

fefac



European Feed Manufacturers Guide (EFMC)

A community guide to good practice for the
EU industrial compound feed and premixtures
manufacturing sector for food producing animals

Version 1.2

December 2014

TABLE OF CONTENT

0. INTRODUCTION	3
1. SCOPE AND DEFINITIONS	5
1.1. Scope	5
1.2. Legal Definitions	5
1.3. Other Definitions	7
2. FEED SAFETY MANAGEMENT SYSTEM	10
2.1. General Requirements	10
2.1.1. Risk Analysis and HACCP (see Annex I on the application of the HACCP principles)	10
2.1.2. Management Responsibilities	10
2.1.3. Feed Safety Management Structure	10
2.1.4. Training	11
2.1.5. External Communication with feed chain partners	11
2.2. Traceability, Record Keeping and Product Recall	12
2.2.1. General Requirements	12
2.2.2. Product Traceability Records	12
2.2.3. Documentation Requirements	13
2.2.4. Incoming Feed Sourcing	13
2.2.5. End Product Specifications	14
2.2.6. Record Keeping	14
2.2.7. Control Plan	14
2.2.8. Internal Audits	15
2.2.9. Non-conforming Feed and Product Recall	16
2.2.10. Complaints Procedure in Relation to Safety	16
2.3. Inspection, Sampling and Analysis (monitoring)	16
2.3.1. Physical Inspection	17
2.3.2. Sampling	17
2.3.3. Sampling frequency for monitoring	17
2.3.4. Analysis	18



3. GOOD HYGIENE PRACTICES	19
3.1. General Requirements.....	19
3.2. Control of Contaminants and Carry-over	19
3.2.1. Carry-over.....	19
3.2.2. Undesirable Substances and Products / Biological Hazards / Negative List.....	19
3.3. Additives.....	21
3.4. Plant Design and Maintenance / Personal Hygiene	21
3.4.1. Building construction and layout	21
3.4.2. Storage, Production Facilities and Manufacturing Equipment	22
3.4.3. Planned Maintenance	24
3.4.4. Personal Hygiene	25
3.5. Purchase, Delivery, Intake of Incoming Feed.....	25
3.5.1. Purchase	25
3.5.2. Specifications of Feed Materials, Feed Additives and Premixtures	25
3.5.3. Delivery, Intake and Storage of Incoming Feed	26
3.6. Manufacturing Process, Storage and Delivery of Compound Feed and Premixtures.....	26
3.6.1. Manufacturing.....	26
3.6.2. Storage of finished feed.....	30
3.7. Transport and Delivery	31
3.8. Product Traceability Records.....	32
3.8.1. Incoming Feed.....	32
3.8.2. Finished Feed.....	33
3.8.3. Delivery	33
4. REFERENCE DOCUMENTS	34
4.1. EU Food and Feed Legislation (non-exhaustive list).....	34
4.2. International Standards	34
ANNEX I: GUIDANCE FOR THE APPLICATION OF HACCP PRINCIPLES	34
ANNEX II: SPECIFIC REQUIREMENTS FOR MEDICATED FEED	50
ANNEX III: GUIDANCE FOR THE IMPLEMENTATION OF CERTAIN SECTIONS OF THE EFMC.....	58
ANNEX IV: LIST OF NATIONAL FEED MANUFACTURERS' GUIDES.....	66
ANNEX V: LIST OF REPRESENTATIVES OF EUROPEAN FEED BUSINESS SECTORS	67



0. INTRODUCTION

The industrial compound feed sector is a significant link in the production chain of food products from animal origin. Producing safe feed and food products is first and foremost a question of good management practices at each stage of the feed and food chain from primary production to final processing. It is, therefore, the responsibility of each operator in the feed and food chain to comply with all relevant current food and feed safety requirements, to implement good practices to ensure the safety of the goods he produces and to meet customers' requirements.

In parallel with the development of the EU feed legislation, which mainly focused on food safety objectives, the EU compound feed industry has developed feed safety assurance systems laying down a number of requirements to support the proper implementation of the feed and food safety standards and establishing its own standards where required. These feed safety assurance systems have been developed either individually or collectively at national level. Since 1998, FEFAC has established guidelines for the development of national guides to good practice for the manufacturing of compound feed and premixtures in order to foster the practical implementation of good hygiene practices and to achieve a common technical ground for the development of feed safety assurance systems.

Regulation (EC) No 183/2005 on feed hygiene acknowledges the positive contribution of good hygiene practices to achieve the objectives laid down in the EU feed safety legislation and encourages the development of national or Community guides to good practice by feed business sectors, in consultation with any interested party.

The FEFAC guidelines were adapted to meet the requirements of the Feed Hygiene Regulation and were renamed as the European Feed Manufacturers Guide (EFMC). The main objective of the EFMC is to help ensure the safety of feed for food producing animals and of food stemming from those animals and designed for human consumption through implementation of Good Manufacturing Practice during the purchase, handling, storage, processing and distribution of compound feed for food producing animals in accordance with the objectives of the CODEX Code of Practice on Good Animal Feeding and the requirements laid down in the EU General Food Law (Regulation (EC) No 178/2002), in particular Article 17. The guidance document¹ on the implementation of the General Food Law approved by the Standing Committee on the Food Chain and Animal Health at its meeting of 20 December 2004 must be regarded as an essential document that operators should refer to for compliance with the General Food Law Principles.

From 2002 on, FEFAC organised annual meetings with other partners of the chain listed in Annex V of the Guide. The purpose of these meetings was to involve our chain partners at an early stage of the development of the EFMC and also to discuss the development of guides to good practice in the feed chain at large. A formal consultation, extended to EU organisations of consumers, retailers and modern restaurants was launched in July 2004 with a view to prepare the adoption of the final draft EFMC by the FEFAC Council. The outcome of this formal consultation was considered at a stakeholders' workshop on 20 October 2004. The comments exclusively focused on provisions regarding the sourcing of feed materials, provisions that are no longer mentioned in the present guide. The final draft EFMC was notified to the EU Commission in accordance with Article 22 of Regulation (EC) No 183/2005 and then further amended to take into account the comments and requests of the Standing Committee on the Food Chain and Animal Health. It was once more assessed by the Standing Committee on the Food Chain and Animal Health at its meeting on 29 January 2007. The title "European Feed Manufacturers' Guide (EFMC): a Community

¹ The document is available at the following link: http://ec.europa.eu/food/food/foodlaw/guidance/guidance_rev_7_en.pdf

Guide to Good Practice for the Industrial EU Compound Feed and Premixture Manufacturing Sector for Food Producing Animals” and the references of the EFMC were published in the OJEC No C64 of 20 March 2007, page 17.

A special Committee, the so-called Feed Safety Management Committee, was established within FEFAC to review, on a regular basis and at least once a year, the European Feed Manufacturers’ Guide against any new development in the technological, scientific, normative and legislative area and, if needed, to proceed to necessary adjustments, in consultation with other interested parties. The draft updated versions of the guide will be notified to the EU Commission for assessment.

With a view to ensuring that the coexistence of nationally developed guides to good practice does not result in undesirable barriers to trade within the EU, the present EFMC is also designed to provide practical information for the benchmarking of national guides to good practice for the production of safe compound feed and premixtures in order to facilitate the mutual recognition of these existing national guides to good practice by the public authorities, national guides owners and stakeholders in the feed and food chain. The EFMC may also be used as a reference document for the development of feed safety assurance systems. In this case, the development of certification rules is the responsibility of the national scheme owners and should be based on EN 45011.

Medicated feed is a specific form of compound feed, which is often produced in the same plant as conventional compound feed. Therefore, the manufacturing, storage and delivery have to comply with EU legal feed hygiene requirements as laid down in Regulation (EC) No 1831/2003. This is why any EFMC provision pertinent for conventional compound feed is also pertinent for medicated feed. In addition, medicated feed is subject to specific EU legislation, i.e. Directive 90/167/EEC, which provides for additional hygiene and safety practices. Considering the differences in terms of implementation of this Directive at national level, it was decided to include these additional requirements in a separate Annex II. However, any national good practices developed in accordance with article 4(d) of Directive 90/167/EEC may take precedence over the present good practices laid down hereafter.

The EFMC only covers safety related issues, i.e. the safety of feed for animals to ensure human as well as animal health. The following essential feed safety related elements have to be covered in any code of practice applied by compound feed, and premixtures manufacturers:

- The type of products: premixtures, compound feedingstuffs;
- The operations covered:
 - The sourcing of feed materials, premixtures and feed additives
 - The production, storage, transport and distribution of premixtures and compound feed;
- A “HACCP”-based risk analysis addressing the risks linked to chemical, physical and microbiological hazards
- A full traceability system including a detailed record keeping procedure;
- A detailed sampling plan, including uniform sampling methods and sample storage;
- A complaint and recall procedure;
- Written procedures whose implementation is subject to internal and independent checks;
- A review procedure.

Additional elements such as targets for improvement of the plant performance may be included.



1. SCOPE AND DEFINITIONS

1.1. Scope

The present European Feed Manufacturers' Guide (hereafter referred to as the Guide) covers premixtures and compound feedingstuffs for food producing animals. To facilitate the reading and use of the present Guide, any provision applying to compound feed applies also to medicated feed unless otherwise specified in Annex II of this Guide. It covers all operations referred to in Article 5 par. 2 of Regulation (EC) No 183/2005 under the responsibility of the compound feed and/or premixture manufacturer, including purchase of incoming feed, handling and storage of feed, processing and delivery of compound feed and premixtures. The Guide does not cover the production of premixes for medicated feedingstuffs. The Guide, although primarily designed for the industrial manufacturing of feed, may also be applied by on-farm compound feed producers using premixtures and/or feed additives and falling within the scope of Article 5, par. 2 of Regulation (EC) No 183/2005.

1.2. Legal Definitions

Batch: An identifiable quantity of feed determined to have common characteristics, such as origin, variety, type of packaging, packer, consignor or labelling, and, in the case of a production process, a unit of production from a single plant using uniform production parameters or a number of such units, when produced in continuous order and stored together (Regulation (EC) No 767/2009).

Compound feed: Mixtures of at least two feed materials, whether or not containing additives, for oral animal-feeding in the form of complete or complementary feed (Regulation (EC) No 767/2009).

Complete feed: Compound feed which, by reason of their composition, is sufficient for a daily ration (Regulation (EC) No 767/2009).

Complementary feed: Compound feed which has a high content of certain substances but which, by reason of their composition, is sufficient for a daily ration only if used in combination with other feed (Regulation (EC) No 767/2009).

Feed (or feedingstuff): Any substance or product, including additives, whether processed, partially processed or unprocessed, intended to be used for oral feeding to animals (Regulation (EC) No 178/2002).

Feed additives: Substances, micro-organisms or preparations, other than feed materials and premixtures, which are intentionally added to feed or water in order to perform, in particular, one or more of the following functions (Regulation (EC) No 1831/2003):

- a) Favourably affect the characteristics of feed;
- b) Favourably affect the characteristics of animal products;
- c) Favourably affect the colour of egg yolk, ornamental fish and birds;
- d) Satisfy the nutritional needs of animals;
- e) Favourably affect the environmental consequences of animal production;

- f) Favourably affect animal production, performance or welfare, particularly by affecting the gastro-intestinal flora or digestibility of feedingstuffs;
- g) Have a coccidiostatic or histomonostatic effect.

Feed hygiene: Means the measures and conditions necessary to control hazards and to ensure fitness for animal consumption of a feed, taking into account its intended use (Regulation (EC) No 183/2005).

Feed material: Products of vegetable or animal origin, whose principal purpose is to meet animals' nutritional needs, in their natural state, fresh or preserved, and products derived from the industrial processing thereof, and organic or inorganic substances, whether or not containing feed additives, which are intended for use in oral animal-feeding either directly as such, or after processing, or in the preparation of compound feed, or as carrier of premixtures.

Food: Any substance or product, whether processed, partially processed or unprocessed, intended to be, or reasonably expected to be ingested by humans (Regulation (EC) No 178/2002).

Hazard: Biological, chemical or physical agent in, or condition of, feed with the potential to cause an adverse health effect (Regulation (EC) No 178/2002).

Medicated feed(ingstuffs): Any mixture of a veterinary medicinal product or products and feed or feeds which is ready prepared for marketing and intended to be fed to animals without further processing, because of its curative or preventive properties or other properties as a medicinal product (Directive 2001/82/EC).

Premixtures: Mixtures of feed additives or mixtures of one or more feed additives with feed materials or water used as carriers, not intended to direct feeding to animals (Regulation (EC) No 1831/2003).

Risk: A function of the probability of an adverse health effect and the severity of that effect, consequential to a hazard (Regulation (EC) No 178/2002).

Risk analysis: A process consisting of three interconnected components: risk assessment, risk management and risk communication (Regulation (EC) No 178/2002).

Risk assessment: A scientifically based process consisting of four steps: hazard identification, hazard characterisation, exposure assessment and risk characterisation (Regulation (EC) No 178/2002).

Risk management: The process, distinct from risk assessment, of weighing policy alternatives in consultation with interested parties, considering risk assessment and other legitimate factors, and, if need be, selecting appropriate prevention and control options (Regulation (EC) No 178/2002).

Traceability: Ability to trace and follow a feed or substance intended to be, or expected to be incorporated into a feed, through all stages of production, processing and distribution (Regulation (EC) No 178/2002).

Undesirable substances: Any substance or product, with the exception of pathogenic agents, which is present in and/or on the product intended for animal feed and which presents a potential danger to animal or human health or to the environment or could adversely affect livestock production (Directive 2002/32/EC).

Withdrawal period: Period necessary between the last administration of the veterinary medicinal product to animals under normal conditions of use and the production of foodstuffs from such animals, in order to ensure that such foodstuffs do not contain residues in quantities in excess of the maximum limits laid down in application of Regulation (EC) No 470/2009 (Directive 2001/82/EC).

1.3. Other Definitions

Carry-over: Means the level of transfer of any substance or product from one production batch to the immediate subsequent batch in a particular section of the plant, for example, a mixer or a hand tip point.

Cleaning: Removing manually or mechanically the residues and dirt from objects and surfaces, including feed and dust, that may be a source of contamination. The concept of cleaning may also include possible disinfection.

Contamination/Cross-contamination: The undesired introduction of impurities of a chemical or microbiological nature or foreign matter into or onto an incoming or a finished feed during production, sampling, packaging or repackaging, storage or transport.

Control: Monitor and measure processes and products against policies, objectives and requirements for the product and report results.

Control point: Any step at which biological, chemical, or physical factors can be controlled. Also known as “point of attention”.

Control measure: Any action and activity that can be used to prevent or eliminate a food / feed safety hazard or reduce it to an acceptable level.

Corrective action: Action to eliminate the cause of a detected nonconformity or other undesirable situation.

Critical Control Point (CCP): A step at which control can be applied and is essential to prevent or eliminate a feed / food safety hazard or reduce it to an acceptable level.

Critical limit: A criterion that separates acceptability from unacceptability.

Disinfection: A process intended to inactivate / kill pathogenic microorganisms and viruses, to prevent infections. Bacterial spores are normally resistant to most disinfectants.

Feed Safety Assurance: Part of feed safety management focused on providing confidence that feed safety requirements will be fulfilled.

Feed Safety Management: Coordinated activities to direct and control an organization with regard to feed safety.

Feed Safety Manager: Appointed staff member responsible for the development, implementation and management of the Feed Safety Management System.

Finished feed: A general term used to denote products obtained at the end of the processing chain of the company, i.e. compound feedingstuffs or premixtures, and ready for delivery to customers. By extension, it also applies to premixtures manufactured by the compound feed manufacturer for own use.

Flushing: Involves taking a known feed or feed material, for example ground grain, and moving a quantity through the system to purge feed from a previous batch that remains.

“HACCP” (Hazard Analysis and Critical Control Point): A system which identifies, evaluates and controls hazards which are significant for feed safety.

Hazard analysis: The process of collecting and evaluating information on hazards, and conditions leading to their presence, to decide which are significant for feed safety and therefore must be addressed in the HACCP plan.

Hazard identification: The identification of biological, chemical and physical agents, including in the production process, capable of causing adverse health effects and which may be present in a particular feed.

Incoming feed: A general term used to denote raw materials delivered at the beginning of the production chain, i.e. feed materials, feed additives, processing aids, premixtures.

Manufacture/Production: All operations of receipt of materials, production, packaging, repackaging, labelling, re-labelling, control, release, storage and distribution of premixtures and compound feed and the related controls.

Prerequisite programmes: Procedures, including Good Manufacturing Practices, which address operational conditions providing the foundation for the HACCP system.

Record: Document (paper or electronic) stating results achieved or providing evidence of activities performed.

Reference samples (also called record samples): Aggregate samples taken upon arrival of the batch of incoming feed or dispatch of the batch of finished feed and kept for an appropriate time as evidence for traceability purpose and to allow for further analyses.

Returns: Compound feedingstuffs or premixtures generated either during the production process or subsequently, that are suitable for reworking. Returns originate from a variety of sources, each with its special characteristics. They include:

- (a) Out- of- date stock;
- (b) Non-conforming feed - e.g. starting up problems, poor texture, deterioration in plant and on farm, errors in ordering or dissatisfaction;
- (c) Sievings on plant processing, where applicable, or at bulk loading of textured feedingstuffs;
- (d) Flushings and cleanings - resulting from plant scouring and change-overs;
- (e) Broken bags and spillage.

A distinction must be made between internal returns (i.e. products which have not left the site) from external returns.

Site: Factories / buildings sharing the same premises, under the same senior management control and involved in various stages of the same continuous process.

Supplier: Organisation or person that directly supplies an incoming feed.

Validation: Confirmation, through the provision of objective evidence that the requirements for a specific intended use or application have been fulfilled.

Waste: Any substance or object in the categories set out in Annex 1 of the Waste Framework Directive, which the holder discards or intends, or is required to discard. Feed materials resulting from food or drink manufacturing and safe returns complying with the EU feed safety legislation shall not be regarded as waste.

Withdrawal feed: Feed distributed to animals during the withdrawal period for veterinary medicinal products. By extension, the term withdrawal feed also applies to feed distributed during the period when the use of coccidiostats and histomonostats is prohibited.

2. FEED SAFETY MANAGEMENT SYSTEM

2.1. General Requirements

- The purpose of the EFMC is to ensure the achievement of feed safety standards that reflect the importance of compound feed and premixtures within the human food chain and to meet contractual and legal obligations.
- A Feed Safety Management System must be established, documented, implemented and maintained. The system must be adapted to regulatory and other feed safety developments.
- The structure of the Feed Safety Management System must include policies, requirements and documented procedures that reflect best practices.
- A formal risk assessment must be carried out with the aim of identifying and controlling hazards that might adversely affect the safety of any supplied feed. Risk assessments must be carried out in accordance with HACCP principles.
- The Feed Safety Management System must ensure that all activities with impact on the safety are consistently defined, implemented and maintained. ISO standards or other comparable standards may be used to define the Feed Safety Management System.

2.1.1. Risk Analysis and HACCP (see Annex I on the application of the HACCP principles)

2.1.2. Management Responsibilities

- The Management (from CEO to the operational management) must be committed to the implementation of a Feed Safety Management System, which has to be documented.
- The Management must:
 - Define the scope of the Feed Safety Management System by identifying products/product categories and production sites covered by the system and by ensuring the establishment of safety objectives;
 - Ensure that feed safety requirements are part of the business goals of the company;
 - Review the Feed Safety Management System at defined intervals of not more than 12 months, and when major or significant changes to plant or products occur, to ensure its suitability and effectiveness of (changes and improvements).

2.1.3. Feed Safety Management Structure

- An organisation chart must be established and kept permanently updated. The chart should specify the respective staff responsibilities in relation to feed safety.

- The authority of the staff performing feed safety related tasks has to be documented. One nominated Feed Safety Manager must have the appropriate authority to carry out his mission.
 - All staff involved must be suitably experienced, trained and qualified;
 - The scale of resource dedicated to the feed safety management must be appropriate to the type or quantity of compound feed and premixtures being supplied and the hazards involved;
 - Regarding internal communication, all staff must be regularly informed about issues with an impact on feed safety.

2.1.4. Training

- The Management must ensure that all staff members are adequately trained in the practice of the tasks they may be required to perform and should be informed about issues which have an impact on feed safety. The required levels of knowledge and skills must be maintained by on-going training.
- Training must cover not only specific tasks but also good manufacturing and/or delivery practice in general and the importance of personal hygiene. It may include, where appropriate:
 - An understanding of the present Guide to Practice, of its Annexes and of company procedures;
 - An understanding of the plant;
 - The accuracy and use of equipment;
 - The maintenance of accurate records and documentation;
 - The implementation of the HACCP Plan relating to CCPs including monitoring, recording, reporting and taking appropriate action as detailed within the Plan and company procedures;
 - The significance of incoming feed that are handled and particular precautions to be observed in use and dangers of misuse;
 - The importance of correct sampling;
 - The safety precautions to be taken in handling additives and premixtures as indicated by their manufacturer;
 - The significance of potentially hazardous substances and the special requirements of manufacturing feedingstuffs from feed materials containing these and
 - The importance of correct loading.
- The training must be documented.

2.1.5. External Communication with feed chain partners

- External communication among the different members of the feed and food chain is an essential tool to ensure in the best possible way the safety of feed and food products. Therefore, the users of this Guide must also make sure that their needs to ensure the safety of the compound feeds and premixtures they produce are passed on and recognised by their suppliers and customers. Manufacturers of

compound feeds and/or premixtures must ensure that all feed safety hazards are not only identified, evaluated and controlled but also communicated throughout the food chain so that any harm of animal or human health can be prevented.

- The manufacturer of compound feeds and/or premixtures will make available, on request of the farmer-customer, the results of its monitoring.
- There must be a procedure for notifying interested parties of the feed chain, control authorities and operators both upstream and downstream, of any non-conformity with feed safety requirements and other specifications. This procedure shall include provisions for the management of recalls when needed (see also 2.2.9).

2.2. Traceability, Record Keeping and Product Recall

2.2.1. General Requirements

- A system of documentation must be established to ensure traceability, which identifies i) suppliers and intermediaries of incoming feed to feed plant, and ii) to whom these incoming feed have been supplied once processed into finished feed.
- The traceability system should also allow tracing-back from the finished feed through quality control data and batch records to the feed ingredients used and the suppliers.
- There must be trace-back or trace-forward of finished feed if actual or potential health risks have been identified.

2.2.2. Product Traceability Records

The manufacturer must record:

- The name and address of all suppliers/intermediaries and the sources of incoming feed, including the batch numbers for purchased feed additives.
- The approval or registration number of suppliers according to EU legislation.
- For compound feed manufacturers, the name and address of premixture manufacturers or intermediaries, including batch numbers.
- The nature and quantity of finished feed and their manufacturing date. Records must show that each batch was manufactured in accordance with the actual formula and that special procedures to observe safety requirements and for the avoidance of carry-over were followed.
- The name and address of the customer to whom each batch is delivered.
- The reference samples of incoming feed and each batch of finished feed must be retained for a period appropriate to the use for which the finished feed is placed on the market.

2.2.3. Documentation Requirements

- The user of this Guide must produce and implement an own set of operating procedures incorporating the requirements of this Guide.
- The procedures can be part of a Feed Safety Management System as part of a national, industry or company scheme.
- The required procedures in this Guide have to be:
 - Documented;
 - Reviewed and approved;
 - Readily available and understood;
 - Revised to reflect significant changes;
 - Dated, and signed by an authorised person.
- The Feed Safety Management System documentation must include the documented procedures and records required by the EFMC.

2.2.4. Incoming Feed Sourcing

2.2.4.1. Purpose

Incoming feed must be:

- Traceable.
- Conform to the required standard specifications for incoming feed (see 3.5.2) and
- Controlled for undesirable substances, Salmonella and other known hazards according to a control plan established based on an “HACCP”-study.
- For oils and fats and their derivatives falling under the scope of point 5 of par.4 of Annex of Regulation (EU) No 225/2012, a proof enabling to link the delivered batch or all components thereof to a certificate of analysis for dioxin and dioxin-like PCBs from an accredited laboratory shall be available at the latest at the moment of delivery.

2.2.4.2. Supplier Assessment

Incoming feed must be:

- Delivered by suppliers approved or registered in accordance with resp. article 10 and 9 of the Feed Hygiene Regulation, including wholesalers and traders; and
- Delivered by suppliers assessed on a regular basis by the purchaser (and prior to any delivery of incoming feed in case of a new supplier) or participating in a feed safety assurance system, subject to certification by a third party, and recognised by the purchaser. These safety assurance systems must be based on relevant sector-based guides to good practice where they exist, developed in accordance with Article 22 of Regulation (EC) No 183/2005.

The purpose of the supplier assessment in terms of HACCP is to check that there is an effective feed safety management system including a robust monitoring programme. In case an incoming feed would be deemed as non-compliant with EU or, by default, national feed safety standards, the ability of the supplier to deliver shall be reconsidered based, if appropriate, on an audit, depending on the nature of the non-compliance and the nature of the corrective actions taken by the supplier. Conditions for future deliveries should be reviewed accordingly.

2.2.5. End Product Specifications

- There must be internal product specifications in full detail prior to manufacture, independently from the written specifications routinely available to purchasers for each finished feed. The written specifications for purchasers must at least include:
 - The precise identification of the finished feed (name) and
 - Any hazards or limitations for their use.

2.2.6. Record Keeping

- All records required by the EFMC must be kept for the required minimum period according to the EU legislation and/or national provisions. By default, a 5 years period is recommended.
- The storage conditions must prevent any deterioration or damage to the records.
- The records must be sorted and filed for complete and easy information and be legible.

2.2.7. Control Plan

- A control plan must be drawn up and implemented for incoming feed, finished feed and intermediates.
- The feed safety control plan, which has to be based on HACCP Principles, must:
 - Define checks on Critical Control Points in the manufacturing process;
 - Enable the control of the safety status of the incoming feed, in particular compliance with relevant legislation with a particular focus on maximum limits for undesirable substances and prohibited material;
 - Ensure that finished feed complies with the specifications defined by the manufacturer and the relevant legislation;
 - Establish the sampling procedures for incoming feed, finished feed and microbiological status of the plant/equipment, where samples have to be taken, the quantities and the frequency (monitoring), taking into account the volume and risk characterisation of incoming and finished feed;
 - Specify which methods of analysis must be used;
 - Ensure that the monitoring results are recorded;
 - Address the nature, content and homogeneous dispersion of the additives concerned in the finished feed. Frequent homogeneity tests shall be conducted at the most relevant stages of the process (see Annex III C);

- Ensure that the levels of incidental presence of substances and products subject to restriction of use are as low as reasonably achievable (ALARA principle);
- Determine what action must be taken in case of non-compliance;
- Define the responsibilities of the staff involved in the production and feed safety control.
- In addition, concerning the control of Salmonella and other pathogens, the control plan should target the minimization of their occurrence in finished feed by controlling the contamination of the incoming feed and the manufacturing plant (PRP) and/or the reduction of their occurrence during feed production. The control plan should in particular:
 - Check the Salmonella status of incoming feed; the intensity of this monitoring depends on the existence of a Salmonella reduction treatment further in the process and the risk associated with specific feed materials;
 - Establish the Salmonella and overall microbiological status in the feed plant via a monitoring programme at predefined areas/equipment;
 - Verify, where appropriate, that the processes aimed at preventing growth of / reducing Salmonella and other microbiological contamination are sufficiently controlled and the presence of Salmonella and other pathogens is monitored;
 - Monitor the performance against the pre-established targets, having regard to national policies.
- The control plan must:
 - Be effectively implemented;
 - Be regularly reviewed on the basis of the findings (e.g. the Salmonella status), the information collected from suppliers and customers and any target for improvement;
 - Record the results of relevant controls (including samples), which must be kept by the manufacturer, and which must be retained to be able to trace incoming and finished feed;
 - Record the manufacturing history of each batch produced;
 - Identify areas of responsibility in the event of a complaint.

2.2.8. Internal Audits

- There must be a documented procedure requiring the carry out of an audit programme to check that internal systems are operating as intended and that they are effective.
- Internal audits must show the compliance with the requirements of this Guide, the “HACCP” system, the applicants’ formal procedures and the legislation pertaining to compound feed and premixtures’ safety.
- All relevant activities must be audited at least once a year.
- Internal audits must be carried out by qualified personnel, be formally reported and record any aspects where operations are not in compliance with operational requirements. Any non-compliance must be corrected and the audit report then be updated accordingly.
- All personnel carrying out internal audits must be trained to carry out such audits and be able to demonstrate their effectiveness in this role.

2.2.9. Non-conforming Feed and Product Recall

- A procedure shall be established to deal with non-conformity with feed safety requirements and other specifications. This procedure shall include provisions for the management of recalls when needed.
- The responsibility for review and disposal of non-conforming feed must be defined.
- The recording of all incidences and action decisions must only be made by nominated staff.
- Non-conforming finished feed should be dealt with through disposal, rework or downgrading.
- All requirements for reprocessing and re-evaluation on completion must be documented.
- In addition, in case of non-compliance with feed safety requirements whether for an incoming or finished feed, the Feed Safety Manager shall
 - Immediately inform the relevant competent authorities in accordance with Regulation (EC) No 178/2002;
 - Inform the supplier (in case of non-conformity on incoming feed) or the customer (in case of non-conformity of finished feed);
 - Isolate and block the contaminated batch until agreement with competent authorities is achieved on the action to be carried out (i.e. sending back to supplier, detoxification/disinfection, change of destination or destruction);
 - In case of contamination of an incoming feed, identify all finished feed which may contain part of the contaminated incoming feed, isolate and block any such potentially contaminated finished feed still present in the plant, identify the purchasers of potentially contaminated finished feed that would have already been placed on the market and inform them;
 - Recall feed already placed on the market if deemed necessary in agreement with competent authorities when remedial measures are not sufficient to achieve a high level of health protection.

2.2.10. Complaints Procedure in Relation to Safety

- The complaint procedure in relation to safety must include systems for:
 - The allocation of responsibility for the management of complaints;
 - The recording of the name of the complaining customer;
 - The recording of the finished feed under complaint;
 - An investigation into the cause of the complaint;
 - A reply to the customer and
 - All necessary corrective actions in a timely and effective manner.

2.3. *Inspection, Sampling and Analysis (monitoring)*

- Inspection, sampling and testing must be done through competent staff. There must be records of adequate staff training, its experience and qualifications.

2.3.1. Physical Inspection

- A physical inspection must check the colour, physical form, odour and freedom from contamination by insect pests, from mould and excessive damage of the incoming and finished feed. The goods must comply with the incoming feed and finished feed specifications.
- Incoming batches of additives must be examined visually, on receipt, for damage to the containers. Any damage thought likely to have affected the quality of the product must be reported to the Feed Safety Manager.

2.3.2. Sampling

- The purpose of sampling is in particular:
 - To keep a reference sample of batches of incoming feed and all batches of delivered finished feed for traceability and counter analysis purpose (reference samples);
 - To proceed to analyses of incoming feed, finished feed, as well as the equipment as regards the microbiological status, in accordance with the monitoring programme (see 2.3.1.3).
- Sampling of incoming and finished feed as well as areas/equipment has to be carried out using adequate techniques.
- The sampling method shall be appropriate to the nature and the volume of the delivery. Unless required by specific legislation (e.g. dioxin monitoring established by Regulation (EU) No 225/2012), the operator may use a sampling method other than the official method laid down in Regulation (EC) No 152/2009. Such method shall allow samples to be taken in a way that provides as representative samples as possible of the batch, taking into account the likelihood of non-uniform distribution of the hazard. The size of the delivery shall also condition the number of incremental samples to be taken.
- The samples must be kept in appropriate, sealed and labelled containers and be disposed of in a controlled way.
- Further guidance on how to take samples is given in Annex III F.

2.3.3. Sampling frequency for monitoring

- The sampling schedules for monitoring are the responsibility of the Feed Safety Manager. There must be documentation of the location, method and frequencies of sampling.
- An effective control plan requires a monitoring programme of incoming and finished feed, designed on the basis of a defined method for the determination of the frequency of analysis taking into account the nature, volume / number of batches and the risk characterisation of each type of incoming and finished feed established in accordance with the HACCP programme.
- The frequency of analysis for the targeted analyte may take into account
 - Relevant previous monitoring results for incoming feed;
 - The possible determination of a CCP in the process for specific hazards.

- The monitoring programme shall be reviewed whenever required, e.g. when the risk characterisation for incoming or finished feed changes, taking into account in particular emerging risks (new hazard or modification of the occurrence of a hazard, e.g. in case of weather conditions favourable to mycotoxin's presence or in case of repeated findings of the same contaminants from the same area) and available information through the Rapid Alert System for Food and Feed ([link](#)) or the listing of the incoming feed on the list of food/feed of non-animal origin subject to increased level of official controls on imports.
- Specific guidance for the monitoring of Salmonella status of incoming feed, finished feed and/or the plant as appropriate depending on the Salmonella risk management strategy is provided in Annex I.7.

2.3.4. Analysis

- The user of this Guide must possess a properly equipped control laboratory or make use of an external laboratory, preferably accredited.
 - The laboratory must demonstrate the reproducibility and accuracy of its results. In house test methods must be regularly verified by results from accredited laboratories or national reference laboratories (NRL).
- The relevant methods of analysis must be regularly reviewed and approved by:
 - Accreditation by a nationally recognised accreditation authority according to EN 17025;
 - Validation through the participation in a recognised ring test;
 - Alternatively, validation through other recognised means (e.g. a comparison with the results of a recognised laboratory);
 - The test report must be of up-to-date and refer to the batch of feed in question.

3. GOOD HYGIENE PRACTICES

3.1. General Requirements

- A hazard analysis study (“HACCP”) of the whole production process (i.e. from sourcing of incoming feed, through to farm delivery of finished feed including operations of transport, storage and manufacturing) must be done in order to identify potential associated hazards for consumer and animal health.

3.2. Control of Contaminants and Carry-over

- Controls to protect incoming and finished feed from contamination must take place. In particular, intake points, processing equipment, conveying systems and storage facilities must be designed and operated to minimise the possibility of ingress.
- The control of contaminants must be carried out by trained personnel.

3.2.1. Carry-over

- Control of carry-over must always be considered within the HACCP study. Attention should be paid to each additive, added separately or in the form of a premixture with a view to establish a list of critical substances for the purpose of control of carry-over. Each part of the process, loading and delivery must be considered in the HACCP study. Specific attention must be paid to the plant design (see 3.4.1), the dust management (see 3.4.1.4), the cleanliness of equipment (see 3.4.2.1) and scheduling (see 3.6.1).
- Carry-over tests must be performed at least once a year at the most relevant stage of the process or after adaptation of the facilities to validate the established procedures for minimisation of carry-over (see Annex E).
- Where a hazard presents a significant risk to the product, control measures to reduce or minimise it (scheduling of manufacturing and, if necessary, flushing) must be established and documented.
- The Critical Control Points for hazards must be identified and particular emphasis be laid upon documenting control procedures and corrective actions.
- Further guidance on the measurement and the control of carry-over is provided in Annex III E.

3.2.2. Undesirable Substances and Products / Biological Hazards / Negative List

3.2.2.1. Control Measures for Undesirable Substances

- During the production of finished feed, the manufacturer must apply control measures to ensure that maximum permitted levels are not exceeded.

- The delivery point of incoming feed is a critical point for the presence of undesirable substances. The maximum limits as laid down in Directive 2002/32/EC on undesirable substances and products as well as the guidance values set out for certain mycotoxins in annex of Commission recommendation 2006/576/EC shall be used as critical limits for judging the acceptability of cereals and cereal products for animal feeding. Dilution of batches containing undesirable at levels above the maximum limits laid down in Directive 2002/32/EC is prohibited. Feed Safety Assurance Systems at the level of suppliers must therefore be taken into account.
- Large lots of compliant feed materials with an aflatoxin B1 content above 5 µg/kg (single result) or when different analytical results on a lot indicate a variable content of aflatoxin B1 in the lot, such lots should be handled with care:
 - To be preferably used for the production of compound feed for which the maximum level is 20 µg/kg (or 10 µg/kg);
 - In case of use for the production of compound feed for which the maximum level is 5 µg/kg (in particularly dairy animals), following management measures (individually or a combination of, in function of the level found) could be considered to ensure compliance of the compound feed with the maximum level (and consequently the food of animal origin):
 - Consider re-sampling of the feed materials to be used whereby the sampling procedure is applied on smaller sublots than the available analytical results refer to in order to have better estimate view on the variability of the presence of aflatoxin, combined with the selection of the sublots with low level of aflatoxin B1 for the production of compound feed which have to be compliant with the maximum level of 5 µg/kg;
 - Consider use the feed material only at low incorporation rates in the compound feed.
- Lots which have been decontaminated should preferably not be used for the production of compound feed for dairy animals or only at low incorporation rates in the compound feed.

3.2.2.2. Control Measures for Biological Hazards

- Preventive actions, monitoring and/or verification plans and corrective actions must be implemented to minimise Salmonella and other microbial contamination and re-contamination.
- The possible microbiological contamination must be monitored and controlled in accordance with microbiological criteria defined as part of the HACCP study. This supposes in particular:
 - Controlling processes, especially related to prevention of growth and to reduction of Salmonella and other pathogens by the heating or disinfection steps;
 - Controlling the Salmonella and the microbiological status of the premises via a monitoring programme targeted at predefined areas and equipment, focusing where relevant on areas after the heating or disinfection steps, where re-contamination or growth can take place;
 - Preserving processed feed from contamination or recontamination during processing, collection, storage, trading and transport, e.g. by closed systems, hygiene practices, or by separating the premises into hygienic zones as appropriate.

- To this end, the manufacturer must in the first place:
 - Define control points in the process, based on risk assessment;
 - Establish the Salmonella and the microbiological status in the feed business via a monitoring programme at predefined areas/equipment;
 - Set a target for improvement based on the continuously updated Salmonella and microbiological status of the feed business operator;
 - Monitor the performance against the target and adapt its monitoring plan accordingly;
 - In case of positive sample, further serotyping must be carried out;
 - Corrective action shall be initiated immediately after detection of Salmonella.
- Further guidance on identification of critical points for the management of the Salmonella and overall microbiological risk, designing of the monitoring programme and corrective actions is provided in Annex I, par. 7.

3.2.2.3. Control Measures for Prohibited Materials and for Feed Materials subject to Legal Restrictions

- The EU legislation has established a list of prohibited materials. Manufacturers must ensure that products on this list are not used at all or not used for species for which they are prohibited.
- Control measures must show reference to the relevant provisions of Regulation (EC) No 999/2001 on BSE-related provisions, in particular the feed ban (Annex IV of Regulation (EC) No 999/2001).
- Control measures must also show reference to the relevant provisions of Regulation (EC) No 1069/2009 in particular the ban on catering waste and the ban on intra-species recycling.

3.3. Additives

- Additives and premixtures must be mixed in appropriate quantity and in a homogeneous way following the manufacturer's instructions of use to ensure that finished feed contains the quantity as specified.
- Companies using these products must comply with the legal criteria regarding the facilities, the management and administration of the plant, as well as with the qualification of the employees.

3.4. Plant Design and Maintenance / Personal Hygiene

3.4.1. Building construction and layout

- The buildings should be soundly constructed of durable materials and fully enclosed or otherwise proofed against pests/vermin and weather.
- Floors, walls and ceilings must be kept clean and in a good state.

- Doors should be soundly constructed, close fitting and, where possible, kept closed other than for personnel entry or for the inward or outward movement of feed. If it is necessary for ventilation purposes to open doors then suitable precautions should be taken to ensure this does not increase the risk of vermin and wild birds gaining entry.
- The buildings should be effectively lit and ventilated.
- In order to minimise dust containing pathogenic micro-organisms from contaminating incoming and finished feed, the intake to the processing area and any dust extraction should be kept physically separated from areas used to store and dispatch finished feed and must not enter the clean area of the production process again.

3.4.1.1. Perimeter and Grounds

- There should be sufficient clean hard standing at entrances and exits to minimise the tracking in of mud, effluent and other wet material by vehicles or personnel. In this respect, specific attention should be paid to farms in the neighbourhood as potential source of infection.
- Where natural drainage is inadequate, external drainage must be installed.
- Where external storage is necessary, items must be protected from contamination and deterioration.
- Where possible, all buildings should be surrounded by clear space, which should be regularly maintained.
- Waste must be collected in a well-defined area.
- Control measures must prevent the presence of domestic, feral and wild animals.

3.4.2. Storage, Production Facilities and Manufacturing Equipment

- Storage, production facilities and manufacturing equipment must be maintained in a clean, tidy condition and be free from accumulated waste.
- Layout, design and the operation of all facilities and equipment must be such that they:
 - Minimise the risk of error;
 - Permit effective cleaning and maintenance;
 - Minimise contamination and carry-over;
 - Ensure dry condition and minimise condensation;
 - Allow the disposal of sewage, waste and rain water without contamination;
 - Allow the mixing of homogeneous products. The dosing, weighing and transport equipment for additives must be adapted to the level of concentration of the feed materials, feed additives and premixtures to be weighed.
- Appropriate and regular checks in accordance with “HACCP” must take place as well as a risk assessment using information the manufacturer of equipment can provide. All checks must be carried out in accordance with written procedures.

- The factory site should be split in two areas, i.e. before and after corrective actions are taken, based on the HACCP study and in particular the identification of critical control points where microbiological criteria apply. Any storage, production facility and equipment which is contaminated with Salmonella or has been used to handle, store or process contaminated feed beyond the CCP must be thoroughly cleaned, disinfected and/or, if necessary, dried before being reused to handle, store or process feed.
- Feed having undergone decontamination must be stored separately from non-treated feed.
- Feed storage areas, production facilities and manufacturing equipment must be free of chemicals, chemical fertilisers, pesticides or other potential contaminants.
- Procedures should be established to keep to a minimum the proportion of out-of-date stocks (e.g. first-in-first-out principle) by applying a careful stock rotation. Materials must be stored in such a way that they are clearly identifiable, and that their intake identification is easily visible. The effectiveness of the stock rotation must be monitored by the Feed Safety Manager.
- A cleaning programme must ensure that all storage facilities are completely emptied and regularly cleaned according to the type and condition of incoming or finished feed stored.

3.4.2.1. Off-site Storage Facilities

- Compliance of off-site storage facilities (including third party stores) for incoming and finished feed before putting on the market must be ensured.
- Third party stores must comply with an approved national or international guide of practice unless formally audited each year by the feed manufacturer.

3.4.2.2. Sieves, Screens, Filters and Separators

- Sieves, screens, filters and separators must be regularly checked for damages and their effective operation. Dust and waste from sieves, ventilators, separators etc. must be handled in a closed system to avoid contamination of incoming and finished feed.

3.4.2.3. Dust Control

- Reasonable precautions must be taken against dust accumulation and other residual materials where incoming and finished feed are processed or stored. The company must define a “dust management plan” which should include procedures for the cleaning and disinfection of the facilities and the equipment. Specific attention must be paid to those feed additives and premixtures with high propensity to generate dust. Specific measures must be defined for such feed additives and premixtures to minimise the impact of such dust on the level of carry-over. This should include provisions regarding dust disposal or rework. Dust and waste should only be removed by vacuum cleaning and not by compressed air.

3.4.2.4. Air Movement

- Where air is used for conveying or cooling, there must be a regular evaluation of the risk of this air to become a vehicle for pathogens. Any necessary precautions to prevent this must be taken.

3.4.2.5. Intake and Loading Facilities

- Intake and loading facilities must be designed and constructed to maintain the safety of incoming and finished feed.
- Contamination through weather, birds' access, etc. must be avoided.

3.4.2.6. Conveyors and Handling Equipment

- Conveyors and handling equipment must be maintained in a sufficiently clean and hygienic condition to avoid them adversely affecting incoming and finished feed.

3.4.3. Planned Maintenance

- The equipment must be subject to a programme of planned maintenance, in particular to avoid adverse effects on the feed safety and hygiene of working conditions.
- Records must be kept on the maintenance of all equipment critical to the production of safe finished feed.

3.4.3.1. Cleaning

- Cleaning methods and material must be chosen depending on the characteristics of the business. Dry cleaning should be the preferred option where applicable.
- Documented cleaning programmes must be established, based on risk analysis, to ensure maintaining the safety of incoming and finished feed at all times. This programme should pay particular attention to parts of the plant beyond the CCP where one exists and/or which have been identified by the HACCP study as areas where stale products might accumulate. In particular, attention should be brought to moist feed residues in cyclones and coolers.
- High risk areas of the plant may require cleaning when shut down. This should be addressed in the HACCP. Warm equipment containing moist feed (conditioners, coolers, etc.) should be cleaned when stopped even for a short period of time.
- The cleaning programmes must be monitored and recorded.
- Further guidance on how to design a cleaning programme is given in Annex III A

3.4.3.2. Waste Management

- Any waste must be visually marked and promptly segregated to eliminate the likelihood of accidental or inadvertent use.
- Waste shall be collected or stored in dedicated waste containers. Waste containers must be covered where possible and stored away from incoming and finished feed storage or production areas.
- Waste must be disposed of legally at frequent intervals.

3.4.3.3. Pest Control

- Pest control procedures must be taken throughout the part of the supply chain for which the feed business is responsible under avoidance of contamination. Records of the pest control procedures must be kept.
- A pest control plan must be drawn up and contain active measures – including inspection - to control and limit pest activity throughout the part of the supply chain for which the feed business is responsible. Such controls must include all classes of animals (e.g. birds, insects and mammals) whether they are wild, feral or domestic.
- Pest infestations must be dealt with promptly and any actions taken must be compatible with feed products.
- Further guidance on how to design a pest control plan is given in Annex III B.

3.4.4. Personal Hygiene

- There must be adequate washing facilities.
- Protective clothing must be worn in production and loading areas.
- There must be clear policies on smoking and eating or drinking on site.
- The staff must get appropriate hygiene training for the direct handling of incoming and finished feed and cleanliness of sampling equipment.
- A procedure must be developed establishing hygiene requirements for visitors, contractors and any other person, including staff members, only temporarily on site.

3.5. Purchase, Delivery, Intake of Incoming Feed

3.5.1. Purchase

- The plant must have a standard specification mentioning the characteristics required for each incoming feed bought outside.
- A standard specification must indicate when and to what extent deviations may be accepted.

3.5.2. Specifications of Feed Materials, Feed Additives and Premixtures

- There must be specifications for feed materials, feed additives and premixtures-to be suitable for purchasing.
- Specifications must at least cover:
 - Analytical characteristics of the incoming feed;
 - The results of the risk analysis carried out for each incoming feed, e.g. the product specification and monitoring programme for undesirable substances;
 - The list of approved geographic origins and sources;
 - The types of feedingstuffs in which their use is approved;
 - Notes on any hazards or limitations on their use and any special characteristics of the incoming feed.

3.5.3. Delivery, Intake and Storage of Incoming Feed

- Each batch of feed materials, feed additives and premixtures delivered to a plant must be traceable.
- Incoming feed must be stored in dry, hygienic conditions, free from vermin and birds.
- There must be a system of site allocation for safe storage (easily identifiable, no mixing with other feed additives, intake identification easily visible). In case of doubt on the identity of a product during storage (damaged packaging), a procedure must be established whereby the Feed Safety Manager must decide about the destination of the product (re-identification, clearance for use, disposal, etc.). Records must be kept about the action taken.
- Sampling and analyses of incoming feed must be done in accordance with the control plan defined under 2.2.7.
- Designated and trained staff must be present at the point of delivery and intake.
- Water used as an ingredient in the manufacturing process must be suitable for animals. If not from human drinking water sources, it should be included in the scope of the HACCP study. The conduits for water should be of an inert nature.
- Feed materials, feed additives and premixtures that have been rejected by the Feed Safety Manager must be clearly identified and segregated from other materials in a manner which precludes their unauthorised use. Disposal of rejected feed additives and premixtures should be undertaken only after consultation with the manufacturer and/or supplier.

3.6. Manufacturing Process, Storage and Delivery of Compound Feed and Premixtures

3.6.1. Manufacturing

3.6.1.1. General Requirements

- A trained employee must be designated as the person responsible for the production process.
- The manufacturer must ensure that the different production stages are carried out according to pre-established written procedures and instructions.
- In order to obtain the desired safety of feed, these procedures must define, control and master critical points of the manufacturing process listed below.
- Both technical and organisational measures must be taken to eliminate as much as possible bacteriological contamination, carry-over and human errors to maintain the hygiene and safety standards.
- Tolerances must be defined for the dosing of each feed material and feed additive.
- A production and, if necessary, a flushing schedule must be established in order to minimise the risk for public health related to carry-over.
- Where required, equipment must be cleaned and/or flushed so as to avoid contamination between batches.
- Flushing must be collected into clearly identified containers and dealt with in accordance with written procedures, unless flushed into the original batch.

3.6.1.2. Calibration

- All inspection, measuring and test equipment used must be calibrated.
- A calibration plan must be established which specifies a.o.
 - The required calibration accuracy;
 - The frequency of calibration;
 - The calibration reference standards.
- Records must be kept on calibration and all equipment must be uniquely identifiable and traceable to calibration records.

3.6.1.3. Incorporation of Feed Additives

- Additives must be incorporated in feed in accordance with the legal requirements. Specific attention should be paid to those additives which the legislation requires to be incorporated in feed in the form of premixtures (liquid or solid), e.g. Vitamins A and D, copper, selenium, coccidiostats and histomonostats.
- Where dosage silos are used for feed additives, the equipment must include adequate dosing and locking systems. The sequence of operations for the transport of additives must be established beforehand and shall be recorded in a written procedure.
- Daily administrative records must be kept on (i) the types of feed manufactured (name) and (ii) the quantity of additives (or premixtures containing additives) of the categories mentioned in Annex IV of the Additives Regulation (EC) No 1831/2003.
- The composition of a batch of feeds to which additives are added must respect the fixed tolerances set in the product specifications.

3.6.1.3.1. Incorporation of Additives and Premixtures into Compound Feed

- Feed additives and premixtures may be added by hand. However, there must be a communication system designed to ensure that additives are correctly added in accordance with the product specifications.
- Feed additives may also be added to the appropriate feed by means of spraying: all precautions must be taken to ensure that the exact dosage is administered (as well as the spraying equipment tested and inspected according to a plan on a regular basis).
- The inclusion rate of the premixture into the compound feed should be predefined on the basis of the assessment of the efficiency of each production line, taking into account the specifications of the equipment manufacturer, the accuracy of calibration and the results of homogeneity tests.

3.6.1.3.2. Incorporation of Feed Additives into Premixtures

- The transport of feed additives in their original packaging or storage silo to the weighing and dosage equipment must be ensured by adequate conveying means.
- The incorporation of feed additives into premixtures requires a locking or warning system in order to ensure that the targeted feed additive is included into the target premixture at the suitable dose. This procedure must be consigned in writing.

3.6.1.4. Weighing

- A regular maintenance programme must ensure that the weighing equipment is kept clean and worn parts are replaced as necessary.
- The weighing equipment must be fit for the purpose and easily cleanable.
- The weighing accuracy must be fit for the quantities of products to be weighed.
- Acceptable deviations to the predefined dose should be established.
- As regards manual addition, a procedure should be established for ensuring that the right products are weighed within predefined tolerances.

3.6.1.5. Mixing

- Cleanliness of the mixer is essential.
- Written maintenance schedules must exist for the examination of the mixer to ensure that wear of the equipment does not lead to build-up of residues when the mixer is emptied.
- Mixers must operate for a pre-set time, which tests have shown to be adequate in order to ensure the appropriate mixing of feedingstuffs and feed additives.
- The accuracy and efficiency of the mixing process must be regularly checked at intervals of not more than six months to ensure that feed additives are evenly dispersed throughout the mix.

3.6.1.6. Temperature and Time Control – Pelleting and Cooling

- Finished feed shall be cooled to ambient temperature to avoid in particular the risk of condensation during storage, which is a risk factor for microbiological (re)contamination.
- Where the temperatures of the finished feed, process and/or environment are critical to the product's safety and legality, this must be adequately controlled, monitored and the control measures be recorded.
- A written procedure must exist to ensure the regular cleaning of the cooler whenever dust exists.
- Air drawn into the cooler is a potential source of bacterial contamination. Therefore, it should as far as possible be drawn from clean areas of the mill, and in particular not be drawn from intake areas.
- Attention should be paid when incorporating feed additives to their stability during the subsequent processes. Incoming feed that are incorporated after heat treatment should be subject to specific risk assessment.

3.6.1.7. Metal Detection and Magnets

- Metal detection equipment and magnets must be included in the processing systems where necessary and regularly checked for their effective operation. Records of the checks must be kept.

3.6.1.8. Management of Returns

- The production of finished feed must be organised, both on an internal and external level, with an eye to limit possible returns to a minimum.
- A procedure for the approval, handling and reuse of returns shall be established by the Feed Safety Manager. This procedure shall establish in particular the following:

Approval:

- External returns should be avoided as much as possible;
- Any external return shall be subject to approval. Feeds which have been discharged on farm must be formally risk assessed by the Feed Safety Manager before becoming an approved return, with a special attention to the integrity of the feed and any adulteration it could have undergone, including bacteriological, chemical and physical contamination;
- Unapproved returns shall be considered as waste material and must be dealt with in accordance with appropriate rules (see 3.4.3.2).

Traceability/storage:

- All approved returns must be clearly identified and the sources of returns must be identified and recorded;
- Areas where returns are stored shall be designated and records shall be kept of the amount and storage location of each return;
- The quantity of returns, which have been reprocessed, must be recorded on a daily basis. These administrative registers must also indicate the batches of the respective feed in which these returns were reprocessed and the inclusion level.

Reuse:

- Internal returns (other than flushing or cleaning material) must, as far as possible, be reincorporated into their original batch or "run". They should be handled in a closed system. Otherwise, they may be incorporated in other batches under strict conditions, in particular:
 - Return containing substances (feed materials, feed additives or where relevant, veterinary medicinal products) whose use is restricted/prohibited in certain species may not be reincorporated in feed for these species;
 - A maximum permitted percentage of approved returns shall be specified and may not be exceeded.
- Flushing or cleaning materials used to minimise carry-over of chemical substances (feed materials, feed additives or medicines) must not be placed on the market as such. It may be reincorporated in a batch of a feed in which the chemical substance is deliberately added;
- The declarations under the heading "Composition" and "Feed additives" on the compound feed label as provided for in Regulation (EC) No 767/2009 shall take into account the composition of the reused material.

3.6.2. Storage of finished feed

3.6.2.1. General Requirements

- Finished feed, which meets the specifications, must be stored in suitable packaging materials or containers.
- The finished feed must be kept in good hygienic storage facilities and only be accessible to persons who are granted an authorisation by the manufacturer.
- Storage areas must be constructed to insure maximum prevention against the entrance of domestic, feral and wild animals.
- To reduce chances of contamination, trained personnel must carry out routine checks, eliminating, to the best of their ability, the presence of these undesirables.
- The finished feed must be stored as to make it easily identifiable (product name, number, date and time of manufacture).
- The way in which finished products are stored must in no way lead to confusion or contamination between different finished feed, between feed materials or feed additives containing high levels of undesirable substances and finished feed or between supplemented feedingstuffs and feed additives.
- Compound feedingstuffs intended to be put into circulation, must comply with the provisions laid down in Regulation (EC) No 767/2009 on compound feed.
- The storage facilities must be cleared completely and cleaned on a regular basis. The cleaning procedures must follow a planned and recorded cleaning programme.
- The storage areas must enable goods to be stored in clean, dry and in orderly conditions.

3.6.2.2. Finished Feed Packaging

- Finished feed packaging must meet either internal or customer specifications and be suitable for the means of delivery and transport used and the type of finished feed. The packaging must be designed to protect finished feed.
- The packaging as well as the delivery documents must be clear and unambiguous. All relevant legal information must be included on delivery documents or attached labels to the product packaging.
- Finished feed sold in bulk and bags must include any details required under the labelling regulations in the country of production and receipt.
- Pallets must be clean and in good state and must be stored in a dry environment.

3.6.2.3. Finished Feed Labelling

- Finished feed must be labelled in accordance with the relevant legislation (see chapter 4 – reference documents).

3.6.2.4. Storage at the Customer's Premises

- In order to avoid undesirable effects on the safety of the feed, the manufacturer must inform his customers about the storage conditions of the feed, if the nature of the compound feed and premixtures delivered should require this.

3.7. Transport and Delivery

- In case transport of incoming or finished feed is subcontracted, the feed manufacturers shall check that the transporter is registered in accordance with Article 9 of Regulation (EC) No 183/2005.
- The transport of incoming as well as finished feed must be made by using only hygienic vehicles and in compliance, where existing, with a transport guide or relevant transport sections of sectoral guides developed in accordance with Article 22 of Regulation (EC) No 183/2005. Use may be made of the International Database Transport (for) Feed, establishing the level of 'the most adequate' minimal cleaning system in order to ensure the safety of products intended for animal feed, and transported subsequently.
- All means of transport whether owned or contracted, whether in bulk or packed, must be appropriate and adequately controlled with specific regard to hygiene and potential contamination.
- To facilitate the traceability of finished products during or after transport, the individual load compartments used must be recorded.
- The feed manufacturer must develop a system for order taking and fulfilment to ensure that the customer receives the type of feed he ordered, that the feed is properly labelled in accordance with the legal requirements and that all measures have been taken to ensure the safety of the feed delivered.
- Before the feed is loaded, no materials from previous loadings must remain in the container (tank truck, boxes) which must be clean and dry.
- All vehicles used for delivery of feed must be kept clean and operated according to a transport Guide. The transport guide must prescribe that:
 - A list of the 3 previous transported materials must be available;
 - All vehicles and containers, to be used for carrying feed, including those operated by third parties, should be inspected at the time of loading and found to be clean and, for the transport of dried feed, dry, in accordance with written procedures, before being used for the transport of products;
 - All vehicles used for the transport of incoming and finished feed must be subject to regular cleaning and disinfection programmes ensuring that these are in a clean state, with no accumulation of residual waste material;
 - If these vehicles are used for the transport of goods or materials presenting a health risk - as defined by the person in charge of feed safety control - the vehicles must be cleaned thoroughly, disinfected and dried as required by the guide and taking into account the HACCP study before they are used for the transport of incoming and finished feed.
- In the absence of transport guides for finished feed, other proofs of hygiene and traceability of previous loads must be specified.

- Incoming and finished feed must be protected from contamination and kept dry during transport. Enclosed vehicles or containers must be used whenever possible for loose bulk, but where this is impracticable, the loads must be covered/sheeted at all times except during loading, unloading and sampling. The cover used must be maintained in a clean condition by being regularly cleaned, disinfected and dried.

3.8. Product Traceability Records

3.8.1. Incoming Feed

- Reference samples of incoming feed shall be kept.
- Records must be kept of the following details for each delivery of incoming feed:
 - Batch/Lot number;
 - GM status;
 - Date/time of intake;
 - Delivery vehicle identification;
 - Name of incoming feed;
 - Quantity delivered;
 - Name of supplier;
 - Delivery order or reference;
 - Analytical results relevant for the feed safety management;
 - Country of origin;
 - Registration number where relevant;
 - Identifier of storage allocation.
- For purchased premixtures, the following additional records must be kept:
 - Approval or registration number where relevant;
 - Manufacturers' batch number(s) and number of containers for each batch.
- For additives, the following additional records must be kept:
 - Approval or registration number, where relevant;
 - Manufacturers' batch number(s) and number of containers for each batch;
 - Generic name of the feed additives or legal E number as mentioned in the EU register of feed additives;

- Average quantities of active substances guaranteed by the supplier;
- Instructions of use;
- Shelf life time.

3.8.2. Finished Feed

- Reference samples of all finished feed shall be kept.
- Records must be kept of following details for each batch of manufactured products:
 - Nature of the feed (product number, species of destination);
 - Batch number;
 - Manufacturing date/time;
 - Nature and proportion of feed materials, premixtures and feed additives used in accordance with the actual formula;
 - Procedures followed to ensure safety requirements and avoidance of carry-over;
 - Identifier of storage allocation.

3.8.3. Delivery

- Records must be kept regarding the customer to whom the feed was sold to:
 - Nature of the feed (product number, species of destination);
 - Batch number;
 - Name and address of the customer;
 - Date/time of delivery;
 - Delivery order or reference;
 - Delivery vehicle identification.

4. REFERENCE DOCUMENTS

4.1. EU Food and Feed Legislation (non-exhaustive list)

The following is a non-exhaustive list of EU legal reference relevant for the implementation of this guide. The Regulations are directly applicable in national law, whereas Directives shall be subject to implementation in specific national texts. All the references below shall be considered in their latest version. These may be available in consolidated format at <http://eur-lex.europa.eu/advanced-search-form.html>.

- The General Food Law Regulation ((EC) No 178/2002)
- The Feed Hygiene Regulation ((EC) No 183/2005) (including amending Regulation (EU) No 225/2012)
- The Official Control Regulation ((EC) No 882/2004)
- The Additives Regulation ((EC) No 1831/2003)
- The Directive on Undesirable Substances in Animal Nutrition (2002/32/EC including Commission Regulation 574/2011)
- The Pesticides Residues Regulation ((EC) No 396/2005).
- The Regulation laying down the rules for the prevention, control and eradication of certain transmissible spongiform encephalopathies ((EC) No 999/2001)
- The Regulation laying down health rules concerning animal by-products not intended for human consumption ((EC) No 1069/2009) and its implementation rules (Regulation (EC) No 142/2011)
- The Medicated Feed Directive (90/167/EEC)

Below a list of additional texts that are relevant for e.g. labelling or manufacturing of feed for use in organic farming

- The Marketing of Feed Regulation ((EC) No 767/2009/EEC)
- Catalogue of feed materials ((EC) No 68/2013)
- GM Food&Feed Labelling Regulation ((EC) No 1829/2003)
- Organic farming legislation ((EC) No 834/2007 and 889/2008)

4.2. International Standards

- “HACCP” Guidelines - CODEX Alimentarius Food Hygiene Basic Texts
- “HACCP” Handbook
- EU Commission guidance document for the implementation of procedures based on the HACCP principles and facilitation of the implementation of the HACCP principles in certain food businesses.
- **CODEX Code of Practice on Good Animal Feeding**

ANNEX I: GUIDANCE FOR THE APPLICATION OF HACCP PRINCIPLES

1. INTRODUCTION

Hazard Analysis and Critical Control Points (HACCP) is a system that was devised to identify, evaluate and control hazards that are significant for food and feed safety. This Guidance is designed to help operators using HACCP principles within their businesses in the following operations, although its use must be supported by thorough training by those experienced in the practical application of the principles:

- Purchase of feed materials, premixtures, feed additives and additive- like substances;
- Production of compound feeds and/or premixtures;
- Storage, packing and delivering of compound feed and/or premixtures.

In its purest form, HACCP is solely concerned with food safety and only with food intended for human consumption. The methodology behind HACCP is, however, suitable for much wider application, e.g. in the feed sector, when considering potential hazards to both human and animal health. With the introduction of the EU Feed Hygiene Regulation (EC) No 1831/2003, feed may not be placed on the market or fed to any food producing animal if they are unsafe and adherence to HACCP principles is a legal obligation for all “feed business operators”. The techniques associated with HACCP can also be used to consider additional issues that may not strictly be hazardous, but are of critical interest to the feed industry. This Guidance is intended to optimise the benefits of developing HACCP systems into practical and beneficial tools for feed businesses. In so doing, the methodology used for HACCP is utilised to consider wider issues than would be the case in textbook HACCP studies. For this reason, references in this Guidance to “HACCP” should be interpreted as meaning ‘HACCP principles’ as described in CODEX Alimentarius and “HACCP methodology” rather than “pure” HACCP.

This Guidance is designed for use both by companies for whom HACCP may be a completely new concept and also for those companies with prior experience of HACCP. Companies already operating a HACCP system will find this Guidance particularly useful if they are seeking certification against an accredited feed industry assurance scheme or have found that their existing HACCP system does not bring significant benefits to the business. HACCP systems can be effectively implemented to provide benefits to companies of all sizes, from one-man operations to multi-national corporations. This Guidance is therefore intended for use by businesses both large and small but is not meant to cover all specific situations and circumstances faced by feed business operators in all EU Member States. For this reason, practical HACCP examples were not introduced as such in this Guidance in order to prevent any inappropriate transposition of these examples into individual HACCP plans.

2. THE AIM OF HACCP IN COMPOUND FEED AND PREMIXTURE SECTORS

It is important, right at the outset, to consider what is to be achieved by using HACCP principles and then to keep this in mind throughout the whole process of developing and maintaining a risk management system.

Most businesses will be familiar with ISO 9000, which focuses on systems and procedures. However, HACCP is different as it focuses on the product. Systems, procedures and records will inevitably play a part in delivering the controls required by HACCP, but systems and procedures

are only required by HACCP where they help to maintain the integrity of the product. ISO 9000 and similar standards are not an essential requirement for a successful HACCP.

By definition, HACCP is intended to control hazards, typically divided into physical, chemical and biological hazards.

In the context of the feed supply chain, the hazards to be considered fall into two main groups:

- ***Hazards that have the potential to cause direct harm to animals eating feedingstuffs or humans consuming animal products.***

These may be physical (e.g. stones are a choking hazard, wire may pierce the gut wall, glass may cut the gut, etc.), chemical (e.g. mycotoxins produced from fungal activity, fertilisers or pesticides used in the growing of crops, etc.) or biological (e.g. various diseases, salmonellae or other pathogens).

Although compound feeds are usually designed for specific animal species, the same feed materials/additives may be fed to many animal species. The sensitivity and tolerance of different livestock species to nutrients or anti-nutrients is extremely variable. Any consideration of hazards, therefore, has to include the particular needs and sensitivities of all the species for which the feedstuff is intended.

- ***Hazards that have potential to cause actual (or perceived) harm to humans consuming animal products.***

The hazards most likely to affect humans through this route are of chemical or biological origin. For example, chemicals hazardous to humans include Aflatoxin B1 that may be present in certain feed materials, synthesised in the gut of dairy cows and excreted into milk as Aflatoxin M1. The most notorious biological hazards are probably the various types of salmonella that can be present in feed materials and feed products, ingested by livestock and subsequently contaminate eggs or carcasses. In addition, it may be that regulations, the media or consumers regard an aspect of a feed product or feed material as "hazardous" although there is no factual basis for concern. An example is the EU ban of meat fit for human consumption from any livestock feeds, where the legal framework assumes the feeding of meat is potentially hazardous and therefore the feed business operator must do the same. Control of these kinds of issues may need to be included in the HACCP Plan.

In the compound feed and premixture sectors, the aim of HACCP is to identify what hazards exist and their inherent risks having a detrimental effect on both animals and humans, and then to implement controls, so that any potential effect can be prevented or reduced to an acceptable level.

It is important to remember that potential hazards may be inherent to the products themselves (e.g. mycotoxins in crops or heavy metals in minerals) or to their production processes (e.g. by adding fertilizers or pesticides to growing crops, through combustion gases from direct flame driers and solvent residues from oil extraction). They may also be introduced subsequently during transport, storage and handling (e.g. through contamination, weather damage, pest damage or chemicals used in pest control).

In a business environment of limited financial and personnel resources, HACCP methodology helps to focus attention on the areas of the business that really matter if hazards and the risks of them occur and are to be controlled. Consequently, there is a business advantage in developing a HACCP system - it ensures right-targeted spending of money and time to assure the products' safety.

3. THE HACCP PRINCIPLES

The Codex Alimentarius Commission of the World Health Organisation has issued a list of seven HACCP principles (CAC/RCP 1 - 1969, rev. 4 - 2003), which have been widely adopted and form the basis of most HACCP guidelines.

These principles are:

- 1) Conduct a hazard analysis
- 2) Determine the Critical Control Points (CCPs)
- 3) Establish critical limit(s)
- 4) Establish a system to monitor control of the CCPs
- 5) Establish the corrective action to be taken when monitoring indicates that a particular CCP is not under control
- 6) Establish procedures for verification to confirm that the HACCP system is working effectively
- 7) Establish documentation concerning all procedures and records appropriate to these principles and their application.

These principles will be used to lead us through the development of a HACCP system in the following sections of this Guidance.

In addition, HACCP studies may cross-refer to Prerequisite programmes (see 4.5)

4. PREPARATION FOR THE HACCP STUDY

4.1. Selecting the HACCP Team

In a classic HACCP Team, the following disciplines will be represented but not necessarily by different persons in every case:

- Team Leader. This may be one of the persons identified below and ideally will be someone who has been trained in HACCP principles and has experience of applying them.
- Quality Assurance/Quality Control/Technical. This will require someone who understands the products under consideration and the historical hazards and critical issues associated with them.
- Production. This will require someone who is closely involved with the production process and has an intimate knowledge of what happens where in the process.
- Engineering. This will require someone who understands the mechanics of the processing plant, where material may accumulate inside machinery, where heat or moisture may be applied and how to gain access to machinery.
- Additional, Part-Time Expertise. This may require specialists who offer technical or specific expertise on purchasing, operational activities, distribution, microbiology, specific species requirements, etc.

It is essential that Team members are familiar with what actually happens in the business and are not too far away from day-to-day activities. They must be given the authority to carry the project forward, but may not necessarily themselves be amongst the most senior members of the company.

It is important to have a person available who is competent in HACCP techniques if no member of the Team has the necessary training and experience.

There will necessarily be a lot of documentation generated by the HACCP Study. The inclusion in the Team of someone with skills to record all this information will allow the Team to focus on the task.

For complex businesses the core HACCP Team should ideally be supplemented with:

- A qualified HACCP expert (if no member of the core Team is already qualified)
- Secretarial/computing services.

Once the HACCP Team has been appointed, it can then move on to consider the HACCP study.

4.2. HACCP Study Documentation

It is important that all parts of the HACCP Study are recorded and documented. This will provide information for the Project as it develops and references for future HACCP reviews.

4.3. Scope of the Hazard Analysis

The business can ultimately only exercise direct control over those areas where the product is owned by the business. Not all potential hazards may however be identified in this part of the supply chain and it is important for the study to consider all potential hazards, whether they are introduced in areas where the business has direct control or outside of these. This is particularly true for feed materials/additives where it will be necessary to gain an understanding of how and where these are produced and what happens to them between the point of production and their delivery to compound feed / premixtures manufacturers. Identifying the potential hazards in feed materials/additives will play a significant part in determining specifications and contractual requirements imposed upon suppliers by the business.

4.4. Products to be included in the HACCP Study and Product Descriptions

The HACCP Team must consider and document all products that are to be included in the study, as well as all locations and processes relevant to them. This should include different physical forms of products, products intended for different species and products produced by different processes. The HACCP Team must also understand the intended use of the products by the customer.

Where product specifications already exist, the HACCP Team should refer to these. Where they do not already exist, the Team must work with the relevant departments of the business to develop product specifications. It is possible that the HACCP risk assessment will uncover potential hazards that need to be included in the product specifications (e.g. limitations in the way products are used).

4.5. Prerequisite Programmes

Before undertaking a HACCP Study, a company should have in place basic operating procedures validated as effective by internal auditing systems. These procedures are referred to as “prerequisites” (i.e. “required as a prior condition”) for the HACCP system.

Some examples of prerequisite programmes include:

- Smoking, eating and drinking policy
- Cleaning schedules and hygiene audits
- Pest control programme
- Supplier approval procedures and regular re-assessment in particular after a series of non-compliances (for Salmonella, this may include control and monitoring programmes).
- Plant operating procedures and instructions
- Job descriptions and responsibilities
- Staff training including sampling and hygiene standard.
- In-house tests (for self-monitoring) to be cross checked by accredited laboratories.

The establishment and the validation of effective procedures to control potential hazards in these areas allow the HACCP System to focus on those hazards not controlled by other means. Subsequent HACCP reviews must revisit prerequisites as well as the HACCP System itself to ensure that large areas with potential hazards are not ignored.

4.6. Producing Flow Diagrams

A flow diagram (or series of flow diagrams for ease of use) should be created dividing the business process into a series of numbered steps (for ease of reference), from the start of the operation, through processing (where applicable) to distribution to the customer, taking into account any storage, transport or handling involved.

For any manufacturing business, a current engineering flow diagram should be available to the HACCP Team. The HACCP Team should confirm the details of any engineering flow diagrams produced by physically checking them against the process being studied, prior to progressing to the next stage.

Flow diagrams should include (where relevant):

- All administrative processes such as order receipt and product formulation
- All relevant inputs to the process flow, including raw materials and any products purchased for re-sale
- All mechanical process steps
- Passive equipment (such as stone traps and magnets)
- Recycle and return loops where fractions are returned to the process
- Potential areas for cross-contamination

- All areas where product is not enclosed
- Storage, packing and transport steps
- Steps where fractions are removed from the process (and do not return)

This list is not necessarily exhaustive.

The overview flow diagram will subsequently need to be broken down into smaller and more detailed sections for working purposes and the determination of potential hazards.

4.7. Description of the Business Process

It is useful to describe the business processes in simple terms. This ensures that all members of the HACCP Team fully understand the process flow. Process descriptions are helpful for external auditors and enforcement officers with statutory authority.

5. THE HACCP STUDY

5.1. Hazard Analysis (Codex Principle 1)

Hazard – “a biological, chemical or physical agent or condition with the potential to cause an adverse effect”.

HACCP concerns the product. It is essential to bear in mind both the process of production and expected use of the product.

5.1.1. Identifying Hazards

At each step of the process, the HACCP Team should list all the potential hazards that might reasonably be expected to present a threat. At this stage all hazards should be listed and any that may be removed from the study as prerequisites can be identified at a later stage.

Key considerations are:

- Hazards inherent to the product
- Hazards that may be introduced at the process step in question
- Hazards that may increase at the process step in question

5.1.2. Risk Assessment

The HACCP Team should next undertake a risk analysis of all the hazards identified. The aim is to identify those that have the highest impact on feed or food safety by assessing the likelihood of each occurring and the severity of its effect. Existing controls should be ignored in this exercise.

Some practitioners find it helpful to use a simple model for scoring hazards. A practical tool that can be used to manage the risk assessment exercise is suggested in the risk score table at the end of this guidance.

Whether or not a risk scoring method is used, it is necessary to ensure that the most significant risks receive the most attention.

5.1.3. Tabulating the HACCP Study

For ease of reference it is beneficial to use a HACCP table to summarise the data accumulated from the HACCP Study. When using such a table, it is important that the details include actions, responsibilities and timescales.

5.1.4. Creating Control Measures

Control Measure – “a control measure is any action and/or activity that can be used to prevent or eliminate a hazard or reduce it to an acceptable level”.

It is important to apply a control measure or measures wherever there is a hazard with a high risk score (3 or above) to eliminate it or reduce it to an acceptable level. The control measure(s) can take several forms but must be practical and achievable. When determining control measures the following considerations apply:

- Can the hazard be eliminated?
- Can the hazard be removed by engineering design?
- Can the hazard be managed by automated process control systems?
- Can the hazard be managed by staff action?

5.1.5. Validation

Any controls applied must be validated to ensure they are effective. For example, this means demonstrating by analytical or other means that a statement made about a control is true and the control works as intended. Records of this must be kept for future reference.

5.2. Determining the Critical Control Points (Codex Principle 2)

Critical Control Point (CCP) - “a step at which control can be applied and is essential to prevent or eliminate a hazard or to reduce it to an acceptable level”

Critical controls points (CCPs) are those that are essential for excluding hazards or for maintaining them at acceptable levels and where no subsequent process or procedure will be able to control the hazard adequately in the event of a failure. Determining whether control points are “critical” can be done using a decision tree. An example of a decision tree is shown in the chart at the end of this guidance.

Having determined and confirmed the CCPs it is important to clearly identify them in all HACCP-related documentation. In the case of physical equipment these should be clearly labelled or otherwise identified.

5.3. Establishing the Critical Limits (Codex Principle 3)

Critical Limit – “a criterion separating acceptability from unacceptability”

Having determined all the CCPs in the process under study, the HACCP Team must detail the critical limits for the control measures at each of these. The critical limit is what separates the acceptable from the unacceptable. Some critical limits will be determined by legislative requirements, while others will be determined by experience or scientific research.

5.4. Establishing a Monitoring System (Codex Principle 4)

Monitoring – “the act of conducting a planned sequence of observations or measurements to assess whether a control measure is operating within specified parameters”

Businesses must be aware when critical limits have been breached or where there is a trend indicating that they may be breached. Achieving this may require automatic recording, observation and/or testing. Whichever methodology is most appropriate, monitoring must be recorded.

Ideally, monitoring systems must be designed to identify as quickly as possible any controls that are becoming ineffective, prior to their failure. Therefore, the frequency of any monitoring is also important and should be specified as part of the HACCP System.

It is essential that properly qualified and authorised staff undertakes monitoring activities and those authorised to undertake monitoring must be specified in the HACCP System. For example, if testing forms part of the monitoring activity, the HACCP System must define how samples are taken, and by whom, as well as who monitors the test results. The monitoring frequency must also be specified in the HACCP System.

5.5. Establishing a Corrective Action Plan (Codex Principle 5)

Corrective Action – “an action to be taken when monitoring indicates a loss of control”

The HACCP Team must specify the actions to be taken in the event of a CCP going out of control. Responsibilities for implementing corrective actions must be clearly assigned and documented.

It is important to ensure procedures also consider action to be taken with regard to any product processed since controls were last confirmed as operating within acceptable limits. This may require bonding of stock or even recall of products from customers or intermediaries.

5.6. Verification (Codex Principle 6)

Verification – “the application of methods, procedures, tests and other evaluations, in addition to monitoring, to ensure compliance with the HACCP Plan”

Verification systems must be implemented by the HACCP Team to ensure not only that all personnel staff are complying with the requirements of the System, but also that the System is effective. Verification systems must review the whole HACCP System and its associated records. There may be several CCPs in the HACCP Plan to control one hazard type each with its own appropriate monitoring. However, the verification activity should cover the control of that hazard throughout the whole process. When establishing verification systems, the following should be considered:

- Sampling & Testing
- Complaints Monitoring
- Internal Auditing of the HACCP System
- External Auditing of the HACCP System

5.7. Establishing Documentation (Codex principle 7)

No HACCP System will work effectively unless the controls it identifies as necessary are properly implemented. In most circumstances this will require the establishment of procedures and records. Therefore, a HACCP System must include two types of documentation.

- The HACCP Plan itself - this encompasses all the details previously described in this Guidance.
- Procedures and Records - these include written procedures detailing control measures and other aspects of the HACCP Plan, together with associated records. These may form part of a quality system (such as ISO 9001/2), or may solely be connected to the HACCP Plan. For practical purposes, it is usually most effective to integrate HACCP Procedures and Records into the overall quality system of the business, wherever possible.

6. HACCP SYSTEM REVIEW AFTER IMPLEMENTATION

6.1. Immediate HACCP System Review

There are a number of circumstances under which sections of the HACCP System, or even the whole HACCP System, may need to be reviewed immediately. In particular, where any changes are being considered, the HACCP Review must always form part of the planning process. In such circumstances the HACCP Team must instigate an immediate review to ensure all identified hazards will still be under control and no new ones result from the changes. Minutes of Immediate Reviews must be kept for future reference and be considered as part of the Scheduled Review. Some examples of circumstances that may require an Immediate Review of part or all of the HACCP System are noted below (this list is not exhaustive):

- Changes in raw materials, suppliers or sources
- Changes in formulation
- Changes in factory equipment or layout
- Proposed modifications or replacement of process and handling equipment
- Changes in cleaning or maintenance practices
- Changes in packaging, transport or storage
- Changes in personnel, whether replacement or reduction in numbers
- Changes in product type or use
- Changes in customer basis that may affect the hazard analysis
- Changes in legislation/other requirements
- A breach of HACCP critical limits
- Feedback/complaints from customers
- New knowledge regarding potential hazards

6.2. Scheduled HACCP System Review

At least annually, the HACCP Team must meet to discuss the HACCP System from start to finish in a scheduled HACCP Review. Minutes must be kept of Scheduled Reviews for future reference. Among the issues to be considered are:

- The records of any breaches of critical limits, corrective actions that were implemented at the time and the lessons to be drawn from this. The aim should be to ensure that critical limits are never breached.
- Records of any deviations from targets and the lessons to be drawn from this. Excessive deviation from targets may indicate controls are too loose and need to be tightened. Very few deviations from target may suggest controls are too tight and excessive costs could be incurred as a consequence.
- The results of any internal or external audit and any lessons to be drawn from these. (It is however essential not to use an impending review as an excuse to leave corrective actions unresolved).
- The continued validity of the principles upon which the HACCP System has been built. Do changes in regulations, industry and company practices, equipment or personnel require changes to be made at the level of the HACCP System? (This is to ensure that no changes have escaped Immediate Review.)

In any effective HACCP System fully integrated within a business, the above areas should be addressed on a routine basis and not be left for the Scheduled HACCP System Review.

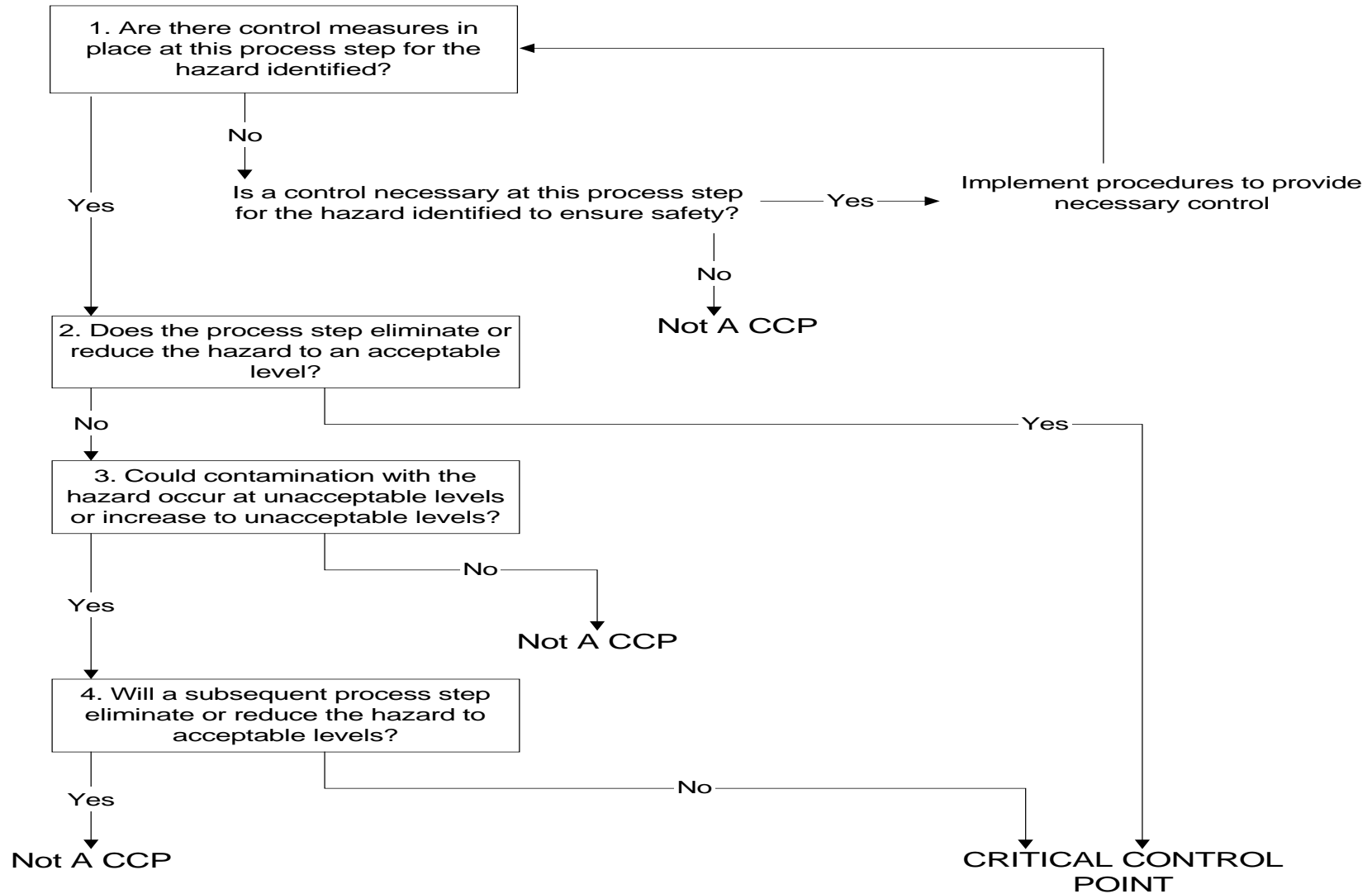
Risk Score (the combined value of severity and probability of occurrence)

Risk Assessment		Probability of Occurrence (if not controlled)		
		High (3)	Medium (2)	Low (1)
Severity Of Occurrence	High (3)	9	6	3
	Medium (2)	6	4	2
	Low (1)	3	2	1

This table is based on two basic elements for risk characterisation, i.e. severity and probability. Where appropriate, additional parameters such as the detectability or additional ranking category (“very high” for instance) may be included in order to allow a specific adaptation of the risk assessment on a case by case basis.

HACCP Critical Control Point Decision Tree

Questions should be followed in sequence for each hazard identified at each process step



7. SPECIFIC GUIDANCE FOR THE SALMONELLA AND OTHER MICROBIOLOGICAL RISK

The microbiological safety of animal feeds has implications for both animal health and consumers of livestock products. Animal feed is a significant vector for the entry of Salmonella into the food chain. Serotyping is a necessary step in the analysis which is important for the traceability.

7.1. Defining CCP/CPs for the risk management of Salmonella and other pathogens

Prerequisites programmes and, if relevant, Control points (CP) shall be defined in relation to the risk with Salmonella and other pathogens. Companies may identify one or several Prerequisites / CPs. If a CCP is identified, Prerequisites / CP may not be needed before that CCP (subject to risk assessment) unless they are needed to secure the functionality of the CCP. Microbiological objectives may be different depending on animal species. Similarly, Prerequisites / CPs may differ depending on the type of feed being produced (e.g. meal vs. pellets).

Typical control points in a compound feed mill may be:

- Analytical control at reception of incoming feed materials and premixtures: where there is no CCP further on in the process, the Salmonella risk management objective is to monitor Salmonella entering the feed mill. In some instances incoming feed is rejected or treated before being accepted in the feed mill or action taken to change the supplier. Analytical control of incoming feed shall focus on those at-risk. In the case of liquid feed, a good indicator can be PH. Such a control point is not easy to handle, because of the time required before analytical results are known, in particular serotypes. If there is a CCP further on in the process, analytical control at reception of incoming feed serves a screening / suppliers evaluation and improvement purpose and allow reducing contamination of premises, which can be important for the feed safety of final product.
- Heat treatment / pelleting: at-risk feed materials or compound feeds may be subject to heat treatment that reduces/controls Salmonella and other pathogens. The control focuses on effective heat treatment parameters (time/temperature/moisture) as long as these parameters have been proved efficient to effectively reduce/control microbiological contamination. In this respect, a standard pelleting is not expected to suffice. Alternatively, the control may also focus on compliance with microbiologically defined objectives in relation to the likely level of contamination; this point may serve as a CCP.
- Chemical treatment: this process aims at inhibiting/controlling Salmonella and other pathogens in incoming or finished feed by using chemical substances specifically authorised for this purpose in feed². Controls are based on records of quantities of chemical substances used. The instructions on the chemical substance which are given in the safety/product data sheet should be strictly adhered to (e.g. concentration or application time).

Monitoring of final feed alone is not adequate to measure the efficiency of the CPs and CCPs within the process, but may serve as a verification tool.

² The use of formaldehyde as biocide for treatment of feed, permitted in certain EU countries, will be prohibited from 1 July 2015.

7.2. Monitoring programme

A monitoring plan for Salmonella and other pathogens must be established by compound feed and premixture manufacturers for incoming feed focusing particularly, but not exclusively, on those of higher risk. To this end, attention should be paid to the EFSA report on [Microbiological risk assessment in feedingstuffs for food-producing animals - Scientific Opinion of the Panel on Biological Hazards](#) from July 2008 singling out oilseed meals, and feed materials of animal origin as the generally most frequently contaminated feed materials as well as recently harvested grain/wheatfeed. The notifications to the RASFF are also an important source of information (http://ec.europa.eu/food/food/rapidalert/rasff_portal_database_en.htm).

The frequency for sampling and analysis depends on the animal which the feed is intended for. This is relevant in particular for feed mills dedicated to certain species. Since poultry is more salmonella-sensitive, the monitoring programme for the production of poultry feed should be more intensive. If Salmonella is found in a sample, a further serotyping must be performed. Further sub-typing methods such as pulsed field gel electrophoresis (PFGE), ribotyping or sequencing may be helpful to further trace the origin of identical serotypes.

The monitoring plan for Salmonella and other pathogens must identify possible contamination during the process and help understanding the reason for contamination in the process. This monitoring plan is based on risk assessment and is redefined when needed based on results of previous monitoring plans or process changes.

Whenever a control point (CCP) is defined, the monitoring plan shall focus on it. Sampling at subsequent points in the process will verify the effectiveness of the CCP. The monitoring plan should focus on the environment and, if applicable processing equipment, with a key focus on the clean part of the plant, i.e. after the CCP/treatment.

The monitoring results for Salmonella and other pathogens will be used to verify whether the HACCP plan, including all process control points, pre-requisites and corrective actions taken are effective in controlling Salmonella.

The monitoring plan should be adapted to the risk management strategy of the operator and its suppliers, including wholesalers and shippers.

Generic monitoring plans established at national level as part of official or sector specific control programme for Salmonella in feed should serve as a baseline for the design of the company specific monitoring plan. By default, the elements laid down in par. 7.2.1 – 7.3.3 should be used as a guideline by compound feed and premixtures manufacturers to design their own monitoring plan.

7.2.1. Incoming feed

- Monitoring of feed materials is performed on feed materials at reception in particular if there is no control step further on in the process and in case of contamination detected in a finished feed, having regard to traceability. The focus of the monitoring should be on those feed materials with the highest risk profile (e.g. oilseed meals, fishmeal and recently harvested grain / wheatfeed). Analytical results available from the supplier may be used but it is necessary to check that these are reliable (e.g. from accredited laboratories, same batch or same production date).

7.2.2. Buildings

- The focus of the analyses should be on dust or swab samples from ledges, walls and floors. Samples from dust units and vacuum cleaners may be included. Dust is important to sample as Salmonella concentrates in dust that is derived from the surface of feed particles and pellets.
- Swabs should be used only in wet areas, e.g. where there is condensation or pooled surface water and smooth surfaces with very little dust. Dust samples should be used only for dry areas.
- Sampling frequency shall be adapted to the microbiological status of the plant.

7.2.3. Plant and equipment

- The focus of the analyses should be on dust escaping from coolers, pellet shakers and outloading gantry chutes. Dust around bagging equipment can also be included.
- Other operations where dust, feed or swab samples could be taken are intake, grinding, weighing, hand addition, mixing, pelleting, cooling, (inside and outside the cooler), cyclone, heating area, conveying and packing areas in manufacturing plants as appropriate.
- Swabs should be used only in wet areas and smooth surfaces with very little dust. Dust samples should be used only for dry areas.
- Sampling frequency shall be adapted to the microbiological status of the plant.

7.2.4. Storage areas

- The focus of the analyses should be on dust or swab samples from storage bay walls and floors, ceiling/top of the silos, storage bin tops (inside and outside) and outloading areas.
- Sampling frequency shall be adapted to the microbiological status of the plant.

7.2.5. Finished feed

- The focus should be put on those finished feed with the higher risk.

7.2.6. Vehicles

- The focus of the analyses should be on dust or swab samples from sheets, covers, internal bodies, rear door or hatch and blower units of bulk vehicles, as well as buckets and vehicle bodies of loading shovels.

7.3. Corrective actions

Any finding of Salmonella must be further investigated. Highly drug resistant Salmonella and repeated isolation of the same serotype may also trigger further investigations. The action to be taken following the isolation of Salmonella and other pathogens will depend on the circumstances of the isolation, the serotype and the existence of CP/CCPs in the process.

7.3.1. Incoming feed

- If reception is a control point, the following actions shall be considered:
 - Restricted use if there is no CCP further on in the process; or
 - Decontamination of feed materials in the plant;
 - Information of the supplier whatever the serotype;
 - Handling in agreement with the supplier (decontamination offside, disposal, return to supplier, etc.) under the supervision of control authorities, having regard where appropriate to the national policy on serotypes.
- Otherwise
 - Clean and flush intake, routes and storage;
 - Vehicle cleaning (whether own vehicles or third party);
 - Consider additional cleaning of plant and equipment; and
 - Review of test frequency and test results on incoming feed, in particular when the serotype is known as of high significance for public health.

7.3.2. Processing equipment

- If a control point is identified in the manufacturing process, the following actions shall be considered:
 - Review of parameters of the decontamination process (heat treatment); and
 - Consider additional cleaning of plant and equipment after the CP/CCP;
 - Consider additional training or changes in process or procedures
- Otherwise
 - Cleaning of plant and equipment
 - Controls of rodents, birds, pets and feral animals in case of repeated contamination that cannot be related to incoming feed.

7.3.3. Finished feed

- Carry out traceability to identify the source of contamination;
- Review processing conditions and relevant pre-requisite programmes;
- Review previous monitoring results;
- Additional cleaning of storage and vehicles (where appropriate);
- Additional cleaning of plant and equipment;
- Review of test frequency and test result on finished feed;
- Information and handling in agreement with the customer (decontamination, disposal, return, etc.) under the supervision of control authorities, having regard where appropriate to the national policy on serotypes;
- Consider additional training or changes in process or procedures.

ANNEX II: SPECIFIC REQUIREMENTS FOR MEDICATED FEED

Preamble

On request of the EU Commission, this Annex is provided to assist feed business operators producing medicated feed in complying with additional feed safety requirements laid down in EU Directive 90/167/EC on medicated feed. These additional requirements have been classified along the structure of the EFMC for easy reading. Requirements laid down in Directive 90/167/EEC applying not only to the manufacturing of medicated feed have been directly inserted in the EFMC. Any requirement in the core part of the EFMC applying to incoming feed also applies by extension to pre-mix for medicated feedingstuffs. Likewise, any requirement applying to finished feed also applies by extension to medicated feed.

1.1. Scope

- This Annex is relevant to companies involved in the processing or producing of medicated feed on the same plant as conventional compound feed.

1.2. Legal Definitions

Premix for medicated feedingstuffs: Any veterinary medicinal product prepared in advance with a view to the subsequent manufacture of medicated feedingstuffs (Directive 2001/82/EC).

Veterinary medicinal product:

- a) Any substance or combination of substances presented as having properties for treating or preventing disease in animals; or
- b) Any substance or combination of substances which may be used in or administered to animals with a view either to restore, correct or modify physiological functions by exerting a pharmacological, immunological or metabolic action, or to make a medical diagnosis (Directive 2001/82/EC as amended by Directive 2004/28/EC).

2.1. General Requirements

2.1.2. Management Responsibilities

- A Medicated Feed Manager with proven and adequate qualifications must be appointed as responsible for medicated feed in the company.
- This Medicated Feed Manager is in particular responsible for the control of orders of premix for medicated feedingstuffs and the validation of the list of authorised premix for medicated feedingstuffs (authorised at either EU or national level) and the list of approved suppliers of premix for medicated feedingstuffs. He is also responsible for the scheduling programme established under 3.6.1 and the validation of the register (see 3.8) and must assure that controls are operated as foreseen.

2.1.4. Training

- Training must include safety precautions to be taken in handling veterinary medicinal products and medicated premixtures as indicated by their manufacturer.

2.2. Traceability, Record Keeping and Product Recall

2.2.4.2. Supplier Assessment

- A list of approved suppliers of premix for medicated feedingstuffs must be established and maintained under the supervision of the Medicated Feed Manager.
- Incoming premix for medicated feedingstuffs must be delivered by suppliers approved or registered according to the Community code related to veterinary medicinal products.

2.2.6. Record Keeping

- The records compiled in the register (see 3.8) must be kept for at least three years after the date of the last entry and must be available at any time to the competent authorities in case of checking.

2.2.7. Control plan

- The control plan for medicated feed, must address the nature, the shelf life and the inclusion rate of the premix for medicated feedingstuffs as well as the homogeneous dispersion of veterinary medicinal products concerned in the finished feed. A particular attention shall be paid to carry-over of veterinary medicinal products into following batches of feed.
- To establish the frequency of the controls, the operators shall take into account the following criteria:
 - Quantity of the production of medicated feed per year;
 - Variety of medicated feed produced.

In any case, homogeneity, stability and carry-over tests shall be conducted at regular intervals at the most relevant stage of the process at least every three years.

- The results of the controls must be recorded and must contain:
 - Name of the product;
 - Batch number;
 - Reference to specifications and modalities of control of the product;
 - Where relevant, analytical results;
 - Date of the control;
 - Details of the person in charge of the control;
 - Action taken in case of non-conformity.

2.2.9. Non-conforming Feed and Product Recall

- Non-conforming finished medicated feed recalled from customers should be disposed of.
- Non-conforming feed stored in the manufacturing plant should be dealt with disposal or rework under the responsibility of the Medicated Feed Manager.
- Returns of medicated feed from customers must not be accepted.

2.3. Inspection, Sampling and Analyses (monitoring)

2.3.1.2. Sampling

- Samples are taken for each batch of premix for medicated feedingstuffs and retained for a period appropriate for the use to which the feed is placed on the market.
- The following information must be mentioned on the sample label:
 - Generic name of the premix for medicated feedingstuffs;
 - Date of reception of the premix for medicated feedingstuffs;
 - Batch number of the supplier or internal batch number if different from the supplier's batch number;
 - Quantity.
- Samples are taken for each batch of manufactured medicated feed and retained for a period appropriate for the use to which the feed is placed on the market.
- The following information must be mentioned on the sample label:
 - Name of the medicated feed;
 - Batch number of the medicated feed;
 - Manufacturing date;
 - Quantity;
 - Batch number and name of the incorporated premix for medicated feedingstuffs;
 - Active substance level.
- By derogation, the label may only contain the batch number, provided all other information items are collated together and available in a (electronic) file.

3.2. Control of Contaminants and Carry-over

3.2.1. Carry-over

- Each medicated premixture must be regarded as critical substance for the purpose of control of carry-over.
- The scheduling programme defined in 3.6.1 must avoid the manufacturing of withdrawal feed or feed for continuous food producing animals such as dairy cows or laying hens after the manufacturing of medicated feed. Cleaning procedures and instructions after production of medicated feed and before resuming production of conventional compound feed must be available to the workers on their working place.
- In order to further reduce the risk of carry-over, the following measures shall among others be considered:
 - Use of premix for medicated feedingstuffs formulated in such a way as to lower dust emission;
 - Specific areas and equipment dedicated to the weighing of premix for medicated feedingstuffs;
 - Use of equipment with full emptying.

3.3. Veterinary Medicinal Products

- Veterinary medicinal substances must only be incorporated in medicated feed in the form of authorised premix for medicated feedingstuffs in accordance with Directive 2001/82/EC on the Community code relating to veterinary medicinal products. When provided for under national law, veterinary medicinal products may be incorporated in the medicated feed in the form of intermediate products prepared from such premix for medicated feedingstuffs and from one or more feed materials.
- Premix for medicated feedingstuffs must be mixed in appropriate quantity and in a homogeneous and stable way following the manufacturer's instructions of use to ensure that medicated feed contain the quantity as specified.

3.4. Plant Design and Maintenance / Personal Hygiene

3.4.2. Storage, Production Facilities and Manufacturing Equipment

- The dosing, weighing and transport equipment for premix for medicated feedingstuffs must be adapted to the level of concentration of the premix for medicated feedingstuffs to be weighed.

3.4.2.3. Dust Control

- Specific attention must be paid to those premixes for medicated feedingstuffs with high propensity to generate dust. Specific measures must be defined for such premix for medicated feedingstuffs to minimise the impact of such dust on the level of carry-over. This should include provisions regarding dust disposal or rework.

- The incorporation device for premix for medicated feedingstuffs must be designed in such a way as to reduce dust emissions and to facilitate the cleaning and the maintenance.
- The efficiency of dust controls on premix for medicated feedingstuffs must be checked at least once a year. If appropriate the criteria of these dust controls may be adapted accordingly.

3.5. Purchase, Delivery, Intake of Incoming Feed

3.5.2. Specifications of Premix for Medicated Feedingstuffs

- A list of authorised premix for medicated feedingstuffs must be established and checked frequently. The list must include the denomination of the premix for medicated feedingstuffs and their authorisation numbers.

3.5.3. Delivery, Intake and Storage of Incoming Feed

- Premix for medicated feedingstuffs must be stored in suitable separate and secured rooms or hermetic containers which are specifically designed for the storage of such products. Access to premix for medicated feedingstuffs must be restricted to the Medicated Feed Manager and staff members specifically authorised by him.
- Each batch of premix for medicated feedingstuffs delivered to the plant must be traceable.
- There must be a system of site allocation for safe storage (easily identifiable, no mixing with other premix for medicated feedingstuffs, first-in-first-out principle, intake identification easily visible). In case of doubt on the identity of a product during storage (damaged packaging), a procedure must be established whereby the Feed Safety Manager must decide about the destination of the product (clearance for use, disposal, etc.). Records must be kept about the action taken.
- Premix for medicated feedingstuffs that have been rejected by the Feed Safety Manager must be clearly identified and segregated from other materials in a manner which precludes their unauthorised use. Disposal of rejected premix for medicated feedingstuffs should be undertaken only after consultation with the manufacturer and/or supplier.

3.6. Manufacturing Process, Storage and Delivery of Compound Feed and Premixtures

3.6.1.1. General Requirements

- Tolerances must be defined for the dosing of each medicated premixture.
- Medicated feed may be manufactured only by an approved manufacturer.
- Medicated feed should be delivered either directly to farmers or to approved distributors, in accordance with national law.
- Medicated feed may not be delivered to the final customer before the original of the prescription is transmitted to the person responsible for delivering the medicated feed (i.e. the manufacturer or an approved distributor).

- Unless otherwise specified under national law, medicated feed may be manufactured before the emission of a prescription.
- Unless otherwise specified under national law, the veterinary prescription:
 - Must be established on the basis of the model annexed to Directive 90/167/EC;
 - Is valid for no more than 3 months;
 - Is valid for one treatment only.
- Medicated feed may be produced only from nationally or EU authorised premix for medicated feedingstuffs or intermediate products produced from the mixture of these premix for medicated feedingstuffs with feed materials. Medicated feed produced from a medicated premixture authorised in the country of production may be put on the market of another Member State if the active substance is authorised as medicated premixture in the Member State of destination.
- By derogation, medicated feed may be produced from premix for medicated feedingstuffs not authorised in the Member State of production when the medicated feed is destined to another EU Member State and the premix for medicated feedingstuffs used is approved in the Member State of destination. In that case, the premix for medicated feedingstuffs and the medicated feed must be stored in separate areas with a clear indication that the product is destined to delivery to another Member State.
- Medicated feed must be produced from a single medicated premixture. By derogation, medicated feed may be produced from several premixes for medicated feedingstuffs on prescription and under the responsibility of the prescribing veterinarian provided that there is no specific authorized therapeutic agent in premixture form for the disease to be treated or for the species concerned or it is not available within the timeline required to minimize the impact on animal welfare. The number of premixes included in a medicated feed must be documented.
- The manufacturer must ensure that the medicated feed may not contain the same coccidiostat or histomonostat, incorporated as feed additives, as the active substance contained in the medicated premixture.
- The manufacturer must ensure that the daily dose of veterinary medicinal product is contained in a quantity of feed corresponding to at least half the daily feed ration of the animals treated or, in the case of ruminants, corresponding to at least half the daily requirements of non-mineral complementary feed.

3.6.1.3. Incorporation of Premix for Medicated Feedingstuffs into Animal Feed

- Where dosage silos are used for premix for medicated feedingstuffs, the equipment must include adequate dosing and locking systems.
- Daily administrative records must be kept of (i) the types of feed manufactured (name) and (ii) all premix for medicated feedingstuffs that have been incorporated into these feeds. The latter information must be recorded chronologically in a register (see 3.8).
- The composition of a batch of animal feed to which premix for medicated feedingstuffs are added must respect the fixed tolerances set in the marketing authorisations of premix for medicated feedingstuffs.

3.6.1.3.1. Incorporation of Premix for Medicated Feedingstuffs into Compound Feed

- Premix for medicated feedingstuffs may be added by hand. However, there must be a communication system designed to ensure that premix for medicated feedingstuffs are correctly added in accordance with the marketing authorisations of premix for medicated feedingstuffs.

3.6.1.6. Temperature and Time Control – Pelleting and Cooling

- The pelleting conditions must be adapted to the stability of the incorporated medicated premixture.
- Dust sieving shall be suspended to avoid medicated feed being reincorporated into subsequent batches of other feed.

3.6.1.8. Management of Internal Returns

- Any rework of internal returns of medicated feedingstuffs must comply with pre-established procedure and be subject to approval by the Medicated Feed Manager.

3.6.2.1. Storage - General Requirements

- The manufacturer shall have suitable and adequate storage designed in such a way as to avoid contamination with other finished feed.
- Medicated feedingstuffs shall be stored in suitable separate and secured rooms or hermetic containers which are specially designed for the storage of such products

3.6.2.2. Finished Feed Packaging

- Medicated feed may be placed on the market only in packages or containers (including individual truck load compartments) sealed in such a way that, when the package is opened, the closure of the seal is damaged and they cannot be re-used. Where the design of bulk vehicles does not permit appropriate sealing, written procedures must be implemented to protect the integrity of each parcel of a medicated feed.

3.6.2.3. Finished Feed Labelling

- The label of medicated feed must be labelled with the indication “Medicated feedingstuffs”.

3.7. Transport and Delivery

- Vehicles used for the transport of medicated feed must be cleaned as required by the Guide and taking into account the HACCP study before they are used for the transport of incoming or finished conventional feed.
- Medicated feed may only be delivered to the final customer on presentation of the prescription. The manufacturer must check that the medicated feed has been produced in accordance with the prescription.

- For medicated feed destined to another Member State, the delivery shall be accompanied by a certificate issued by the Member State of origin whenever required by the Member State of destination.

3.8. Product Traceability Records

- The manufacturer must ensure that all information relating to the purchase, manufacture and delivery of medicated feed is readily available and can be reconciled to enable traceability. The following information must be collated and recorded on a daily basis in a register:
 - For premix for medicated feedingstuffs:
 - Generic name of the premix for medicated feedingstuffs and veterinary medicinal substance;
 - Name and address of the supplier;
 - Date of reception;
 - Where relevant, the name of market authorisation / product licence number holder;
 - Manufacturers' batch number(s) and number of containers for each batch;
 - Average quantities of active substances guaranteed by the supplier;
 - Shelf life;
 - Internal batch number if different from the supplier's batch number;
 - Stocks of premix for medicated feedingstuffs.
 - For medicated feed:
 - Nature, quantity and batch number of the medicated feed;
 - Nature and quantities of medicated premixture used;
 - Theoretical concentration of the active substances;
 - Date/time of production;
 - Names and addresses of the customers to which the medicated feed was delivered;
 - Where relevant, the prescription number and the name and address of the veterinarian;
 - Stocks of medicated feed.
- The register may take the form of an electronic file.
- The register is kept for a period of three years at least.
- Prescriptions are kept for a period of three years at least.

ANNEX III: GUIDELINES FOR IMPLEMENTATION OF CERTAIN SECTIONS OF THE EFMC

A. GUIDANCE FOR THE DEVELOPMENT OF A CLEANING PROGRAMME

Cleaning must remove residues and dirt that may be a source of contamination. The necessary cleaning methods (e.g. physical methods such as vacuum cleaning or chemical) and materials will depend on the nature of the business and may include disinfection, but must be compatible with feed safety legislation. However, disinfection alone is not sufficient and shall be completed by other cleaning steps. Because bacteria need moisture to grow, wet cleaning is often undesirable and should only be used where shown to be necessary as part of the HACCP plan and may include disinfection which must be done with effective disinfectants at suitable concentration where appropriate. Wherever possible, vacuum cleaning is best practice and compressed air should be avoided.

Operators must ensure that at all stages of the production, storage or handling of incoming feed and finished feed sufficient standards of cleanliness are operated in such a way that exposure to pests and pathogens is minimised.

Only food compatible cleaning and disinfectant shall be used in accordance with manufacturers' recommendations and safety data sheet requirements. Where cleaning agents and disinfectants / sanitizers come into contact with feed ingredients, the operator must ensure that control systems provide the correct and effective dilution levels at all times.

Cleaning and disinfection agents must be food and feed compatible and stored separately.

Where process machinery, conveyors or storage vessels are cleaned using wet cleaning methods, these must be dried prior to use.

The operator must establish a cleaning programme. He may contract the service to a competent organisation. The cleaning programme should specify:

- The responsible person / organisation.
- The product manufacturing and storage areas as well as transport facilities and manufacturing equipment that must be kept clean.
- The method for cleaning (including a description of the chemical agent used where relevant).
- The frequency of cleaning.
- The authorised person for inspection.
- The storage area of the chemical agents where relevant.
- Records of cleaning operations and inspections.

B. GUIDANCE FOR THE DEVELOPMENT OF A PEST CONTROL PLAN

When developing a pest control programme, the operator may either contract services to a competent pest control organisation, or shall have trained personnel, for the regular inspection and treatment of premises to stop and eradicate pest infestation. Where the services of a pest control contractor are employed, the service contracted shall be clearly defined and reflect the activities of the site. The effectiveness of the pest control programme must be reviewed periodically.

Animals must, wherever possible, be excluded from the grounds of factories and the area surrounding stores and processing plants, in particular the bulk feed out-loading areas, intake pits and vehicle parking areas. Where the presence of wild birds and other pests is unavoidable, procedures must be implemented to protect incoming and finished feed from potential contamination. Wherever there is a significant risk from pests, access points must be proofed against their entry. Doors must be kept closed whenever possible and must be close-fitting and proofed against pests when closed.

Buildings must be kept in good repair and condition to prevent pest access and to eliminate potential breeding sites. Holes, drains and other places where pests are likely to gain access must be kept sealed wherever possible. Where sealing is not possible, measures such as wire mesh screens must be in place to reduce the possibility of pest entry.

Waste and scrap materials, old pallets, overgrowth of vegetation or other materials which can encourage and harbour rodents must be removed from the proximity of the building. In particular, feed spills should be promptly removed.

Only approved pesticides handled by trained operators shall be used for pest control. Control measures should be in place to ensure that poison baits cannot contaminate the feed. This may include using non-grain baits and securing bait points to avoid accidental contamination. Where practical, baits should be outside the actual production and storage areas unless there is a current pest problem in these areas.

Where shooting is undertaken, non-toxic ammunition must be used.

The pest control plan should specify:

- Qualifications of staff / organisation involved in pest control activities.
- A list of targeted pests (rodents, birds, insects, pets and feral animals etc.).
- The product manufacturing and storage areas as well as transport facilities that must be inspected.
- The frequency of inspection.
- The method for preventing pest intrusion (traps, etc.).
- The method for eliminating pests (traps, chemicals including Product Safety Data Sheet).
- The type of pesticides (including safety data sheets) and their storage area.
- Map(s) indicating the location of any bait stations and the baits which are used.
- The storage area of the chemical agents where relevant.
- Records of any pest found.
- Details of corrective actions implemented.

C. GUIDANCE FOR HOMOGENEITY TESTS

Purpose of the homogeneity test: to check the dispersion of feed additives and veterinary medicinal products across appropriate batch sizes, thus allowing measuring the mixer efficiency.

The frequency of homogeneity tests is defined in the control plan. However, the frequency of tests must be intensified in case of repeated deviations.

Method of measurement: a batch of feed is manufactured, containing the target parameter, which typically could be a trace element, a mineral or an external tracer. Minimum 8 samples need to be taken as close to the mixer discharge as possible and at predetermined intervals throughout the batch and put into sequentially numbered containers. The whole set of individual samples must be sent for separate analysis. The test must be conducted on the maximum batch size.

Interpretation of the data must look at variation between samples and may also look at average recovery.

Interpretation of results: a target maximum percent coefficient of variation (CV) and mean percent recovery must be established taking into account the analyte, the target levels and background values. In most cases, a target CV of less than 10% should be achieved.

In case the CV would exceed the target, corrective actions should be implemented, e.g. increasing mixing time.

The CV is expressed as the ration standard deviation (SD) / mean, expressed in percentages.

D. GUIDANCE FOR CALIBRATION PROCEDURES

The calibration procedure should include the following elements:

- Person responsible for maintenance of measurement devices.
- Unique identifier of all measurement devices.
- Calibration accuracy for each device.
- Calibration protocol traceable to international or national measurement standards. Where no standards exist, the basis for calibration or verification must be recorded.
- Frequency of calibration (should be adapted depending on the results of the previous calibration tests).
- Records of calibration results and validation.
- Corrective actions (adjustment, verification of the validity of previous measurement results).

E. GUIDANCE FOR THE MEASUREMENT AND CONTROL OF CARRY-OVER

Several factors may influence the level of carry-over of a substance in a feed mill: the facilities themselves (the equipment of the facilities), the substance itself, the feed matrix and the measures that are taken to control carry-over.

Measurement of premise bound carry-over - carry over test

Several methods exist to measure the plant bound carry-over. These methods must follow the following general principles:

- The tracer (a constituent of the feed such as a feed additive - coccidiostats or an external tracer), the carry-over target and the sampling stage must be determined in accordance with the risk assessment.
- One or several batches of feed containing the tracer are manufactured.
- The measure must be carried out on at least the next batch of feed manufactured after the batch containing the tracer.
- In case several batches of the same lot are produced, samples must be representative of the lot. The number of samples must be defined in such a way as to minimise the risk of misevaluation.
- When analysing the tracer, samples may be gathered.
- Results interpretation: the carry-over is calculated as a percentage of the concentration in the first batch manufactured without tracer divided by the concentration of the tracer in the last batch containing the tracer.

In case the carry-over would exceed the target, corrective actions should be implemented.

On the basis of the results of carry over tests, the operators must define the sequence of production.

Sequence of production

Sequencing (or scheduling) of production does not allow for a reduction of carry-over but enables to manage carry-over in order to prevent any adverse impact on animal or public health.

- Each plant must establish its own rules for drawing up production schedules derived from the HACCP study taking into account the premise bound carry-over test, the characteristics of the substances (depending on adhesive strength, electrostatic properties and the size and density of the particles) and the species for which they are authorised. In addition, attention should be paid to the risk for animal and public health, with the adoption, where required of scheduling exclusions (e.g. no production of horse feed after a batch of feed containing ionophores). This task shall be conducted by the Feed Safety Manager.
- In order to establish this schedule, the company must define for each substance regarded as at-risk further to the HACCP study the number of batches to be produced between a batch containing a given active substance (additive including coccidiostats and histomonostats or veterinary medicinal substances) and a batch for a non-target species or for withdrawal feed or for continuous food producing animals (dairy cows, laying hens). This number of batches will be defined for each animal species, taking into account the level of carry-over of the plant, the physical characteristics of the substance and the level of risk for animal and public health.

Flushing

Where necessary, the equipment must be flushed to avoid carry-over between batches. Flushing must be done using a specified amount of wheat feed or other suitable material, proven to purge the system adequately.

F. GUIDANCE FOR SAMPLING METHOD

- Sampling must be designed to obtain a sample that is as representative of the sampled batch of material as possible, taking into account the likelihood of non-uniform distribution of contamination.
- Sampling can be done either manually or automatically, using automated in line sampling devices. A proper labelling of the samples is necessary so that the batch can be identified later. It should include the name of the product, the date, the name of the supplier and batch number, etc.
- For manual sampling, a suitable recipient (scoop, hand scoop, mug, etc.) or instrument (a sampling drill, etc.) is required. Incremental samples are collected in a catch basin (e.g. plastic bucket). In this catch basin, the incremental samples are mixed to form an aggregate sample and then split into a bag or a jar.
- If a sampling probe is used, it should be adjustable to the depth of the space. The sampling device must be adjusted according to the size of the incremental sample and the sampling frequency.
- The sampling materials, as well as the surfaces and recipients, must be kept in a dry and clean condition and must be free of odours. One must ensure that the material used, is not a source of contamination. The materials must be easy to clean, to inspect and to maintain.
- Once the sample is taken, it must be labelled and sealed, and stored in a way so as to prevent alteration of the product.
- If necessary, samples must be refrigerated.

Monitoring equipment and location

- Samples should be collected from the complete batch. For incoming products, it is possible to take samples from the product flow during unloading. If using an automatic sampling device, it is recommended, to collect the sample as close as possible to the place where the product changes ownership.
- Samples should be collected in a way so as to prevent contamination (e.g. with dust, rain, previous products).

Composition of the final sample

- The final sample is taken from the aggregate sample, which in turn consists of several incremental samples. The incremental samples should be equal in size. The incremental samples may be collected by allowing a small portion of the batch to continuously flow through the sampling device, or by taking, a with intervals determined series of incremental samples.
- The incremental samples are then gathered in a receiving bin. The product is carefully mixed to ensure homogeneity of the aggregate sample.
- The final sample is taken from the aggregate sample. A certain quantity is being kept in a bag or a jar (sealed and labelled).

Quantity and number of samples

- The quantity and number of incremental samples depend on the tonnage of the product to be sampled. For incoming feed, tables 1 and 2 in which the number of incremental samples and the quantity of the final sample is indicated, are applicable.
- The final sample for finished feed may be composed of a single sample taken at the point of loading if the whole batch is loaded at once.

- **Table 1: Quantities up to 500 ton**

Size of consignment	Number of incremental samples	Quantity of the aggregate sample	Final sample
Up to 15 tons	5	10 kg	500 g
15 to 30 tons	8	16 kg	500 g
30 to 500 tons	11	22 kg	500 g

- **Table 2: Quantities exceeding 500 tons**

Size of consignment	Aggregate sample	Final sample
501 to 5,000 tons	20 kg/500 tons	500 g
>5,000 tons	10 kg/500 tons	500 g

The sending of samples to a laboratory

After taking a representative sample and storing it in a sealed container, if the sample is intended to be analysed, it is of utmost importance that the sample is rapidly analyzed. Unnecessary delays in demonstrating a potential hazard or security problem can be avoided, if the sample is rapidly sent to the lab. Deterioration in the quality of the sample will thus be avoided. For example, if the sample is stored in a sealed container for some time, condensation might occur. This could affect the analysis results.

The reference samples of incoming feed and each batch of product manufactured must be retained for a period appropriate to the use for which the feed is placed on the market.

Additional instructions as regards sampling for the purpose of analysing for microbiological quality

In case of sampling for the purpose of analysing for microbiological quality, the following additional guidance should be followed:

- Samples of feed for microbiological analysis should be taken and preserved very carefully.
- The person taking the samples must take care not to contaminate the sample or the product being sampled from either footwear, clothing or personal contact.
- Samples of finished feed should be taken directly after treatment, attention being paid to the duration of the treatment as recommended by the supplier of chemical products in case of chemical treatment or the minimum duration of treatment as defined as part of the HACCP study.
- Poor storage conditions (such as the presence of condensation in the bag, or a too long waiting period) could affect the analysis results.
- Sampling instruments (e.g. shovel and bucket) should be cleaned and/or disinfected.
- In case of manual sampling, disposal items should be used such as long gloves used by vets or inseminators.

- Manual sampling of feed should use the following technique:
 - The bag inverted over the hand;
 - The sample is taken by pushing the bag into the material, filling the hand (app. 25 grams) and then pulling the bag back over the hand without touching the inside of the bag;
 - If sampling tools are used they must be sterile;
 - Tie a knot in or otherwise seal the bag.
- Any labelling of the test sample is attached externally above the knot or written on the outside without breaking the bag. As minimum include in the identification of the test sample to link it to: date of sampling, site, initial of sampler, unambiguous description of the sampling point.
- Samples of 25-100g dust should be collected using a gloved hand or clean brush/scrapper from dry places/surfaces where dust has escaped from equipment on to the surrounding floor, surface of the equipment or nearby beams and ledges but also material from vacuum cleaning. Dust from sieves, coolers and cyclone aspiration systems as well as on beams beside outloading bin chutes is useful for identification of Salmonella that has been present at a low level or intermittently in the bulk material that has been processed. Swabs should be used only for sampling wet places where there is condensation and scrapings only when specifically investigating the location of a problem within closed equipment (e.g. inside of the cyclone, cooler, etc.). A serotyping should always take place if the detection of salmonella was positive.
- Samples must be sent, as soon as possible after sampling, to the laboratory. Large temperature differences should be avoided.

ANNEX IV: LIST OF NATIONAL GUIDES TO GOOD PRACTICE BASED ON THE EFMC

EU Member States

- Portugal (IACA): [Guia de Boas Práticas para os Industriais de Pré-Misturas e de alimentos compostos para animais destinados à produção de géneros alimentícios](#)
- The Netherlands (Productschap Diervoeder): [GMP+-certification scheme B1](#)
- Belgium (OVOCOM): [Code GMP général pour le secteur de l'alimentation animale \(NL\)](#)
- Luxembourg (OVOCOM): [Code GMP général pour le secteur de l'alimentation animale](#)
- Italy (ASSALZOO): [Codex-ASSALZOO](#)
- France (SNIA/Coop de France Nutrition Animale): [Guide de Bonnes Pratiques de la Fabrication des Aliments Composés pour Animaux](#)
- Germany (QS): [QS Leitfaden für die Futtermittelwirtschaft](#)
- UK (AIC): [Universal Feed Assurance Scheme \(UFAS\)](#) - Code of Practice for the Manufacture of Safe Compound Animal Feedingstuffs
- Spain (CESFAC): [Alimentacion Animal Certificada](#)
- Czech Republic (CMSO ZZN): [Pravidla správné výrobní hygienické praxe pro výrobce premixů a krmiv s použitím premixů nebodoplnkových krmiv určených k výživě hospodářských zvířat.](#)
- Denmark (DAKOFO): EFMC has been translated in the national language and will serve as the reference code for the organisation's members (contact [DAKOFO](#) for more information)
- Ireland: [Irish Feed Assurance Scheme](#) - Code of Practice for the Manufacture of Safe Compound Animal Feedingstuffs
- Austria (VFÖ): [Austrian Feed Manufacturers' Code - Guidelines on the control of Salmonella in the feed production \(to be released soon\)/Leitfaden zur Beherrschung von Salmonellen in der Futtermittelproduktion.](#)
- Poland (IZBA Gospodarcza): EFMC has been translated in the national language and will serve as the reference code for the organisation's members (contact [IZBA](#) for more information)
- Slovakia (AFPWTC): Slovak Feed Manufacturers' Code (contact [AFPWTC](#) for more information)
- Finland (FFDIF): [Finish Feed Manufacturers' Code](#)
- Croatia (CFIA): Croatian version of EFMC (contact [CFIA](#) for more information)

EFTA countries

- Switzerland (VSF): SFPS Schweizerischer Futtermittel-Produktionsstandard ([Leitlinien für eine gute Verfahrenspraxis für die Herstellung von Futtermitteln \(FR\)](#))

ANNEX V: LIST OF REPRESENTATIVES OF EUROPEAN FEED BUSINESS SECTORS CONSULTED FOR THE DEVELOPMENT OF THE FIRST VERSION OF THIS GUIDE

- **Starch Europe:** Association des Amidonniers et Féculiers
- **AVEC:** Association of Poultry Processors and Poultry Trade in the EU countries
- **BEUC:** The European Consumers' Organisation
- **CEFS:** Comité Européen des Fabricants de Sucre
- **CIDE:** European Dehydrators Association
- **COCERAL:** Comité du Commerce des Céréales, Aliments du Bétail, Oléagineux, Huile d'Olive, Huiles et Graisses et Agrofouritures
- **COPA-COGECA:** European Farmers - European Agri-Cooperatives
- **EDA:** European Dairy Association
- **EEPA:** European Egg Processors Association
- **EFPRA:** European Fat Processors and Renderers Association
- **EMFEMA:** International Association of the European Manufacturers of Major, Trace and Specific Feed Mineral Materials
- **EMRA:** European Modern Restaurant Association
- **EUROCOMMERCE:** Retail, Wholesale and International Trade Representation to the EU
- **EUROMALT:** Committee of the Malting Industry of the European Union
- **European Flour Millers Association:** European Flour Millers Association
- **FEDIOL:** EU Oil and Protein Meal Industry
- **FEFANA:** EU Feed Additives and Premixtures Association
- **FoodDrinkEurope:** European Food and Drink Industry
- **IFAH-Europe:** International Federation for Animal Health - Europe
- **IFFO:** International Fish Meal and Fish Oil Organisation
- **UECBV:** European Livestock and Meat Trading Union