

Export Food Production Safety and Health Requirements (2011 – 23rd Notice)

出口食品生产企业安全卫生要求 (2011 年第 23 号公告)

Article 1

In order to regulate the safety and health management of export food production enterprises and improve the quality of food safety and hygiene, according to the relevant provisions of the "Food Safety Law of the People's Republic of China" and its implementing regulations, and the Codex Alimentarius Commission "General Rules for Food Hygiene" Make this requirement. This requirement is a general principle and regulation on food safety and hygiene for export food producers.

Article 2

The enterprises engaged in the production, processing and storage of foodstuffs for export registration shall hereinafter conduct their production, processing, storage and transportation in accordance with the laws and regulations of the State and relevant importing countries (regions) and the food safety and hygiene standards, and abide by the following basic principles:

- (1) Bear the main responsibility for food safety;
- (2) Establishing and implementing a food safety and hygiene control system centered on hazard analysis and prevention and control measures, and ensuring the effective operation of the system;
- (3) Retain the food safety information in the food chain and maintain the traceability of products;
- (4) Equipped with appropriate production equipment and professional and technical personnel and health quality management personnel;

(5) To assess the risk of intentional pollution and possible unexpected problems existing in the production process, establish preventive control measures and implement food protection plans if necessary;

(6) Establish a mechanism of integrity, to ensure that the data and information provided is true and valid.

Article 3

Export food producers shall establish and effectively operate the food safety and hygiene control system and meet the following requirements:

- (1) Analyze the source of the product, the intended use, the method of packaging, the mode of consumption and the technological process of the product, etc., identify the hazards that may exist in the food itself and in the production and processing, and take the corresponding preventive and control measures; the key to influencing food safety and hygiene procedures should be clear operational procedures to ensure effective control, timely correction of deviations, continuous improvement of deficiencies, all of which should be recorded;
- (2) To establish and effectively implement the procedures for the evaluation of qualified suppliers of raw materials, food additives and food-related products;
- (3) Establish and effectively implement food processing and hygiene control procedures to ensure that the processing water (ice), food contact surfaces, processing and operation sanitation, personnel health and hygiene, toilet facilities, external pollutants, pest control and poisonous and harmful substances are under control, and recorded;
- (4) To establish and effectively implement the product traceability system, accurately record and maintain the information and batches of food safety related to the food chain, and identify the completeness and effectiveness of product traceability;
- (5) To establish and effectively implement a product recall system to ensure that manufactured products with safety or health quality issues are promptly warned about and recalled if necessary;
- (6) To establish and effectively implement the control system for nonconforming products, including the identification, recording, evaluation, segregation and disposal of nonconforming products;
- (7) To establish and effectively implement the procedures for the maintenance of processing equipment and facilities and ensure that the processing equipment and facilities meet the needs of production and processing;

- (8) To establish and effectively implement the staff training plan and make training records so as to ensure that the personnel in different positions are proficient in their own work;
- (9) Establishing the internal audit system of management system and continuously improving the safety and health control system of enterprises;
- (10) For the relevant records reflecting the control of product safety and hygiene, the administrative regulations such as marking, collection, cataloging, filing, storage, custody and handling shall be formulated and implemented. All records should be true, accurate, standardized and traceable, with a retention period of not less than 2 years.

Article 4

The export food producing enterprises listed in the export food producing enterprise that must carry out HACCP system certification and verification shall establish and implement HACCP according to the requirements of the Codex Alimentarius Commission "HACCP System and Its Application Guidelines" system.

Article 5

Export food producers shall ensure that their production and management personnel are suitable for their job needs and meet the following requirements:

- (1) Access to the production area should maintain good personal hygiene and sanitation; entering the manufacturing area clothes should be changed, hands washed, disinfection; coveralls, hats and shoes should be disinfected and maintain cleanliness;
- (2) Persons involved in food production should be physically qualified before they can go to work and undergo annual health check. Any person who has an infected wound, skin disease, gastrointestinal disease or respiratory disease that may contaminate food should report his symptoms or disease, and be dismissed from work;
- (3) Health quality control personnel engaged in supervision, guidance and staff training shall be familiar with the relevant laws and regulations of the country and relevant importing countries (regions) and food safety standards, and shall have the qualifications and abilities to adapt to their work. After passing the job examination.

Article 6

The environment of the factory of export food producing enterprises shall avoid pollution and meet the following requirements:

- (1) Enterprises should be located far away from poisonous and harmful sites and other sources of pollution. The design and construction of such sites should avoid exposure to toxic materials. No other products in the plant area should be engaged in, produced and stored in a manner that impedes the hygiene of food.

- (2) The production area should be isolated from the non-production area, otherwise effective measures should be taken so that the production area will not be polluted and disturbed by the non-production area;
- (3) The establishment of storage facilities for raw materials, auxiliary materials, finished products, chemical substances and packaging materials that are suitable for the production capacity and meet the requirements of hygiene as well as facilities for the temporary storage of sewage, waste and garbage;
- (4) The main roads should be laid for the passage of vehicles hardened pavement (such as concrete or asphalt pavement, etc.), the road is smooth, no water, no dust;
- (5) Avoid the existence of breeding places for mosquitoes and flies, waste and garbage containers should be spill-proof, impermeable, anti-corrosion and waste and garbage should be kept neat, and disposed of in a timely manner;
- (6) Bathroom toilets should be washed, hands should be washed, flies, rat and other pest controls should be in place, maintain adequate natural or mechanical ventilation, keep clean with no odors;
- (7) Drainage system should be kept clear, no odors;
- (8) There should be rodent-proof and fly-proof facilities and toxic bait should not be used. Animals that are not related to the production and processing should not be present. Dogs kept for safety purposes may not enter the production area.
- (9) The treatment and discharge of waste water, waste materials and dust generated in the production shall comply with the relevant state regulations.

Article 7

The manufacturing areas and facilities for food production and processing shall be set up reasonably and easily for proper maintenance and cleaning. The surfaces of the articles, devices and equipment in contact with the food shall be clean and smooth, and shall be cleaned and sterilized at the proper frequency and Meet the following requirements:

- (1) The manufacturing areas area and height should be compatible with the production capacity and equipment placement to meet the food processing flow and processing and sanitation requirements of the processed food; the non-toxic materials such as anti-skidding, sealing, anti-absorption should be easy to clean and easy to drain and wash the structure, keep clean, ensure that good flow of waste water/sewage flows from clean area to non-clean area; product exports should have anti-rodent and insect proof measures.

- (2) The manufacturing area interior walls, doors and windows light color, good sealing, anti-absorption, easy to clean non-toxic building materials, keep clean and smooth, sterilize when necessary, open windows should be equipped with pest-fly screens;
- (3) Manufacturing area roof or ceiling and overhead structures shall be capable of preventing the formation, falling off of dust, mildew and condensed water and keeping them clean;
- (4) The manufacturing area should have sufficient natural or artificial lighting, light does not change the true nature of the processed material is appropriate, light intensity should be able to ensure the production, testing the normal operation of posts; fixed lighting facilities should have protection to prevent debris falling into food
- (5) Temperature and humidity control requirements of the process and place, installation of temperature and humidity display device;
- (6) The manufacturing area should have suitable natural or mechanical ventilation facilities to keep the manufacturing area ventilated. The intake and exhaust system should be designed and constructed so that it is easy to maintain and clean, allowing air to flow from a high-clean area to a low-clean area.
- (7) Adequate number of hand-washing, disinfection, hand drying equipment or supplies, shoe disinfection facilities and hand-washing faucets shall be provided at suitable places in the manufacturing area without manual switch-on and, when necessary, the manufacturing area shall supply hot water of suitable temperature for hand washing;
- (8) There is a locker room connected with the manufacturing area and corresponding to the number of employees. There are separate locker rooms in different cleaning requirements areas. Bathrooms meeting the sanitary requirements are set up as required. The locker rooms and toilets should be kept clean and free from any peculiar odors, its facilities and layout should avoid polluting the manufacturing area;
- (9) The manufacturing area should have separate areas for the cleaning and disinfection of food containers and industrial utensils to prevent the cleaning and disinfection areas from polluting the manufacturing area. The cleaning and disinfecting facilities should be easy to clean with sufficient water supply and drainage capacity and if necessary hot water supply;
- (10) Equipment and containers (excluding disposable containers and packaging) in contact with foodstuffs shall be made of non-toxic materials which are resistant to corrosion, rust, absorption and easy to clean. They shall be constructed to be easy to clean and disinfect and neatly arranged and well maintained

- (11) Containers for waste and non-food products shall be made of impermeable material and be specially marked. Containers containing chemical substances should be identified, if necessary locked away;
- (12) A sufficient sewage discharge system should be provided and kept open, suitable waste disposal facilities should be provided to avoid contamination of food or the production water;
- (13) The raw and auxiliary material library shall meet the storage requirements, be hygienic and tidy, temperature and humidity controlled when necessary; store separately different raw and auxiliary materials to avoid being damaged and contaminated.

Article 8

Production and processing water (including ice, steam) should ensure safety and health, and meet the following requirements:

- (1) Belong to the city water supply, the local health administrative department shall require the annual inspection and obtain the official issued by the test certificate of conformity;
- (2) Facilities that have their own water supply shall be tested and qualified by the local health administrative department prior to use; they shall be tested at least once every half year and obtained the official test certificate issued by the government;
- (3) Where the importing country (region) has a clear request for water quality, it shall comply with the relevant requirements;
- (4) Storage facilities, water pipelines made of non-toxic materials, the outlet should prevent reflux device. Water storage facilities should be built in non-polluting areas, regularly cleaned and disinfected, and protected;
- (5) Non-production and processing water should be fully identified in the independent system of recycling, shall not enter the production and processing water system.

Article 9

Export food producers shall take effective measures to ensure the safety of raw materials, food additives and food-related products and meet the following requirements:

- (1) According to the characteristics of raw and auxiliary materials, it should avoid being polluted by environmental pollutants, agricultural inputs, chemical substances, pests, plant and animal diseases and other diseases in the primary production process;
- (2) Should be purchased, the use of raw materials and accessories, food additives, food-related products that meet the requirements of safety and health requirements, require suppliers to provide permits and product certification documents, and suppliers to

conduct a comprehensive assessment of the failure to provide qualified documents
Food raw materials, should be tested in accordance with food safety standards;

- (3) Animal-derived raw materials for secondary processing shall come from the export food producing enterprises filed with the inspection and quarantine institutions;
- (4) If the subcontracted food production enterprise does not change the traits of food or only cut it simply and does not use other physical or chemical methods to process the food, its raw materials should come from the export food manufacturing enterprises filed by the inspection and quarantine institutions;
- (5) The raw materials for import shall be provided with the valid certification documents of the exporting country (region) and the import inspection certificate issued by the inspection and quarantine authority;
- (6) A system of inspection record of raw materials, food additives and food-related products should be established to faithfully record the name, specifications, quantity, supplier's name and contact information, date of purchase, etc. The raw materials of food, food additives, Food-related products accepted into the plant after the standard use; Exceed the shelf life of raw materials, food additives, food-related products shall not be used for food production, non-food substances shall not be used for food production;
- (7) The food additives shall be used in accordance with the provisions of the varieties, the scope of use and the dosage of food additives in the standards of the state and the relevant importing countries (regions).

Article 10

The process of food production and processing shall prevent cross-contamination, ensure that the products are suitable for consumption by consumers, and meet the following requirements:

- (1) Processing technology should be designed to prevent cross-contamination; according to the processing technology and product characteristics, through physical separation or time staggered, different cleaning and sanitation requirements of the area separately set to control the processing area of flow of people and logistics to prevent cross-contamination;
- (2) According to the processing technology, product characteristics and expected consumption, control the processing time, product temperature and manufacturing area ambient temperature, to ensure the accuracy of temperature measurement device and regularly calibrated;
- (3) Effective control of special processing links closely related to food safety and hygiene such as freezing, cold storage, cooling, heat treatment, drying, irradiation, chemical

preservation, vacuum or improved air packaging shall be scientifically based or internationally accepted standards Prove that the steps taken to meet the safety and health requirements;

- (4) To establish and effectively implement the cleaning and disinfection procedures for production equipment, tools, containers and venues, to carry out sanitary cleaning work after the first shift and to inspect them by hand;
- (5) Containers for food shall not directly touch the ground; collect any nonconforming product, ground product or waste that has been produced during the process by using special containers with obvious signs and shall be disposed of in a timely manner and the container And transport timely disinfection;
- (6) The waste water and waste generated in the process shall not cause any pollution to the products and manufacturing areas hygiene;
- (7) The process of internal and external packaging should prevent cross-contamination, if necessary, between the inside and outside the packaging should be set separately; for the packaging of food, packaging materials in line with safety and health standards and maintain clean and complete to prevent contamination of food; re-use of food packaging the material should be easy to clean and sterilized if necessary. The packaging mark should meet the relevant laws and regulations of the country and the relevant importing country (region). The packaging materials should be kept dry, and the inner and outer packaging materials should be stored separately to avoid being contaminated.

Article 11

The foodstuffs to be exported shall be hygienically cleaned and stored in accordance with the following requirements:

- (1) The repository should be kept clean, disinfected regularly, anti-mildew, anti-rat, anti-insect facilities; products should be clearly marked for traceability, and maintain a certain distance from walls and ground;
- (2) Pre-cooling, quick-freezing, cold storage should meet the product temperature and humidity control requirements, equipped with automatic temperature recording device and regularly calibrated; regular defrosting, defrosting operation may not contaminate the product within the warehouse or cause the product does not meet the temperature requirements;
- (3) Transport should be kept clean and well-maintained, according to product features with rain, dust, cooling, insulation and other facilities; transport process to maintain the necessary temperature and humidity to ensure that products from damage and pollution, if necessary different food will be effectively isolated.

Article 12

Enterprises should avoid the use of chemical products to pollute the products and meet the following requirements:

- (1) Specialized warehousing, for detergents, disinfectants, pesticides, fuels, lubricating oils and chemical reagents, used in factories, manufacturing areas and laboratories shall be stored and marked clearly, the regulations on the administration of storage and requisition of chemicals shall be established and strictly implemented, Set up a special custody and record, in accordance with the instructions for use of the product;
- (2) The chemicals temporarily used in the production and processing area should be locked away and access controlled;
- (3) To avoid contamination of food, food contact surfaces and food packaging materials.

Article 13

Enterprises shall monitor the safety and hygiene of the products by testing and shall meet the following requirements:

- (1) Where an enterprise has a laboratory, it shall be reasonably arranged so as to avoid any pollution to production, processing and products. It shall be equipped with inspectors of relevant professional and technical qualifications, lab management documents, standard materials and inspection facilities required for carrying out the work And instruments and equipment; testing equipment should be required to test or calibrate; should be in accordance with the provisions of the procedures and methods of sampling, in accordance with relevant national standards, industry standards, corporate standards, such as testing the product to determine and keep records of test results;
- (2) If an enterprise entrusts a 3rd party laboratory with the enterprise product testing items, it shall have the corresponding qualifications and abilities as identified or approved by the competent department and sign a contract.

Article 14

New technology should provide scientific basis or internationally accepted standards to prove their compliance with safety and health requirements, approved by the competent authorities before they can be applied.

In the premise of ensuring food safety and hygiene, if necessary, according to the traditional process of production and processing products.

Article 15

This requirement by the national certification and accreditation supervision and management committee is responsible for the interpretation.

Annex 2:

Implementation of export food production enterprises product catalog

Classification Number and Product Category

- 01 canned food
- 02 aquatic products
- 03 meat and meat products
- 04 tea
- 05 enteric-coated
- 06 bee products
- 07 egg products
- 08 frozen fruits and vegetables, dehydrated fruits and vegetables
- 09 sugars
- 10 milk and dairy products
- 11 drinks
- 12 alcohol
- 13 peanuts, dried fruit, nut products
- 14 kinds of preserved fruits
- 15 food products and noodles, sugar products
- 16 edible oils and fats
- 17 seasoning
- 18 quick-frozen instant food
- 19 functional foods
- 20 edible gelatin class
- 21 pickled vegetables
- 22 others

Annex 3:

Export food production enterprises need to verify the HACCP system catalog

Classification Number and Product Category

- 1 cans
- 2 aquatic products (live goods, chilled, drying, except pickled products)
- 3 meat and meat products
- 4 quick-frozen vegetables
- 5 fruit and vegetable juices
- 6 frozen instant foods containing meat or aquatic products
- 7 milk and dairy products category

出口食品生产企业安全卫生要求（2011年第23号公告）

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第一条 为规范出口食品生产企业的安全卫生管理，提高食品的安全卫生质量水平，根据《中华人民共和国食品安全法》及其实施条例、国际食品法典委员会《食品卫生通用规范》等有关规定，制定本要求。本要求是对出口食品生产企业在食品安全卫生方面的一般性原则和规定。

第二条 申请出口备案的食品生产、加工、储存企业（以下简称出口食品生产企业）应依照国家和相关进口国（地区）法律、法规及食品安全卫生标准进行生产、加工、储存、运输等，并遵守以下基本原则：

- （一）承担食品安全的主体责任；
- （二）建立和实施以危害分析和预防控制措施为核心的食品安全卫生控制体系，并保证体系有效运行；
- （三）保留食品链的食品安全信息，保持产品的可追溯性；
- （四）配备与生产相适应的专业技术人员和卫生质量管理人员；
- （五）评估生产过程中存在的人为故意污染风险及可能的突发问题，建立预防性控制措施，必要时实施食品防护计划；
- （六）建立诚信机制，确保提供的资料和信息真实有效。

第三条 出口食品生产企业应建立并有效运行食品安全卫生控制体系，并达到如下要求：

- （一）分析产品的来源、预期用途、包装方式、消费方式及产品工艺流程等信息，识别食品本身和生产加工过程中可能存在的危害，采取相应的预防控制措施；对影响食品安全卫生的关键工序，应制定明确的操作规程，保证控制有效、及时纠正偏差、持续改进不足，做好记录；
- （二）建立并有效执行原辅料、食品添加剂、食品相关产品的合格供应商评价程序；
- （三）建立并有效执行食品加工卫生控制程序，确保加工用水（冰）、食品接触表面、加工操作卫生、人员健康卫生、卫生间设施、外来污染物、虫害防治、有毒有害物质等处于受控状态，并记录；
- （四）建立并有效执行产品追溯系统，准确记录并保持食品链相关食品安全信息和批次、标识信息，实现产品追溯的完整性和有效性；
- （五）建立并有效执行产品召回制度，确保出厂产品在出现安全卫生质量问题时及时发出警示，必要时召回；
- （六）建立并有效执行对不合格品的控制制度，包括不合格品的标识、记录、评价、隔离和处置等内容；

- (七) 建立并有效执行加工设备、设施的维护程序，保证加工设备、设施满足生产加工的需要；
- (八) 建立并有效执行员工培训计划并做好培训记录，保证不同岗位的人员熟练完成本职工作；
- (九) 建立管理体系内部审核制度，持续完善改进企业的安全卫生控制体系；
- (十) 对反映产品安全卫生控制情况的有关记录，应制定并执行标记、收集、编目、归档、存储、保管和处理等管理规定。所有记录应真实、准确、规范并具有可追溯性，保存期不少于 2 年。

第四条 列入必须实施危害分析与关键控制点（HACCP）体系验证的出口食品生产企业范围的出口食品生产企业，应按照国家食品法典委员会《HACCP 体系及其应用准则》的要求建立和实施 HACCP 体系。

第五条 出口食品生产企业应保证其生产和管理人员适合其岗位要求，并符合下列要求：

- (一) 进入生产区域应保持良好个人清洁卫生和操作卫生；进入车间时应更衣、洗手、消毒；工作服、帽和鞋应消毒并保持清洁卫生；
- (二) 与食品生产相关的人员应经体检合格后方可上岗并每年进行健康检查，凡出现伤口感染或者患有可能污染食品的皮肤病、消化道疾病或呼吸道疾病者，应立即报告其症状或疾病，不得继续工作；
- (三) 从事监督、指导、员工培训的卫生质量管理人员，应熟悉国家和相关进口国（地区）的相关法律法规、食品安全卫生标准，具备适应其工作相关的资质和能力，考核合格后方可上岗。

第六条 出口食品生产企业的厂区环境应避免污染，并符合下列要求：

- (一) 企业选址应远离有毒有害场所及其他污染源，其设计和建造应避免形成污垢聚集、接触有毒材料，厂区内不得兼营、生产、存放有碍食品卫生的其他产品；
- (二) 生产区域宜与非生产区域隔离，否则应采取有效措施使得生产区域不会受到非生产区域污染和干扰；
- (三) 建有与生产能力相适应并符合卫生要求的原料、辅料、成品、化学物品和包装物料的储存设施，以及污水处理、废弃物和垃圾暂存等设施；
- (四) 主要道路应铺设适于车辆通行的硬化路面（如混凝土或沥青路面等），路面平整、无积水、无积尘；
- (五) 避免存有卫生死角和蚊蝇孳生地，废弃物和垃圾应用防溢味、不透水、防腐蚀的容器盛放和运输，放置废弃物和垃圾的场所应保持整洁，废弃物和垃圾应及时清理出厂；
- (六) 卫生间应有冲水、洗手、防蝇、防虫、防鼠设施，保持足够的自然通风或机械通风，保持清洁、无异味；
- (七) 排水系统应保持畅通、无异味；

- (八) 应有防鼠、防虫蝇设施，不得使用有毒饵料；不宜饲养与生产加工无关的动物，为安全目的饲养的犬只等不得进入生产区域；
- (九) 生产中产生的废水、废料、烟尘的处理和排放应符合国家有关规定。

第七条 食品生产加工车间及设施均应设置合理，易于进行适当的维护和清洗，与食品接触的物品、装置和设备表面均应保持清洁、光滑，以合适的频次进行有效清洗和消毒，并符合下列要求：

- (一) 车间的面积、高度应与生产能力和设备的安置相适应，满足所加工的食品工艺流程和加工卫生要求；车间地面应用防滑、密封性好、防吸附、易清洗的无毒材料修建，具有便于排水和清洗的构造，保持清洁、无积水，确保污水从清洁区域流向非清洁区域；车间出口及与外界连通处应有防鼠、防虫蝇措施；
- (二) 车间内墙面、门窗应用浅色、密封性好、防吸附、易清洗的无毒材料修建，保持清洁、光滑，必要时应消毒，可开启的窗户应装有防虫蝇窗纱；
- (三) 车间屋顶或者天花板及架空构件应能防止灰尘、霉斑和冷凝水的形成以及脱落，保持清洁；
- (四) 车间内应具备充足的自然或人工照明，光线以不改变被加工物的本色为宜，光线强度应能保证生产、检验各岗位正常操作；固定的照明设施应具有保护装置，防止碎片落入食品；
- (五) 在有温度、湿度控制要求的工序和场所安装温湿度显示装置；
- (六) 车间应具有适宜的自然或机械通风设施，保持车间内通风良好。进排风系统在设计 and 建造上应便于维护和清洁，使空气从高清洁区域流向低清洁区域；
- (七) 在车间内适当的地点设足够数量的洗手、消毒、干手设备或者用品、鞋靴消毒设施，洗手水龙头应为非手动开关，必要时车间还应供应用于洗手的适宜温度热水；
- (八) 设有与车间连接并与员工数量相适应的更衣室，不同清洁要求的区域设有单独的更衣室，视需要设立符合卫生要求的卫生间，更衣室和卫生间应保持清洁卫生、无异味，其设施和布局应避免对车间造成污染；
- (九) 车间内宜有独立区域用于食品容器和工器具的清洗消毒，防止清洗消毒区域对加工区域的污染，清洗消毒设施应易于清洁，具有充分的水供应和排水能力，必要时供应热水；
- (十) 与食品接触的设备 and 容器（一次性使用的容器 and 包装除外），应用耐腐蚀、防锈、防吸附、易清洗的无毒材料制成，其构造应易于清洗消毒，摆放整齐并维护良好；
- (十一) 盛装废弃物及非食用产品的容器应由防渗透材料制成并予以特别标明。盛装化学物质的容器应标识，必要时上锁；
- (十二) 应设有充分的污水排放系统并保持通畅，应设有适宜的废弃物处理设施，避免其污染食品或生产加工用水；
- (十三) 原辅料库应满足储存要求，保持卫生和整洁，必要时控制温度和湿度；不同原辅料分别存放，避免受到损坏和污染。

第八条 生产加工用水（包括冰、蒸汽）应确保安全卫生，并符合以下要求：

- （一）属于城市供水的，应按当地卫生行政部门要求每年检测并取得官方出具的检测合格证明；
- （二）属于自备水源的，应在使用前经当地卫生行政部门检测合格；使用中应至少每半年检测一次并取得官方出具的检测合格证明；
- （三）进口国（地区）对水质有明确要求的，按相关要求执行；
- （四）储水设施、输水管道应用无毒材料制成，出水口应有防止回流的装置。储水设施应建在无污染区域，定期清洗消毒，并加以防护；
- （五）非生产加工用水应在充分标识的独立系统中循环，不得进入生产加工用水系统。

第九条 出口食品生产企业应采取有效措施保证原辅料、食品添加剂、食品相关产品的安全性，符合下列要求：

- （一）根据原辅料特性，应避免其初级生产过程中受到环境污染物、农业投入品、化学物质、有害生物和动植物病害等污染；
- （二）应采购、使用符合安全卫生规定要求的原辅料、食品添加剂、食品相关产品，要求供应商提供许可证和产品合格证明文件，并对供应商进行全面评价；对无法提供合格证明文件的食品原辅料，应依照食品安全标准进行检验；
- （三）二次加工的动物源性原料应来自检验检疫机构备案的出口食品生产企业；
- （四）不改变食品性状或仅进行简单切割、不使用其他物理或化学方法处理食品的分包装出口食品生产企业，其原料应来自检验检疫机构备案的出口食品生产企业；
- （五）进口原辅料应提供有效的出口国（地区）证明文件及检验检疫机构出具的进口检验合格证明；
- （六）应建立食品原辅料、食品添加剂、食品相关产品进货查验记录制度，如实记录其名称、规格、数量、供货者名称及联系方式、进货日期等内容；食品的原辅料、食品添加剂、食品相关产品经进厂验收合格后方准使用；超过保质期的原辅料、食品添加剂、食品相关产品不得用于食品生产，非食品用途的物质不得用于食品生产；
- （七）应依照国家和相关进口国（地区）标准中食品添加剂的品种、使用范围、用量的规定使用食品添加剂。

第十条 食品生产加工过程应防止交叉污染，确保产品适合消费者食用，并符合下列要求：

- （一）加工工艺应设计合理，防止交叉污染；根据加工工艺和产品特性，通过物理分隔或时间交错，将不同清洁卫生要求的区域分开设置，控制加工区域人流、物流方向，防止交叉污染；
- （二）根据加工工艺、产品特性和预期消费方式，控制加工时间、产品温度和车间的环境温度，保证温度测量装置的准确性并定期进行校准；

- (三) 应对速冻、冷藏、冷却、热处理、干燥、辐照、化学保藏、真空或改良空气包装等与食品安全卫生密切相关的特殊加工环节进行有效控制，应有科学的依据或国际公认的标准证明该环节采取的措施能够满足安全卫生要求；
- (四) 建立并有效执行生产设备、工具、容器、场地等清洗消毒程序，班前班后进行卫生清洁工作，专人负责检查；
- (五) 盛放食品的容器不得直接接触地面；对加工过程中产生的不合格品、跌落地面的产品和废弃物，用有明显标志的专用容器分别收集盛装，并由专人及时处理，其容器和运输工具及时消毒；
- (六) 加工过程中产生的废水、废料不得对产品及车间卫生造成污染；
- (七) 内外包装过程应防止交叉污染，必要时内外包装间应分开设置；用于包装食品的内、外包装符合安全卫生标准并保持清洁和完整，防止污染食品；再次利用的食品内外包装材料要易于清洁，必要时要进行消毒；包装标识应符合国家和相关进口国（地区）有关法律法规标准要求；包装物料间应保持干燥，内、外包装物料分别存放，避免受到污染。

第十一条 出口食品的储存、运输过程应卫生清洁，并符合下列要求：

- (一) 储存库应保持清洁，定期消毒，有防霉、防鼠、防蝇虫设施；库内产品应有明显标识以便追溯，并与墙壁、地面保持一定距离；库内不得存放有碍卫生的物品；
- (二) 预冷库、速冻库、冷藏库应满足产品温度、湿度控制要求，配备自动温度记录装置并定期校准；定期除霜，除霜操作不得污染库内产品或造成库内产品不符合温度要求；
- (三) 运输工具应保持卫生清洁并维护良好，根据产品特点配备防雨、防尘、制冷、保温等设施；运输过程中保持必要的温度和湿度，确保产品不受损坏和污染，必要时应将不同食品进行有效隔离。

第十二条 企业使用化学物品应避免污染产品，并符合下列要求：

- (一) 厂区、车间和实验室使用的洗涤剂、消毒剂、杀虫剂、燃油、润滑油、化学试剂等应专库存放，标识清晰，建立并严格执行化学品储存和领用管理规定，设立专人保管并记录，按照产品的使用说明谨慎使用；
- (二) 在生产加工区域临时使用的化学物品应专柜上锁并由专人保管；
- (三) 避免对食品、食品接触表面和食品包装物料造成污染。

第十三条 企业应通过检测监控产品的安全卫生，并符合下列要求：

- (一) 企业如内设实验室，其应布局合理，避免对生产加工和产品造成污染，应配备相应专业技术资格的检测人员，具备开展工作所需要的实验室管理文件、标准资料、检验设施和仪器设备；检测仪器应按规定进行检定或校准；应按照规定的程序和方法抽样，按照相关国家标准、行业标准、企业标准等对产品进行检测判定，并保有检测结果记录；

(二) 企业如委托社会实验室，其承担的企业产品检测项目，应具有经主管部门认定或批准的相应资质和能力，并签订合同。

第十四条 新技术/新工艺应提供科学的依据或国际公认的标准证明其符合安全卫生要求，经主管部门批准后方可应用。

在保证食品安全卫生的前提下，必要时可按传统工艺生产加工产品。

第十五条 本要求由国家认证认可监督管理委员会负责解释。

附件 2:

实施出口食品生产企业备案的产品目录

分类号	产品类别
01	罐头类
02	水产品类
03	肉及肉制品类
04	茶叶类
05	肠衣类
06	蜂产品类
07	蛋制品类
08	速冻果蔬类、脱水果蔬类
09	糖类
10	乳及乳制品类
11	饮料类
12	酒类
13	花生、干果、坚果制品类
14	果脯类
15	粮食制品及面、糖制品类
16	食用油脂类
17	调味品类
18	速冻方便食品类
19	功能食品类
20	食用明胶类
21	腌渍菜类
22	其他

附件 3:

出口食品生产企业备案需验证 HACCP 体系的产品目录

序号	产 品 类 别
1	罐头类
2	水产品类（活品、冰鲜、晾晒、腌制品除外）
3	肉及肉制品类
4	速冻蔬菜
5	果蔬汁
6	含肉或水产品的速冻方便食品
7	乳及乳制品类