monthly audits, inventory is checked daily via pre-SSOP.

A crack in the window between the shooting area and the slaughterhouse is not listed in the checklist for glass/hard plastic, pre-SSOP and SSOP. **Minor NC on 4.9.3.2.**

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).

**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 not allowed (and not present) in and near open product areas.

Wooden pallets used in storage areas were observed to be in good condition.

Some packaging may be delivered on wooden pallets.



**4.9.6 Other physical contaminants**

Other specific controls on physical contamination such as packaging:  
De boxing and debagging procedures include controls for physical contamination. Plasters are all blue and metal detectable.

Management of portable handheld equipment:  
Metal detection is used. Single piece biros are used with no small parts evident.

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**

Detection equipment (metal detection) is installed as result of the risk analysis mainly to protect equipment and is controlled as CP.

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

One x-ray ( ) is used but for fat% and not for foreign body contamination removal.

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

Detected FB's are collected and investigated by QA.

The following evidence was reviewed:  
- Demonstration during site tour of metal detection trimmings

**4.10.2 Filters and sieves**

No filters or sieves used.

**4.10.3 Metal detectors and X-ray equipment**

Metal detection is used mainly for equipment protection. Detection equipment not installed as result of the risk analysis and controlled as CP.

Monitoring frequency: beginning/end of the day, every 2 hours and between breaks.

Metal detection verification is performed through test sticks. The testing procedure is found to be suitable. Correct training.

Corrective actions are clearly defined in the control plan. Data is maintained in documentation. The sensibility of the detector is justified. A stop and alarming system are in place.

Metal detection was tested during this audit. All sampled employees' conduction metal detection were demonstrably trained for this CP.

In case of detection of foreign body contamination, the material is analysed by QA.



**The following evidence was reviewed:**

- F-TIL-NL-10064 v4 metal detection cutting area, seen during site tour
- F-TIL NL-10081 metal finds trimmings, seen during site tour
- Test pieces on packing line: 10 mm SS, 10 mm Fe, 10 mm NFe.
- Test pieces on cutting line: 10 mm SS, 7 mm Fe, 7 mm NFe.
- Annual metal detector calibration by

**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 ( ) and own workers. Social areas cleaned by .

Documented cleaning and disinfection procedures are in place and maintained for the building, plant and all equipment. Cleaning procedures seen included: in the manual of external cleaner .

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.

A cleaning plan is present, together with external cleaning partner . Detailed plan was seen including method and used chemicals.

In depth cleaning activities on chilled departments (deboning) every 8 weeks performed: This is including dismantling tires /equipment. Chilled department is split up in zones: zone A-H, in depth cleaning scheduled 1x approx. 8 weeks of every zone.

Company is working on modification of type of cleaning agents: almost all chemicals switched to Meeting with / QA is planned 1 x 6 weeks, daily contact on performances by email, cleaning observation forms and WhatsApp. Daily monitoring by PRE-SSOP's per department: good control was seen.

Cleaning is monitored through audits and chemical / residue and microbiological testing. And monitoring via amount of detergent used. Also, a dedicated employee is installed to guide the daily cleaning operations.

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Limits of acceptable and unacceptable cleaning performance is defined for food contact surfaces and processing equipment: visual inspections.

Areas visited on the factory inspection were observed to be clean and tidy.

**The following evidence was reviewed:**

- Chemical residue control 520x/year. No issues.
- Titration by \_\_\_\_\_ on 02-03-2026 (4x / year)
- Cleaning plan 22-12-2025
- Seen proof of zone A, in depth cleaning (a.o. transport belts) performed week 1, 8 and 15 2026 (zone A-H 1x approx. every 8 weeks).
- F-TIL-NL-10066 Pre-SSOP v3, results of week 3
- Planning \_\_\_\_\_ cleaning on heights
- P-TIL-NL-00003 method cleaning and disinfection cattle trucks v7

4.11.7 Cleaning in place (CIP)

CIP is not applicable.

4.11.8 Environmental monitoring

The environmental monitoring programme is detailed in: **P-NLFOOD-10032**

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: spoilage bacteria, Listeria, coliforms, yeast and moulds.

Comment on the results of environmental monitoring programme:

Results seen were within specification aside from one slightly elevated count on coliforms that was satisfactory upon retest.

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:**

- Trend analysis agar results 2025 – 2026, around 60 samples a week. 65% of the samples are food contact surfaces. Average score 0,45 (goal Vion Tilburg 0,55 / goal Vion Group 1,0).
- Listeria swabs 276 swabs / year: 0 positives. Conform P-FOOD-10000.

4.12 Waste and waste disposal

Waste is categorized in several items as general waste, slib, waste for fermentation.

All waste containers were identified with contents.

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: categorised Cat 1 and Cat 3 material to and .  
 Records of destruction are being retained.

The following evidence was reviewed:

- All waste and disposal bins are labelled with their type of waste. Correct disposal observed.

4.13 Management of surplus food and products for animal feed

Na

4.14 Pest management

Pest control is contracted to .  
 The scope is detailed as: rats, mice, cockroaches and flying insects.

No internal pest controller applicable.  
 No presence of infestation during the last certificated period or observed during the BRCGS audit.

Routine visits per year: 12x. Content of routine inspection: all traps and all 18 EFKs, ok  
 In-depth inspection is performed yearly.  
 Frequency is suitable.

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

**The following evidence was reviewed:**

- Folder of with maps dd 2026-02-06, adjusted for all building activities and new washing area.
- PM certificate dd 2022-02-10
- Competence certificate of pest manager valid until 2026-12-09 ( )
- Advion cockroaches gel: Licenced spec 2020-07-06
- Trendanalyse over 2025.

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.

No products contain allergens, and so segregation is not required. Udders are removed in the slaughtering line and correctly segregated.

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

Stocks of materials are kept on site and stock rotation is via system identifying FIFO usage.



Delivery and storage record are in place for each packaging item and are kept at their storage location; seen during the audit within the traceability exercise with no issues noted.  
 Outside storage is not applicable.  
 No controlled atmosphere storage.

**The following evidence was reviewed:**

- Clean, tidy and organised storage areas finished products
- F-TIL-NL-10167 Food defence opening and closing doors storage areas finished product and carcasses (daily).

**4.16 Dispatch and transport**

The transport of finished goods is all outsourced to external service providers. There are no company vehicles. This is organised and controlled by HQ. An overview is maintained in the site approved supplier list.

Verified GFSI certification of: (IFS exp. 28-05-2026) and Distrifresh

Temperature checks and hygiene monitoring controls are in place for: loading finished product. This is daily using pre-use check sheets, managed as a CCP.

Records of evidence were reviewed during the factory inspection and through the auditor vertical audit (see details below).

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

**The following evidence was reviewed:**

- F-TIL-NL-0009 checklist loading dispatch on 12-01-2026

Details of non-applicable clauses with justification	
Clause/Section Ref	Justification
4.9.4.	No such packaging
4.10.2.	No filters and sieves
4.10.3.5.	No X-ray for foreign body detection
4.10.4.	No magnets for this product
4.10.5	No optical sorting equipment for this product
4.10.6.	No glass, cans or rigid containers
4.10.7.	No such equipment

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4.11.7.	No CIP
4.12.4.	No such practices
4.13.	No products for animal feed
4.14.3.	Pest control is outsourced
4.15.4.	No controlled atmosphere
4.15.5.	No outsourced storage

## 5. Product control

### 5.1 Product design/development

The product design/development procedures are clearly detailed in: **P-NLFOOD-10165** Shelf-life testing

There is no real product design or development. Product range may be a different cut, but even this is very limited and would consist out of a variation on current products – which is not limitless. Product is mostly minor product adjustments rather than new developments.

Shelf-life validation:

Shelf-life trials follow documented protocols that reflect appropriate conditions.

Shelf-life testing is done yearly, where an article from every group is tested. This is planned in document: Planning sampling micro 2026. For each group of products samples are taken (carcasses, slices, by products/organical material, technical parts, upon customer requirements and purchased from other slaughter houses).

P-NLFOOD-10165, standards (microbiology, organoleptic) are taken in P-FOOD-10008. When shelf-life tests are done, there is a microbiological as well as an organoleptic test that is done. Typical shelf lives are 10 days for offal products, 14 days for trimmings and 35 days for other cuts (vacuum packed products). Fresh products generally hold 6 days of shelf life. Last test on product used for the traceability test was performed and seen during the audit – all results clearly within the tolerances (which is also the case for the other products seen).

Some products have positive release upon customers request.

**The following evidence was reviewed:**

- Yearly check on organical material: on metals, PFAS, PCB, pesticides, dioxine and ochratoxine A, 8/12/25.
- Weekly checks on carcasses, once a week 2025 and 2026.

### 5.2 Product labelling

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The following documentation describes the process: **P-TIL-NL-10087 Traceability**

Traceability follows the carcasses and the byproducts from the live animal. After slaughter, these are provided with tags which include the identification number of the animal (e.g. ), the birth date, class, weight and other information necessary for the rest of the process. This includes a scan tag, which is used to scan the animals into the batches that are created. Final product labelling is according to legal aspects as required by the company; several checks done during production tour. Finished product labelling includes specific regulatory information, such as the veterinary mark (NL 87 EG) and the information with regards to where animals were born, raised, slaughtered and cut. There is no artwork, so no approval (only B2B). There is 1 ingredient only and no allergens to be declared. Since all products are B2B, no specific cooking instructions are provided

**The following evidence was reviewed:**

- Labelling of boxes and crates with batch numbers before dispatch according to VO 1760/2000

**5.3 Management of allergens**

The following documents form the controls in this area: **P-TIL-NL-10127 Process control plan**

Allergens handled on site are milk in udder.

The risk assessment covers all potential sources, including cross contamination. Measures implemented include removal of udders in the slaughtering line.

Allergen containing re-work:  
No rework

Claims for individuals:  
No allergen claims are made.

**The following evidence was reviewed:**

Udder removal in the line by competent person during audit day 2

**5.4 Product authenticity, claims and chain of custody**

Product authenticity is detailed in: **P-TIL-NL-10224 Food Fraud 10223**

**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. Company is holding an IFS PIA declaration on integrity.

Review of the vulnerability plan is programmed to be completed annually.  
Date of the last review: 2025-12-18

Claims:  
A claim is made for Organic



**The following evidence was reviewed:**

- IFS PIA declaration

**5.5 Product packaging**

The packaging materials for finished products are plastic, crates, dolavs.

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

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

**The following evidence was reviewed:**

- F-TIL-NL-10117 v1 receiving and tracing packaging 28-12-2025 / 23-01-2026. Demo seen during site tour.
- DoC LDPE bag 90 mu 1-01-2026
- BRC certificate exp. 26-01-2027

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

The testing programme is outlined in: **P-FOOD-10008 and P-FOOD-10009**

A laboratory testing plan is developed for the next steps and is based on 2073/2005 EU legislation. All tests are done by an external lab Normec, which is ISO 17025 accredited. Schemes are as following:

- Carcasses: twice per week, 5 carcasses: TVC, Entero's, STEC, Salmonella
- Quarters that are bought externally, every delivery, 5x: TVC, Entero's, Salmonella, Listeria
- Technical pieces, weekly (5x): TVC, Entero's, Salmonella, Listeria
- Vacuum products, weekly: TVC, Entero's, Salmonella, Listeria
- Trimmings, quarterly: TVC (weekly 5x), Entero's (weekly 5x), st. aureus, yeasts and moulds, Pseudomonas, Salmonella, Listeria and STEC
- Organs, weekly (5x): TVC and Entero's

A test plan on chemical parameters including heavy metals, pesticides, OTA, PCB, PFAS and dioxins. Seen lab reports 11-11-2025 and 18-03-2026. DNA sequencing is per carcass.

Products that will be used to produce ready-to-eat products are positively released on Listeria, STEC and Salmonella. The customer needs to indicate that the products will be used for ready-to-eat items.

A plan of analysis is available and systematically followed, a dedicated QA team member is responsible. Product samples are taken from production at the line.

No onsite laboratories.

Out of specification laboratory results follow a defined escalation route.

**The following evidence was reviewed:**

- Trends 03-2025 / 03-2026 on micro results. No issues.
- P-TIL-NL-10132 v7 Positive release.
- Seen lab report :
  - 15-04-2026 bovenbil
  - 28-01-2026 bavet
  - 26-03-2026 heart
- P-FOOD-10008 micro standards v22
- P-FOOD-10010 shelf life testing v5

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- Results shelf life tests 04-02-2025 (colour, odour, TVC, Enterococcus): trimmings, trimmings vacuum, trimmings vacuum frozen, vastdeel, heart. No issues.

5.7 Product release

Positive release only for products that will be used for ready-to-eat items. These are analysed for Listeria, Salmonella and STEC (all pooled) and, according to the results, these products can be used for ready-to-eat items or have an alternative routing (e.g. selling to a processor who cooks). This process is described in procedure P-TIL-NL-10132.

intended for RTE products: STEC, salmonella: certificates are provided together with the delivery of beef intended to be used for RTE beef, to be produced by the customer. Seen lab report 10-04-2026 of tartar vac. NL art. 257.

5.8 Pet food and animal feed

No pet food produced.

5.9 Animal primary conversion

The risk assessment with regards to prohibited substances is taken in the HACCP study and is considered as being sufficient. This is also sampled through the government analysis programme. The site is in receipt of live animals, which are inspected by the government themselves and the stable responsible. The VKI passport of the animal will already be verified before entrance in the stable.

The traceability system covers the raw materials through work in progress to finished product including packaging materials and distribution according to procedure identification and traceability (P-TIL-NL-10067). This system is fully based on electronic data and written documents, day batch codes and bar codes:

- Cattle wear an earmark (+ accompanied by passport, track record and VKI according to Dutch I&R)
- Beef carcasses / quarters get a serial number (together with date of slaughter + origin + classification)
- Quarters (own production + additional purchase) get a batch code (date of production + origin)
- Finished product is traced depending on the date of production (SSCC-number per piece / crate / box is scanned at dispatch)
- Primary packaging materials are tracked based upon the date of starting a new batch
- Time and temperature requirements are fully established throughout the process and were found suitable.

Details of non-applicable clauses with justification

Clause/Section Ref	Justification
5.3.5.	No use of rework
5.3.6.	No such warnings needed

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5.3.7.	No such claims
5.3.8.	No such processes necessary
5.8.	No pet food or primary animal conversion

**6. Process control**

**6.1 Control of operations**

The processes covered on the site include slaughtering and cutting to specification. Control of operations based on process control sheets as reviewed during the production round and for the vertical audit process trail which cover controls/inspection of the process and product relevant to quality and food safety (start-up-checks, settings/program, characteristics, inspections product, CCPs, product weight, label checks, etc.). Process monitoring checks are including pre-SSOP, SSOP, temperature, product, metal detector and equipment checks, label checks and hygiene rounds as well as checks at intake and at storage. Temperature is constantly monitored by the online monitoring system. Chilling and freezing controls management is constantly verified (for further details see under 2 The Food Safety Plan – HACCP). Verified all these process controls during the audit round in production and during the vertical traceability check.

**Examples of lists and checks seen include:**

- Pre-SSOP lists for cutting on F-TIL-NL-10072 and expedition on F-TIL-NL-10066
- SSOP list packaging on F-TIL-NL-10121 and cutting F-TIL-NL-10076
- Metal detectors: F-TIL-NL-10064 and notification of findings on F-TIL-NL-10081
- Weight verification: F-TIL-NL-10114
- BBE verification: F-TIL-NL-10120
- Product verification: F-TIL-NL-10133

**6.2 Labelling and pack control**

There is a process and line clearance check for labelling and removal of labelling from the line at a product change over which is only on batch change-over. Records of checks were sampled from previous days and from the vertical audit trail.

At the time of the audit there was a change over in the cutting area and this was witnessed. No issues. There is no online verification equipment for the correct label.

Label check: **P-TIL-NL-10122 v4 shelf life registration on labels Vion Tilburg**

**The following evidence was reviewed:**

- Label control on art. 257, trace test
- F-TIL-NL-10120 label check registration seen during site tour



**6.3 Quantity, weight, volume and number control**

All products are sold by weight. Metrology verifies the balances for commercial purpose. No issues identified. Calibration of the scales is demonstrable. Apart from the calibration there also is a daily verification of the weighing scales with calibrated weights, as seen for the weighing scales before labelling

Stomachs are sold by quantity.

No online check weighers.

**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: see evidence

There's a list of measuring equipment that is to be calibrated, last verification 04-03-2026. This includes items checked by the quality department. will hold items calibrated by the technical department. Main procedure is P-TIL-NL-10074.

Calibration records of metal detectors (annual check), thermometers (annual check), scales (annual check), pH measuring equipment.

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

**The following evidence was reviewed:**

- Ext. calibration scale nr. 3 packaging
- Ext. calibration scale 9-2026
- Ext. calibration thermometer expedition s/n 33923411 06-06-2026 by
- Ext. calibration thermometer maintenance (for PT100 check) 09-12-2025
- Int. calibration F-TIL-NL-10049 calibration instrument 15-05-2025 / 04-03-2026

**Details of non-applicable clauses with justification**

Clause/Section Ref	Justification
6.2.4.	No such equipment

**7. Personnel**

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

Induction training is required for all new employees and includes the company hygiene rules, site policy, general product safety and quality aspects, etc. There is a 2 yearly refresher training for inductions in place.

Training needs for personnel engaged in activities related to product safety, quality and legality are further defined in a competence matrix.



Employee training is defined in a documented procedure. For operators there are records of sign off against key tasks.

At this visit, HACCP team and CCP employees were sampled. Clear competency records and refresher training records were seen.

New monitoring program Accelerate Today is in use since a few weeks for personal performance and identify improvement/training needs or new challenges and goals.

**The following evidence was reviewed:**

- system with all employees and there attended trainings.
- Monitoring program Accelerate Today explained by HR manager
- Machine instructions
- Health certificate (every 5 years), incl. tetanus injection
- Booklet “werken bij Vion”
- Introduction video in 7 languages, incl test. 80% correct otherwise re-exam before start in production area.
- Internal audit certificates and by LRQA on 14-06-2022
- Induction training GB 21-04-2026 and 26-03-2026
- Refresher hygiene training 01-10-2025
- CCP 2 / 3 / 5 training 10-03-2025
- Metal detection training 10-03-2025

**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.

Adequate facilities in place. Hand and boot washing takes place at entry of the production and warehouse areas. No issues observed regarding washing stations. Staff 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:**

- New staff locker room gender specific at entrance of cold areas
- Locker rooms for authorities
- Locker room for cleaning agency workers
- Locker room for slaughter personnel

**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.

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The following evidence was reviewed:  
 Medical screening of employees is done at the start and further every 5 years, as allowed by law and for export licence.

**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, aprons, sleeves and other garment is used in production processes. White coats and trouser, hair/beard nets available for visitors.

Laundering of clothing is done by external service provider (professional laundry service). Limited in-house washing of clothing is done.

Segregation of clean and dirty clothing is effectively managed; there are dedicated closed bins for dirty clothing. Clean clothing is provided in a dedicated area by personnel.

**The following evidence was reviewed:**

- Staff facilities with bins for dirty clothing and handout point for clean clothing
- All aprons, gloves are for single use

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



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

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



<b>9. Requirements for traded products</b>	
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	
<p>Examples of traded products: &lt;list some examples of traded products&gt;            All traded products within the scope are included: Yes/No            Specifications are reviewed every three years: Yes/No</p> <p>The following evidence was reviewed:</p>	
9.4 Product inspection and laboratory testing	
Not applicable	
9.5 Product legality	
Not applicable	
9.6 Traceability	
Not applicable	

<b>Module 11: Meat Supply Chain Assurance</b>	
<b>Scope</b>	Click or tap here to enter text.
<b>11.1 Traceability</b>	
Click or tap here to enter text.	
<b>11.2 Approval of meat supply chain</b>	
Click or tap here to enter text.	

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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

Click or tap here to enter text.

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)

Click or tap here to enter text.



**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.

