

MONDAY, SEPTEMBER 10 | 83RD TF, IOANNIS VELLIDIS C.C.  
3<sup>RD</sup> EXPORT USA FORUM 2018  
**FOOD USA** INNOVATION  
& DISRUPTION  
IS ON



ORGANIZERS

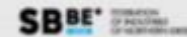


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## SESSION IV

BE 'APPROVED' - BE QUALIFIED  
FOR THE EUROPEAN AND USA MARKETS

# COMPLIANCE ASSESSMENT – FOOD SAFETY STANDARDS APPLICATION AND VERIFICATION

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## National and International Recognition



UKAS Accredited No 9742



**CERTIFICATION PROGRAMS FOR FOOD SAFETY  
ISO 22000 HACCP - COMPLIANCE AUDITS FOR FDA STANDARDS**



# Acidified Food categories

- Foods are classified as acid, low-acid or acidified based on the natural acidity of the product.
- Acid foods have a pH at or below 4.6.
- Low- acid foods have a pH above 4.6. Acidified foods contain low-acid ingredients that have food-grade acids or other acidic foods added to them to lower the final equilibrium pH to 4.6 or below.

- What are the responsibilities of the processing authority? First a processing authority must establish thermal processes (21 CFR 113.83)

“...Without a properly established process, process control at the processor is useless. Establishing processes requires among other things; 1) considerable knowledge about product characteristics and the effect of each processor's equipment and procedures on those characteristics of importance to heat penetration; 2) experience in conducting heat penetration, temperature distribution, thermal death time studies and other scientific methods; and 3) the ability to determine through evaluation of data generated by these studies and tests, that sufficient testing has been accomplished to identify all possible factors that could affect the heating characteristics of the product and the safety of the final product...”

“.....A processing authority is responsible for the evaluation of processing deviations (21 CFR 113.89); to determine whether a specific lot is, or is not, a potential danger to health. The decision is usually based only on the review of processing and production records, which are presumed to be accurate...”

[www.fda.gov](http://www.fda.gov)

# Documents Versus Real Quality



VS





# Swiss Approval

## Process Authority service PLUS Field/ Onsite verification of Compliance

### Audit Scope

provide evidence that a particular product within the Category of Acidified Foods and /or Thermally Processed Low Acid Foods complies with

- USA / Code of Federal Regulations:
  - i. CFR 21 114: Acidified Foods
  - ii. CFR 21 113: Thermally Processed Low- Acid Foods packaged in Hermetically sealed Containers
- ISO22000 Food Safety Management standards
- GREEK-EU Laws/Directives for Food Safety

# Audit Check list

- Product & Process Characteristics check list
- 21 CFR 114/ 113 Check List
- Key Facts of Conformity according to FSMS (ISO 22000:2005) Check list





# The Audit process

## Stage 1 Audit:

Initial Assessment of the Food Producing Establishment based on its ability to produce Safe Food

(IN ACCORDANCE with Ref. Requirements)

The Audit is performed using an extensive check list (Swiss Approval – Process Authority control list)

- Positive findings, Areas of improvement, Non-Conformities / Deviations are handed to the Customer via an Audit Report
- The Audit Outcome reflects the ability - or not- of a Food Canning Establishment to produce safe products



# The Audit process

## Stage 2 Audit:

Conducted on the production Lot that will be shipped to US.

- The Audit is performed using an extensive check list (Swiss Approval-Registrar Approved)
- Findings and/or Non Conformities of Stage 1 Audit are assessed
- The Audit Outcome (Positive findings, Non-Conformities, etc) and All needed information (check list) is handed to the customer via an Audit Report
- The Audit Outcome reflects the ability - or not- of a specific Product to be shipped to the US

# Audit Outcome

No.	Unit/Department Site	Positive findings
1	Certification	Firm is certified with BRC Global Standard: Food ver. 7 and IFS ver. 6 from TUV Nord
2	Sanitary condition	Firm implements the appropriate sanitary conditions for this product category
3	Knowledge	Firm has the appropriate knowledge and experience in the production of acidified foods
4	Verification	Microbiological tests at the end of shelf life are available for a number of products that verifies suitability of process conditions.
5	Production	Visual instructions for operators observed at the shop floor

# Audit Outcome

No.	Unit/Department Site	Opportunities for improvement	Rating
1	Production	To review the procedure of calibrating the pH meters following manufacturer's instructions and requirements of 21 CFR 114. Write simple instructions and make them visible on the shop floor	1
2	Production	To review document for writing down the calibration data (13A)	1
3	Production	An improvement in testing and documentation for water chlorination should be implemented	2
4	Production	In code marking and in case of PL products, the manufacturer should be included. Consider using a code incorporated in LOT printing.	2
5	Production	For work in progress products stored in the warehouse a "STOP" sign is used to avoid improper handling. Consider adding some more information to the "STOP" sign, like LOT and the reason to be held in the warehouse, for better handling	2
6	Production	At production record No 8, critical limits (min and max values) as per scheduled processes should be noted. Also include the recording of pasteurization belt speed to provide a relevant recording of process time.	2
7	Production	Integrate process source documents for xxx and ddd products with more information on the target heat treatment offered to the product, not only at the reference temperature (Fo).	2
8	Quality Assurance	Accelerated incubation tests are available for various products. Consider doing one for product to be shipped to US.	1
9	Quality Assurance	In process flow diagrams incorporate the places where pH measurement is performed.	1





# Benefits- Value

- Training on Compliance Prerequisites and Standards- Acquaintance of Expertise and Knowledge (In-house)
- Establishment of Continuous Internal Quality controls- Minimizing risks of food safety
- Sustainable food process management – ensuring ALWAYS final product quality

**Achieving competence for Food Exports to the USA Market – Trust to the Customer – Sales Effectiveness**



150 professional Engineers full  
time Employees  
2000 large-scale and medium-  
scale/ small companies  
more than 3000 individuals



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