IFS
Food

IFS Food Version 7
OCTOBER 2020

Final IFS Assessment Report

Main certification audit

Announced

Assessed company: Encebe Vleeswaren B.V.

Date of Assessment: 20/09/2021 until 23/09/2021

GS1 GLN(s): 8713279000252

Sanitary legal authorisation number: NL341EG

Name and address of certification body

LRQA France
Tour Swiss Life 1
Boulevard Vivier Merle
69443 Lyon cedex 03
France

Accreditation number of the certification body

COFRAC 05-0069

Assessment Overview
IFS Food Version 7, OCTOBER 2020

Assessment details

Lead auditor:	***Date/time:***	***Date of previous Assessment:***
Co-auditor: -	20/09/2021 (08:15-17:15) 21/09/2021 (08:30-17:00) 22/09/2021 (07:00-15:30) 23/09/2021 (08:45-17:00)	25/09/2020
Trainee(s): -		***Certification body and auditor of previous Assessment:***
Witness auditor: -		LRQA France
Interpreter: -		
Technical expert: -		

Reviewer: Ms Kiriaki Panagiotidou

Name and address of the company (or head office):	***Name and address of the assessed site:***
Vion Food International N.V. Boseind 15 5281RM Boxtel Netherlands	Encebe Vleeswaren B.V. Boseind 10 5281 RM Boxtel Netherlands
	COID: 55703
	Contact person in case of emergency (e.g. recall): Name: E-Mail: Phone:

Phone:	***Fax:***	***Phone:***	***Fax:***
Website:	***E-Mail:***	***Website:***	***E-Mail:***
www.vionfoodgroup.com			

Scope of the Assessment

Production of (cutting, mincing, blending, marinating, fermenting, drying, cooking, pasteurising, sterilising, slicing) of meat products MAP packed in sealed trays, canned, packed in foil, stuffed in casings or bulk packed.
Production of (cutting, mincing, blending, cooking, pasteurising) of ready to eat plant based vegetable pates and sausages packed in artificial casings.

Product scope(s): 1

Technology scope(s): A, B, C, D, E, F

Additional information

Exclusions:	No
Partly outsourced processes:	Yes

Assessment Overview

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1. Sausages (big, industrial calibre) are dried and cured in externernal curing cabins, located in a Lichtevoorde (NL) which is a (formal) meatproduct production site rented by Vion, mother company. Only a small part of this factory is in use. The product recepion/ dispatch and during curing is controlled and checked by Vion employees of location Groenlo and Encebe together. Location is included i internal auidit programm, PRP programmes are implmented as pest control, hygiene checks etc.
2. raw material like herbs and spices, plant based premixed, plant based proteins, are recieved on Vion location Leeuwraden (NL). Vion Leeuwarden prepares the batches raw material (weighing and ensebling, mixing, packing) for the vegan production as this site in leeuwarde is a deadicated vegan production site for Vion. For each production order, the (dry) packed plant based raw materials are transported to Encebe.

Decentralised structure(s):	No
Multi-location production sites:	No

Final result of the Assessment

As a result of the Assessment performed on 20/09/2021 until 23/09/2021, "LRQA France" found that the processing activities of **Encebe Vleeswaren B.V.** for the above-mentioned scope of Assessment comply with the requirements set out in the IFS Food Standard, Version 7, **at Higher Level**, with a score of 96.44%.	Recertification Assessment between 24.08.2022 and 02.11.2022 in case of announced Assessment and between 29.06.2022 and 02.11.2022 in case of unannounced Assessment.

Observations regarding non-conformities (D evaluation of KO requirements and Majors)

na

Description of follow-up on corrections and corrective actions from previous Assessment

All deviations of previous audit have been followed up and have been verified to be cklosed.
Except 4.9.6.1 of which was scored with a B during previous audit and now was seen again (damaged doors), upgraded to score C.

Company Profile

Company data

Year of construction of the assessed site(s):	
If the site was fully reconstructed, enter the year:	
Area of the production site:	
Number of buildings: ***Number of floors:*** ***Number of production lines:***	
Decentralised structure(s):	No
Maximum number of employees at peak season within a calendar year and explanation: About contracted employees and emporary workers: Packing/slicing smoking dep. washing dep. Other dep.	
Detailed description of product groups and products per scope produced in the company. Full view of the company's on-site processes: Product scope 1 "Red and white meat, poultry and meat products and plant based vegan products ": Complete view of the company's processes - technology scopes: (P1, P2, P4, P6, P8, P9, P11 & P12): Cutting, mincing, blending, marinating(P12) - Slicing (P9) - Fermenting /curing and smoking (P4) - pasteurising/cooking (P2 and P11) - sterilising (P1) - MAP packing and vacuum(P8 and P12) – Chilled, frozen (P6) - canned (P12) - sliced and packed in foil (P12) – stuffed in casings (P12) of meat products of beef, pork and poultry and plant based vegan prodicts in artificial casings, consumer packed and bulk paced (P12). Beside own production, company has outsourced processes and/or products.	
Does the assessed site have seasonal production?	Yes
Canning and sterilising of "boterhamworst" is usually produced during the summer months form around april until end of july, but also then not every week. In case of unannounced audit on first audit day planning check on production schedules (and adjustment by the site if needed) so all technical scopes can be assessed during the on site sudit (as this is required).	
Seasonal breaks more than one week?	No
Does the assessed site have fully outsourced products in addition to the main processes/products?	No
Does the assessed site have traded products in addition to main processes/products?	No
Description about key investments made by the company related to the production and product safety and quality in the last 12 months (construction changes, machinery, etc.) New smoking cabin has been ordered, operations have been started to install. Some equipment like stuffing machine has been replaced and BSI production is runing now (was already built during last audit but wasnot fully in use at that time).	
Does the company fulfil the requirements about the use of the IFS (Food) Logo, as defined in the IFS Food Certification protocol (Part 1)?	Yes

Company Profile

Working language of the site and language in which the food safety and quality management system is written:

Dutch

If the site is certified for other standards, specify the name(s) of the standard(s):

IFS Standards: No

GFSI Standards: No

Other standards: ISO9001, IKB, BIO, chain of custody

Additional information:

Encebe Vleeswaren BV is a middle-sized producer of meats preparations and meat products and is part of the Vion Food International Group. The company is located in Boxtel at the same location as the slaughterhouse of Vion Boxtel (part of facility VION Boxtel) and next to head quarter of Vion.
The company is producing and selling ca. 80 different final products divided into several product groups of meats and sausages: Pasteurised meat preparations, sliced MAP packed meat products, cooked (smoked) sausages, sterilized products, fermented sausages, salted RTE products, Salted BtoB products, Bacon fat product (BSI) B to B.
From Q4 2021 also vegan products are produced, same process as for meat sausages in artificial casings, but at that time on a deep cleaned line, production on Saturday as no meat is present during this production on the area. This process was seen during the assessment.
The canning process was also specially planned for during this assessment. However, during the production, the seaming machine broke down and could not be repaired in time within the audit time. Because the situation was force majeure. We finished the assessment of this process by interviewing responsible and specially trained employees and for the remaining process the documents and process reports of the previous canning production of July 2021 were reviewed.
Products are produced by the own production process. The production quantity is approximately per week.
Main selling market is the industrial market and a minor part at the retail (supermarkets). The strategy is focused at growth in the industrial market, for which an assortment tailor-made product is produced, and growth in the retail market of sliced ready to eat meat products.

Company has about oduction lines, possible that not all lines are in process at the same time. Vegan products are produced most of the time on a seperate day, (planning is saturday), so no meat production at the same time in the same area. BSI production most of the time 1 production per week.

Product scope 1 "Red and white meat, poultry and meat products" including vegan plant based products
Complete view of the company's processes - technology scopes:
(P1, P2, P4, P6, P8, P9, P11 & P12):
Receptionand storage of raw material in chilled area (P6), Cutting, mincing, blending, marinating(P12) - Slicing consumer products and industrial products High care (P9) - Fermenting /curing and smoking (P4) - pasteurising/cooking (P2 and P11) - sterilising (P1) - MAP packing and vacuum(P8 and P12) – Chilled, frozen, IQF frozen for industrial products like rookworst sliced (P6) - canned boterhamworst (1.8 kgs) (P12) - sliced and packed in foil (consumer products) (P12) – stuffed in casings (P12) of meat products of beef, pork and poultry and plant based vegan products in artificial casings, consumer packed and bulk paced (P12).

Beside own production, company has outsourced processes and/or products.

Assessment data

Language in which the IFS Food Assessment was conducted:	Dutch
Assessment duration (only for IFS Food Assessment):	34.25h (calculated Assessment time: 26h)

Increasing time reasons:

Others

Company Profile

Site is a bit complex: all types of technology scopes, producing sometimes on (partly) on the same lines, so not all processes can be assessed at the same time/day). So several times to change clothes and enter the production area again which costs a lot of time all together.
Beside this new for this site is production of vegan plan-based pates and sausages, which was an extension on the current valid scope. This way was chosen to increase the 3,5 day on site with 0.5 day, in total 4 days.
For the next on site audit, 4 days is also needed on site so assess all processes.

Which products were produced and which processes have been running during the on-site evaluation?

BSI fat packed in foil, sliced fat packed in foil, boterhamworst in casings, dried sausage in casings, Rookworst (smoked dutch sausage), rookworst sliced (smoked dutch sausage) sliced IQF frozen, snijworst (sliced in consumer MAP packing), salami(sliced in consumer MAP packing), grillworst, boterhamworst blik, cooked bacon (Vacuum packed), salted bacon (in casings).Vegan "liver" sausage stuffed in artificial casings

Summary table of all chapters and result (in percentage) per chapter

	Chapter 1	Chapter 2	Chapter 3	Chapter 4	Chapter 5	Chapter 6
	Governance & commitment	Food safety and quality management system	Resource management	Operational processes	Measurements, analyses, improvements	Food defence plan
Major non-conformities	0	0	0	0	0	0
KO non-conformities	0	0	0	0	0	0
A	12	26	25	122	32	4
B	0	0	0	0	0	0
C	0	0	0	8	3	0
D	0	0	0	0	0	0
N/A	0	0	0	4	1	0
Result per chapter (%)	100	100	100	95.38	93.57	100

Overall summary:

Table of compulsory fields for specific defined IFS Food Assessment requirements and key elements

Part of the IFS Assessment report	N° of IFS Food v7 requirement	Explanation
Policy	1.1.1	Encebe is part of the Vion Group, headquarter is also based in Boxtel, next to Encebe site and a Pork Slaugtersite of Vion. Several departments are manged central at the HQ but good cooperation between HQ and production site was seen. A corporate policy is established and approved Sept 2020 Good business practice Encebe policy 01-01-2021 and Encebe Delicious on a daily basis Sept 2021 all gathered in OGSM dashboeard Specific objectives are set. OGSM dashboard was assessed. Objectives defined for 2021 on several subjects (employees HR, costs, kg's etc.) Quality/client focus objects for Encebe are: -Micro results (listeria 0, Salmonella 0 and entero's max 1/ sample of a batch) -First time right (blocked batches max 6.5/week -Complaints max 1.6 /week (0.1 /1000kg output
Corporate structure	1.2.1	This was checked, by sampling, trough interviews with employees and senior management The organisation has monitored and documented the effectiveness of their operation with different mechanisms : Clear organisation structure and meeting structure. ech deoartment has its own managager which have daily meeting in Tier 1. -Daily department huddle (employees / manager on operational level) -Meetings: Tier 1, Tier 2, Tier 3 also with HQ management
	1.2.3	An organisational chart was seen : P-NCB-NL-10001 1 Sept. 2021
	1.2.5	The company communicates relevant information to responsible staff by: -Daily department huddle (employees / manager on operational level) -Meetings: Tier 1, Tier 2, Tier3 -TV screens in canteen -Meeting in canteen with employees -Training in groups
	1.2.6	Health authority involved:NVWA The last visit was on 11-11-2021
Management review	1.4.1	The last management review sampled was : Q2 July 2021 (including yearly review) Management review 4x year (every Q)
Document management	2.1.1.3	A procedure concerning control of documents and their amendments was seen: P-NCB-NL-10011 5 0kt 2017
Records and documented information	2.1.2.2	A procedure concerning records to be kept was seen : P-NCB-NL-10011 5 0kt 2017

HACCP analysis	2.2.3.7	Specified CCPs: Sterilisation Autoclaving Holding time Heat Treatment Pasteurisation Cooling Freezing pH value Others: nitrite in brine Others: adding acids (listeria control) Further explanation: In total 10 CCP's are determined including critical limits: CCP 1. Temperature control of (returned) fresh pork meat / beef at reception (≤7°C), every batch min. 5 samples, incase Vion delivery (within own chain, 2 samples/batch) CCP 2. Temperature control of (returned) animal by-products/organs at reception (≤3°C) every batch min. 5 samples, incase Vion delivery (within own chain, 2 samples/batch) CCP 3. Temperature control of separated meat at reception (≤2°C) every batch min. 5 samples, incase Vion delivery (within own chain, 2 samples/batch) CCP 4. NO2 in brine (absence or presence by indicator paper) >= 1 g/1000L: check of every batch brine inteded use for raw (uncooked) salted products CCP 5. Temperature control of heat-treated meat products sterilization (2,45 hours at 106°C) CCP 6. pH after fermentation process (pH≤5,3 within 45 hours per cart) CCP 7. Temperature control of heat-treated meat products pasteurization (P70>3 minutes) CCP 8a. Temperature control of minced meat at dispatch (≤2°C) (former CP) every batch min. 5 samples CCP 8b. Temperature control of meat preparations at dispatch (≤4°C) (former CP) every batch min. 5 samples CCP 9. Temperature control of chicken meat at reception (≤4°C) every batch min. 5 samples CCP 10. Adding acids for Listeria control, signed for adding

Establish a monitoring system for each CCP	2.2.3.8.1	In total 10 CCP's are determined including critical limits: CCP 1. Temperature control of (returned) fresh pork meat / beef at reception (≤7°C) CCP 2. Temperature control of (returned) animal by-products/organs at reception (≤3°C) CCP 3. Temperature control of separated meat at reception (≤2°C) CCP 4. NO2 in brine (absence or presence by indicator paper) >= 1 g/1000L CCP 5. Temperature control of heat-treated meat products sterilization (2,45 hours at 106°C) CCP 6. pH after fermentation process (pH≤5,3 within 45 hours) CCP 7. Temperature control of heat-treated meat products pasteurization (P70>3 minutes) CCP 8a. Temperature control of minced meat at dispatch (≤2°C) (former CP) CCP 8b. Temperature control of meat preparations at dispatch (≤4°C) (former CP) CCP 9. Temperature control of chicken meat at reception (≤4°C) CCP 10. Adding acids for Listeria control Yes/No Sampling during this evaluation: CCP 1, 2, 3 and 9 : reception of meat products, Expedition day 1 CCP 4. sampled during brine preparation Day 3 "salting"department CCP 5 and 7. Temperature control of heat-treated meat products sterilization (2,45 hours at 106°C): Sampled on day 2 during "pasteurisation" assessment on high risk department. CCP 6. pH after fermentation process (pH≤5,3 within 45 hours): Sampled on day 2 and 3 : managing maturation process from start on sausage department to end of fermentation process on high care / maturation chambers CCP 8a and 8b Sampled on day 1 and 2 at the expedition department CCP 10. Adding acids for Listeria control signed for yes: Sampled day 1, day 2 and day 3 at the dough preparation for sausages and brine preparation. During the tracetest extra sampling of CCP 1, 6, 8
HACCP analysis	2.2.3.10	The annual verification concerning the HACCP plan was conducted 17 July 2021 Procedure P Vion 10004 12 jan 21
Personal hygiene	3.2.1	Document related to personal hygiene was seen P-FOOD-10017 6 Jan 2021
	3.2.2	This was checked during the evaluation and interviews. Before entry visitor has to sign for the hygiene regulations, all contractors and other employees have performed an entry test including hygiene rules. If they did not succeed in the test, they cannot start to work for the organisation.
	3.2.8	The protective clothing: -General: White coat and trousers for normal production area, work shoes, hairnet (coloured depending of function) and beard net (if required) -High care department: White coat and trousers with red accents for incl. area dedicated work shoes, hairnet (coloured) and beard net (if required) -Vegan: White coat and trousers and usage of orange apron covering the white coat and trousers including orange hear net Clothes are washed by an external company
Training and instruction	3.3.1	There are training and/or instruction program implemented : plan (budget/department) 2021, P-NCB-NL-10227 15 jun 2021

Training and instruction	3.3.2	Number of training sampled : HACCP team 08-04-2019 14-06-17, planned for 5-10-21 and 27-09-21 (both new QA /management employees) Number or training records checked: CCP 10 03-09-2021 and Vega 03-09-2021 metal (CP) 14-04-2021 Metal (CP) 30-04-2021, Line 5 (High risk cleaning) 30-04-2021 CCP 7 20-08-2021 and CCP 5 20-08-2021 metal (CP) 30-04-2021, CCP 8 03-09-2021 CCP 1,2,3,9 12-01-2021 CCP 4 14-09-2021 CCP6 20-08-2021 line 5 cleaning High risk) 03-03-2021 High risk req and chemie 06-01-2021 HACCP manager 12 Oct 2019 Haccp training manager
Staff Facilities	3.4.1	The staff facilities are well maintained, appropriate and are in line with the type of production.
	3.4.5	Hand washing facilities available at access points to production areas are complete, well equipped: cleaning for hands with warm water, single use paper for drying hands, and disinfection to provide entry to production area incl. shoe brush. Appropriate number of sufficiently equipped hand washing basins are available in the production areas of which most are exclusively for hand washing only.
Specifications	4.2.1.1	The following finished product specifications were sampled and checked: all < 3 years old. conform procedure P-NCB-NL 10010 16 juli 2021: BSI leverkaas Frozen back fat snijworst gerookt voor Bio Grillworst IQF rookworstschijfjes 180 dagen vries. ontbijtspek gerookt Boterhamworst canned vegan pate For retail brand finished products specifications have been agreed : Yes
		For product was no specification availiable, is a product for VION International group
	4.2.1.3	•The specifications were sampled and checked for: peesend 8-12-2013 73985 Buikrand bevroren 2 nov 2020 27-22-2020 Foil (under) Foil (Top) 27-3-2019 DOC and spec 17-12-2020 casing permeable 8-6-2021 • The company ensures that the specifications are up to date . PPD checks the specifications every 3 years. casing permeable delivery 31/5/2021 and 10/5/2021 14-07-2021 clicing dep. Foil under : complaint 11 june 2021: emergency delivery: 15-08 and 9/7 2021 delivery.. Top foil: del 9/7 2021 and 24/6 -2021

Specifications	4.2.1.5	•Special claims are used as Bio "and free from gluten" in one type of boterham sausage. This is controlled by the organisation by checks on several points during production and integrity audits. Also Chain f custody audits are performed by externalaudits. All ok. •The company is NOT working with products / raw materials consisting of GMOs, containing GMOs or produced from GMOs. A non-GMO policy is in place. concerning products and raw materials
Formulas/Recipes	4.2.2.1	Customer agreements : checked for agreement with • Provide the information about customer agreement that has been checked during the IFS Assessment: Contract 20-04-2021 • Topics checked on e.g. ammount/pack, label, delivery performance, rest TGT
Product development/ Product modification/ Modification of production processes	4.3.2	Samples of product development checked: BBQ worst spek project just started Vegan boterhamworst t/m article BB process step is in progress. Then 1 more step to go on techn. evaluation proc. P-NCB-NL-10246 16 sept 2021 System
	4.3.4	Labels checked : boterhamworst, snijworst, vet met zonder zwoerd.
Purchasing	4.4.1	Purchasing process documentation checked : P-food 10026 29-10-2019 Purchase requirements P-NLfood 10555 24-01-2020 Puchase] Reliability, service, quality, cost, delivery, conformity, innovative, reaction time if problems occur. In system : preferred suppliers
	4.4.2	Purchasing procedure : P-food 10026 29-10-2019 Purchase requirements
	4.4.3	Last supplier's assessment :29-01-2021 (meat, packing, additives)
	4.4.5	Purchased services checked risk based described in NL-F00d-10155 13-04-2021 Transport is performed by another company of the Vion group, audited regulary and a test regime (agar tests) is part of the checks and control system. Purchased service checked : 29-01-2021 contract 22-03-2017 clothes contract 26-9-2016 lab) 29-01-2021 contract 31-3-2020 distrifresh 7-1-2021
Product packaging	4.5.1	The packing materials types for finished products are : plastic packaging like trays/scales with foil, MAP, sealed foil packs (consumer & BtoB), vacuum packed, crates with innerbag, crates with product folded in foil. Casings to produce sausage is also seen as primary packaging and tins for B toB (sterilised products) The suppliers are GFSI certified for BRCGS Packaging / FSSC22000-ISO-TS22002-4 pack. In case not, from these suppliers filled out questionnair is on file.

Factory location	4.6.1	The site is located in an industrial area. No invfluence of other industry was seen. The conditions of extenal earas are well maintained, fits to the company activities.
Plant layout and process flows	4.8.2	The building is constructed/adapted for food handling and is well maintained. The process flow, from receipt of goods to dispatch, are logically designed to *avoid sufficient separation between flows to prevent contamination risks.* High risk area has a separate entry, dedicated to secure the high sensitive area. Chemicals are stored separate, no contamination risk. Product containing allergens are stored in a separate area in cell 150 also Vega rm is stored separate. Dirty / used material and equipment is stored in washing area as soon as possible also to avoid contamination risk. Good control was seen.
Constructional requirements	4.9.1.1	The site's premises are in basic condition designed and constructed, in basic maintained, easy to be cleaned, suitable for the specific processes to ensure food safety.
Water	4.9.9.1	• Potable water is sourced from the city mains • The potable water is checked, the plan of analysis includes several analyses such as colour, odour, taste, turbidity, TPC 22 C, E coli, Entero coccen: 4x year 1 sample, all ok Ice: TPC and Entero's 1 x year, but last year THT analyses of self produced ice: 8 day's < 2 Entero's: ok. (procedure says ice: THT 5 days) • Analyses performed by an external accredited laboratory
Compressed air and gases	4.9.10.1	• No compressed air is used with direct contact with food or primary packaging material. • Gases which come in direct contact with food or primary packaging materials are part of the hazard analysis and assessment of associated risks *Procesbeheersplan* 17-9-2021 P -NCB NL 10027 • Declaration of compliance of used gases checked : Stikstof 6-11-2019 Foodgrade EU 231/2012
Cleaning and disinfection	4.10.1	• Cleaning is performed by third-party service provider Description of the cleaning and desinfection procedures, CIP (only for the washing machine), manual cleaning of rooms and equipment. • Cleaning and desinfection schedules checked : Bestek 14-08-2020
	4.10.8	Safety Data Sheets checked : : 8-4-2-20 17-7-18 26-10-2016
	4.10.9	Cleaning chemicals storage was found in good condition: In cell 150 storage of chemicals was stored separate in this closed location
	4.10.11	The areas and objects are to be cleaned and disinfected by a third party service provider Bestek 14-08-2020
Waste management	4.11.1	Waste management procedure : P-food-10021 9 -10-2020

Foreign material risk mitigation	4.12.2	• Metaldetection are placed in line: producing sausages, packing sliced products • Foreign material detectors not defined as CCP but as CP: For the removal of potential foreign bodies metal detectors are in place at the end of each packaging line and in line during stuffing sausages. Department "Worstmakerij" (0.8 mm Fe, 1.2 mm, non-Fe, and 2.4 mm SS), Department "Industrial" (2.0 mm Fe, 2.5 mm, non-Fe, 3.0 mm SS) Department "slice" (1.2 mm Fe, 2.4 mm non-Fe, and 3.2 mm SS), The frequency of testing is depending on type of produc/place in the process, variating from 4x/day until 1/hour by using test pieces according the accuracies described.
	4.12.10	Before stuffing casings with salted meat products, the meat pieces are checked on little bones, to cut away. During preparing bacon (fat) for usage "leverkaas" the product is checked for e.g. blood pieces, thickness, during weighing meat before cutting, the meat is checked during this process on foreign body like plastic pieces. All these checks are trained by training on the job: laid down in a skill matrix. In this matrix deviations are shown between "starter" (1) and fully experienced employee (5) yearly checked by responsible manager. Performance of these checks are recorded if needed in the SSOP list.
Pest monitoring and control	4.13.2	• Pest control is managed by : 8x year • Frequency and kind of checks: For rodents (rats and mice) and insects (cockroaches and flying insects); frequency of control is 8 x / year; maintenance of EFK is 4 x / year. Assessment on the Pest control system and a Pest risk inventory 1x / year (Frequency of the in-depth pest control survey is risk based and accepted) • No pest detection like mice pr rats, only a few flies, but no investation. Pest control is contracted to (central) Seen report 17-09-2021, actions are demonstrably solved. For this year this survey is planned for next week. All documentation is present in the contract map of digital revised 8-9-2020). Up to date site plans are available to show the location of rodent baits, mouse traps, crawling and flying insect control units. Constructional action points are solved. Only Non-Tox is used. Trends over 2020 ytd. show no signs of rodent. Good control seen. Visit report 24-01 2020 seen and last inspection of 14 Sept 2020. Inspector valid EVM license until 08-2022, 19-08-2021 Inspection report (partly outsourced: Location Ilchtevoorde: last check by 18-8-2021, only fly detected, no rats and mice. No Investation freq 8x year license until 21-1-23
Receipt and storage of goods	4.14.1	Incoming goods inspection plan : Meat: all receipt batches are checked visually and on temperature (CCP) Micro checks following sampling plan 2020, only from "not vion raw material" .Of incomming batches of Vion sites the micro analyses of the producing sites are shared with Encebe.
	4.14.2	System in place : Dry raw materials are stored in cell 150 (ambient). allergen containing RM are stored separate also vegen ingredients are stored on a special location in this cell. Meat products are stored chilled or froen, depending on type product, also Finished products can be stored chilled or frozen. All products are scanned (barcode) when used/re-placed.

Receipt and storage of goods	4.14.5	This was checked for: chemicals, raw materials used for vegan production, spices for dryed sausages.
Transport	4.15.1	Conditions of the trucks are checked before loading. This was checked for: 20-09-2021
Maintenance and repair	4.16.1	Maintenance plan was seen in ultimo, no specific date, adjustments /version is an ungoing process.
Equipment	4.17.1	Equipment checked : This was checked for the weber slicing machine incl. the belts and snaresof line 5 spec. and DOC 05-01-2015
Traceability	4.18.1	• The traceability system : •During the IFS Assessment a vertical audit / product trail was performed for a product initiated by the auditor: Snijworst art sliced 14-07-2021 for on line 5 in packages 175 grams. No rework was used, vliesvlees, zwoerd, peeseind, buikranden frozen, bactoflavor, herbs and spices, redbeet, wood to smoke, (casing), clips, lussen (rope), top and bottom foil: specifications, DOC's and checks on reception of these products were assessed. ok The kg's of raw materials were broadly taken, which resulted in a plus of kg's on kg FP. This should be tighter also because you expected to have less kg's because of drying of the product. No rework was used. Th related checks and documents incl. data the traceability was demonstrated succesfully from finished product to raw materials and vice versa. CCP's and CP were checked for and recorded incl weight control (e weight).
	4.18.2	The last traceability test performed by the company was done on 12-2-21, Salami 10014
Allergen risk mitigation	4.19.2	• Allergen risk assessment and verification : In the basic HACCP analyses included but re-assessed and verified: Validation report 11-9-2020 • Identifed allergens are: Lactose (milk), mustard, egg, gluten, soy • Preventive and control measures in place to ensure cross contamination is minimised Crosslist/ processtep defined risk on cross contamination in validation report described.including control measures like cleaning, intensive vet cleaning Vital tests based, worse case recipes, a product change procedure incl. checklist made (tabel) on which product turn over the line has to be cleaned in between, good control was seen.

Food Fraud	4.20.2	The company conducted a vulnerability assessment: Yes Raw material groups/ product groups identified: 3 Meat Beef Organic / Fairtrade Pork Organic / Fairtrade Species Claim Poultry Organic / Fairtrade 10 Spices Others: specific bio spices like pepper etc. Organic / Fairtrade Description why the identified raw materials are vulnerable to food fraud: The result of the assessment was that trough all meassures taken, at the end no raw material was identified to be sensitive to vulnerabilty Explanation which criteria were selected: e. g. criteria as costs, easability to vulnerate, traters or direct producers, history of known cases of vulnerability for specific type of product, reliability supplier (delivery history) Details of the assessment: Asssessment performed by HQ Vion, revieuw min. annually, good control was seen Further explanation: Vulnerable assessments: Procedure: P-NCB-NL-10237 22-07-2020: packing materials also included P-NCB-NL-10238 22-09-2021
	4.20.3	Mitigation plan last review : No mitigation plan as the products were not asessed as sensitive for adulteration. Assessed were e.g. broaker, delivery quality, duration of business relationship, delivery quality (history)= chain score... chance of discovery, potential for forgery > 50 control measures No food fraud vulneral raw materials were identified.
	4.20.4	Last review of the Food fraud risk assessment : 22-9-2021
Internal audits	5.1.1	Internal audit reports checked : 31-08-2021 and 20-05-2021 genal product site assessments Encebe announced and unannounced Audit Lichtenvoorde (rented are for partly outsourced proces) July 2021. Yearly selve assessment against all IFS requirements, Aug 2021
	5.1.2	The following activities are identified as critical to the food safety and product quality All KO requirements of IFS are audited min. 1 x year., the CCP 5 sterilisation temp was not demonstrably checked for in the 2 last audits, so this was > 1 year ago, since audited for. As 1 of the 2 audits always announced is, these activities should be plannned so assessment is possible.
Site factory inspections	5.2.1	• Site and factory inspections : On daily basis performed by QC employee. Records including pictures (and responsible person) on file, per day, verified after correction performed by QC employee. Good control was seen. • Sampled inspection checks: wk 12, 32, wk 21, wk 35 2021

Process and working environment validation and control	5.3.1	• Environmental monitoring parameters and limits defined by the company based on a risk assessment . • The following criteria were identified for validation of process and work environment : On weekly base a quart of the factory is swabbed: Listeria and Salmonella swabs (limit: absent) and TPC (30 degree, score system0 = good, to >30: realy bad)) records were seen. Sometimes Listeria or higher TPC, then extra samples are taken, it is not strucural. • The following work environment monitoring parameters were defined by the company: temperature conditions of the high risk area and CCP's pH of raw meat product, heating steps, seam test (on cans), carts on racks to check on sterilisation temp/time • Last process and work environment validation seen; records of all CCP's are logged on daily base, records are checked this audit . An overview of all swab results is seen (excell)
	5.3.2	During the IFS assessment use of rework was checked for rookworst schijfjes 89014 17-08-2021 Rework plan
***Calibration*, adjustment and checking of measuring and monitoring devices**	5.4.1	*Clearly documented list is in place with overviews of all monitoring devices* used within the company which was checkef for during the IFS assement Measuring and monitoring devices checked : Themometer C/EV/104 Freq. 1 x 2 months - last cal. 18-08-2021 (CCP1) Thermometer Cookingcabin 3 (pasteurisation CCP) 12-08-21 frq. 1x year CO2 O2 freq 1x 3 months 9-08-2021 (CP) high risk Frontmate line 5 30-07-2021 high risk Vloerschaal Exp 163-050 30-07-21 Stopper 4 metaldetection 17-11-2020 Slice dep. samples 100 gr. weight calibrated high risk
	5.4.2	Measuring and monitoring devices checked : Themometer C/EV/104 Freq. 1 x 2 months - last cal. 18-08-2021 (CCP1) Thermometer Cookingcabin 3 (pasteurisation CCP) 12-08-21 frq. 1x vear CO2 O2 freq 1x 3 months 9-08-2021 (CP) high risk Frontmate 5 30-07-2021 high risk Vloerschaal Exp 163-050 30-07-21 Frontmatec. Stopper 4 metaldetection 17-11-2020 Slice dep. samples 100 gr. weight calibrated high risk
Quantity control monitoring	5.5.1	•Frequency and methodology of quantity checking: E weight and minimum weight systems are used. •Company uses "e" mark on packaging : Yes (consumer packing, sliced products)
Product and process analysis	5.6.1	• No own laboratory on site •The following analyses are performed by an external laboratory Micro (pathogens and others) on final products and additives. Water analysis (see at other chapter), shelf life tests, allergen monitoring plan, PAK's, 1x 4 or 6 wk environmental monitoirngsplan (weekly). cleaning verification by rodac 1x 4 wks per department (it is not possible to type the all frequencies of all type of analysis in this report) KPI dashboard weekly review by QA team

Product and process analysis	5.6.2	Laboratory :
Product release	5.7.1	Product release procedure : P NCB-NL-10013 5 aug 2019
Management of complaints from authorities and customers	5.8.1	•Compliant rate in 2020 is 76 against in 2019 432. •Foreign materials identified. 13 for ambient and 29 fresh against in 2019 23/21E.g. mostly about bones, metal (not all granded) and plastic • Range or indicator of complaints raised by consumers, retailers and authorities separately. 2021 YTD: Food safety, integrity, last quarter, 1 bone, 1 crunch bone, 1 plastic 1x smelll: these coplaints were not split in the overvieu of the organization for consumers/retailers etc. 2020 this were 5x plastic in total... KPI 0,6/1000kg 2021 statys YTD: <0,6/1000kg. No complaints from authorities
	5.8.2	Complaints samples checked : ' pastic piece in snijworst 10050
Management of incidents, product withdrawal, product recall	5.9.1	Withdrawal/recall procedure : P-NCB-NL_10023 1 sept 2021
	5.9.2	Number of withdrawals: 1 Reasons: Antibiotics / chemical residue detected in final product Number of recalls: 0 Further explanation: • Withdrawals cause : Ethyleenoxide in ginger powder was found 15-02-2021, used only in bio salami dried sausage kaliber 80: ppm was very low in finished product: NVWA contact resulted into a withdraw and no recall because of low % of Ethyleenoxide in FP, not exeeding the MRL in the finished product • No other food safety issue cause of recalls : • Last test : 15-02-2021
Management of non-conformities and non-conforming products	5.10.1	Procedure for non-conformities and nonconforming products : P NCB-NL-10013 5 aug 2019
Corrective actions	5.11.1	• Procedure for corrective actions : P-Food-10018 9 juni 2015
		Corrective actions are described in several instructions on CCP in case of deviations, but specific for that subject. No specific general corrective action procedure was availiable, only a procedure for non conforming products. Not clear described and proof seen on how deviations and corrective actions are analised to avoid recurrences

Corrective actions	5.11.2	• Samples chosen during the Assessment for the follow-up of the corrective actions: -Action point list Encebe 6-9-2021 -Hygiene rounds - Agar cleaning checks/ environmental checks - Corrective actions procedure P Vion 1001 15-2-2021 -Complaint list In Action point list Encebe several open actions were seen over due since half of july 2021, no specific reasons were given.
Food defence plan	6.2	• Food defence plan: A t/m K plan on several food defence points to be tested during the review (bullet points in the procedure. • Procedure : P-Food- 10051 16 juli 2019 • Annual review and last test. 05-06-2021

Summary of all deviations and non-conformities found for each chapter and requirement:

N°	Reference	IFS requirement	Evaluation	Explanation
1	4.2.1.1	Specifications shall be available and in place for all finished products. They shall be up to date, unambiguous and in compliance with legal and customer requirements.	C	The following finished product specifications were sampled and checked: all < 3 years old. conform procedure P-NCB-NL 10010 16 juli 2021: BSI leverkaas Frozen back fat snijworst gerookt voor Bio Grillworst IQF rookworstschijfjes 180 dagen vries. ontbijtspek gerookt Boterhamworst canned vegan pate For retail brand finished products specifications have been agreed : Yes For produc was no specification availiable, is a product for VION International group
2	4.9.4.1	Ceilings (or, where no ceilings exist, the inside of roofs) and overhead fixtures (including piping, cableway, lamps etc.) shall be constructed to minimise the accumulation of dirt and condensation and shall not pose any physical and/or microbiological contamination risks.	C	The sealant seams on the ceiling of the dough preparation containing moulds.
3	4.9.6.1	Doors and gates shall be in good condition and easy to clean. They shall be constructed of non-absorbent materials to avoid: - splintering parts - flaking paint - corrosion.	C	Reception goods at Cell 112, a tear of about 10 cm was seen in the door jamb and on top of the gate the sealant was torn apart from the overhead beam. Previous audit also a damaged door was seen. Re-occurrence.
4	4.9.6.2	External doors and gates shall be constructed to prevent the access of pests; they shall be self-closing, unless non-essentiality is justified by risk assessment.	C	Gate connected to cell 150 was not protected against access of pests as teh protective tarp was partly removed. Also a lot of autumn leaves were found behind the 2nd gate. This means that both gates were opend at the same time which is not the intention of a lock room
5	4.9.8.3	Air conditioning equipment and artificially generated airflow shall not compromise product safety and quality.	C	Rust was detected on condensor of cell 105 and also beginnin of rust on condensor cell 130.

N°	Reference	IFS requirement	Evaluation	Explanation
6	4.10.2	Cleaning and disinfection shall result in effectively cleaned premises, facilities and equipment. Defined methods shall be adequately implemented, documented and monitored.	C	The computer cabin of the cutter was found dirty inside. This must be cleaned by own employees and is not outsourced A projects is running on improvement of cleaning by "own" employees.
7	4.10.5	The effectiveness of the cleaning and disinfection measures shall be verified and justified by risk assessment. The verification shall be based on an appropriate sampling schedule and shall consider: - visual inspection - rapid testing - analytical testing methods. Resultant corrective actions shall be documented.	C	Verification of cleaning activities was not always fully conform procedure: - Periodic cleaning activities were not demonstrably verified after perfomance of this cleaning activity. - The effectiveness check of cleaning by rodac plates (TPC), was not always effective. Seen some samples scoring red / not good (TPC>90 5cm2) were not re-sampled inmediate the next week as they thould (as descibed in the procedure)
8	4.18.1	KO N° 7: A traceability system shall be in place that enables the identification of product lots and their relation to batches of raw materials and primary packaging materials. The traceability system *shall incorporate all relevant* records of: - receipt - processing - use of rework - distribution. Traceability shall be ensured and documented until delivery to the customer.	C	• The traceability system : •During the IFS Assessment a vertical audit / product trail was performed for a product initiated by the auditor: Snijworst art sliced 14-07-2021 for on line 5 in packages 175 grams. No rework was used, vliesvlees, zwoerd, peeseind, buikranden frozen, bactoflavor, herbs and spices, redbeet, wood to smoke, (casing), clips, lussen (rope), top and bottom foil: specifications, DOC's and checks on reception of these products were assessed. ok The kg's of raw materials were broadly taken, which resulted in a plus of kg's on kg FP. This should be tighter also because you expected to have less kg's because of drying of the product. No rework was used. Th related checks and documents incl. data the traceability was demonstrated succesfully from finished product to raw materials and vice versa. CCP's and CP were checked for and recorded incl weight control (e weight).

N°	Reference	IFS requirement	Evaluation	Explanation
9	5.1.2	Internal audits of activities, which are critical to food safety and product quality, shall be carried out at least once a year.	C	The following activities are identified as critical to the food safety and product quality All KO requirements of IFS are audited min. 1 x year., the CCP 5 sterilisation temp was not demonstrably checked for in the 2 last audits, so this was > 1 year ago, since audited for. As 1 of the 2 audits always announced is, these activities should be plannned so assessment is possible.
10	5.11.1	A procedure shall be in place for the recording and analysis of non -conformities and non-conforming products, with the objective to avoid recurrences by preventive and/or corrective actions. This may include a root cause analysis.	C	• Procedure for corrective actions : P-Food-10018 9 juni 2015 Corrective actions are described in several instructions on CCP in case of deviations, but specific for that subject. No specific general corrective action procedure was availiable, only a procedure for non conforming products. Not clear described and proof seen on how deviations and corrective actions are analised to avoid recurrences
11	5.11.2	KO N° 10: Corrective actions shall be clearly formulated, documented and undertaken as soon as possible to avoid the further occurrence of non-conformities. The responsibilities and the timescales for corrective actions shall be clearly defined.	C	• Samples chosen during the Assessment for the follow-up of the corrective actions: -Action point list Encebe 6-9-2021 -Hygiene rounds - Agar cleaning checks/ environmental checks - Corrective actions procedure P Vion 1001 15-2-2021 -Complaint list In Action point list Encebe several open actions were seen over due since half of july 2021, no specific reasons were given.

Summary of points of attention:

N°	Reference	IFS requirement	Evaluation	Explanation

No points of attention found

Detailed IFS Assessment report:

N°	Reference	IFS requirement	Evaluation	Explanation
1	1.1.1	The senior management shall develop, implement and maintain a corporate policy, which shall include, at a minimum: - food safety and product quality - customer focus - food safety culture. This corporate policy shall be communicated to all employees and shall be broken down into specific objectives for the relevant departments.	A	Encebe is part of the Vion Group, headquarter is also based in Boxtel, next to Encebe site and a Pork Slaugtersite of Vion. Several departments are manged central at the HQ but good cooperation between HQ and production site was seen. A corporate policy is established and approved Sept 2020 Good business practice Encebe policy 01-01-2021 and Encebe Delicious on a daily basis Sept 2021 all gathered in OGSM dashboeard Specific objectives are set. OGSM dashboard was assessed. Objectives defined for 2021 on several subjects (employees HR, costs, kg's etc.) Quality/client focus objects for Encebe are: -Micro results (listeria 0, Salmonella 0 and entero's max 1/ sample of a batch) -First time right (blocked batches max 6.5/week -Complaints max 1.6 /week (0.1 /1000kg output
2	1.1.2	All relevant information related to food safety, product quality and authenticity shall be communicated effectively and in a timely manner to the relevant personnel.	A	
3	1.2.1	KO n°1: The senior management shall ensure that employees are aware of their responsibilities related to food safety and product quality and that mechanisms are in place to monitor the effectiveness of their operation. Such mechanisms shall be clearly identified and documented.	A	This was checked, by sampling, trough interviews with employees and senior management The organisation has monitored and documented the effectiveness of their operation with different mechanisms : Clear organisation structure and meeting structure. ech deoartment has its own managager which have daily meeting in Tier 1. -Daily department huddle (employees / manager on operational level) -Meetings: Tier 1, Tier 2, Tier 3 also with HQ management
4	1.2.2	The senior management shall provide sufficient and relevant resources to meet the product and process requirements.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
5	1.2.3	The department responsible for food safety and quality management shall have a direct reporting relationship to the senior management. An organisational chart shall be available, showing the structure of the company.	A	An organisational chart was seen : P-NCB -NL-10001 1 Sept. 2021
6	1.2.4	The senior management shall ensure that all processes (documented and undocumented) are known by the relevant personnel and are applied consistently.	A	
7	1.2.5	The senior management shall have a system in place to ensure that the company is kept informed of all relevant legislation, scientific and technical developments, industry codes of practice, food safety and product quality issues, and that they are aware of factors that can influence food defence and food fraud risks.	A	The company communicates relevant information to responsible staff by: -Daily department huddle (employees / manager on operational level) -Meetings: Tier 1, Tier 2, Tier3 -TV screens in canteen -Meeting in canteen with employees -Training in groups
8	1.2.6	The senior management shall ensure that the certification body is informed of any changes that may affect the company's ability to conform to the certification requirements. This shall include, at a minimum: - any legal entity name change - any production site location change. For the following specific situations: - any product recall - any product recall and / or withdrawal by official order for food safety and / or food fraud reasons - any visit from health authorities which results in notifications and / or penalties issued by authorities the certification body shall be informed within three (3) working days.	A	Health authority involved:NVWA The last visit was on 11-11-2021

N°	Reference	IFS requirement	Evaluation	Explanation
9	1.3.1	A process shall be in place to identify fundamental needs and expectations of customers. The feedback from this process shall be used as input for the company's continuous improvement.	A	
10	1.4.1	The senior management shall ensure that the food safety and quality management system is reviewed at least annually, or more frequently if significant changes occur. Such reviews shall include, at a minimum: - a review of objectives and policies including elements of food safety culture - results of audits and site inspections - positive and negative customer feedback - process compliance - authenticity and conformity issues - status of corrections and corrective actions - notifications from authorities.	A	The last management review sampled was : Q2 July 2021 (including yearly review) Management review 4x year (every Q)
11	1.4.2	Actions from the management review shall be clearly aimed at supporting improvement. The management review shall assess follow-up actions from previous management reviews and any change that could affect the food safety and quality management system. The management review shall be fully documented.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
12	1.4.3	The senior management shall identify and regularly review (e.g. by internal audits or on-site verification) the infrastructure and work environment needed to conform to product requirements. This shall include, at a minimum: - buildings - supply systems - machines and equipment - transport - staff facilities - environmental conditions - hygienic conditions - workplace design - external influences (e.g. noise, vibration). The results of the review shall be considered, with due consideration to risks, for investment planning.	A	
13	2.1.1.1	The food safety and quality management system shall be documented and implemented, and shall be kept in one location (food safety and quality manual or electronic documented system).	A	
14	2.1.1.2	All documents shall be clearly legible, unambiguous and comprehensive. They shall be available to the relevant personnel at all times.	A	
15	2.1.1.3	A documented procedure shall exist for the control of documents and their amendments. All documents which are necessary for compliance with the product requirements shall be available in their latest version. The reason for any amendments to documents, critical to the product requirements, shall be recorded.	A	A procedure concerning control of documents and their amendments was seen: P-NCB-NL-10011 5 0kt 2017

N°	Reference	IFS requirement	Evaluation	Explanation
16	2.1.2.1	Records and documented information shall be legible and genuine. They shall be maintained in a way that subsequent revision or amendment is prohibited. If records are documented electronically, a system shall be in place to ensure that only authorised personnel have access to create or amend those records (e.g. password protection).	A	
17	2.1.2.2	All records and documented information shall be kept in accordance with legal and customer requirements. If no such requirements exist, records and documented information shall be kept for a minimum of one year after the specified shelf life. For products which have no shelf life, the duration of record and documented information keeping shall be justified and this justification shall be documented.	A	A procedure concerning records to be kept was seen : P-NCB-NL-10011 5 0kt 2017
18	2.1.2.3	Records and documented information shall be securely stored and easily accessible.	A	
19	2.2.1.1	The basis of the company's food safety management system shall be a fully implemented, systematic and comprehensive HACCP based plan, following the Codex Alimentarius principles and any legal requirements of the production and destination countries which may go beyond such principles. The HACCP plan shall be specific and implemented at the production site.	A	
20	2.2.1.2	The HACCP plan shall cover all raw materials, packaging materials, products or product groups as well as every process from incoming goods up to dispatch of finished products, including product development.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
21	2.2.1.3	The company shall ensure that the HACCP plan is based upon scientific literature, or expert advice obtained from other sources, which may include: trade and industry associations, independent experts and regulatory authorities. This information shall be maintained in line with any new technical process development.	A	
22	2.2.1.4	The company shall ensure that in the event of changes to raw materials, packaging materials, processing methods, infrastructure and/or equipment, the HACCP plan is reviewed to assure that product safety requirements are complied with.	A	
23	2.2.2.1	Assemble HACCP Team: The HACCP team shall have the appropriate specific knowledge and expertise and be a multidisciplinary team which includes operational staff.	A	
24	2.2.2.2	Those responsible for the development and maintenance of the HACCP plan shall have an internal team leader and shall have received adequate training in the application of the HACCP principles and specific knowledge of the product and processes.	A	
25	2.2.3.1	Describe product: A full description of the product including all relevant information on product safety shall exist, such as: - composition - physical, organoleptic, chemical and microbiological characteristics - legal requirements for the food safety of the product - methods of treatment, packaging, durability (shelf life) - conditions for storage, method of transport and distribution.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
26	2.2.3.2	Identify intended use: The intended use of the product shall be described in relation to the expected use of the product by the end consumer, taking vulnerable groups of consumers into account .	A	
27	2.2.3.3	Construct flow diagram: A flow diagram shall exist for each product, or product group, and for all variations of the processes and sub-processes (including rework and reprocessing). The flow diagram shall be dated, and after the determination of control measures, clearly identify each CCP and other control measures. In the event of any changes, the flow diagram shall be updated.	A	
28	2.2.3.4	On-site confirmation of the flow diagram: Representatives of the HACCP team shall verify the flow diagram, by on-site verifications, at all operation stages and shifts. Where appropriate, amendments to the diagram shall be made.	A	
29	2.2.3.5	Conduct a hazard analysis for each step: A hazard analysis shall be conducted for all possible and reasonably expected physical, chemical (including radiological and allergens) and biological hazards. The analysis shall also include hazards linked to materials in contact with food, packaging materials and hazards related to the work environment.. The hazard analysis shall consider the likely occurrence of hazards and the severity of their adverse health effects. Consideration shall be given to the specific control measures that shall be applied to control each hazard. to control each hazard.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
30	2.2.3.6	Determine critical control points and other control measures: The determination of relevant CCPs and other control measures shall be facilitated by the application of a decision tree or other tool(s), which demonstrates a logical reasoned approach.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
31	2.2.3.7	Establish critical limits for each CCP: For each CCP, the appropriate critical limits shall be defined and validated to clearly identify when a process is out of control.	A	Specified CCPs: Sterilisation Autoclaving Holding time Heat Treatment Pasteurisation Cooling Freezing pH value Others: nitrite in brine Others: adding acids (listeria control) Further explanation: In total 10 CCP's are determined including critical limits: CCP 1. Temperature control of (returned) fresh pork meat / beef at reception (≤7°C), every batch min. 5 samples, incase Vion delivery (within own chain, 2 samples/batch) CCP 2. Temperature control of (returned) animal by-products/organs at reception (≤3°C) every batch min. 5 samples, incase Vion delivery (within own chain, 2 samples/batch) CCP 3. Temperature control of separated meat at reception (≤2°C) every batch min. 5 samples, incase Vion delivery (within own chain, 2 samples/batch) CCP 4. NO2 in brine (absence or presence by indicator paper) >= 1 g/1000L: check of every batch brine inteded use for raw (uncooked) salted products CCP 5. Temperature control of heat-treated meat products sterilization (2,45 hours at 106°C) CCP 6. pH after fermentation process (pH≤5,3 within 45 hours per cart) CCP 7. Temperature control of heat-treated meat products pasteurization (P70>3 minutes) CCP 8a. Temperature control of minced meat at dispatch (≤2°C) (former CP) every batch min. 5 samples CCP 8b. Temperature control of meat preparations at dispatch (≤4°C) (former CP) every batch min. 5 samples CCP 9. Temperature control of chicken meat at reception (≤4°C) every batch min. 5 samples CCP 10. Adding acids for Listeria control, signed for adding

N°	Reference	IFS requirement	Evaluation	Explanation
32	2.2.3.8.1	KO N° 2: Specific monitoring procedures in terms of method, frequency of measurement or observation and recording of results, shall be established for each CCP to detect any loss of control at that CCP. Each defined CCP shall be under control. Monitoring and control of each CCP shall be demonstrated by records.	A	In total 10 CCP's are determined including critical limits: CCP 1. Temperature control of (returned) fresh pork meat / beef at reception (≤7°C) CCP 2. Temperature control of (returned) animal by-products/organs at reception (≤3°C) CCP 3. Temperature control of separated meat at reception (≤2°C) CCP 4. NO2 in brine (absence or presence by indicator paper) >= 1 g/1000L CCP 5. Temperature control of heat-treated meat products sterilization (2,45 hours at 106°C) CCP 6. pH after fermentation process (pH≤5,3 within 45 hours) CCP 7. Temperature control of heat-treated meat products pasteurization (P70>3 minutes) CCP 8a. Temperature control of minced meat at dispatch (≤2°C) (former CP) CCP 8b. Temperature control of meat preparations at dispatch (≤4°C) (former CP) CCP 9. Temperature control of chicken meat at reception (≤4°C) CCP 10. Adding acids for Listeria control Yes/No Sampling during this evaluation: CCP 1, 2, 3 and 9 : reception of meat products, Expedition day 1 CCP 4. sampled during brine preparation Day 3 "salting"department CCP 5 and 7. Temperature control of heat-treated meat products sterilization (2,45 hours at 106°C): Sampled on day 2 during "pasteurisation" assessment on high risk department. CCP 6. pH after fermentation process (pH≤5,3 within 45 hours): Sampled on day 2 and 3 : managing maturation process from start on sausage department to end of fermentation process on high care / maturation chambers CCP 8a and 8b Sampled on day 1 and 2 at the expedition department CCP 10. Adding acids for Listeria control signed for yes: Sampled day 1, day 2 and day 3 at the dough preparation for sausages and brine preparation. During the tracetest extra sampling of CCP 1, 6, 8

N°	Reference	IFS requirement	Evaluation	Explanation
33	2.2.3.8.2	Records of CCP monitoring shall be verified by a responsible person within the company and maintained for a relevant period.	A	
34	2.2.3.8.3	The operative personnel in charge of the monitoring of CCPs and other control measures shall have received specific training/ instruction.	A	
35	2.2.3.8.4	Control measures, other than CCPs, shall be monitored, recorded and controlled by measurable or observable criteria.	A	
36	2.2.3.9	Establish corrective actions: In the event that the monitoring indicates that a particular CCP or control measure other than CCP is not under control, adequate corrective actions shall be taken and documented. Such corrective actions shall also take into account any action taken relating to non-conforming products and identify the root cause for the loss of control of CCPs.	A	
37	2.2.3.10	Establish verification procedures: Procedures of verification shall be established to confirm that the HACCP plan is working correctly. Verification of the HACCP plan shall be performed at least once a year. Examples of verification activities include: - internal audits, - analyses - sampling - deviations - complaints The results of this verification shall be incorporated into the HACCP plan.	A	The annual verification concerning the HACCP plan was conducted 17 July 2021 Procedure P Vion 10004 12 jan 21

N°	Reference	IFS requirement	Evaluation	Explanation
38	2.2.3.11	Establish documentation and record keeping Documentation related to the HACCP plan shall be in place. Examples of documentation include: - hazard analysis - determination of CCPs and other control measures - determination of critical limits - processes, procedures Examples of records include: - outcome of CCPs and other control measures monitoring activities - observed deviations and implemented corrective actions.	A	
39	3.1.1	All personnel performing work that affects product safety, quality and legality shall have the required competence appropriate to their role as a result of education, work experience and/ or training.	A	
40	3.1.2	The responsibilities, competencies and job descriptions for all job titles, with an impact on food safety and product quality shall be clearly defined, documented and in place. Assignment of key roles shall be defined.	A	
41	3.2.1	Documented requirements relating to personal hygiene shall be in place and shall include, at a minimum, the following areas: - hair and beards - protective clothing (including their conditions of use in staff facilities) - hand washing, disinfection and hygiene - eating, drinking and smoking - actions to be taken in case of cuts or skin abrasions - fingernails, jewellery and personal belongings (including medicine) - notification of infectious diseases and conditions impacting food safety via a medical screening procedure. The requirements shall be based on hazard analysis and assessment of associated risks.	A	Document related to personal hygiene was seen P-FOOD-10017 6 Jan 2021

N°	Reference	IFS requirement	Evaluation	Explanation
42	3.2.2	KO N° 3: The requirements for personal hygiene shall be in place and applied by all relevant personnel, contractors and visitors.	A	This was checked during the evaluation and interviews. Before entry visitor has to sign for the hygiene regulations, all contractors and other employees have performed an entry test including hygiene rules. If they did not succeed in the test, they cannot start to work for the organisation.
43	3.2.3	Compliance with personal hygiene requirements shall be checked regularly.	A	
44	3.2.4	Visible jewellery (including piercing) and watches shall not be worn. Any exceptions shall have been comprehensively evaluated by hazard analysis and assessment of associated risks and shall be effectively managed.	A	
45	3.2.5	Cuts and skin abrasions shall be covered with a coloured plaster/bandage different from the product colour. Where appropriate: - plasters / bandages shall contain a metal strip - single use gloves shall be worn.	A	
46	3.2.6	In work areas where wearing headgear and/or beard snood (coverings) is required, the hair shall be covered completely to prevent product contamination.	A	
47	3.2.7	Clearly defined usage rules shall exist for work areas/ activities where it is required to wear gloves (coloured differently from the product colour).	A	

N°	Reference	IFS requirement	Evaluation	Explanation
48	3.2.8	Suitable protective clothing shall be available and in sufficient quantity for each employee.	A	The protective clothing: -General: White coat and trousers for normal production area, work shoes, hairnet (coloured depending of function) and beard net (if required) -High care department: White coat and trousers with red accents for incl. area dedicated work shoes, hairnet (coloured) and beard net (if required) -Vegan: White coat and trousers and usage of orange apron covering the white coat and trousers including orange hear net Clothes are washed by an external company
49	3.2.9	All protective clothing shall be thoroughly and regularly laundered in-house or by approved contractors or by employees. This decision shall be justified by risk assessment. Defined requirements shall ensure, at a minimum: - sufficient segregation between dirty and clean clothing at all times - defined laundering conditions on water temperature and detergent dosage - avoidance of contamination until use. The effectiveness of the laundering shall be appropriately monitored.	A	
50	3.2.10	In case of any health issue or infectious disease that may have an impact on food safety, actions shall be taken in order to minimise contamination risks.	A	
51	3.3.1	The company shall implement documented training and/or instruction programs with respect to the product and process requirements and the training needs of the employees, based on their job, and shall include: - training contents - training frequency - employee's task - languages - qualified trainer/tutor.	A	There are training and/or instruction program implemented : plan (budget/department) 2021, P-NCB-NL-10227 15 jun 2021

N°	Reference	IFS requirement	Evaluation	Explanation
52	3.3.2	The documented training and/or instruction shall apply to all personnel, including seasonal and temporary workers and employees from external companies, employed in the respective work area. Upon employment, and before commencing work, they shall be trained/instructed in accordance with the documented training/instruction programs.	A	Number of training sampled · HACCP team 08-04-2019 14-06-17, planned for 5-10-21 and 27-09-21 (both new QA /management employees) Number or training records checked: · CCP 10 03-09-2021 and Vega 03-09 -2021 metal (CP) 14-04-2021 Metal (CP) 30-04-2021, Line 5 (High risk cleaning) 30-04-2021 CCP 7 20-08-2021 and CCP 5 20-08 -2021 · metal (CP) 30-04-2021, CCP 8 03-09 -2021 CCP 1,2,3,9 12-01-2021 CCP 4 14-09-2021 CCP6 20-08-2021 line 5 cleaning High risk) 03-03-2021 High risk req and chemie 06-01- 2021 HACCP manager 12 Oct 2019 Haccp training manager
53	3.3.3	Records of all training/instruction events shall be available, stating: - list of participants (including their signature) - date - duration - contents of training - name of trainer/tutor. A procedure or program shall be in place to prove the effectiveness of the training and/or instruction programs.	A	
54	3.3.4	The contents of training and/or instruction shall be regularly reviewed and updated when necessary. Special consideration shall be given, at a minimum, to these specific issues: - food safety - food fraud - product quality - food defence - food related legal requirements - product/process modifications - feedback from the previous documented training/instruction programs.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
55	3.4.1	The company shall provide suitable staff facilities, which shall be proportional in size, equipped for the number of personnel, designed and controlled so to minimise food safety risks. Such facilities shall be kept in a clean and good condition.	A	The staff facilities are well maintained, appropriate and are in line with the type of production.
56	3.4.2	Product contamination risks by food and drink and/or foreign materials shall be minimised. Consideration shall be given to food and drink from vending machines, canteen and/or brought to work by personnel.	A	
57	3.4.3	Changing rooms shall be located to allow direct access to the areas where food products are handled. If this is not possible, preventive measures shall be in place to minimise product contamination risks. Where necessary, outdoor clothing and protective clothing shall be stored separately.	A	
58	3.4.4	Toilets shall neither have direct access nor pose contamination risks to an area where food products are handled. Toilets shall be equipped with adequate hand washing facilities. Sanitary facilities shall have adequate natural or mechanical ventilation. Mechanical airflow from a contaminated area to a clean area shall be avoided.	A	
59	3.4.5	Hand hygiene facilities shall be provided and shall adress, at a minimum: - adequate number of wash basins - suitably located at access points to and/or within production areas - sole use for cleaning hands only. The necessity of similar equipment in further areas (e.g. packing area) shall be based on hazard analysis and assessment of associated risks.	A	Hand washing facilities available at access points to production areas are complete, well equipped: cleaning for hands with warm water, single use paper for drying hands, and disinfection to provide entry to production area incl. shoe brush. Appropriate number of sufficiently equipped hand washing basins are available in the production areas of which most are exclusively for hand washing only.

N°	Reference	IFS requirement	Evaluation	Explanation
60	3.4.6	Hand hygiene facilities shall provide: - running potable water at an appropriate temperature - appropriate cleaning and disinfection equipment - appropriate means for hand drying.	A	
61	3.4.7	Where the processes require a higher standard of hygiene, the hand washing equipment shall provide, in addition: - hand contact-free fittings - hand disinfection - waste container with hand contact-free opening.	A	
62	3.4.8	Based on hazard analysis and assessment of associated risks, a program shall be in place to control effectiveness of hand hygiene.	A	
63	3.4.9	Where it is justified by risk assessment, cleaning and disinfection facilities shall be available and used for boots, shoes and further protective clothing.	A	
64	4.1.1	All requirements related to food safety and product quality, within the defined agreement with customers, and any revision of these clauses, shall be communicated to and implemented by each relevant department.	A	
65	4.1.2	In accordance with customer requirements, the senior management shall inform their affected customers, as soon as possible, of any issue related to product safety or legality, including non-conformity/ies identified by competent authorities.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
66	4.2.1.1	Specifications shall be available and in place for all finished products. They shall be up to date, unambiguous and in compliance with legal and customer requirements.	C	The following finished product specifications were sampled and checked: all < 3 years old. conform procedure P-NCB-NL 10010 16 juli 2021: BSI leverkaas Frozen back fat snijworst gerookt voor Bio Grillworst IQF rookworstschijfjes 180 dagen vries. ontbijtspek gerookt Boterhamworst canned vegan pate For retail brand finished products specifications have been agreed : Yes For product was no specification availiable, is a product for VION International group
67	4.2.1.2	A procedure to control the creation, approval and amendment of specifications shall be in place and shall include, where required, the acceptance of the customer(s). Where required by customers, product specifications shall be formally agreed. This procedure shall include the update of finished product specification in case of any modification related to: - raw materials - formulas/recipes - processes which impact the finished products - packaging materials which impact the finished products.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
68	4.2.1.3	KO N° 4: Specifications shall be available and in place for all raw materials (ingredients, additives, packaging materials, rework). Specifications shall be up to date, unambiguous and be in compliance with legal requirements and, if existing, with customer requirements.	A	•The specifications were sampled and checked for: peesend 8-12-2013 Buikrand bevroren 2 nov 2020 27-22-2020 and spec 17-12-2020 8-6-2021 • The company ensures that the specifications are up to date : PPD checks the specifications every 3 years. casing 14-07-2021 clicing dep. Foil under : complaint 11 june 2021: emergency delivery: 15-08 and 9/7 2021 delivery.. Top foil: 9/7 2021 and 24/6 - 2021
69	4.2.1.4	Specifications and/or their contents shall be available on site for all relevant personnel.	A	
70	4.2.1.5	Where customers specifically require that products are "free from" certain substances or ingredients (e.g. gluten, pork, etc.), or that certain methods of treatment or production are excluded (e.g. GMOs), verifiable procedures shall be in place.	A	•Special claims are used as Bio "and free from gluten" in one type of boterham sausage. This is controlled by the organisation by checks on several points during production and integrity audits. Also Chain f custody audits are performed by externalaudits. All ok. •The company is NOT working with products / raw materials consisting of GMOs, containing GMOs or produced from GMOs. A non-GMO policy is in place. concerning products and raw materials
71	4.2.2.1	KO N° 5: Where there are customer agreements related to: - product recipe (including raw materials characteristics) - process - technological requirements - packaging - labelling these shall be complied with.	A	Customer agreements : checked for agreement with • Provide the information about customer agreement that has been checked during the IFS Assessment: Contract 20-04-2021 • Topics checked on e.g. ammount/pack, label, delivery performance, rest TGT

N°	Reference	IFS requirement	Evaluation	Explanation
72	4.3.1	For each new development or modification of products, a hazard analysis and assessment of associated risks shall be conducted.	A	
73	4.3.2	The product development/ modification process shall result in specifications about formulation, packaging requirements, manufacturing processes and process parameters related to the fulfilment of product requirements. This includes factory trials and product testing. The progress and results of product development/modification shall be recorded.	A	Samples of product development checked: BBQ worst spek project just started Vegan boterhamworst t/m article BB process step is in progress. Then 1 more step to go on techn. evaluation proc. P-NCB-NL-10246 16 sept 2021 System food connected.
74	4.3.3	Shelf-life tests or adequate validation through microbiological, chemical and organoleptic evaluation, shall be carried out and consideration shall be given to product formulation, packaging, manufacturing and declared conditions. In accordance with this evaluation, the shelf-life shall be established.	A	
75	4.3.4	A procedure shall be in place to ensure that labelling complies with current legislation of the destination country/ies and customer requirements.	A	Labels checked : boterhamworst, snijworst, vet met zonder zwoerd.
76	4.3.5	Recommendations for preparation and/ or use of food product instructions shall be established, where appropriate.	A	
77	4.3.6	The company shall demonstrate through studies and/ or perform relevant tests to validate nutritional information or claims which are declared on labelling, throughout the shelf life of the products.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
78	4.3.7	In the event of changes to process characteristics or product formulation, including rework and/or packaging materials, the company shall ensure that the food safety and product quality requirements are complied with. Labelling shall be reviewed and adapted when necessary.	A	
79	4.4.1	The company shall control purchasing processes to ensure that all externally sourced raw materials, semi-finished products, packaging materials and services, which have an impact on food safety and product quality, conform to defined requirements.	A	Purchasing process documentation checked : P-food 10026 29-10-2019 Purchase requirements P-NLfood 10555 24-01-2020 Puchase] Reliability, service, quality, cost, delivery, conformity, innovative, reaction time if problems occur. In system preferred suppliers
80	4.4.2	A procedure for the approval and monitoring of suppliers (internal and external) shall be in place. The approval and monitoring procedure shall contain clear assessment criteria, such as: - audits performed by an experienced and competent person - certificates of analyses - supplier reliability - complaints - required performance standards.	A	Purchasing procedure : P-food 10026 29-10-2019 Purchase requirements
81	4.4.3	The results from the supplier assessments shall be reviewed regularly and this review shall be justified by risk assessment. Records of the reviews and the consequential actions of assessment shall be documented.	A	Last supplier's assessment :29-01-2021 (meat, packing, additives)

N°	Reference	IFS requirement	Evaluation	Explanation
82	4.4.4	The purchased raw materials, semi-finished products and packaging materials shall be checked in accordance with the existing specifications and, justified by risk assessment, for their authenticity. The schedule of these checks shall take into account, at a minimum, defined food safety and product quality risks. The frequency and/or scope of sampling shall be based on: - the impact of the raw materials, semi-finished products and packaging materials on the finished product - the supplier's status.	A	
83	4.4.5	The purchased services shall be checked in accordance with the existing specifications. The schedule of these checks shall take into account, at a minimum: - the defined service requirements - the supplier's status (according to its assessment) - the impact of the service on the finished product.	A	Purchased services checked risk based described in NL-F00d-10155 13-04-2021 Transport is performed by another company of the Vion group, audited regulary and a test regime (agar tests) is part of the checks and control system. Purchased service checked : (cleaning) 29-01-2021 contract 22-03-2017 clothes contract 26-9-2016 (lab) 29-01-2021 contract 31-3-2020 distrifresh 7-1-2021
84	4.4.6	Where a company outsources part of product processing and / or primary packaging and/or labelling, the company shall have it documented in the food safety and quality management system and ensure control over such processes to guarantee that food safety and product quality are not compromised. Control of such outsourced processes shall be identified and documented. When required by the customer, there shall be evidence that he has been informed and has agreed to such outsourced process.	A	For drying of sausages a location was rented in the near of Vion location Groenlo named Lichtevoorde. All checks and proces control is manged by colleages of loaction Groenlo together with employees of Encebe, reported to Q manager of manager Encebe. Seen records, ok NVWA 27-07-2021 audit location Lichtevoorde: Lichtevoorde EG 287 Storage and transport was included in the HACCP analyses. Seen record 16-07-2021 of dispatch checks and Pre SSOP 25-06-2021

N°	Reference	IFS requirement	Evaluation	Explanation
85	4.4.7	A written agreement shall be in place, covering the outsourced processes and describing any arrangements made in connection with it, including in-process controls, sampling and analyses.	A	
86	4.4.8	The company shall approve the supplier of the outsourced processes through: - certification against IFS Food or other GFSI recognised food safety certification standard or - documented supplier audit, performed by an experienced and competent person, which shall include, at a minimum, requirements for food safety, product quality, legality and authenticity.	A	Audit location "Lichtevoorde" has been performed 02-07-2021: all ok
87	4.5.1	Based on hazard analysis, assessment of associated risks and intended use, the company shall define the key parameters for the packaging materials in detailed specifications complying with the current relevant legislation and other relevant hazards or risks. The company shall check and verify the suitability and existance of functional barrier(s) of the consumer unit packaging material for each relevant product tests/analysis such as: - organoleptic tests - storage tests - chemical analyses - migration test results.	A	The packing materials types for finished products are : plastic packaging like trays/scales with foil, MAP, sealed foil packs (consumer & BtoB), vacuum packed, crates with innerbag, crates with product folded in foil. Casings to produce sausage is also seen as primary packaging and tins for B toB (sterilised products) The suppliers are GFSI certified for BRCGS Packaging / FSSC22000-ISO-TS22002-4 pack. In case not, from these suppliers filled out questionnair is on file.
88	4.5.2	For all packaging materials which could have an impact on products, certificates of conformity shall exist which attest conformance with legal requirements. In the event that no specific legal requirements are applicable, evidence shall be available to demonstrate that packaging materials are suitable for use. This applies for packaging materials which could have an influence on raw materials, semi-finished and finished products	A	

N°	Reference	IFS requirement	Evaluation	Explanation
89	4.5.3	The company shall ensure that the used packaging and labelling corresponds to the product being packed and comply with agreed customer product specifications. This shall be regularly checked and documented.	A	
90	4.6.1	The company shall investigate the extent to which the factory environment (e.g. ground, air) may have an adverse impact on food safety and product quality. Where it is established that product safety and/or quality could be compromised, appropriate control measures shall be implemented. The effectiveness of the implemented measures shall be periodically reviewed (e.g. extremely dusty air, strong smells).	A	The site is located in an industrial area. No invfluence of other industry was seen. The conditions of extenal earas are well maintained, fits to the company activities.
91	4.7.1	All external areas of the factory shall be clean, tidy and maintained in good condition. Where natural drainage is inadequate, a suitable drainage system shall be installed.	A	
92	4.7.2	Outdoor storage shall be kept to a minimum. Where goods are stored outside, it shall be justified by risk assessment to ensure that there are no contamination risks or adverse effects on food safety and quality.	A	
93	4.8.1	A site map covering all buildings of the facility shall be available. Plans shall be in place that clearly describe the process flows of: - finished products - packaging materials - raw materials - personnel - waste - water	A	

N°	Reference	IFS requirement	Evaluation	Explanation
94	4.8.2	The process flow, from receipt of goods to dispatch, shall be established, reviewed and where necessary, modified to ensure that the microbiological, chemical and physical contamination risks of raw materials, packaging material, semi-finished and finished products are avoided. The cross-contamination risks shall be minimised through effective measures.	A	The building is constructed/adapted for food handling and is well maintained. The process flow, from receipt of goods to dispatch, are logically designed to avoid sufficient separation between flows to prevent contamination risks. High risk area has a separate entry, dedicated to secure the high sensitive area. Chemicals are stored separate, no contamination risk. Product containing allergens are stored in a separate area in cell 150 also Vega rm is stored separate. Dirty / used material and equipment is stored in washing area as soon as possible also to avoid contamination risk. Good control was seen.
95	4.8.3	In the case of areas sensitive to microbiological, chemical and physical risk(s) which is/are justified by risk assessment, they shall be designed and operated to ensure product safety is not compromised.	A	
96	4.8.4	Laboratory facilities and in-process controls shall not affect product safety.	A	
97	4.9.1.1	Premises where food products are prepared, treated, processed and stored shall be designed and constructed to ensure food safety.	A	The site's premises are in basic condition designed and constructed, in basic maintained, easy to be cleaned, suitable for the specific processes to ensure food safety.
98	4.9.2.1	Walls shall be designed and constructed to prevent the accumulation of dirt, reduce condensation and mould growth, and facilitate cleaning.	A	
99	4.9.2.2	The surfaces of walls shall be in good condition and easy to clean; they shall be impervious and wear-resistant to minimise product contamination risks.	A	
100	4.9.2.3	The junctions between walls, floors and ceilings shall be designed to facilitate cleaning.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
101	4.9.3.1	Floor covering shall be designed to meet production requirements and shall be in good condition and easy to clean. Surfaces shall be impervious and wear-resistant.	A	
102	4.9.3.2	The hygienic disposal of water and other liquids shall be ensured. Drainage systems shall be easy to clean and designed to minimise the product contamination risks (e.g. entry of pests, areas sensitive to transmission of odour or contaminants).	A	
103	4.9.3.3	Water or other liquids shall reach drainage, using appropriate measures without difficulties. Puddles shall be avoided.	A	
104	4.9.3.4	In food handling areas, machinery and piping shall be arranged so that waste water, if possible, to flow directly into a drain.	A	
105	4.9.4.1	Ceilings (or, where no ceilings exist, the inside of roofs) and overhead fixtures (including piping, cableway, lamps etc.) shall be constructed to minimise the accumulation of dirt and condensation and shall not pose any physical and/or microbiological contamination risks.	C	The sealant seams on the ceiling of the dough preparation containing moulds.
106	4.9.4.2	Where false ceilings are used, an access to the vacant area shall be provided in order to facilitate cleaning, maintenance and inspections for pest control.	A	
107	4.9.5.1	Windows and other openings shall be designed and constructed to avoid the accumulation of dirt and shall be maintained in good condition.	A	
108	4.9.5.2	Where there are contamination risks, windows and roof glazing shall remain closed and fixed during production.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
109	4.9.5.3	Where windows and roof glazing are designed to be opened for ventilation purposes, they shall be fitted with easily removable, good condition pest screens or other measures to avoid any contamination.	NA	No such roof glazing used
110	4.9.5.4	In areas where unpackaged products are handled, windows shall be protected against breakage.	A	
111	4.9.6.1	Doors and gates shall be in good condition and easy to clean. They shall be constructed of non-absorbent materials to avoid: - splintering parts - flaking paint - corrosion.	C	Reception goods at Cell 112, a tear of about 10 cm was seen in the door jamb and on top of the gate the sealant was torn apart from the overhead beam. Previous audit also a damaged door was seen. Re-occurrence.
112	4.9.6.2	External doors and gates shall be constructed to prevent the access of pests; they shall be self-closing, unless non-essentiality is justified by risk assessment.	C	Gate connected to cell 150 was not protected against access of pests as teh protective tarp was partly removed. Also a lot of autumn leaves were found behind the 2nd gate. This means that both gates were opend at the same time which is not the intention of a lock room
113	4.9.6.3	Plastic strip curtains, separating the internal areas shall be in good condition and easy to clean.	A	
114	4.9.7.1	All production, storage, receipt and dispatch areas shall have adequate levels of light.	A	
115	4.9.8.1	Adequate natural and/or artificial ventilation shall be in place in all areas.	A	
116	4.9.8.2	If ventilation equipment is installed, filters and other components shall be easily accessible and checked, cleaned or replaced as necessary.	A	
117	4.9.8.3	Air conditioning equipment and artificially generated airflow shall not compromise product safety and quality.	C	Rust was detected on condensor of cell 105 and also beginnin of rust on condensor cell 130.

N°	Reference	IFS requirement	Evaluation	Explanation
118	4.9.8.4	Dust extraction equipment shall be installed in areas where considerable amounts of dust are generated.	NA	No dust extraction
119	4.9.9.1	Water which is used as an ingredient in the production process, or for cleaning, shall be of potable quality at the point of use and supplied in sufficient quantity; this also applies to steam and ice used within the production area.	A	• Potable water is sourced from the city mains • The potable water is checked, the plan of analysis includes several analyses such as colour, odour, taste, turbidity, TPC 22 C, E coli, Entero coccen: 4x year 1 sample, all ok Ice: TPC and Entero's 1 x year, but last year THT analyses of self produced ice: 8 day's < 2 Entero's: ok. (procedure says ice: THT 5 days) • Analyses performed by an external accredited laboratory
120	4.9.9.2	Recycled water which is used in the process, shall not pose a contamination risks.	A	No recycled water in use
121	4.9.9.3	The quality of water (including recycled water), steam or ice shall be monitored following a sampling plan on hazard analysis and assessment of associated risks.	A	
122	4.9.9.4	Non-potable water shall be transported in separate, properly marked piping. Such piping shall neither be connected to the drinking water system nor allow the possibility of reflux, to avoid contamination of potable water sources or factory environment.	A	
123	4.9.10.1	The quality of compressed air that comes in direct contact with food or primary packaging material shall be monitored based on hazard analysis and assessment of associated risks. If gases are used, they shall demonstrate adequate safety and quality through a declaration of compliance and shall be suitable for the intended use.	A	• No compressed air is used with direct contact with food or primary packaging material. • Gases which come in direct contact with food or primary packaging materials are part of the hazard analysis and assessment of associated risks Procesbeheersplan 17-9-2021 P -NCB NL 10027 • Declaration of compliance of used gases checked : Stikstof 6-11-2019 Foodgrade EU 231/2012
124	4.9.10.2	Compressed air shall not pose contamination risks.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
125	4.10.1	Based on hazard analysis and assessment of associated risks, cleaning and disinfection schedules shall be available and implemented. These shall specify: - objectives - responsibilities - the products used and their instructions for use - dosage of cleaning and disinfection chemicals - the areas to be cleaned and/ or disinfected - cleaning and disinfection frequency - documentation requirements - hazard symbols (if necessary).	A	• Cleaning is performed by third-party service provider Description of the cleaning and desinfection procedures, CIP (only for the washing machine), manual cleaning of rooms and equipment. • Cleaning and desinfection schedules checked : Bestek 14-08-2020
126	4.10.2	Cleaning and disinfection shall result in effectively cleaned premises, facilities and equipment. Defined methods shall be adequately implemented, documented and monitored.	C	The computer cabin of the cutter was found dirty inside. This must be cleaned by own employees and is not outsourced to A projects is running on improvement of cleaning by "own" employees.
127	4.10.3	Monitoring records for cleaning and disinfection shall be available.	A	
128	4.10.4	Only qualified personnel shall be allowed to undertake cleaning and disinfection. The personnel shall be trained and retrained to carry out the cleaning and disinfection schedules.	A	
129	4.10.5	The effectiveness of the cleaning and disinfection measures shall be verified and justified by risk assessment. The verification shall be based on an appropriate sampling schedule and shall consider: - visual inspection - rapid testing - analytical testing methods. Resultant corrective actions shall be documented.	C	Verification of cleaning activities was not always fully conform procedure: - Periodic cleaning activities were not demonstrably verified after perfomance of this cleaning activity. - The effectiveness check of cleaning by rodac plates (TPC), was not always effective. Seen some samples scoring red / not good (TPC>90 5cm2) were not re-sampled inmediate the next week as they thould (as descibed in the procedure)
130	4.10.6	Cleaning and disinfection schedules shall be reviewed and modified, in the event that changes occur products to products, processes or cleaning and disinfection equipment, if necessary.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
131	4.10.7	The intended use of cleaning and disinfection utensils shall be clearly identified. Cleaning and disinfection utensils shall be used in a way that avoids contamination.	A	
132	4.10.8	Safety Data Sheets and instructions for use shall be available for chemicals and cleaning and disinfection agents. Personnel responsible for cleaning and disinfection shall be able to demonstrate their knowledge of such instructions, which shall always be available on site.	A	Safety Data Sheets checked : 8-4-2-20 17-7-18 26-10-2016
133	4.10.9	Cleaning and disinfection chemicals shall be clearly labelled, used and stored appropriately, to avoid contamination.	A	Cleaning chemicals storage was found in good condition: In cell 150 storage of chemicals was stored separate in this closed location
134	4.10.10	Cleaning and disinfection activities shall be carried out in periods of non-production. If this is not possible, these operations shall be controlled in order not to affect the products.	A	
135	4.10.11	Where a company hires a third-party service provider for cleaning and disinfection activities, all requirements specified above shall be clearly defined in the service contract.	A	The areas and objects are to be cleaned and disinfected by a third party service provider Bestek 14-08-2020
136	4.11.1	A waste management procedure shall be in place to avoid cross contamination.	A	Waste management procedure : P-food-10021 9 -10-2020
137	4.11.2	All local legal requirements for waste disposal shall be met.	A	
138	4.11.3	Food waste and other waste shall be removed as quickly as possible from areas where food is handled. The accumulation of waste shall be avoided.	A	
139	4.11.4	Waste collection containers shall be clearly marked, suitably designed, in a good state of repair, easy to clean, and where necessary disinfected.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
140	4.11.5	If a company decides to separate food waste and to reintroduce them into the feed supply chain, adequate measures or procedures shall be implemented to prevent a contamination or deterioration of this material.	NA	No food waste re-introduced into the feed supply chain
141	4.11.6	Waste shall be collected in separate containers in accordance with the intended means of disposal. Such waste shall be disposed by authorised third parties only. Records of waste disposal shall be kept by the company.	A	
142	4.12.1	The products being processed shall be protected against physical contamination, which includes but is not limited to: - environmental contaminants - oils or dripping liquids from machinery - dust spills. Special consideration shall also be given to product contamination risks caused by: - equipment and utensils - pipes - walkways - platforms - ladders. If, for technological characteristics and/or needs, it is not possible to protect the products, appropriate control measures shall be defined and applied.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
143	4.12.2	KO N° 6 Based on hazard analysis and assessment of associated risks, procedures shall be in place to avoid contamination with foreign material. Contaminated products shall be treated as non-conforming products.	A	• Metaldetection are placed in line: producing sausages, packing sliced products • Foreign material detectors not defined as CCP but as CP: For the removal of potential foreign bodies metal detectors are in place at the end of each packaging line and in line during stuffing sausages. Department "Worstmakerij" (0.8 mm Fe, 1.2 mm, non-Fe, and 2.4 mm SS), Department "Industrial" (2.0 mm Fe, 2.5 mm, non-Fe, 3.0 mm SS) Department "slice" (1.2 mm Fe, 2.4 mm non-Fe, and 3.2 mm SS), The frequency of testing is depending on type of produc/place in the process, variating from 4x/day until 1/hour by using test pieces according the accuracies described.
144	4.12.3	Where metal and/or other foreign material detectors are required, they shall be installed to ensure maximum efficiency of detection in order to avoid subsequent contamination. Detectors shall be subjected to regular maintenance to avoid malfunction.	A	
145	4.12.4	The adequate accuracy of all equipment and methods designed to detect and/or eliminate foreign material, shall be specified. Functionality checks of such equipment and methods shall be carried out regularly. In case of malfunction or failure, corrective actions shall be defined, implemented and documented.	A	
146	4.12.5	Potentially contaminated products shall be isolated. Access and actions for the further handling or checking of these isolated products shall be carried out only by authorised personnel according to defined procedures. After this check, contaminated products shall be treated as non-conforming products.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
147	4.12.6	In areas where raw materials, semi-finished and finished products are handled, the use of glass and/or brittle materials shall be excluded; however where the presence of glass and/or brittle materials cannot be avoided, the risks shall be controlled and the glass and/or brittle materials shall be clean and pose no risks to product safety.	A	
148	4.12.7	Based on hazard analysis and assessment of associated risks, preventive measures shall be in place for the handling of glass packaging, glass containers or other kinds of containers in the production process (turn over, blow, rinse, etc.). After this process step there shall be no further contamination risks.	NA	No glass packing
149	4.12.8	Procedures shall be in place describing the measures to be taken in case of glass breakage and/or brittle material. Such measures shall include identifying the scope of goods to be isolated, specifying authorised personnel, cleaning the production environment and releasing the production line for continued production.	A	
150	4.12.9	Breakages of glass and brittle material shall be recorded. Exceptions shall be justified and documented.	A	
151	4.12.10	Where visual inspection is used to detect foreign materials, the employees shall be trained and operative changes shall be performed at an appropriate frequency to maximise the effectiveness of the process.	A	Before stuffing casings with salted meat products, the meat pieces are checked on little bones, to cut away. During preparing bacon (fat) for usage "leverkaas" the product is checked for e.g. blood pieces, thickness, during weighing meat before cutting, the meat is checked during this process on foreign body like plastic pieces. All these checks are trained by training on the job: laid down in a skill matrix. In this matrix deviations are shown between "starter" (1) and fully experienced employee (5) yearly checked by responsible manager. Performance of these checks are recorded if needed in the SSOP list.

N°	Reference	IFS requirement	Evaluation	Explanation
152	4.12.11	In areas where raw materials, semi-finished and finished products are handled, the use of wood shall be excluded; however where the presence of wood cannot be avoided, the risks shall be controlled and the wood shall be clean and pose no risks to product safety.	A	
153	4.13.1	Site infrastructure and operations shall be designed and built to prevent pest infestation.	A	
154	4.13.2	The company shall have adequate pest control measures in place which shall be in compliance with local legal requirements and shall take into account, at a minimum: - factory environment (potential pests) - type of raw material/finished products - site plan with area for application (bait map) - constructional designs susceptible for pest activity, such as ceilings, cellars, pipes, corners - identification of the baits on site - responsibilities, in-house/ external - agents used and their instructions for use and safety - frequency of inspections - rented storage if applicable. The pest control measures shall be based on hazard analysis and assessment of associated risks.	A	• Pest control is managed by : 8x year • Frequency and kind of checks: For rodents (rats and mice) and insects (cockroaches and flying insects); frequency of control is 8 x / year; maintenance of EFK is 4 x / year. Assessment on the Pest control system and a Pest risk inventory 1x / year (Frequency of the in-depth pest control survey is risk based and accepted) • No pest detection like mice pr rats, only a few flies, but no investation. Pest control is contracted to (central) Seen report 17-09-2021, actions are demonstrably solved. For this year this survey is planned for next week. All documentation is present in the contract map of (digital revised 8-9-2020). Up to date site plans are available to show the location of rodent baits, mouse traps, crawling and flying insect control units. Constructional action points are solved. Only Non-Tox is used. Trends over 2020 ytd. show no signs of rodent. Good control seen. Visit report 24-01 2020 seen and last inspection of 14 Sept 2020. Inspector valid EVM license until 08-2022, 19-08-2021 Inspection report (partly outsourced: Location Ilchtevoorde: last check by 18-8-2021, only fly detected, no rats and mice. No Investation freq 8x year icense until 21-1-23

N°	Reference	IFS requirement	Evaluation	Explanation
155	4.13.3	Where a company hires a third-party service provider for pest control, all requirements specified above shall be clearly defined in the service contract. A person at the company shall be appointed and trained to monitor the pest control measures. Even if the pest control service is outsourced, responsibilities for the necessary actions (including ongoing supervision of pest control activities) shall remain within the company.	A	
156	4.13.4	Pest control inspections and resulting actions shall be documented. Implementation of actions shall be monitored and recorded. Any infestation shall be documented and control measures taken.	A	
157	4.13.5	Baits, traps and insect exterminators shall be fully functioning, sufficient in number, designed for purpose, placed in appropriate positions and used in a way that avoids any contamination risks.	A	
158	4.13.6	Incoming deliveries shall be inspected on arrival for the presence of pests. Any findings shall be recorded.	A	
159	4.13.7	The effectiveness of the pest control measures shall be monitored, including trend analysis, to allow timely appropriate actions. Records of this monitoring shall be available.	A	
160	4.14.1	All incoming goods, including packaging materials and labels, shall be checked for conformity against specifications and a determined inspection plan. The inspection plan shall be justified by risk assessment. Records of those inspections shall be available.	A	Incoming goods inspection plan : Meat: all receipt batches are checked visually and on temperature (CCP) Micro checks following sampling plan 2020, only from "not vion raw material" .Of incomming batches of Vion sites the micro analyses of the producing sites are shared with Encebe.

N°	Reference	IFS requirement	Evaluation	Explanation
161	4.14.2	The storage conditions of raw materials, semi-finished, finished products and packaging materials shall correspond to product specification and shall not have any negative impact on other products.This shall be defined in an implemented and maintained system.	A	System in place : Dry raw materials are stored in cell 150 (ambient). allergen containing RM are stored separate also vegen ingredients are stored on a special location in this cell. Meat products are stored chilled or froen, depending on type product, also Finished products can be stored chilled or frozen. All products are scanned (barcode) when used/re-placed.
162	4.14.3	Raw materials, packaging, semi -processed, finished products shall be stored so as to minimise the contamination risks or other negative impact.	A	
163	4.14.4	Appropriate storage facilities shall be available for the management and storage of working materials, process aids, and additives. The personnel responsible for the management of storage facilities shall be trained.	A	
164	4.14.5	All products shall be clearly identified. Use of products shall be undertaken in accordance with the principles of First In/ First Out and/ or First Expired/ First Out.	A	This was checked for: chemicals, raw materials used for vegan production, spices for dryed sausages.
165	4.14.6	Where a company hires a third-party storage service provider, the service provider shall be certified against IFS Logistics or any other GFSI recognised certification standard covering the respective scope of activity. If not, all relevant requirements equivalent to the company's own storage practices shall be fulfilled and this shall be clearly defined in the respective contract.	A	
166	4.15.1	The conditions inside the vehicles, such as: - absence of strange smells - high dust load - adverse humidity - pests - mould shall be checked before loading and documented to ensure compliance with the specified conditions.	A	Conditions of the trucks are checked before loading. This was checked for: 20-09-2021

N°	Reference	IFS requirement	Evaluation	Explanation
167	4.15.2	Where goods are transported at certain temperatures, the temperature inside the vehicles shall be checked and documented before loading.	A	
168	4.15.3	Procedures to prevent contamination during transport, including loading and unloading, shall be in place. Different categories of goods (food/ non-food) shall be taken into consideration, if applicable.	A	
169	4.15.4	Where goods are transported at certain temperatures, maintaining the adequate range of temperatures during transport shall be ensured and documented.	A	
170	4.15.5	Adequate hygiene requirements for all transport vehicles and equipment used for loading/unloading (e.g. hoses of silo installations) shall exist. Measures taken shall be recorded.	A	
171	4.15.6	The loading/unloading area shall be appropriate for its intended use. They shall be constructed in a way that: – the risks of pest intake is mitigated – products are protected from adverse weather conditions – accumulation of waste is avoided – condensation and growth of mould are prevented – cleaning can be easily undertaken.	A	
172	4.15.7	Where a company hires a third-party transport service provider, the service provider shall be certified for IFS Logistics or any other GFSI recognised certification standard covering the respective scope of activity. If not, all relevant requirements equivalent to the company's own transport practices shall be fulfilled and this shall be clearly defined in the respective contract.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
173	4.16.1	An adequate maintenance plan shall be in place, maintained and documented, that covers all critical equipment (including transport) for compliance with product requirements. This applies both to internal maintenance activities and service providers. The plan shall include responsibilities, priorities and due dates.	A	Maintenance plan was seen in , no specific date, adjustments /version is an ungoing process.
174	4.16.2	Product requirements and prevention of contamination shall be ensured during and after maintenance and repair work. Records of maintenance and repair work shall be kept.	A	
175	4.16.3	All materials used for maintenance and repair shall be fit for the intended use and shall not pose contamination risks.	A	
176	4.16.4	Failures and malfunctions of plant and equipment (including transport) that are essential for food safety and quality, shall be identified, documented and reviewed to enable prompt actions and to improve the maintenance plan.	A	
177	4.16.5	Temporary repairs shall be carried out not to compromise food safety and product quality. Such work shall be documented and a short-term deadline set for eliminating the issue.	A	
178	4.16.6	Where a company hires a third-party maintenance and repair service provider, all the company specified requirements regarding material, equipment and operational rules shall be clearly defined, documented and maintained in the service contract, to prevent any product contamination.	A	
179	4.17.1	Equipment shall be suitably designed and specified for the intended use. Before commissioning, it shall be verified that the product requirements are complied with.	A	Equipment checked : This was checked for the weber slicing machine incl. the belts and snaresof line 5 HC, spec. and DOC 05-01-2015

N°	Reference	IFS requirement	Evaluation	Explanation
180	4.17.2	For all equipment and utensils with direct food contact, a certificate of conformity shall be in place, which confirms compliance with legal requirements. In case no specific legal requirements are in place, evidence shall be available, such as: - certificate of conformity - technical specifications - manufacturer's self-declaration to demonstrate that they are suitable for the intended use.	A	
181	4.17.3	Equipment shall be located to allow effective cleaning and maintenance operations.	A	
182	4.17.4	The company shall ensure that all product equipment is in a condition that shall not compromise food safety and product quality.	A	
183	4.17.5	The company shall ensure that in the event of changes to equipment, the process characteristics are reviewed in order to assure that the product requirements, as agreed with customers, are complied with.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
184	4.18.1	KO N° 7: A traceability system shall be in place that enables the identification of product lots and their relation to batches of raw materials and primary packaging materials. The traceability system shall incorporate all relevant records of: - receipt - processing - use of rework - distribution. Traceability shall be ensured and documented until delivery to the customer.	C	• The traceability system : •During the IFS Assessment a vertical audit / product trail was performed for a product initiated by the auditor: Snijworst art 301320 sliced 14-07-2021 for on line 5 in packages grams. No rework was used, vliesvlees, zwoerd, peeseind, buikranden frozen, bactoflavor, herbs and spices, redbeet, wood to smoke, (casing), clips, lussen (rope), top and bottom foil: specifications, DOC's and checks on reception of these products were assessed. ok The kg's of raw materials were broadlv taken, which resulted in a plus of g's on kg FP. This should be tighter also because you expected to have less kg's because of drying of the product. No rework was used. Th related checks and documents incl. data the traceability was demonstrated succesfully from finished product to raw materials and vice versa. CCP's and CP were checked for and recorded incl weight control (e weight).
185	4.18.2	The traceability system shall be tested on a periodic basis, at least annually and each time the traceability system changes. The test samples shall represent the complexity of the company´s product range. The test records shall verify upstream and downstream traceability (from delivered products to raw materials, and vice versa). The traceability of the finished product shall be performed within four (4) hours maximum.	A	The last traceability test performed by the company was done on 12-2-21, Salami 10014
186	4.18.3	Test results, including the timeframe for obtaining the information, shall be recorded and where necessary appropriate actions shall be taken. Timeframe objectives shall be defined and be in compliance with customer requirements.	A	
187	4.18.4	The traceability system shall identify the relationship between batches of final products and their labels.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
188	4.18.5	Traceability shall be ensured at all stages, including work in progress, post treatment and rework.	A	
189	4.18.6	Labelling of semi-finished or finished product lots shall be made at the time when the goods are directly packed to ensure a clear traceability of goods. Where goods are labelled at a later time, the temporarily stored goods shall have a specific lot labelling. Shelf life (e.g. best before date) of labelled goods shall be established using the original production batch.	A	
190	4.18.7	If required by the customer, identified representative samples of the manufacturing lot or batch number shall be stored appropriately and kept until expiration of the "Use by" or "Best before" date of the finished product and if necessary, for a determined period beyond this date.	A	
191	4.19.1	Raw material specifications that identify allergens requiring declarations relevant to the country of sale of the finished products shall be available. The company shall maintain a continuously up-to-date listing of all raw materials containing allergens used on the premises. This shall also identify all blends and formulas to which such raw materials containing allergens are added.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
192	4.19.2	Based on hazard analysis and assessment of associated risk, preventive and control measures shall be in place from receipt to dispatch, to ensure that potential cross contamination of products by allergens is minimised. The potential cross contamination risks related to: - environment - transport - storage - raw materials shall be considered. Control measures shall be verified.	A	• Allergen risk assessment and verification : In the basic HACCP analyses included but re-assessed and verified: Validation report 11-9-2020 • Identifed allergens are: Lactose (milk), mustard, egg, gluten, soy • Preventive and control measures in place to ensure cross contamination is minimised *Crosslist/ processtep defined risk on cross* contamination in validation report described.including control measures like cleaning, intensive vet cleaning *Vital tests based, worse case recipes,* a product change procedure incl. checklist made (tabel) on which product turn over the line has to be cleaned in between, good control was seen.
193	4.19.3	Finished products containing allergens that require declaration shall be declared in accordance with legal requirements. Accidental or technically unavoidable cross-contaminations of legally declared allergens and traces shall be labelled. The decision shall be based on a hazard analysis and assessment of associated risks. The potential cross-contamination with allergens from raw materials processed in the company shall also be taken into account on the product label.	A	
194	4.20.1	The responsibilities for a food fraud vulnerability assessment and mitigation plan shall be clearly defined. The responsible person(s) shall have the appropriate specific knowledge and have the full commitment *from the senior management.*	A	

N°	Reference	IFS requirement	Evaluation	Explanation
195	4.20.2	A documented food fraud vulnerability assessment shall be undertaken on all raw materials, ingredients, packaging materials and outsourced processes, to determine the risks of fraudulent activity in relation to substitution, mislabelling, adulteration or counterfeiting. The criteria considered within the vulnerability assessment shall be defined.	A	The company conducted a vulnerability assessment: Yes Raw material groups/ product groups identified: 3 Meat Beef Organic / Fairtrade Pork Organic / Fairtrade Species Claim Poultry Organic / Fairtrade 10 Spices Others: specific bio spices like pepper etc. Organic / Fairtrade Description why the identified raw materials are vulnerable to food fraud: The result of the assessment was that trough all meassures taken, at the end no raw material was identified to be sensitive to vulnerabilty Explanation which criteria were selected: e. g. criteria as costs, easability to vulnerate, traters or direct producers, history of known cases of vulnerability for specific type of product, reliability supplier (delivery history) Details of the assessment: Asssessment performed by HQ Vion, revieuw min. annually, good control was seen Further explanation: Vulnerable assessments: Procedure: P-NCB-NL-10237 22-07-2020: packing materials also included P-NCB-NL -10238 22-09-2021
196	4.20.3	A documented food fraud mitigation plan shall be developed, with reference to the vulnerability assessment, and implemented to control any identified risks. The methods of control and monitoring shall be defined and implemented.	A	Mitigation plan last review : No mitigation plan as the products were not asessed as sensitive for adulteration. Assessed were e.g. broaker, delivery quality, duration of business relationship, delivery quality (history)= chain score... chance of discovery, potential for forgery > 50 control measures No food fraud vulneral raw materials were identified.
197	4.20.4	The food fraud vulnerability assessment shall be regularly reviewed, at least annually, and/or in the event of increased risks. If necessary, the food fraud mitigation plan shall be revised/updated accordingly.	A	Last review of the Food fraud risk assessment : 22-9-2021

N°	Reference	IFS requirement	Evaluation	Explanation
198	5.1.1	KO N° 8: The company shall have an effective internal audit program in place which shall cover at least all the requirements of the IFS Standard. Scope and frequency of internal audits shall be determined and justified by risk assessment. The internal audit program shall also apply to off-site storage locations owned or rented by the company.	A	Internal audit reports checked : 31-08-2021 and 20-05-2021 genal product site assessments Encebe announced and unannounced Audit Lichtenvoorde (rented are for partly outsourced proces) July 2021. Yearly selve assessment against all IFS requirements, Aug 2021
199	5.1.2	Internal audits of activities, which are critical to food safety and product quality, shall be carried out at least once a year.	C	The following activities are identified as critical to the food safety and product quality All KO requirements of IFS are audited min. 1 x year., the CCP 5 sterilisation temp was not demonstrably checked for in the 2 last audits, so this was > 1 year ago, since audited for. As 1 of the 2 audits always announced is, these activities should be plannned so assessment is possible.
200	5.1.3	The auditors shall be competent and independent from the audited department.	A	
201	5.1.4	Internal audit results shall be communicated to the senior management and to persons responsible for the concerned activities. Necessary corrective actions and a schedule for implementation shall be determined, documented and communicated to the relevant person. All corrective actions resulting from the internal audits shall be verified.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
202	5.2.1	Site and factory inspections shall be planned and carried out for topics such as: - constructional status of production and storage premises - external areas - product control during processing - hygiene during processing and within the infrastructure - foreign material hazards - personnel hygiene. The frequency of inspections shall be justified by risk assessment and be based on the history of previous experience.	A	• Site and factory inspections : On daily basis performed by QC employee. Records including pictures (and responsible person) on file, per day, verified after correction performed by QC employee. Good control was seen. • Sampled inspection checks: wk 12, 32, wk 21, wk 35 2021
203	5.3.1	The criteria for process and working environment validation and control shall be clearly defined. Where the control of process and working environment parameters (temperature, time, pressure, chemical properties, etc.) are essential to ensure the food safety and product quality requirements, such parameters shall be monitored and recorded continuously and/ or at appropriate intervals.	A	• Environmental monitoring parameters and limits defined by the company based on a risk assessment . • The following criteria were identified for validation of process and work environment : On weekly base a quart of the factory is swabbed: Listeria and Salmonella swabs (limit: absent) and TPC (30 degree, score system0 = good, to >30: realy bad)) records were seen. Sometimes Listeria or higher TPC, then extra samples are taken, it is not strucural. • The following work environment monitoring parameters were defined by the company: temperature conditions of the high risk area and CCP's pH of raw meat product, heating steps, seam test (on cans), carts on racks to check on sterilisation temp/time • Last process and work environment validation seen; records of all CCP's are logged on daily base, records are checked this audit . An overview of all swab results is seen (excell)
204	5.3.2	All rework operations shall be validated, monitored and documented. These operations shall not affect the food safety and product quality requirements.	A	During the IFS assessment use of rework was checked for rookworst schijfjes 89014 17-08-2021 Rework plan
205	5.3.3	Procedures shall be in place for prompt notification, recording and monitoring of equipment malfunction and process deviations.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
206	5.3.4	Process validation shall be performed using the collected data that is relevant for food safety and the processes. If substantial modifications occur, a re-validation shall be carried out.	A	
207	5.4.1	The company shall identify and record the measuring and monitoring devices required to ensure compliance with food safety and product quality requirements. Their calibration status shall be recorded. Measuring and monitoring devices shall be legally approved if required by legislation.	A	Clearly documented list is in place with overviews of all monitoring devices used within the company which was checkef for during the IFS assement Measuring and monitoring devices checked : Themometer C/EV/104 Freq. 1 x 2 months - last cal. 18-08-2021 (CCP1) Thermometer Cookingcabin 3 (pasteurisation CCP) 12-08-21 frq. 1x year CO2 O2 freq 1x 3 months 9-08-2021 (CP) high risk 5 30-07-2021 high risk Vloerschaal Exp 163-050 30-07-21 Stopper 4 metaldetection 17 -11-2020 Slice dep. samples 100 gr. weight calibrated high risk
208	5.4.2	All measuring devices shall be checked, adjusted and calibrated at specified intervals, with a monitoring system. This system shall be in accordance with defined, recognised standard/ methods and within relevant limits of the process parameters values. The results of the checks, adjustments and calibrations shall be documented.	A	Measuring and monitoring devices checked : Themometer C/EV/104 Freq. 1 x 2 months - last cal. 18-08-2021 (CCP1) Thermometer Cookingcabin 3 (pasteurisation CCP) 12-08-21 frq. 1x year CO2 O2 freq 1x 3 months 9-08-2021 (CP) high risk 30-07-2021 high risk Vloerschaal Exp 163-050 30-07-21 Stopper 4 metaldetection 17 -11-2020 Slice dep. samples 100 gr. weight calibrated high risk

N°	Reference	IFS requirement	Evaluation	Explanation
209	5.4.3	All measuring devices shall be used exclusively for their defined purpose. Where the results of measurements or the status of the device indicate a malfunction, the device in question shall be immediately repaired or replaced. Where necessary, corrections and corrective actions on processes and products shall be carried out.	A	
210	5.5.1	The company shall define compliance criteria to control lot quantity. A frequent and methodological strategy for quantity control shall be in place to meet legal requirements of the destination country/ies and customer specifications.	A	•Frequency and methodology of quantity checking: E weight and minimum weight systems are used. •Company uses "e" mark on packaging : Yes (consumer packing, sliced products)
211	5.5.2	Checks shall be implemented and recorded, according to a sampling plan which ensures a proper representation of the manufacturing lot. Results of these checks shall be compliant with defined criteria for all products ready to be delivered.	A	
212	5.6.1	Testing plans, for internal and external analysis shall be justified by risk assessment to ensure that product safety, quality, safety, legal and specific customer requirements are met. The plans shall cover topics, such as: - raw materials - semi-finished products, - finished products - packaging materials - contact surfaces of processing equipment - relevant parameters for environmental monitoring. All test results shall be recorded.	A	• No own laboratory on site •The following analyses are performed by an external laboratory Micro (pathogens and others) on final products and additives. Water analysis (see at other chapter), shelf life tests, allergen monitoring plan, PAK's, 1x 4 or 6 wk environmental monitoirngsplan (weekly). cleaning verification by rodac 1x 4 wks per department (it is not possible to type the all frequencies of all type of analysis in this report) KPI dashboard weekly review by QA team

N°	Reference	IFS requirement	Evaluation	Explanation
213	5.6.2	Analyses, which are relevant for food safety, shall preferably be performed by laboratories with appropriate accredited programs/ methods (ISO/IEC 17025). If the analyses are performed internally or by a laboratory without the appropriate accredited programs/ methods, the results shall be verified on a regular basis by laboratories accredited to these programs/ methods (ISO/IEC 17025).	A	Laboratory :
214	5.6.3	Procedures shall exist which ensure the reliability of the internal analyses results, based on officially recognised analysis methods. This shall be demonstrated by ring tests or other proficiency tests.	A	
215	5.6.4	Results of analyses shall be evaluated promptly by competent personnel. Appropriate corrective actions shall be undertaken for any unsatisfactory results. The analytical results shall be reviewed regularly in order to identify trends and, when necessary, corrective actions shall be taken.	A	
216	5.6.5	Where internal analyses or controls are undertaken, these shall be carried out in accordance with defined procedures by trained and approved personnel, in defined areas or laboratories, using appropriate equipment.	NA	In case of NA: No internal analyses, no own laboratory
217	5.6.6	For verification of the quality of the finished product, internal organoleptic tests shall be carried out regularly. These tests shall be in accordance with specifications and related to the impact on respective parameters of product characteristics. The results of these tests shall be documented.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
218	5.6.7	The testing plan shall be regularly reviewed and updated, based on results, changes to legislation or issues that may have an impact on product safety, quality or legality.	A	
219	5.7.1	A procedure for quarantine (blocking/hold) shall be in place that is justified by risk assessment. The procedure shall ensure that only raw materials, semi-finished and finished products and packaging materials conforming to product requirements, are processed and dispatched.	A	Product release procedure : P NCB-NL-10013 5 aug 2019
220	5.8.1	A procedure shall be in place for the management of product complaints and of any written notification from the competent authorities –within the framework of official controls-, any ordering action or measure to be taken when non-compliance is indetified.	A	•Compliant rate in 2020 is against in 2019. •Foreign materials identified. for ambient and fresh against in 2019 1E.g. mostly about bones, metal (not all granded) and plastic • Range or indicator of complaints raised by consumers, retailers and authorities separately. 2021 YTD: Food safety, integrity, last quarter, 1 bone, 1 crunch bone, 1 plastic 1x smelll: these coplaints were not split in the overvieu of the organization for consumers/retailers etc. 2020 this were 5x plastic in total... KPI 0,6/1000kg 2021 statys YTD: <0,6/1000kg. No complaints from authorities
221	5.8.2	All complaints shall be registered, readily available and assessed by competent staff. Where it is justified, appropriate actions shall be taken immediately.	A	Complaints samples checked : plastic piece in snijworst
222	5.8.3	Complaints shall be analysed with a view to implementing appropriate actions to avoid the recurrence of the non-conformity.	A	
223	5.8.4	The results of complaint data analysis shall be made available to the relevant responsible persons.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
224	5.9.1	A procedure shall be implemented and maintained for management of incidents and potential emergency situations with an impact on food safety, quality and legality. It shall include, at a minimum: - the decision making process - the nomination of a person, authorised by the company and permanently available, to initiate the incident management process in a timely manner - the nomination and training of an incident management team, - an up to date alert contact list including customer information, sources of legal advice, contacts availability, - a communication plan including authorities.	A	Withdrawal/recall procedure : P-NCB-NL_10023 1 sept 2021
225	5.9.2	KO N° 9: An effective procedure for the withdrawal and/or the recall of all products shall be in place. This procedure shall include a clear assignment of responsibilities and a comprehensive information policy for customers and consumers.	A	Number of withdrawals: 1 Reasons: Antibiotics / chemical residue detected in final product Number of recalls: 0 Further explanation: • Withdrawals cause : Ethyleenoxide in ginger powder was found 15-02-2021, used only in bio salami dried sausage kaliber 80: ppm was very low in finished product: NVWA contact resulted into a withdraw and no recall because of low % of Ethyleenoxide in FP, not exeeding the MRL in the finished product • No other food safety issue cause of recalls : • Last test : 15-02-2021
226	5.9.3	The procedures for management of incidents and product withdrawal/recall, shall be subject to regular internal testing, at least once a year. This test shall be carried out to ensure the effective implementation and operation of the full procedure and shall include the verification of the updated contact data.	A	

N°	Reference	IFS requirement	Evaluation	Explanation
227	5.10.1	A procedure shall be in place for the management of all non-conforming raw materials, semi-finished products, finished products, processing equipment and packaging materials. This shall include, at a minimum: - defined responsibilities - isolation/ quarantine procedures - risk assessment - identification including labelling - decision about the further usage like release, rework/post treatment, blocking, quarantine, rejection/disposal.	A	Procedure for non-conformities and nonconforming products : P NCB-NL-10013 5 aug 2019
228	5.10.2	The procedure for the management of non-conforming products shall be understood and applied by all relevant employees.	A	
229	5.10.3	Where non-conformities are identified, immediate actions shall be taken to ensure that food safety and product quality requirements are complied with.	A	
230	5.10.4	Finished products (including packaging) that are out of specifications shall not be placed on the market under the corresponding label, unless a written approval of the brand owner is available.	A	
231	5.11.1	A procedure shall be in place for the recording and analysis of non-conformities and non-conforming products, with the objective to avoid recurrences by preventive and/or corrective actions. This may include a root cause analysis.	C	• Procedure for corrective actions : P-Food-10018 9 juni 2015 Corrective actions are described in several instructions on CCP in case of deviations, but specific for that subject. No specific general corrective action procedure was availiable, only a procedure for non conforming products. Not clear described and proof seen on how deviations and corrective actions are analised to avoid recurrences

N°	Reference	IFS requirement	Evaluation	Explanation
232	5.11.2	KO N° 10: Corrective actions shall be clearly formulated, documented and undertaken as soon as possible to avoid the further occurrence of non-conformities. The responsibilities and the timescales for corrective actions shall be clearly defined.	C	• Samples chosen during the Assessment for the follow-up of the corrective actions: -Action point list Encebe 6-9-2021 -Hygiene rounds - Agar cleaning checks/ environmental checks - Corrective actions procedure P Vion 1001 15-2-2021 -Complaint list In Action point list Encebe several open actions were seen over due since half of july 2021, no specific reasons were given.
233	5.11.3	The effectiveness of the implemented corrective actions shall be assessed and the results of the assessment documented.	A	
234	6.1	The responsibility for the food defence plan shall be clearly defined. Those responsible shall have the appropriate specific knowledge and training, and have full commitment from the senior management.	A	
235	6.2	A food defence plan and procedure shall be developed based on probability and be implemented in relation to assessed threats. This shall include: - legal requirements - identification of critical areas and/or practices and policy of access by employees - visitors and contractors - all other appropriate control measures. The food defence plan shall be reviewed at least annually, and updated when appropriate.	A	• Food defence plan: A t/m K plan on several food defence points to be tested during the review (bullet points in the procedure. • Procedure : P-Food- 10051 16 juli 2019 • Annual review and last test. 05-06-2021
236	6.3	The test on the effectiveness of the food defence plan and the related control measures shall be included in the internal audit and the inspection plan.	A	
237	6.4	A documented procedure shall exist for managing external inspections and regulatory visits. Relevant personnel shall be trained to execute the procedure.	A	

ANNEX to the IFS Assessment report

List of key participants:

Assessment participants					
Name	**Position**	**Opening meeting**	**On-site assessment**	**Documenta-tion review**	**Closing meeting**
	General Manager	☑	☐	☑	☑
	Quality manager	☑	☑	☑	☑
	Quality	☑	☑	☑	☑
	PPD	☑	☑	☑	☐
	Service bureau	☑	☐	☐	☐
	Encebe 2	☑	☑	☑	☑
	HR	☑	☐	☑	☐
	QC	☐	☑	☑	☐
	Group Quality manager	☐	☐	☑	☑
	Production manager	☐	☑	☑	☑
	prod. management	☐	☐	☑	☑
	Sales	☐	☐	☑	☐
	Purchase	☐	☐	☑	☐
	Maintenance	☐	☐	☑	☐
	Quality	☐	☐	☑	☑
	Quality	☐	☐	☑	☑
	Salting	☐	☑	☐	☐
	Planning	☐	☐	☑	☐
	Dough + sausage preparation	☐	☑	☐	☐
	Reception raw materials	☐	☑	☐	☐
	High Care/ slicing and packing	☐	☑	☐	☐
	(production) employees	☐	☑	☐	☐

Product scopes

IFS Food product scopes	
1.	Red and white meat, poultry and meat products
2.	Fish and fish products
3.	Egg and egg products
4.	Dairy products
5.	Fruit and vegetables
6.	Grain products, cereals, industrial bakery and pastry, confectionary, snacks
7.	Combined products
8.	Beverages
9.	Oils and fats
10.	Dry goods, other ingredients and supplements
11.	Pet food

Technology scopes

IFS technology scope	IFS processing step – including processing/treating/manipulation/ storing		Technology oriented classification which also takes product risks into consideration
A	P1	Sterilisation (e.g. cans)	**Sterilisation (in final packaging) with the purpose to destroy pathogens** Sterilised (e.g. autoclaved) products in final packaging
B	P2	Thermal pasteurisation, UHT/aseptic filling, hot filling Other pasteurisation techniques e.g. high pressure pasteurisation, microwave	**Pasteurisation with the purpose to reduce food safety hazards (and UHT process)**
C	P3	Irradiation of food	**Processed products: treatment with purpose to modify products and/or extend the shelf life and/or reduce food safety hazards by preservation techniques and other processing techniques**
	P4	Preserving: salting, marinating, sugaring, acidifying/pickling, curing, smoking, etc. Fermentation, acidification	
	P5	Evaporation/dehydration, vacuum filtration, freeze drying, microfiltration (less than 10 µ mesh size)	Note—exception: Irradiation is attributed to this category although aimed for the destruction of microorganisms
D	P6	Freezing (at least –18°C/0°F) including storage quick freezing, cooling, chilling processes and respective cool storing	Systems, treatments to maintain product integrity and/or safety
	P7	Antimicrobial dipping/spraying, fumigation	Treatment with purpose to maintain the quality and/or integrity of the products including treatments to remove contamination and/or prevent contamination

IFS technology scope	IFS processing step – including processing/treating/manipulation/ storing		Technology oriented classification which also takes product risks into consideration
E	**P8**	Packing MAP, packing under vacuum	**Systems, treatments to prevent product contamination**
	P9	Processes to prevent product contamination esp. microbiological contamination, by means of high hygiene control and specific infrastructure during handling, treatment and/or processing e.g. clean room technology, "white room", controlled working room temperature for food safety purpose, disinfection after cleaning, positive air pressure systems (e.g. filtration below 10 µ)	P9 is applicable in any case when there are at least 2 procedures/methods implemented in a company to guarantee product safety/product hygiene e.g.: • disinfection of equipment + chilled room temperature (e.g. dissection of meat) • disinfection + special hygiene equipment for employees (e.g. hygiene sluice) • room with over-pressure + special hygiene equipment for employees (e.g. hygiene sluice), • air filtration + room with over-pressure
	P10	Specific separation techniques: e.g. filtration like reverse osmoses, use of active charcoal	
F	**P11**	Cooking, baking, bottling, brewing, fermentation (e.g. wine), drying, frying, roasting, extrusion, churning	**Any other manipulation, treatment, processing not being listed in A, B, C, D, E and not controlled as a CCP or as a control measure.**
	P12	Coating, breading, battering, cutting, slicing, dicing, dismembering, mixing/blending, stuffing, slaughtering, sorting, manipulation, packing, storing under controlled conditions (atmosphere) except temperature, labelling	
	P13	Distillation, purification, steaming, damping, hydrogenating, milling	

IFS Scoring System

Result	Explanation	Points
A	Full compliance.	20 points
B (point of attention)	Point of attention as it may lead to a future deviation.	15 points
C (deviation)	Part of the requirement is not implemented.	5 points
D (deviation)	The requirement is not implemented.	-20 points
Major (non-conformity)	A Major non-conformity can be given to any regular requirement (which is not defined as a KO requirement). Reasons for Major rating are: • There is a substantial failure to meet the requirements of the standard, which includes but is not limited to food safety and/or the legal requirements of the production and/or destination countries. • A process is out of control which might have an impact on food safety.	Major non-conformity will subtract 15% of the possible total amount; the certificate cannot be issued.
KO requirement scored with a D (non-conformity)	The requirement is not implemented.	KO non-conformity will subtract 50% of the possible total amount; the certificate cannot be issued.

Scoring and issue of certificate

Assessment result	Status	Action company	Report form	Certificate
Total score is ≥ 95%	Passed at IFS Food higher level following the receipt of the action plan	Send completed action plan within four (4) weeks of receiving the provisonal report.	Report including action plan provides status	Yes, certificate at higher level, 12-month validity. The certificate shall only be issued when the corrections are closed.
Total score is ≥ 75% and < 95%	Passed at IFS Food foundation level after receipt of the action plan	Send completed action plan within four (4) weeks of receiving the provisional report.	Report including action plan provides status	Yes, certificate at foundation level, 12 -month validity. The certificate shall only be issued when the corrections are closed.
Total score is < 75%	Not passed	Actions and new initial Assessment to be agreed upon (no earlier than six (6) weeks after the Assessment where the final score was <75%).	Report provides status	No
Maximum one Major and total score is ≥75%	Not passed unless further actions taken and validated after follow-up Assessment	Send completed action plan within four (4) weeks of receiving the provisional report. Follow-up Assessment maximum six (6) months after the Assessment date.	Report including action plan provides status	Certificate at foundation level, if the Major non-conformity is finally solved during the follow-up Assessment. The certificate shall only be issued when the corrections are closed.
> one Major and/or total score is < 75%	Not passed	Actions and new initial Assessment to be agreed upon	Report provides status	No
At least one KO requirement scored with D	Not passed	Actions and new initial Assessment to be agreed upon	Report provides status	No