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FSSC 22000 V5.1 FOR FOOD MANUFACTURING CHECKLIST

PART 1: ISO 22000: 2018					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
4	**CONTEXT OF THE ORGANIZATION**				
4.1	**Understanding the organization and its context** External and internal issues are identified, reviewed and up to date. They are relevant to the purpose of the food safety management system it's in place.				
4.2	**Understanding the needs and expectations of interested parties** The organization can consistently provide products and service that meet applicable statutory/regulatory and customer requirements with regard of food safety, the organization shall determine and the interested parties that are relevant to the food safety management system.				
4.3	**Determining the scope of the food safety management system** The organization had determined the boundaries and applicability of the food safety management system to establish its scope the scope shall specify the products and services processes and production sites that are addressed by the food management systems and shall include the activities, processes product or service that can have an influence on the food safety of the end products.				

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4.4	**Food safety management system** The organization had established implemented, maintained, updated, and continually improve a food safety management system including the processes needed and their interactions, in accordance with the requirements of document.				
Summary:					
5	**LEADERSHIP**				
5.1	**Leadership and commitment** Top management has demonstrated leadership and commitment with respect the food safety management system by ensuring that the integration of food safety management system requirements into the organization's business process and the resource needed for the food safety management system are available etc.				
5.2	**Policy** Top management have established, implemented, and maintained a food safety policy that Is appropriate to the purpose and context of organization and provides a framework for setting and reviewing the objectives of food safety management system.				
5.2.1	**Establishing the food safety policy** Top managements state a commitment to satisfy applicable food safety requirements, including statutory and regulatory requirements and mutually agreed customer requirements related to food safety and included a commitment to continual improvement of the food safety management system.				
5.2.2	**Communicating the food safety policy** Top management has communicated the policy, made sure every employee understood the food safety policy and applied the policy at all levels within the organization.				

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5.3	**Organizational roles, responsibilities** Top management has ensured that the responsibilities and authorities for relevant roles are assigned, communicated, and understood within the organization. Top management shall the responsibility and authority for ensuring that the food safety management system conforms to the requirements of this document and reporting on the performance of the food safety management system to top management including appointing the food safety team and the food safety team leaders.			-	-
Summary:					
6	**PLANNING**				
6.1	**Actions to address risks and opportunities** There are actions to address these risks and opportunities How to integrate and implement the actions into its food safety management system processes, evaluate the effectiveness of these actions taken by the organization to address risks and opportunities shall be proportionate and the potential impact on food safety requirements.				
6.2	**Objectives of the food safety management system and planning to achieve them** The organization has established objectives of the food safety management system at relevant functions and levels. The objectives of the food safety management shall be consistent with food safety policy; authorization of results and it is measurable.				

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6.3	**Planning of changes** The organization has determined the need for change to the food safety management system, including personnel changes, the changes shall be carried out and communicated in planned manner. The organization shall consider the purpose of the changes and their potential consequence for supply and maintenance of safe food production, the integrity of the food safety management system, and the availability resources to effectively implement the change including the allocation or re-allocation of responsibilities and authorities.				
Summary:					
7	**SUPPORT**				
7.1	**Resources** The organization had provided the resources needed for the establishment, implementation, maintenance, updating and continual improvement of the food safety management system. The capability of and any constraints on existing internal resources and Resources required from external source are considered.				
7.1.2	**People** The organization has ensured that persons necessary to operate and maintain an effective food safety management system are competent. Where the assistance of external experts is used, evidence of agreement or contracts defining the competency, responsibility and authority of external experts has been retained as documented information.				

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7.1.3	**Infrastructure** The organization has provided the resources for the determination, establishment and maintenance of the infrastructure necessary to achieve conformity with the requirements of the food safety management system. Infrastructure can include land, vessels, buildings and associated utilities, equipment, including hardware and software, transportation, information and communication technology.				
7.1.4	**Work environment** The organization has determined, provided and maintained the resources for the establishment, management and maintenance of the work environment necessary to achieve conformity with the requirements of the food safety management system. A suitable environment can be a combination of human and physical factors.				
7.1.5	**Externally developed elements of the food safety management system** The organisation makes use of externally developed elements for the implemented food safety management system and ensured that the external elements are developed in conformance with requirements, is applicable to the site(s), specifically adapted to the processes and products of the organization, is implemented, maintained and updated as required and retained as documented information.				
7.1.6	**Control of externally provided processes, products or services** The organization has established and applied criteria for the evaluation, selection, monitoring of performance and re-evaluation of external providers of processes, products and/or services used.				
7.2	**Competence** There's necessary competence of person(s) including external providers doing work under its control that affects its food safety performance and effectiveness of food safety management system, ensure that these persons, including the food safety and those responsible for operation of the hazards control plan, are competent based on appropriate education, training, or experience.				

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7.3	**Awareness** The organization had ensured that all relevant persons doing work under the organization control shall be aware of the food safety policy, the objective of the food safety management system relevant to their task(s) and the individual contribution to the effectiveness of the food safety management system, including the benefits of improved food safety performance.				
7.4	**Communication** The organisation had established sufficient information is communicated externally and is available for interested parties of the food chain. the organization shall establish implement and maintain effective communications with: External providers and contractors, Customers and/or consumers in relation to, Product information to enable the safe handling display, storage, preparations, distribution and use of product within the food chain or by the consumer and Identified foods safety hazards that need to be controlled by the other organizations in the food chain, and/or consumers.				
7.4.2	**External communication** The organization has ensured that sufficient information is communicated externally and is available for interested parties of the food chain. The organization has effective communications with external providers and contractors, customers and/or consumers, statutory and regulatory authorities and other organizations that have an impact on, or will be affected by, the effectiveness or updating of the food safety management system. Evidence of external communication is retained as documented information.				
7.4.3	**Internal communication** The organization has an effective system for communicating issues having an impact on food safety. Ensuring that the food safety team is informed in a timely manner of any changes to any process or procedure.				

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7.5	**Documented information** The organization food safety management had included documented information required by this document, document information determined by the organization as being necessary for the effectiveness of the food safety management system and documented information and food safety requirements required by statutory/regulatory authorities and customer. Have created a documented information, the organization shall ensure appropriate to identification and description (e.g., a title, date, author, or reference number), format (e.g., language, software version, graphics) and media (e.g., paper, electronic), and review and approval for suitability and adequacy. The documented information of external origin determined by the organization to be necessary for the planning and operation of the food safety management system shall be identified as appropriate and controlled.				
7.5.2	**Creating and updating** The organization has the appropriate identification and description, format and review and approval processes for suitability and adequacy of documents.				
7.5.3	**Control of documented information** All documented information is available and suitable for its use, is adequately protected, distributed and retrieved as needed, stored and preserved adequately, controlled with regards to changes/ updates, retained and correctly disposed of when required.				
Summary:					

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8	**OPERATION**				
8.1	**Operation planning and control** The organization has met the requirements for the realization of safe products and implemented control and record keeping for the established criteria of the processes.				
8.2	**Prerequisite programs (PRPs)** There's establishment of the hazard control plan, the organization shall update the following information, if necessary, characteristics of raw materials, ingredients, and product – contact materials, characteristics of end product intended use and flow diagrams and description of processes and process environment.				
8.3	**Traceability system** The traceability system can uniquely identify any component of any process from incoming material from the suppliers to the first stage of the distribution route of the end product. This included rework of materials/ products.				
8.4	**Emergency preparedness and response** Top management has prepared and planned to identify preventive actions that deal with potential emergency situation and incidents that may impact on food safety and which are relevant to the role of the organization in the food chain.				
8.4.2	**Handling of emergencies and incidents** The organisation can respond to actual emergency situations and take action to reduce the consequences of the emergency situation, including the impact on food safety during an emergency. Able to periodically test procedures where practical and update the documented information after the occurrence of any incident, emergency situation or tests.				
8.5	**Hazard control** The hazard analysis preliminary information had been collected, updated, and maintained by the food safety team. This shall include but not be limited to the organization products, processes, customers' requirements, equipment, and food safety hazards relevant to the food safety management system.				

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8.5.1	**Preliminary steps to enable hazard analysis** The organization has carried out the hazard analysis, preliminary documented information has been collected, maintained and updated by the food safety team. This includes applicable statutory, regulatory and customer requirements, the organization's products, processes and equipment and relevant food safety hazards.				
8.5.1.2	***Characteristics of raw materials, ingredients and product contact materials*** The organization has ensured that all applicable statutory and regulatory food safety requirements are identified for all raw materials, ingredients and product contact materials. Has maintained documented information concerning all raw materials, ingredients and product contact materials to the extent needed to conduct the hazard analysis.				
8.5.1.3	***Characteristics of end products*** The organization ensured that all applicable statutory and regulatory food safety requirements are identified for all the end products intended to be produced. Also maintain documented information concerning the characteristics of end products to the extent needed to conduct the hazard analysis.				
8.5.1.4	***Intended use*** The intended use, including reasonably expected handling of the end product and any unintended use but reasonably expected mishandling and misuse of the end product, is considered and shall be maintained as documented information to the extent needed to conduct the hazard analysis.				
8.5.1.5	***Flow diagrams and description of processes*** The food safety team has established, updated flow diagrams as documented information for the products or product categories and the processes covered by the food safety management system.				

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8.5.1.5.1	***Preparation of the flow diagrams*** Flow diagrams are clear, accurate and sufficiently detailed to the extent needed to conduct the hazard analysis.				
8.5.1.5.2	***On-site confirmation of flow diagrams*** The food safety team has confirmed on-site the accuracy of the flow diagrams, update the flow diagrams where appropriate and retained the documented information.				
8.5.1.5.3	***Description of processes and process environment*** The food safety team shall describe, to the extent needed to conduct the hazard analysis, the layout of premises, including food and non-food handling areas, processing equipment and contact materials, existing PRPs, external requirements that can impact the choice and the strictness of the control measures and variations resulting from expected seasonal changes or shift patterns.				
8.5.2	**Hazard analysis** The food safety team has conducted a hazard analysis, based on the preliminary information and determined the hazards that needs to be controlled.				
8.5.2.2	***Hazard identification and determination of acceptable levels*** The organization has identified and documented all food safety hazards that are reasonably expected to occur in relation to the type of product, type of process and process environment.				
8.5.2.3	***Hazard assessment*** The organization has conducted, for each identified food safety hazard, a hazard assessment to determine whether its prevention or reduction to an acceptable level is essential.				

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8.5.2.4	***Selection and categorization of control measure(s)*** Based on the hazard assessment, the organization has selected appropriate control measures or combination of control measures that will be capable of preventing or reducing the identified significant food safety hazards to defined acceptable levels. The organization has categorized the selected identified control measures to be managed as OPRP(s) or at CCPs. The categorization is carried out using a systematic approach.				
8.5.3	**Validation of control measure(s) and combinations of control measures** The food safety team has validated that the selected control measures can achieve the intended control of the significant food safety hazard(s). The validation was done prior to implementation of control measure(s) to be included in the hazard control plan and after any change therein.				
8.5.4	**Hazard control plan (HACCP/OPRP plan)** The hazard control plan includes the following information for each control measure at each CCP or OPR: Food safety hazards to be controlled at the CCP or by the OPRP, critical limit(s) at CCP or action criteria for OPRP, monitoring procedures, corrections to be made, records of monitoring, responsibilities and authorities.				
8.5.4.2	***Determination of critical limits and action criteria*** Critical limits at CCPs and action criteria for OPRPs are specified. The rationale for their determination is documented. Critical limits at CCPs are measurable and action criteria for OPRPs are measurable or observable.				

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8.5.4.3	***Monitoring systems at CCPs and for OPRPs*** At each CCP, a monitoring system is established for each control measures to detect any failure to remain within the critical limits. The system includes all scheduled measurements relative to the critical limits. For each OPRP, a monitoring system is established for the control measures to detect failure to meet the action criterion.				
8.5.4.4	***Actions when critical limits or action criteria are not met*** The organization has specified corrections and corrective actions to be taken when critical limits or action criterion are not met. Actions include potentially unsafe products are not released; the cause of nonconformity is identified, and recurrence is prevented.				
8.5.4.5	***Implementation of the hazard control plan*** The organization has implemented and maintained the hazard control plan, and retain evidence of the implementation as documented information.				
8.6	**Updating the information specifying the PRPs and the hazard control plan** There's establishment of the hazard control plan, the organization shall update the following information, if necessary, characteristics of raw materials, ingredients, and product – contact materials, characteristics of product intended use and flow diagrams and description of processes and process environment. When required, the hazard control plan and/or the PRP(s) shall be updated.				
8.7	**Control of monitoring and measuring** The organization had provided evidence that the specified monitoring and measuring methods and equipment is in use is adequate for the monitoring and measuring activities related to the PRP(s) and the hazard control plan. The monitoring and measuring the equipment used shall be calibrate or verified at specified intervals prior to use, adjusted or re-adjusted as necessary, identify to enable the calibration status to be determined. Safeguard from adjustments that would invalidate the measurement result; and protect from damage and deterioration.				

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	The results of calibration and verification shall be retained as documented information. The calibration of equipment shall be traceable to international measurements standards.				
8.8	**Verification related to PRPs and the hazard control plan**				
8.8.1	**<u>Verification</u>** The organization shall establish, implement and maintain verification activities. The verification planning shall define purpose, methods, frequencies and responsibilities for the verification activities. The verification activities shall confirm that: • the PRP(s) are implemented and effective; • the hazard control plan is implemented and effective; • hazard levels are within identified acceptable levels; • input to the hazard analysis is updated; • other actions determined by the organization are implemented and effective.				
8.8.2	**<u>Analysis of results of verification activities</u>** The food safety team has conducted an analysis of the results of verification that shall be used as an input to the performance evaluation of the food management system.				
8.9	**Verification related to PRPs and the hazard control plan** The organization had ensured that data derived from monitoring of OPRPs and CCPs are evaluated by designated persons with sufficient competence and authority to initiate corrective actions and corrections.				
8.9.2	**<u>Corrections</u>** The organization had ensured that when critical limits at CCPs and/or action criteria for OPRPs are not met, the products affected are identified and controlled about their use and release. The organization has established, maintained and updated documented information that includes methods of identification assessment, correction for affected products to ensure their proper handling: and arrangements for review of corrections carried out.				

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8.9.3	**<u>Corrective action</u>** The need for corrective action shall be evaluated when critical limits at CCPs and/or action criteria for OPRPs are not met. The organization shall establish and maintain document information that specify appropriate action to identify and eliminate the cause of detected nonconformities, to prevent recurrence, and to return the process to control after a nonconformity is identified. This action shall include reviewing nonconformities identified by customers and/or consumer complaints/regulatory inspection reports, reviewing trends in monitoring results that may indicate loss of control and determining the cause (s) of nonconformities, documenting the results of corrective action taken; and reviewing corrective action taken to ensure that they are effective. Document information on all corrective actions shall be retained.				
8.9.4	**<u>Handling of potentially unsafe products</u>**				
8.9.4.2	***<u>Evaluation for release</u>*** Each lot of products affected by the nonconformity shall be evaluated. Products affected by failure to remain within critical limits at CCPs shall not be released. Products affected by failure to meet action criterion for OPRPs shall only be released as safe when any of the following conditions apply: evidence other than the monitoring system demonstrates that the control measures have been effective, the combined effect of the control measures for that particular product conforms to the performance intended and the results of sampling, analysis and/or other verification activities demonstrate that the affected products conform to the identified acceptable levels for the food safety hazard(s) concerned.				

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8.9.4.3	***<u>Disposition of nonconforming products</u>*** Products that are not acceptable for release shall be: • reprocessed or further processed within or outside the organization to ensure that the food safety hazard is reduced to acceptable levels • redirected for other use as long as food safety in the food chain is not affected. • destroyed and/or disposed as waste. Documented information on the disposition of nonconforming products, including the identification of the persons with approving authority shall be retained.				
8.9.5	**Withdrawal/ Recall** The organization can ensure the timely withdrawal/ recall of lots of end products that have been identified as potentially unsafe, by appointing competent persons, having the authority to initiate and carry out the withdrawal/recall. The organization shall establish and maintain documented information of the entire recall process.				
Summary:					
9	**PERFORMANCE EVALUATION**				
9.1	**Monitoring, measuring, analysis and evaluation** The organization had determined what need to be monitored and measured, the method for monitoring the measurements, analysis, and evaluation, as applicable, to ensure valid results, when the monitoring shall be performed. The organization had retained appropriate documented information as evidence of the results. The organization had evaluated performance and the effectiveness of the food safety management system.				

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9.1.2	**<u>Analysis and evaluation</u>** The organization has analysed and evaluated appropriate data and information arising from monitoring and measurement, including the results of verification activities related to PRPs and the hazard control plan, the internal and external audits.				
9.2	**Internal audit** The organization had planned, established, implemented, and maintained and audit programme(s) including the frequency, methods, responsibilities, planning requirements and reporting, which shall take into consideration the importance of the process concerned changes in the food safety management system, and a results of monitoring measurements and previous audits				
9.3	**Management review** Top management had reviewed the organization's food safety management system, at planned intervals, to ensure its continuing suitability, adequacy, and effectiveness.				
9.3.2	**<u>Management review input</u>** The management review shall consider the following: • The status of actions from previous management reviews. • Changes in external and internal issues that are relevant to the food safety management system. • Information on the performance and the effectiveness of the food safety management system. • The adequacy of resources. • Any emergency situation, incident or withdrawal/recall that occurred. • Opportunities for continual improvement. The data shall be presented in a manner that enables top management to relate the information to stated objectives of the food safety management system.				

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9.3.3	**<u>Management review output</u>** The outputs of the management review shall include the following: • Decisions and actions related to continual improvement opportunities. • Any need for updates and changes to the food safety management system.				
Summary:					
10	**IMPROVEMENT**				
10.1	**Nonconformity and corrective action** The organization shall retain documented information as evidence of the nature nonconformities and any subsequent action taken.				
10.2	**Continual improvement** Top management shall ensure that is continually updated. To achieve this, the food safety team shall evaluate the food safety management system at planned intervals. The team shall then consider whether it necessary to review the hazard analysis (see8.5.2), the establish hazard control plan (see 8.5.4). the establish PRPs (see 8.2). the updating activities shall be based on input form communication external as well as internal.				
10.3	**Update of the food safety management system** The organizational had continually improved the suitability, adequacy, and effectiveness of the food safety management system to enhance the operation of the organization. Top management shall ensure that the organization continually improve the effectiveness of the food safety management system through the use of communication (see 7.4), management system through the use of communication (see9.3), and internal audit (see 9.2), analysis of result of verification activities, validation of control measure(s) and combination (s) of control measure(s) (, corrective actions (see 8.9.2) and food safety management system updating (see 10.2).				
Summary:					

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
4	**CONSTRUCTION AND LAYOUT OF BUILDINGS**				
4.1	**General requirements** Buildings shall be designed, constructed and maintained in a manner appropriate to the nature of the processing operations to be carried out, the food safety hazards associated with the operations and the potential sources of contamination from the environment. Buildings is of durable construction which presents no hazard to the product.				
4.2	**Environment** Consideration given to potential sources of contamination from the environment. Food production should not be carried out in areas where potentially harmful substances could enter the product. Effective measurements taken to protect against potential contaminants are periodically reviewed.				
4.3	**Locations of establishments** Site boundaries clearly identified. Access to site is controlled. Site must be maintained in very good order. Vegetation to be removed/ tended to. Roads, yards and parking areas properly drained to prevent standing water.				
Summary:					
5	**LAYOUT OF PREMISES AND WORKSPACE**				
5.1	**General requirements** Internal layouts are maintained to facilitate good hygiene and manufacturing practices. The movement patterns of materials, products, people and the layout of equipment is designed to protect against potential contamination.				

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5.2	**Internal design, layout and traffic patterns** The building has adequate space, with a logical flow of materials, products and personnel. Also physical separation of raw and processed areas.				
5.3	**Internal structures and fittings** Process are walls and floors are washable/ cleanable, as appropriate for the process or product hazard. Materials of construction is resistant to the cleaning system applied. Wall floor junctions and corners are rounded in processing areas to facilitate cleaning. Floors to be designed to avoid standing water. In wet process areas, floors are sealed and drained, the drains are trapped and covered. Ceilings and overhead fixtures are designed to minimise build-up of dirt and condensation. External opening windows, roof vents or fan, where present, are insect screened. External opening doors are closed or screened when not in use.				
5.4	**Location of equipment** Equipment to be designed and located to facilitate good hygiene practices and monitoring. Equipment is located to permit operation, cleaning and maintenance.				
5.5	**Laboratory facilities** In-line and on-line test facilities are controlled to minimise the risk of product contamination. Microbiological laboratories are designed, located and operated to prevent contamination of people, plant and products. They shall not open directly to production areas.				

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5.6	**Temporary or mobile premises and vending machines** Designed, located and constructed to prevent pest harbourage and potential contamination of products. Additional hazards associated with temporary structures and vending machines to be controlled.				
5.7	**Storage of food, packaging materials, ingredients and non-food chemicals** Facilities used to store ingredients, packaging and products provide protection against dust, condensation, drains, waste and other sources of contamination. Stage areas are dry and well ventilated. Monitoring and control of temperature and humidity are applied where specified. Storage areas designed or arranged to allow segregation of raw materials, work in progress and finished products. All materials and products to be stored off the floor and with sufficient space between materials and the walls to allow inspection and pest control activities to be carried out. The storage area designed to allow maintenance and cleaning, prevent contamination and minimise deterioration. A separate, secure storage area provided for cleaning materials, chemicals and other hazardous substances. Exceptions for bulk or agricultural crop materials to be documented in the food safety management system.				
Summary:					

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6	**UTILITIES – AIR, WATER, ENERGY**				
6.1	**General requirements** The provisions and distribution routes for utilities to and around processing and storage areas are designed to minimise the risk of product contamination. Utilities' quality to be monitored to minimise product contamination risk.				
6.2	**Water supply** The supply of potable water must be sufficient to meet the needs of the production processes. Facilities for storage, distribution and where needed, temperature control of the water is designed to meet specified water quality requirements. Water used as product ingredient, including ice or steam (including culinary steam), or in contact with products or product surfaces, must meet specified quality and microbiological requirements relevant to the product. Water for cleaning or applications where there is a risk of indirect product contact must meet specified quality and microbiological requirements to the application. Where water supplies are chlorinated, checks are done to ensure the residual chlorine levels at the point of use remains withing the limits given in relevant specifications. Non-potable water must have a separate supply system that is labelled and not connected to the potable water system. Take measures to prevent the non-potable water refluxing into the potable system.				
6.3	**Boiler chemicals** Boiler chemicals, if used, are either: • approved food additives which meet relevant additive specifications. • additives which have been approved by the relevant regulatory authority as safe for use in water intended for human consumption. Boiler chemicals are stored in a separate, secure (locked or otherwise access-controlled) area when not in immediate use.				

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		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
6.4	**Air quality and ventilation** The organization has established requirements for filtration, humidity (RH%) and microbiology of air used as an ingredient or for direct product contact Where temperature and/or humidity are deemed critical by the organization, a control system is put in place and monitored. Ventilation (natural or mechanical) is provided to remove excess or unwanted steam, dust and odours, and to facilitate drying after wet cleaning. Room air supply quality is controlled to minimise risk from airborne microbiological contamination. Ventilation systems are designed and constructed such that air does not flow from contaminated or raw areas to clean areas. Specified air pressure differentials shall be maintained. Systems shall be accessible for cleaning, filter changing and maintenance. Exterior air intake ports shall be examined periodically for physical integrity.				
6.5	**Compressed air and other gases** Compressed air, carbon dioxide, nitrogen and other gas systems used in manufacturing and/or filling shall be constructed and maintained to prevent contamination. Gases intended for direct or incidental product contact is from a source approved for food contact use, filtered to remove dust, oil and water. Where oil is used for compressors, the oil used must be food grade.				
6.6	**Lighting** The lighting provided (natural or artificial) will allow personnel to operate in a hygienic manner. The intensity of the lighting is appropriate to the nature of operations. Light fixtures are protected to ensure that materials, product or equipment are not contaminated in the case of breakages.				
Summary:					

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
7	**WASTE DISPOSAL**				
7.1	**General requirements** Systems are in place to ensure that waste materials are identified, collected, removed and disposed of in a manner which prevents contamination of products or production areas.				
7.2	**Containers for waste and inedible or hazardous substances** Containers for waste and inedible or hazardous substances shall be clearly identified for their intended purpose, located in a designated area, constructed of impervious material which can be readily cleaned and sanitized, closed when not in immediate use and locked where the waste may pose a risk to the product.				
7.3	**Waste management and removal** Provision is made for the segregation, storage and removal of waste. Accumulation of waste is not allowed in food-handling or storage areas. Labelled materials, products or printed packaging designated as waste shall be disfigured or destroyed to ensure that trademarks cannot be reused. Removal and destruction are carried out by approved disposal contractors. The organization shall retain records of destruction.				
7.4	**Drains and drainage** Drains are designed, constructed and located so that the risk of contamination of materials or products is avoided. Drains shall have capacity sufficient to remove expected flow loads. Drains shall not pass over processing lines. Drainage direction shall not flow from a contaminated area to a clean area				
Summary:					

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
8	**EQUIPMENT SUITABILITY, CLEANING, AND MAINTENANCE**				
8.1	**General requirements** Food contact equipment is designed and constructed to facilitate cleaning, disinfection and maintenance. Contact surfaces are not affected by the intended product or cleaning system. Food contact equipment shall be constructed of durable materials able to resist repeated cleaning.				
8.2	**Hygienic design** Equipment can meet established principles of hygienic design, including smooth, accessible, cleanable surfaces, self-draining in wet process areas, framework not penetrated by holes or nuts and bolts. Piping and ductwork are cleanable, drainable, and with no dead ends. Equipment is designed to minimize contact between the operator's hands and the products.				
8.3	**Product contact surfaces** Product contact surfaces are constructed from materials designed for food use. They shall be impermeable and rust or corrosion free.				
8.4	**Temperature control and monitoring equipment** Equipment used for thermal processes is able to meet the temperature gradient and holding conditions given in relevant product specifications. Equipment supports the monitoring and control of the temperature.				

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
8.5	**Cleaning plant, utensils and equipment** Wet and dry-cleaning programmes are documented to ensure that all plant, utensils and equipment are cleaned at defined frequencies. The programmes do specify what is to be cleaned (including drains), the responsibility, the method of cleaning (e.g., CIP, COP), the use of dedicated cleaning tools, removal or disassembly requirements and methods for verifying the effectiveness of the cleaning.				
8.6	**Preventive and corrective maintenance** The preventive maintenance programme includes all devices used to monitor and/or control food safety hazards. Corrective maintenance shall be carried out in such a way that production on adjoining lines or equipment is not at risk of contamination. Lubricants and heat transfer fluids are food grade where there is a risk of direct or indirect contact with the product. The procedure for releasing maintained equipment back to production includes clean up, sanitizing, where specified in process sanitation procedures, and pre-use inspection. Maintenance personnel shall be trained in the product hazards associated with their activities.				
Summary:					
9	**MANAGEMENT OF PURCHASED MATERIALS**				
9.1	**General requirements** Purchasing of materials which impact food safety are controlled to ensure that the suppliers used have the capability to meet the specified requirements. The conformance of incoming materials to specified purchase requirements shall be verified.				

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
9.2	**Selection and management of suppliers** There is a defined process for the selection, approval and monitoring of suppliers. The process used is justified by hazard assessment, including the potential risk to the final product, and includes assessment of the supplier's ability to meet quality and food safety expectations, requirements and specifications and description of how suppliers are assessed.				
9.3	**Incoming material requirements (raw/ingredients/packaging)** Delivery vehicles are checked prior to, and during, unloading to verify that the quality and safety of the material has been maintained during transit. Materials are inspected, tested or covered by COA to verify conformity with specified requirements prior to acceptance or use. The method of verification is documented.				
Summary:					
10	**MEASURES FOR PREVENTION OF CROSS-CONTAMINATION**				
10.1	**General requirements** Programmes must in place to prevent, control and detect contamination. Measures to prevent physical, allergen and microbiological contamination are included.				
10.2	**Microbiological cross-contamination** Areas where potential microbiological cross-contamination exists, the hazard is identified and segregated. Control measures are in place, suitable for each area of processing as follows: Separation of raw from finished or ready to eat products. This can be structural segregation - physical barriers, walls or separate buildings. Access controls with requirements to change into required workwear. Traffic patterns or equipment segregation. Air pressure differentials.				

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
10.3	**Allergen management** Allergens present in the product, either by design or by potential manufacturing cross-contact, is declared. The declaration is on the label for consumer products, and on the label or the accompanying documentation for products intended for further processing. Products are protected from unintended allergen cross-contact by cleaning and line change-over practices and/or product sequencing. Rework containing allergens are used only in products which contain the same allergen(s) or through a process which is demonstrated to remove or destroy the allergenic material.				
10.4	**Physical contamination** Where brittle materials are used, periodic inspection requirements and defined procedures in case of breakage is in place. Glass breakage records are maintained. Measures are in place to prevent, control or detect potential contamination.				
Summary:					
11	**CLEANING AND SANITIZING**				
11.1	**General requirements** Cleaning and sanitizing programmes are established to ensure that the food-processing equipment and environment are maintained in a hygienic condition. Programmes are monitored for continuing suitability and effectiveness.				
11.2	**Cleaning and sanitizing agents and tools** Cleaning and sanitizing agents and chemicals are clearly identified, food grade, stored separately and used only in accordance with the manufacturer's instructions. Tools and equipment are of hygienic design and maintained in a condition which does not present a potential source of contamination.				

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
11.3	**Cleaning and sanitizing programmes** Established and validated by the organization to ensure that all parts of the establishment and equipment are cleaned and/or sanitized to a defined schedule, including the cleaning of cleaning equipment. Cleaning and/or sanitizing programmes must specify: • Areas, items of equipment and utensils to be cleaned and/or sanitized. • responsibility for the tasks specified. • cleaning/sanitizing method and frequency. • monitoring and verification arrangements. • post-clean inspections. • pre-start-up inspections.				
11.4	**Cleaning in place (CIP) systems** CIP systems are separated from active product lines. Parameters for CIP systems are defined and monitored (type, concentration, contact time and temperature of any chemicals used).				
11.5	**Monitoring sanitation effectiveness** Cleaning and sanitation programmes are monitored at frequencies specified by the organization to ensure their continuing suitability and effectiveness.				
Summary:					
12	**PEST CONTROL**				
12.1	**General requirements** Hygiene, cleaning, incoming materials inspection and monitoring procedures are implemented to avoid creating an environment conducive to pest activity.				

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
12.2	**Pest control programmes** The establishment has a nominated person to manage pest control activities and/or deal with appointed expert contractors. Pest management programmes are documented and shall identify target pests, and address plans, methods, schedules, control procedures and, where necessary, training requirements. Programmes include a list of chemicals which are approved for use in specified areas of the establishment.				
12.3	**Preventing access** Holes, drains and other potential pest access points are sealed. External doors, windows or ventilation openings are designed to minimize the potential for entry of pests.				
12.4	**Harbourage and infestations** Storage practices minimize the availability of food and water to pests. Material found to be infested are handled in to prevent contamination of other materials, products or the establishment. Potential pest harbourage (e.g. burrows) are removed. Where outside space is used for storage, stored items shall be protected from weather or pest damage.				
12.5	**Monitoring and detection** Pest-monitoring programmes include the placing of detectors and traps in key locations to identify pest activity. A map of detectors and traps are maintained. Detectors and traps are designed and located to prevent potential contamination of materials, products or facilities. Detectors and traps are of robust, tamper-resistant construction. They are appropriate for the target pest. The detectors and traps are inspected at a frequency intended to identify new pest activity. The results of inspections are analysed to identify trends.				

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
12.6	**Eradication** Eradication measures are initiated immediately after evidence of infestation is reported. Pesticide use and application is restricted to trained operatives and are controlled to avoid product safety hazards. Records of pesticide use are maintained to show the type, quantity and concentrations used; where, when and how applied, and the target pest.				
Summary:					
13	**PERSONAL HYGIENE AND EMPLOYEE FACILITIES**				
13.1	**General requirements** Personal hygiene and behaviour procedures related to the hazard posed to the process area or product are established and documented. All personnel, visitors and contractors are required to comply with the documented requirements.				
13.2	**Personnel hygiene facilities and toilets** Clearly designated personnel hygiene facilities are made available to ensure that the degree of personal hygiene required by the organization can be maintained. The establishment has adequate resources for proper handwashing practices, sinks solely designated for handwashing, a sufficient number of toilets, ensures the hygiene facilities do not open into production areas and have adequate changing facilities.				
13.3	**Staff canteens and designated eating areas** Staff canteens and designated areas for food storage and consumption is situated so that the potential for cross-contamination of production areas is minimized. Storage, cooking and holding temperatures, and time limitations, shall be specified.				

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
13.4	**Workwear and protective clothing** Personnel who work in, or enter into, areas where exposed products and/or materials are handled wear work clothing. Workwear must not have buttons or outside pockets above waist level. Zips or press stud fastenings are acceptable. Workwear is laundered to standards and at intervals suitable for the intended use of the garments. Workwear provides adequate coverage to ensure that hair, perspiration, etc. cannot contaminate the product, unless hazard analysis indicates otherwise. Where gloves are used for product contact, they are clean and in good condition. Use of latex gloves should be avoided. Shoes for use in processing areas fully enclose the foot and is made from non-absorbent materials.				
13.5	**Health status** Employees undergo a medical examination prior to employment in food contact operations (including site catering) unless documented hazard or medical assessment indicates otherwise. (subject to legal restrictions in the country of operation) Additional medical examinations, where permitted, are carried out at intervals defined by the organization.				
13.6	**Illness and injuries** Employees are required to report to management for possible exclusion from food-handling areas when their illness pose a significant risk to the food being handled/ processed. These reports are documented and recorded.				
13.7	**Personal cleanliness** Monitoring measures in place to record any deviations from personal cleanliness.				

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
13.8	**Personal behaviour** A documented policy that describes the behaviours required of personnel in processing, packing and storage areas.				
Summary:					
14	**REWORK**				
14.1	**General requirements** Rework is stored, handled and used in such a way that product safety, quality, traceability and regulatory compliance are maintained.				
14.2	**Storage, identification, and traceability** Segregation requirements for rework (e.g. allergen) shall be documented. Reworked products are clearly identified and/or labelled to allow traceability. The reason for rework designation is recorded (e.g. product name, production date, shift, line of origin, shelf-life).				
14.3	**Rework usage** Where rework is incorporated into a product as an "in-process" step, the acceptable quantity, type and conditions of rework use is specified. The process step and method of addition, including any necessary pre-processing stages, is defined. Where rework activities involve removing a product from filled or wrapped packages, controls are put in place to ensure the removal and segregation of packaging materials and to avoid contamination of the product with extraneous matter.				
Summary:					

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
15	**PRODUCT RECALL PROCEDURES**				
15.1	**General requirements** Systems are in place to ensure that products failing to meet required food safety standards can be identified, located and removed from all necessary points of the supply chain.				
15.2	**Product recall requirements** A list of key contacts in the event of a recall is maintained. Where products are withdrawn due to immediate health hazards, the safety of other products produced under the same conditions is evaluated. The need for public warnings shall be considered.				
Summary:					
16	**WAREHOUSING**				
16.1	**General requirements** Materials and products are stored in clean, dry, well-ventilated spaces protected from dust, condensation, fumes, odours or other sources of contamination.				
16.2	**Warehousing requirements** Effective control of warehousing temperature, humidity and other environmental conditions is provided where required by product or storage specifications. Where products are stacked, are the lower levels protected? Waste materials and chemicals are stored separately. All non-conforming materials are segregated and easily identified. Specified stock rotation systems in place (FIFO). Gasoline- or diesel-powered fork-lift trucks are not used in food ingredient or product storage areas.				

PART 2: ISO/TS 22002:1-2009 for Food Manufacturing

Clause	Requirement	Conform?		Finding Category	Remark
		Yes	***No***	***MI*, MA*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
16.3	**Vehicles, conveyances, and containers** Vehicles, conveyances, and containers are maintained in a state of repair and cleanliness. Also provide protection against damage or contamination of the product. Cleaning to be carried out between loads and records are kept of cleaning activities. Bulk containers are dedicated to food use only.				
Summary:					
17	**PRODUCT INFORMATION / CONSUMER AWARENESS**				
17	Consumers are made aware of the product and its importance so that they can make informed decisions regarding the product. Information relayed in the form of labels, advertisements or company websites.				
Summary:					
18	**FOOD DEFENCE, BIOVIGILANCE AND BIOTERRORISM**				
18.1	**General requirements** The establishment has assessed the hazards to products posed by potential acts of sabotage, vandalism or terrorism and has put in place proportional protective measures.				
18.2	**Access controls** Potentially sensitive areas are access controlled. Access should be physically restricted by use of locks, electronic card key or alternative systems.				
Summary:					

PART 3: FSSC 22000 V5.1 Additional Requirements

Clause	Requirement	Conform?		Finding Category	Remark
		Yes	***No***	***MA*, MI*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
2.5.1	**MANAGEMENT OF SERVICES AND PURCHASED MATERIALS**				
2.5.1(a)	**Management of Services** The organization ensured that where laboratory analysis services are used for the verification and/or validation of food safety, these tests are conducted by a competent laboratory using validated methods and can reproduce results.				
2.5.1(b)	**Emergency Procurement** The organization has a documented procedure for procurement in emergency situations to ensure that products still conform to specified requirements and the supplier have been evaluated**.**				
2.5.1(c)	**Product specifications review procedure** The organization established, implemented and maintain a review process for product specifications to ensure continued compliance with food safety, legal and customer requirements.				
Summary:					
2.5.2	**PRODUCT LABELLING**				
2.5.2	The organization ensures that finished products are labelled according to all applicable statutory and regulatory requirements in the country of intended sale, including allergen and customer specific requirements. Where product is unlabelled, all relevant product information is made available to ensure the safe use of the food by the customer or consumer.				
Summary:					

PART 3: FSSC 22000 V5.1 Additional Requirements					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MA*, MI*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
2.5.3	**FOOD DEFENSE**				
2.5.3.1	**Threat Assessment** The organization has a documented procedure in place to conduct a threat assessment to identify and assess potential threats and developed and implemented mitigation measures for significant threats.				
2.5.3.2	**Plan** The organization has a documented food defence plan specifying the mitigation measures covering the processes and products within the food safety management system's scope.				
Summary:					
2.5.4	**FOOD FRAUD MITIGATION**				
2.5.4.1	**Vulnerability Assessment** The organization haves a documented procedure in place to conduct a food fraud vulnerability assessment to identify and assess potential vulnerabilities and developed and implemented mitigation measures for significant vulnerabilities.				
2.5.4.2	**Plan** The organization haves a documented food fraud mitigation plan specifying the mitigation measures covering the processes and products within the food safety management system's scope.				
Summary:					

PART 3: FSSC 22000 V5.1 Additional Requirements					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MA*, MI*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
2.5.5	**LOGO USE**				
2.5.5	The FSSC 22000 logo can only be used for marketing activities such as the organization's printed matter and / or website and another promotional material.				
Summary:					
2.5.6	**MANAGEMENT OF ALLERGENS (C, E, FI, G, I & K)**				
2.5.6	The organization has a documented allergen management plan that includes: a) Risk assessment covering all potential sources of allergen cross-contamination. b) Control measures to reduce or eliminate the risk of cross-contamination.				
Summary:					
2.5.7	**ENVIRONMENTAL MONITORING (C, I AND K)**				
2.5.7	The organization has in place: a) Risk-based environmental monitoring program. b) Documented procedure for the evaluation of the effectiveness of all controls on preventing contamination from the manufacturing environment and this shall include, at a minimum, the evaluation of microbiological and allergen controls present. c) Data of the monitoring activities including regular trend analysis.				
Summary:					

PART 3: FSSC 22000 V5.1 Additional Requirements					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MA*, MI*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
2.5.8	**FORMULATION OF PRODUCTS (D)**				
2.5.8	Procedures to be in place to manage the use of ingredients that have nutrients that have an adverse animal health impact.				
Summary:					
2.5.9	**TRANSPORT AND DELIVERY (FI)**				
2.5.9	The organization ensured that product is transported and delivered under conditions which minimize the potential for contamination.				
Summary:					
2.5.10	**STORAGE AND WAREHOUSING (ALL CATEGORIES)**				
2.5.10	The organization established, implemented and maintain a procedure and specified stock rotation system that includes FEFO principles in conjunction with the FIFO requirements. The organization has specified requirements in place that define post-slaughter time and temperature in relation with chilling or freezing of the products.				
Summary:					

PART 3: FSSC 22000 V5.1 Additional Requirements

Clause	Requirement	Conform?		Finding Category	Remark
		Yes	***No***	***MA*, MI*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
2.5.11	**HAZARD CONTROL AND MEASURES TO PREVENT CROSS CONTAMINATION (C & I)**				
2.5.11	In case packaging used to impart or product functional effect in food inspection process at lairage and/or evisceration to ensure animals are fit for human consumption.				
Summary:					
2.5.12	**PRP VERIFICATION PROCESS (C, D, G, I & K)**				
2.5.12	Routine site inspections (internal and external).				
Summary:					
2.5.13	**PRODUCT DEVELOPMENT (C, D, E, F, I & K)**				
2.5.13	A product design and development procedure is established, implemented and maintained for new products and changes to product or manufacturing processes to ensure safe and legal products are produced.				
Summary:					
2.5.14	**HEALTH STATUS (D)**				
2.5.14	The organization has a procedure to ensure that the health of personnel does not have an adverse effect on the feed production operations.				
Summary:					

PART 3: FSSC 22000 V5.1 Additional Requirements					
Clause	**Requirement**	**Conform?**		**Finding Category**	**Remark**
		Yes	***No***	***MA*, MI*, CR****	****If no – details NC reference *Justify "not applicable" clauses***
2.5.15	**REQUIREMENTS FOR ORGANIZATIONS WITH MULTI-SITE CERTIFICATION (A, E, FI, G)**				
2.5.15.1	**Central function** The management of the central function ensured that sufficient resources are available, and that roles, responsibilities and requirements are clearly defined for management, internal auditors, technical personnel reviewing internal audits and other key personnel involved in the food safety management system.				
2.5.15.2	**Internal Audit Requirements** An internal audit procedure and program shall be established by the central function covering the management system, central function and all sites. Internal auditors are independent from the areas they audit and be assigned by the central function to ensure impartiality at site level. The management system, centralised function and all sites are audited at least annually or more frequently based on a risk assessment. Internal auditors must meet minimum requirements, and this shall be assessed by the CB annually as part of the audit.				
Summary:					

MI = Minor finding, MA = Major Finding, CR*=Critical Finding