IFS
HPC

IFS HPC Comparison v2-v3

JANUARY 2023

ENGLISH

Contact details of the IFS Offices

GERMANY
IFS Office Berlin
Am Weidendamm 1A
DE - 10117 Berlin
Phone: +49 (0)30726105374
Email: info@ifs-certification.com

ITALY
IFS Office Milan
Federdistribuzione
Via Albricci 8
IT - 20122 Milan
Phone: +39 0289075150
Email: ifs-milano@ifs-certification.com

POLAND | CENTRAL EAST EUROPE
IFS Representative CEE Marek Marzec
IFS Representative Poland Beata Studzińska-Marciniak
ul. Serwituty 25
PL - 02-233 Warsaw
Phone: +48 888787440
Email: ifs-poland@ifs-certification.com

CZECH REPUBLIC
IFS Representative Miroslav Šuška
Phone: +420 603893590
Email: msuska@qualifood.cz

BRAZIL
IFS Office Brazil
Rua Antônio João 800
BR - 79200-000 Aquidauana / MS Brazil
Phone: +55 67981514560
Email: cnowak@ifs-certification.com

NORTH AMERICA
IFS Representative Pius Gasser
Phone: +1 4165642865
Email: gasser@ifs-certification.com

FRANCE
IFS Office Paris
14 rue de Bassano
FR - 75016 Paris
Phone: +33 140761723
Email: ifs-paris@ifs-certification.com

SPAIN
IFS Representative Beatriz Torres Carrió
Phone: +34 610306047
Email: torres@ifs-certification.com

HUNGARY
IFS Representative József Surányi
Phone: +36 307157595
Email: suranyi@lexodus.hu

TÜRKIYE
IFS Representative Ezgi Dedebas Ugur
Phone: +90 5459637458
Email: ifs-turkiye@ifs-certification.com

ROMANIA
IFS Representative Ionut Nache
Phone: +40 722517971
Email: ionut.nache@inaq.ro

LATIN AMERICA
IFS Office Chile
Av. Apoquindo 4700, Piso 12,
CL - Las Condes, Santiago
Phone: +56 954516766
Email: chile@ifs-certification.com

ASIA
IFS Office Asia
IQC (Shanghai) Co., Ltd.
Man Po International Business Center Rm 205,
No. 660, Xinhua Road, Changning District,
CN - 200052 Shanghai
Phone: +86 18019989451
Email: china@ifs-certification.com
asia@ifs-certification.com

IFS HPC

IFS HPC
Comparison HPC v2 - v3

JANUARY 2023

ENGLISH

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
1	**Governance & Commitment**	**1**	**Senior Management Responsibility**
1.1	**Policy**	**1.1**	**Corporate policy / Corporate principles**
1.1.1	The senior management shall ***develop, implement and maintain*** a corporate policy, which shall include, at a minimum: • product requirements, • customer focus, • product safety culture, • ***sustainability.*** This corporate policy shall be communicated to all employees ***and shall be broken down into specific objectives for the relevant departments.***	**1.1.1**	The senior management shall draw up and implement a corporate policy. This shall consider as a minimum: • customer and consumer focus • environmental responsibility • occupational health • buildings • machines and equipment • product requirements (includes: product safety, quality, legality, process and specification). The corporate policy shall be communicated to all employees.
	Merged in 1.1.1	**1.1.2**	The content of the corporate policy shall have been broken down into specific objectives for the relevant departments. The responsibility and the time scale for achievement shall be defined for each department of the company.
	Merged in 1.1.1 and 1.1.2	**1.1.3**	From the corporate policy, the quality and product safety objectives shall be communicated to the employees in the respective departments and shall be effectively implemented. The company shall ensure that all relevant information is communicated effectively and in a timely manner to the relevant personnel.
	Merged in 1.4.1	**1.1.4**	The senior management shall ensure that the achievement of all objectives is regularly reviewed, as a minimum at least once a year.
1.1.2	***All relevant information related to product requirements shall be communicated effectively and in a timely manner to the relevant personnel.***		**Last part of the requirement 1.1.3**

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
1.2	Corporate structure	1.2	Corporate structure
	Merged in 1.2.3	**1.2.1**	An organization chart shall be available showing the structure of the company.
	Merged in 3.1.2	**1.2.2**	Competences and responsibilities, including deputation of responsibility shall be clearly laid down.
1.2.1*	**KO N° 1:** The senior management shall ensure that employees are aware of their responsibilities related to product ***requirements*** and that mechanisms are ***implemented*** to monitor the effectiveness of ***their operation.*** Such mechanisms shall be clearly identified and documented.	**1.2.3**	**KO N°1:** The senior management shall ensure that employees are aware of their responsibilities related to product safety and quality. Senior management shall also ensure that mechanisms are in place to monitor the effectiveness of the operations of the employees. Such mechanisms shall be clearly identified and documented.
	Merged in 3.5.1	**1.2.4**	Employees with influence on product requirements shall be aware of their responsibilities, through job descriptions, and shall be able to demonstrate understanding of their responsibilities.
	Deleted	**1.2.5**	The company shall have an IFS representative nominated by senior management.
1.2.2	The senior management shall provide sufficient and ***appropriate*** resources to meet the product and process requirements.	**1.2.6**	The senior management shall provide sufficient and relevant resources to meet the product requirements.
1.2.3	The department responsible for product safety and quality management shall have a direct reporting relationship to the senior management. ***An organizational chart shall be documented and maintained showing the structure of the company.***	**1.2.7**	The department responsible for quality and product safety management shall have a direct reporting relationship to the senior management.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
1.2.4	The company shall ensure that all processes (documented and undocumented) are known by the relevant personnel and are applied consistently.	**1.2.8**	The company shall ensure that all processes (documented and undocumented) are known by the relevant personnel and are applied consistently.
1.2.5*	***The senior management shall ensure that the certification body is informed of changes that may affect its ability to conform with the certification requirements.*** ***This includes at a minimum:*** • ***any legal entity name change,*** • ***any production site location change.*** ***In addition, for the following specific situations:*** ***product recall(s) by official order and/or any visit from the authorities which results in notification and/or penalties related to product safety and/or legality, the certification body shall be informed within three (3) working days.***		**NEW**
1.3	**Management review**	**1.3**	**Customer focus**
	Deleted	**1.3.1**	A documented process shall be in place to identify fundamental needs and expectations of customers.
1.3.1	The senior management shall ensure that the product safety and quality management system is reviewed. ***This activity shall be planned within a 12-month period and it is execution shall not exceed 15 months.*** Such reviews shall contain at least: • ***a review of policy(ies) and objectives,*** • ***review of the product safety culture,*** • results of audits and ***site inspections,*** • ***positive and negative*** customer feedback, • process compliance and product conformity, • status of ***corrections*** and corrective actions, • ***notifications*** from authorities.	**1.4.1**	Senior management shall ensure that the quality and product safety management systems are reviewed at least annually or more regularly if changes occur. Such reviews shall contain, at least, results of audits, customer feedbacks, process compliance and product conformity, status of preventive and corrective actions, follow up actions from previous management reviews, changes that could affect the product safety and quality management systems, complaints from Authorities and recommendations for improvement.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
1.3.2	***Actions from the management review*** shall be c***learly aimed at supporting improvement. The management review shall assess follow-up actions from previous management reviews and any change that could affect the*** product safety and quality management system. T***he management review shall be fully documented.***	1.4.2	This review shall include the evaluation of measures for the control of the quality and product safety management system and for the continuous improvement process.
1.3.3	***The senior management shall*** identify and review at least ***once within a 12-month period, or whenever significant changes occur*** (e.g. by internal audits or ***site*** inspection) the infrastructure ***and work environment*** needed to achieve ***conformity*** to product requirements. This shall include ***at a minimum*** the following: • buildings ***(including external conditions of the premises***), • supply systems, • machines and equipment, • transport, • ***staff facilities,*** • ***environmental conditions,*** • ***hygienic conditions,*** • ***workplace design,*** • ***external influences (e.g. noise, vibration).*** ***Based on risks,*** the results of the review shall be considered for investment planning.	1.4.3	The company shall identify and review regularly (e.g. by internal audits or factory inspection) the infrastructure needed to achieve conformity to product requirements. This shall include, for example, the following: • buildings • supply systems • machines and equipment • laboratory equipment • transport. The results of the review shall be considered, with due consideration to risk, for investment planning.
	Merged in 1.3.1	1.3.2	The results of this process shall be evaluated and considered to determine quality and product safety objectives.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
1.4	**Management review**	**1.4**	**Management review**
	Merged in 1.3.1	**1.4.1**	Senior management shall ensure that the quality and product safety management systems are reviewed at least annually or more regularly if changes occur. Such reviews shall contain, at least, results of audits, customer feedbacks, process compliance and product conformity, status of preventive and corrective actions, follow up actions from previous management reviews, changes that could affect the product safety and quality management systems, complaints from Authorities and recommendations for improvement.
	Merged in 1.3.2	**1.4.2**	This review shall include the evaluation of measures for the control of the quality and product safety management system and for the continuous improvement process.
	Merged in 1.3.3	**1.4.3**	The company shall identify and review regularly (e.g. by internal audits or factory inspection) the infrastructure needed to achieve conformity to product requirements. This shall include, for example, the following: • buildings • supply systems • machines and equipment • laboratory equipment • transport. The results of the review shall be considered, with due consideration to risk, for investment planning.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
	Merged in 1.3.3	**1.4.4**	The company shall identify and review regularly (e.g. by internal audits or factory inspection) the work environment needed to achieve conformity to product requirements. This shall include, for example, the following: • staff facilities • environmental conditions • hygienic conditions • workplace design • external influences (e.g. noise, vibration). The results of the review shall be considered, with due consideration to risk for investment planning.
2	**Product safety and quality management system**	**2**	**Quality and Product Safety Management System**
2.1	**Quality Management**	**2.1**	**Quality Management**
2.1.1	**Document management**	**2.1.1**	**Documentation requirements**
2.1.1.1	The ***product safety and*** quality ***management*** system shall be documented, implemented ***and maintained and shall be kept in one secure*** location. ***This applies to both physical and/or digital documented systems.***	2.1.1.1	The quality system for quality assurance and safety shall be documented and implemented, and shall be retained in one location (it can be an electronic documented system)
	Merged in 2.2.1.3	2.1.1.2	A documented procedure shall exist for the control of documents and their amendments.
2.1.1.2	All documents shall be clearly legible, unambiguous and comprehensive. They shall be available to relevant personnel at all times.	2.1.1.3	All documents shall be clearly legible, unambiguous and comprehensive. They shall be available to relevant personnel at all times.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
2.1.1.3	A procedure shall be documented, implemented and maintained to control of documents and their amendments. All documents which are necessary for compliance with the product requirements shall be ***available in their latest version.*** The reason for any amendments to documents critical for those requirements shall be recorded.	2.1.1.4	All documents which are necessary for compliance with the product requirements shall be available in their latest version.
		2.1.1.5	The reason for any amendments to documents, critical for the product requirements shall be recorded and approved.
		2.1.1.6	Documents shall be removed from the job area and destroyed if they are outdated.
2.1.2	**Records and documented information**	**2.1.2**	**Record keeping**
2.1.2.1	All relevant records ***and documented information*** necessary for the product requirements shall be completed, detailed and securely maintained and shall be available on request.	2.1.2.1	All relevant records, necessary for the product requirements shall be complete, detailed and securely maintained (e.g. with backup system) and shall be available on request.
2.1.2.2	Records ***and documented information*** shall be legible and genuine. They shall be maintained in a way that subsequent ***revision or amendment is*** prohibited ***unless amendments are done by authorized personnel. If records are documented electronically, a system shall be in place to ensure only authorized personnel have access to create or amend those records (e.g. password protection).***	2.1.2.2	Records shall be legible and genuine. They shall be maintained in a way that subsequent manipulation of records is prohibited.
2.1.2.3*	All records shall be kept in accordance with legal and ***customer requirements. If no such requirements are defined, records and documented information*** shall be kept for a minimum of one year after the shelf life. For products which have no shelf life, the duration of record ***and documented information*** keeping shall be ***justified and this justification shall be documented.***	2.1.2.3	All records, including records showing the effective control of process, product safety and quality shall be kept in accordance with legal requirements and customer specifications (this includes, for instance and where relevant, the cosmetic product information file). They shall be kept for a minimum of one year after the shelf life. For products which have no shelf life, the duration of record keeping shall be in line with customers' requirements.
	Merged in 2.1.2.2	2.1.2.4	Any amendments to records shall only be carried out by authorized persons.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
2.2	**Product Safety Management**	**2.2**	**Product Safety Management**
2.2.1	**Risk assessment framework**	**2.2.1**	**Risk management system (Hazard analysis and Risk assessment)**
2.2.1.1	Before developing the hazard analysis and risk assessment, the company shall have implemented all necessary good manufacturing practices/ ***best practices*** which are commonly used in its scope of activity.	2.2.1.1	Before developing a risk management system, the company shall have implemented all necessary Good Manufacturing Practices (GMP's) which are commonly used in its scope of activity.
2.2.1.2	The basis of the company's product safety management system shall be a fully implemented, systematic and comprehensive risk management system. It shall take into account any legal requirements of the production and destination countries which may go beyond such principles. ***The hazard analysis and risk assessment*** shall be adequate and implemented at each production site.	2.2.1.2	The basis of the company's product safety control system shall be a fully implemented, systematic and comprehensive risk management system. It shall take into account any legal requirements of the production and destination countries which may go beyond such principles. The risk management system shall be implemented at each production site. The risk management system shall cover all raw material groups, products or product groups, as well as every process (included outsourced process) from goods in to dispatch, including product development and product packaging.
2.2.1.3	The ***hazard analysis and risk assessment*** shall cover all raw material groups, products or product groups, as well as every process (included outsourced processes) from ***incoming*** goods ***until*** the dispatch ***of final products,*** including product packaging ***material management.***		
2.2.1.4	The company shall ensure that the ***hazard analysis and*** risk ***assessment shall be*** based upon scientific literature or technical verified specifications relating to the manufactured products and procedures. This information shall be maintained in line with any new technical and scientific process development.	2.2.1.3	The company shall ensure that the risk management system is based upon scientific literature, or technical verified specifications relating to the manufactured products and procedures. This shall be maintained in line with any new technical and scientific process development.
2.2.1.5	***In the event of changes to raw materials, packaging materials, processing methods, infrastructure and equipment, the hazard analysis and risk assessment*** shall be reviewed ***in order to ensure that product safety requirements are complied with.***	2.2.1.4	Risk management system shall be reviewed and necessary changes shall be made when any modification is made in the product, process or any step.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
2.2.2	**Risk assessment team**	**2.2.2**	**Risk management team**
2.2.2.1	The risk ***assessment*** team shall be multidisciplinary and include operational staff. Personnel appointed as risk ***assessment*** team members shall have specific knowledge of hazards and risks associated to products and processes. Where competent knowledge is not available external expert advice shall be obtained.	2.2.2.1	The risk management team shall be multidisciplinary and include operational staff. Personnel appointed as risk management team members shall have specific knowledge of hazards and risks associated to products and process. Where competent knowledge is not available, external expert advice shall be obtained.
2.2.2.2	Those responsible for the development and maintenance of ***product safety*** management system shall have received adequate training in the application of the risk management principles based on the risk assessment tool (Risk matrix, FMEA, HACCP, ***RPN***, etc.) which the company uses.	2.2.2.2	Those responsible for the development and maintenance of risk management system shall have received adequate training in the application of the risk management principles based on the risk management tool (risk matrix, FMEA, HACCP, etc.) which the company uses.
2.2.2.3	The risk ***assessment*** team shall have senior management support and shall be well known and established ***within the company.***	2.2.2.3	The risk management team shall have senior management support and shall be well known and established across the whole facility.
2.2.3	**Hazard analysis and risk assessment**	**2.2.3**	**Hazard analysis and risk assessment**
2.2.3.1	**Describe *the* product** A full description of the product ***shall be documented and maintained and shall contain*** all applicable relevant information on product ***requirements, at a minimum:*** • composition (including rework when applicable), • physical, chemical and microbiological parameters, • methods of treatment, • packaging, • durability (shelf life), • conditions for storage, methods of transport ***and distribution.***	2.2.3.1	**Describe product** The assessment shall make reference to the full description of the product including all applicable relevant information on product safety and regulation such as: • composition (raw materials, rework, reprocessing, etc.), • physical, chemical and microbiological parameters, • methods of treatment, • packaging, labelling, • durability (shelf life), • conditions for storage and method of transport.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
2.2.3.2	**Identify intended use *and foreseeable use*** The intended use ***and foreseeable use of*** the product shall be described in relation to the expected use of the product by the consumer taking into account vulnerable groups of consumers.	2.2.3.2	**Identify intended use** The intended use of the product shall be described in relation to the expected use of the product by the consumer, taking into account vulnerable groups of consumers.
2.2.3.3	**Construct flow diagram** A flow diagram shall ***be documented and maintained*** for each product or product groups, raw material groups and for all variations of the processes and sub-processes (including rework, ***outsourcing and*** reprocessing). The flow diagram shall ***determine every step and clearly identify each critical control point and other control measures. It shall be dated and*** in the event of any changes the flow diagram shall be updated.	2.2.3.3	**Construct flow diagram** A flow diagram shall exist for each product, product groups, raw material groups, etc., and for all variations of the processes and sub-processes (including rework and reprocessing). The flow diagram shall be dated, and clearly identify each control point with the number assigned to it. In the event of any changes the flow diagram shall be updated.
2.2.3.4	**On-site confirmation of the flow diagram** The risk ***assessment*** team shall ***verify the flow diagram by on-site checks*** at all operation stages. Amendments ***to*** the diagram shall be made, ***where appropriate.***	2.2.3.4	**On-site confirmation of the flow diagram** The risk management team shall review the processes at all operation stages against the flow diagram. Where relevant, amendments of the diagram will be made.
2.2.3.5	**Conduct a hazard analysis and risk assessment for each step**	**2.2.3.5**	**Conduct a hazard analysis and risk assessment for each step**
2.2.3.5.1	A hazard analysis shall be ***conducted covering all possible and*** reasonably expected physical, chemical ***(including allergens)*** and biological hazards. A hazard analysis and a risk assessment shall be conducted for each step ***of the process*** from raw materials to the finished products. ***The analysis shall include also hazards linked to materials in direct contact with the product.***	2.2.3.5.1	A hazard analysis shall be available for all physical, chemical and biological hazards that may be reasonably expected. A hazard analysis and a risk assessment shall be conducted for each step, from the raw materials to the finished products, including development and packaging material validation.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
2.2.3.5.2	The hazard analysis ***shall consider the likely occurrence of*** hazards ***and severity of their adverse health effects. Consideration shall be given to the specific control measures that shall be applied to control each hazard.*** The methodology for assessing the risk shall be documented.	2.2.3.5.2	Based on the hazard analysis, the risk assessment shall demonstrate the motivation if a hazard is a risk, taken into account the probability of harm to the consumer and the severity of damage (effect, potential consequences). The methodology for assessing risks shall be documented.
2.2.3.6*	**Determine critical control points** ***and other control measures*** ***The determination of relevant CCP's and other control measures shall be facilitated by the application of a decision tree or other tool(s), which demonstrates a logical reasoned approach.***	2.2.3.6	**Determine critical control points** Based on level of acceptability of risks, **critical control points** shall be identified and documented.
2.2.3.7	**Establish *validated* critical limits for each critical control point** For each critical control point critical limits shall be defined and validated to identify when a process is out of control.	2.2.3.7	**Establish critical limits for each critical control point** For each critical control point, the appropriate critical limits shall be defined and validated in order to clearly identify when a process is out of control.
2.2.3.8*	**KO N° 2:** Establish a monitoring system for each critical control point Specific monitoring procedures in ***terms of method, frequency of measurement or observation and recording of results*** shall be ***documented, implemented and*** maintained ***for each CCP to detect any loss of control at that CCP.*** Each defined CCP shall be under control. Monitoring and control of each CCP shall be demonstrated by records.	2.2.3.8	**Establish a monitoring system for each critical control point** **KO N°2:** Specific monitoring procedures shall be established for each critical control point to detect any loss of control. Records of monitoring shall be maintained for a relevant period. Each defined critical control point shall be under control. Monitoring and control of each critical control point shall be demonstrated by records. The records shall specify the person responsible as well as the date and result of the monitoring activities.
2.2.3.9	Records ***of CCP's monitoring shall be verified by a*** responsible person ***of the company and maintained for a relevant period.***		
2.2.3.10	***The operative personnel in charge of the monitoring of CCP's and other control measures shall have received specific training/instruction.***		**NEW**

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
2.2.3.11	***The control measures other than CCPs, shall be monitored, recorded and controlled by measurable or observable criteria.***		**NEW**
2.2.3.12	**Establish corrective actions** ***In the event that the*** monitoring indicates that a particular CCP or control ***measure other than CCPs is*** not under control, corrective actions shall be ***documented and implemented***. Such corrective actions shall also take into account any ***action taken relating to*** non-conforming products ***and identify the root cause for the loss of control of CCPs.***	2.2.3.9	**Establish corrective actions** For each critical control point, corrective actions shall be established. In case the monitoring indicates that a particular critical control point is not under control, adequate corrective actions shall be taken and documented. Such corrective actions shall also take into account any non-conforming products.
2.2.3.13*	**Establish verification procedures** Procedures of verification shall ***be documented, implemented and maintained to confirm that the hazard analysis and risk assessment are effective.*** Verification ***activities of the hazard analysis and risk assessment*** include for example: • internal audits, • ***testing,*** • sampling, • evaluations, • ***deviations and non-conformities,*** • complaints. The results of this verification shall be ***performed at least once within 12-month period or whenever significant changes occur and shall be incorporated into the hazard analysis and risk assessment.***	2.2.3.10	**Establish verification procedures** Procedures of verification shall be established to confirm that the risk management system is effective. Verification of the risk management system shall be performed at least once a year. Examples of verification activities include: • internal audits, • analysis, • sampling, • evaluations, • complaints by authorities and customers. The results of this verification shall be incorporated into the risk management system.
3	**Resource management**	**3**	**Resource management**
3.1	**Human resources**	**3.1**	**Human resources management**
3.1.1	All personnel performing work that affects product safety, legality and***/or*** quality shall have the required competence by education, work experience and/ or training, commensurate with their role.	3.1.1	All personnel performing work that affects product safety, legality and quality shall have the required competence by education, work experience and/ or training, commensurate with their role, based on documented evaluation of possible risks.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
3.1.2	The responsibilities, competence ***and job descriptions for all job titles having an impact on product safety and product quality, shall be documented, implemented and maintained. Assignment for key roles shall be defined.***	1.2.2	Competences and responsibilities, including deputation of responsibility shall be clearly laid down.
3.2	**Personnel hygiene**	**3.2**	**Personnel hygiene management**
	Deleted	**3.2.1**	**Personnel hygiene**
3.2.1*	***Risk based requirements*** relating to personnel hygiene ***shall be documented, implemented and maintained.*** These include at a minimum the following fields: • hair and beards, • protective clothing ***(including use in staff facilities),*** • hand washing, disinfection ***and hand hygiene,*** • eating, drinking and smoking/ ***vaping or other use of tobacco,*** • actions to be taken in case of cuts or skin abrasions, • fingernails, jewellery and personal belongings ***(including personal medication),*** • ***notification of infectious diseases / health issues.***	3.2.1.1	There shall be documented requirements relating to personnel hygiene. These include, as a minimum, the following fields: • protective clothing • hand washing and disinfection • eating and drinking • smoking • actions to be taken in case of cuts or skin abrasions • fingernails, jewelry and personal belongings • hair and beards. • The requirements shall be based on documented evaluation of possible risks in relation to product and process.
3.2.2	The requirements for personal hygiene shall ***be understood and*** applied by all relevant personnel, contractors and visitors. Compliance with the requirements shall be checked regularly.	3.2.1.2	The requirements for personnel hygiene shall be in place and applied by all relevant personnel, contractors and visitors. Compliance with the requirements shall be checked regularly.
3.2.3	Visible jewellery (incl. piercing) and watches shall not be worn. Any exceptions shall have been comprehensively evaluated based on risks.	3.2.1.3	Visible jewellery (incl. piercing) and watches shall not be worn. Any exceptions shall have been comprehensively evaluated based on documented hazard analysis and risk assessment.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
3.2.4	Cuts and skin abrasions shall be covered with a coloured plaster/ bandage ***that shall not pose contamination risks. Plaster/bandage shall be waterproof and coloured*** different from the product colour. ***Where appropriate:*** • plasters/bandages shall contain a metal strip, • single use gloves shall be worn.	3.2.1.4	Cuts and skin abrasions shall be covered by a coloured plaster/ bandage (different from the product colour). Any exceptions shall have been comprehensively evaluated based on documented hazard analysis and risk assessment.
	Deleted	3.2.1.5	Based on risk assessment, there shall be a program to control effectiveness of hand hygiene.
3.3	**Protective clothing for personnel, contractors and visitors**	**3.2.2**	**Protective clothing for personnel, contractors and visitors**
3.3.1	Company procedures shall exist to ensure that all personnel, contractors and visitors are aware of the rules regarding the management of wearing and changing protective clothing in specified areas in accordance with product requirements.	3.2.2.1	Company procedures shall exist to ensure that all personnel, contractors and visitors are aware of the rules regarding the management of wearing and changing protective clothing in specified areas in accordance with product requirements.
3.3.2	In work areas where wearing headgear and/or beard snood (covering) is required, the hair shall be covered completely so that product contamination is prevented.	3.2.2.2	In work areas where wearing headgear and/or beard snood (covering) is required, the hair shall be covered completely, so that product contamination is prevented.
3.3.3	Usage rules shall ***be implemented*** for work areas/activities where it is required to wear gloves (coloured differently from the product colour).	3.2.2.3	Clearly defined usage rules shall exist for work areas/ activities where it is required to wear gloves (coloured differently from the product colour). Compliance with these rules shall be checked on a regular basis.
3.3.4	When required, suitable protective clothing to ensure personnel safety shall be available in sufficient quantity for each employee.	3.2.2.4	Suitable protective clothing and devices to ensure personnel safety shall be available in sufficient quantity for each employee, when required.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
3.3.5	All protective clothing shall be thoroughly and regularly laundered. Based on risks, the company shall determine if clothing shall be washed by a contract laundry, on-site laundry or by the employee ***according to a documented guidelines which shall include the checking of its cleanliness.***	3.2.2.5	When required, all protective clothing shall be thoroughly and regularly laundered. Based on hazard analysis and risk assessment taken in consideration processes and products, the company shall determine if clothing shall be washed by a contract laundry, on site laundry or by the employee.
	Deleted	3.2.2.6	Guidelines shall exist for laundering of protective clothing and a procedure shall be in place for checking its cleanliness, when required.
	Deleted	3.2.2.7	The company shall review that implemented preventive measures to ensure personnel safety related to hazardous working conditions are effective.
3.4	**Procedure applicable to health and infectious diseases**	**3.2.3**	**Procedures applicable to infectious diseases**
3.4.1	There shall be written and communicated measures for personnel, contractors and visitors in case of any ***health issue or*** infectious disease which may have an impact on product safety. In case of declaration ***of any,*** actions shall be taken to minimize risk of contamination of products ***(if applicable to product or activity).***	3.2.3.1	There shall be written and communicated measures for personnel, contractors and visitors in case of any infectious disease which may have an impact on product safety. In case of declaration of infectious disease, actions shall be taken in order to minimize risk of contamination of products.
3.5	**Training and instruction**	**3.3**	**Training and instruction**
3.5.1	Documented training and/or instruction programs shall be implemented with respect to the product ***and process*** requirements and the training needs of the employees based on their job and shall include: • training contents, • training frequency, • employee's task, • languages, • qualified trainer/tutor, • ***training effectiveness.***	3.3.1	The company shall implement documented training and/or instruction programs with respect to the product requirements and the training needs of the employees based on their job which shall include: • training contents • training frequency • employee's task • languages • qualified trainer/tutor • evaluation methodology.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
3.5.2	The documented training and/or instruction programs shall apply to all personnel, including temporary workers and employees from external companies, employed in the respective work area. Upon employment, and before commencing work, they shall be trained in accordance with the documented training/ instruction programs.	3.3.2	The documented training and/or instruction programs shall apply to all personnel, including temporary workers and employees from external companies, employed in the respective work area. Upon employment, and before commencing work, they shall be trained in accordance with the documented training / instruction programs.
3.5.3	Records shall be available of all training/instruction events stating: • list of participants (this shall include their signature), • date, • duration, • contents of training, • name of trainer/tutor.	3.3.3	Records shall be available of all training/instruction events, stating: • list of participants (this shall include their signature) • date • duration • contents of training • name of trainer/tutor. There shall be a procedure or program in place to prove the effectiveness of the training and/or instruction programs.
3.5.4	The contents of training and/or instruction shall be reviewed and updated ***when necessary. Special considerations shall be given at a minimum to these*** specific issues: • product safety ***and quality (e.g. GMPs, risk assessment, etc.).*** • ***product safety culture,*** • ***product defence,*** • product related legal requirements, • product/process modifications, • ***feedback from the previous documented training/instruction program.***	3.3.4	The contents of training and/or instruction shall be reviewed and updated regularly and take into account company's specific issues, product safety, product related legal requirements and product/process modifications.
3.6	**Staff facilities**	**3.4**	**Staff facilities, sanitary facilities and equipment for personnel hygiene**
3.6.1	***Adequate*** staff facilities shall be provided and shall be proportional in size, equipped for the number of personnel, designed and ***controlled*** so as to minimize product safety risks. Such facilities shall be ***maintained in a way to prevent contamination.***	3.4.1	The company shall provide staff facilities, which shall be proportional in size, equipped for the number of personnel and designed and operated so as to minimize product safety risks. Such facilities shall be kept clean and in good condition.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
3.6.2	***Product contamination risks by food and drink and/or foreign materials shall be minimized. Consideration shall be given*** to food ***and drink from*** vending machines, ***canteen and/or brought to work by personnel.***	3.4.2	There shall be in place rules and facilities to ensure the correct management for personnel belongings and for food and other material brought to work by personnel, food coming from dining room and from vending machines. The food and other material shall only be stored and/or used in designated areas.
3.6.3	The company shall provide suitable changing rooms for personnel, contractors and visitors. Where necessary, outdoor clothing and protective clothing shall be stored separately.	3.4.3	The company shall provide suitable changing rooms for personnel, contractors and visitors. Where necessary, outdoor clothing and protective clothing shall be stored separately.
3.6.4	Changing rooms shall be ***located*** so that they allow direct access to the areas where products are handled. Any exceptions ***shall have been comprehensively evaluated based on risks.***	3.4.4	Changing rooms shall be separated from production area and shall be situated so that they allow direct access to the areas where products are handled. Based on documented evaluation of possible risks, exceptions shall be justified and managed.
3.6.5	Toilets shall not have direct access to an area where products are handled. ***Any exception shall be comprehensively evaluated based on risks.*** The sanitary facilities shall be equipped with adequate hand washing facilities. The sanitary facilities shall have adequate natural or mechanical ventilation. Mechanical airflow from a contaminated area to a clean area shall be avoided.	3.4.5	Toilets shall not have direct access to an area where products are handled. The sanitary facilities shall be equipped with adequate hand washing facilities. Sanitary facilities shall have adequate natural or mechanical ventilation. Mechanical airflow from a contaminated area to a clean area shall be avoided.
3.6.6	Hand hygiene facilities shall be provided near points ***of entry*** to, and within production areas, as well as at staff facilities. Based on risks further areas shall be similarly equipped.	3.4.6	Adequate hand hygiene facilities shall be provided near access points to and within production areas, as well as at staff facilities. Based on documented evaluation of possible risks, further areas shall be similarly equipped.
3.6.7	Hand hygiene facilities shall provide: • ***running potable*** water ***at an adequate temperature,*** • ***adequate cleaning and/or disinfection equipment,*** • ***adequate means*** for hand drying.	3.4.7	Hand washing facilities shall provide as a minimum: • water • liquid soap • appropriate equipment for hand drying.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
3.6.8	***Based on risks*** following additional requirements regarding hand hygiene shall also be provided: • hand contact-free fittings, • hand disinfection, • adequate hygiene equipment, • signage highlighting hand hygiene requirements, • waste container with hand contact free opening.	3.4.8	If necessary, following additional requirements regarding hand hygiene shall also be provided: • hand contact-free fittings • hand disinfection • adequate hygiene equipment • signage highlighting hand hygiene requirements • waste container with hand contact free opening.
3.6.9	***A risk based program shall be implemented and maintained*** to control effectiveness of hand hygiene.	3.2.1.5	Based on hazard analysis and assessment of associated risk, there shall be a program to control effectiveness of hand hygiene.
4	**Operational processes**	**4**	**Planning and production process**
4.1	**Customer focus and contract agreement**	**4.1**	**Contract agreement**
4.1.1	***A process shall be implemented and maintained*** to identify fundamental needs and expectations of customers. ***The feedback from this process shall be taken as input for company's continuous improvement.***	1.3.1	A documented process shall be in place to identify fundamental needs and expectations of customers.
		1.3.2	The results of this process shall be evaluated and considered to determine quality and product safety objectives.
4.1.2	***All*** requirements related to product safety and quality ***within customer agreement, and any revision of these clauses*** between the contract partners, shall be documented, communicated ***and implemented*** by each relevant department.	4.1.2	Changes of existing contractual agreements shall be documented, communicated and updated between the contract partners.
		4.1.1	The requirements which are defined in the contract with the customer shall be established, agreed upon and reviewed concerning their acceptability before a supply agreement is concluded. All clauses related to quality and product safety shall be known and communicated to each relevant department.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.1.3	***In accordance with customer requirements, the senior management shall inform their affected customers as soon as possible, of any issue related to product safety or legality, including deviations and non-conformity/ies identified by competent authorities.***		**NEW**
4.2	**Specifications and formulas**	**4.2**	**Specifications and formulas**
4.2.1	**Raw Materials (including packaging materials), semi-finished products and rework specifications**	**4.2.1**	**Raw Materials (including packaging materials), semi-finished products and rework specifications**
4.2.1.1	Specifications shall be ***documented and implemented*** for all raw materials (raw materials/ingredients, additives, packaging materials, rework) and where relevant, for semi-finished products. The specifications shall be up to date, unambiguous, available and always in conformance with legal requirements.	4.2.1.1	Specifications shall be available and in place for all raw materials (raw materials/ingredients, additives, packaging materials, rework) and, where relevant, for semi-finished product. The specifications shall be up to date, unambiguous, available and always in conformance with legal requirements.
4.2.1.2	Identification of raw materials including packaging materials shall contain the following information: • name of the product, • unique identification code, • date or number of receipt (if relevant), • supplier´s name, • expiry date, if existing, • batch reference given by the supplier and the one given at receipt, if different.	4.2.1.2	Identification of raw materials including packaging materials shall contain the following information: • name of the product, • unique identification code, • date or number of receipt (if relevant) • supplier´s name, • expiry date, if existing • batch reference given by the supplier and the one given at receipt, if different.
4.2.1.3	A re-evaluation of the suitability of raw materials and ***semi-finished products*** shall be in place in cases where they are close to the best before date / ***expiry date*** or when they are returned to storage or other relevant parameters given by the supplier.	4.2.1.3	A re-evaluation of the suitability of raw materials shall be in place, in cases where raw materials are close to the best before date, or when they are returned to storage or other relevant parameters given by the supplier.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.2.1.4	***For all packaging materials which could have an impact on products, relevant documents (e.g. DoC, etc.) shall exist which attest compliance with legal requirements. In the event that no specific legal requirements are applicable, evidence shall be available to demonstrate that packaging materials are suitable for use. This applies for packaging materials which could have an influence on semi-finished and finished products.***		**NEW**
4.2.1.5	***The company shall define the key parameters for the packaging materials in detailed specifications complying with the current relevant legislation and other relevant hazards or risks.***		**NEW**
4.2.2	**Finished product specifications**	**4.2.2**	**Finished product specifications**
4.2.2.1	Specifications shall be ***documented and implemented for all finished products. They shall be*** up to date, traceable, unambiguous, relevant to ***all*** personnel ***and in compliance*** with legal and customer requirements. ***Where required by customers, product specifications shall be formally agreed.***	4.2.2.1	Specifications shall be available for all final products and shall be agreed upon in writing with customers. The specifications shall be up to date, traceable, unambiguous, and available to relevant personnel and always in conformance with legal and customer requirements.
4.2.2.2*	**KO N° 3:** Current and approved finished product specifications shall be the basis for the composition of products. They shall also be the basis for the control of the production process and to monitor the finished products compliance.	4.2.2.2	**KO N°3:** Current and approved finished product specifications shall be the basis for the composition of products. They shall also be the basis to control the production process and to monitor the finished products' compliance.
4.2.2.3	Where products are requested to be ***labelled and/or promoted*** with "free from" certain substances or ingredients, or where certain methods of treatment or production are excluded, ***measures shall be implemented to demonstrate compliance with such statement.***	4.2.2.3	Where customers specifically require that products are "free from" certain substances or ingredients, or that certain methods of treatment or production are excluded, verifiable procedures shall be in place.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.2.2.4	A procedure to ***control*** the creation, approval ***and amendment*** of specifications shall ***be documented, implemented and maintained*** and shall include ***where required, the acceptance of the customer(s).*** This procedure shall include the update of finished product specifications in case of any modification related to: • raw material***s***, • formula***s***/recipe***s***, • processes ***which impact the finished*** products, • packaging ***materials which impact the finished*** products.	4.2.2.4	There shall be a procedure for the creation, the modification and approval of specifications for all parts of the process, which shall include the preliminary acceptance of the customer, if specifications have been agreed with customers.
		4.2.2.5	The specification control procedure shall include the update of finished product specification in case of any modification requested by the customer and/or defined by the company, related to: • raw material • formula/recipe • process with influence on the final products • packaging with influence on the final products.
4.3	**Legislative framework and product development**	**4.3**	**Legislative framework and R&D process**
4.3.1	**Legislative framework**	**4.3.1**	**Legislative framework**
4.3.1.1	The company shall comply with the current applicable legislation ***and where relevant, register its activity of production to the local authorities.*** The company shall be able to demonstrate its own role in the supply chain.	4.3.1.1	The company shall comply with the current applicable legislation and shall be able to demonstrate its own role in the supply chain.
4.3.1.2	The company shall have a system in place to ensure: • it is kept informed of all relevant legislation on product safety and quality issues, • scientific and technical developments, • industry codes of practice. Legislation shall be understood and applied.	4.3.1.2	The company shall have a system in place to ensure that it is kept informed of all relevant legislation on product safety and quality issues, scientific and technical developments and industry codes of practice. Legislation shall be understood and applied.
4.3.1.3	For all relevant raw materials, safety data sheets shall be available in the format required by the destination country and kept up to date.	4.3.1.3	For all relevant raw materials, safety data sheets shall be available in the format required by the destination country and kept up to date.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.3.1.4	Where relevant, the safety data sheet and/or composition for final products shall be provided and communicated to the appropriate organizations (e.g. national safety centers, public website, etc.), taking into consideration the current legislation of the destination country.	4.3.1.4	Where relevant, the safety data sheet and/or composition for final products shall be provided and communicated to the appropriate organizations (e.g. national safety centers, public website, etc.), taking into consideration the current legislation of the destination country.
4.3.1.5	***If applicable,*** the company shall mandate a qualified safety assessor in accordance with the current legislation to consider the general toxicological profile of the ingredients, their chemical structure and exposure level, and finally provide the company with a safety assessment of the finished product regarding human health.	4.3.1.5	In accordance with the current legislation, the company shall mandate a qualified safety assessor to consider the general toxicological profile of the ingredients, their chemical structure and exposure level, and finally provide the company with a safety assessment for human health of the finished product.
4.3.1.6	A ***procedure*** shall ensure that labelling complies with current legislation of destination country and customer requirements.	4.3.1.6	A process shall be in place to ensure that labelling complies with current legislation of destination country and customer requirements.
4.3.1.7	***The company shall ensure that in the event of changes to*** • ***process characteristics,*** • ***product formulation including rework,*** • ***packaging material,*** • ***legal requirements,*** • ***product quality requirements,*** • ***customer requirements,*** ***labelling shall be reviewed and adapted when necessary.***	4.3.1.7	The conformity of the product with its labelling shall be reviewed each time before a new label is issued for use. Such review shall take into account the product requirements and particular relevant legislation in the destination countries.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.3.2	**Product development/ product modification/ modification of production process**	**4.3.2**	**R & D process**
4.3.2.1	The company shall have an implemented procedure for product development/ modification that takes into account risks and patents and that demonstrates that all existing and new products are designed to meet legal requirements. ***Legal changes, e.g. ingredients, etc. which make it necessary to change products and/or subjected to deadlines, shall be coordinated with customers as soon as possible.***	4.3.2.1	The company shall have an implemented procedure for R&D that takes into account risks and patents and that demonstrates that all existing and new products are designed to meet legal requirements.
4.3.2.2	***The product development/modification process shall result in specifications about formulation, packaging requirements, manufacturing processes, process parameters related to the fulfilment of product requirements.*** The progress and results of product development shall be properly recorded ***and have to be ensured by checks such as:*** • ***factory trials,*** • ***performance tests,*** • ***stability tests,*** • ***organoleptic tests,*** • ***product testing,*** • ***compatibility tests.***	4.3.2.2	The progress and the results of R&D shall be properly recorded.
4.3.2.3	Without the authorization from the patent holder, the company shall not use raw materials, composition ***or production processes or other intellectual properties which*** are already patented.	4.3.2.3	Without the authorization from the patent holder, the company shall not use raw materials, composition and shall not process finished products that are already patented.
	Merged in 4.3.2.2	4.3.2.4	Product formulation, manufacturing processes and the fulfilment of product requirements shall have been ensured by factory trials, performance tests, stability tests, organoleptic assessments where relevant and product testing.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.3.2.4	Where relevant, shelf life tests / ***stability tests*** shall be carried out taking into account product formulation, packaging, manufacturing and storage conditions. The shelf life (e.g. ***expiry date***, best before, ***PAO***) of the labelled goods shall be calculated accordingly, from the original production date. Where relevant for products with shelf lives, tests shall be done at the end of the product shelf life on retained samples.	4.3.2.5	Where relevant shelf life tests shall be carried out taking into account product formulation, packaging, manufacturing and storage conditions. The shelf life (e.g. best before date) of the labelled goods shall be calculated accordingly, and from the original production date. Where relevant, for products with shelf lives, tests shall be done at the end of the product shelf life on retained samples.
4.3.2.5	Where specific tests are needed, equipment shall be available and pertinent (such as dosages for regulated ingredients, preservatives, biocides etc.). In case tests are not performed on-site, results of these external tests shall be available.	4.3.2.6	Where specific R&D tests are needed, equipment shall be available and pertinent (such as dosages for regulated ingredients, preservatives, biocides etc.). In case tests are not performed on site, results of these external tests shall be available.
4.3.2.6	Claims shall be supported by scientific evidence (e.g. sun screen formulations, detergents, etc.) to ensure that the product meets the stated claim.	4.3.2.7	Claims shall be supported by scientific evidence (e.g. sun screen formulations, detergents, etc.) in order to ensure that the product meet the stated claim.
4.3.2.7	Where relevant, pilot equipment(s) shall be available and used in order to guarantee the ***possible scale-up.***	4.3.2.8	Where relevant, pilot equipment(s) shall be available and used in order to warranty good formulation´s industrialization.
4.3.2.8	***Recommendations/instructions for application and/or use of the products shall be validated and documented, where appropriate.***		**NEW**
4.3.2.9	The ***finished product*** shall be designed and labelled to prevent non intended use to protect the safety of the potential user. The risk assessment shall address this topic.	4.3.2.9	The consumer packaging shall be designed and labelled to prevent non intended use in order to protect the safety of the potential user. The risk assessment shall address this topic.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.3.2.10	Based on risks, the company shall ***check and verify the suitability and interaction between the product and*** packaging ***in direct contact and intended or expected to be in direct contact, and it shall take into account:*** • ***physical and functional characteristics,*** • organoleptic characteristics ***(if applicable),*** • ***microbiology and chemical parameters (e.g. migration test results).***	4.3.2.10	If required by law and based on documented evaluation of possible risks, the company shall verify the capability of the packaging material for each relevant product (e.g. organoleptic tests, storage tests, chemical analysis).
4.4	**Purchasing**	**4.4**	**Purchasing**
4.4.1	***The purchased materials shall be evaluated based on risks, and supplier´s status for product safety, legality and quality. The results shall be the basis for the testing and monitoring plans.***		**NEW**
4.4.2	***The*** purchasing ***services, which have, based on risks,*** an impact on product safety and product quality, ***shall be evaluated to ensure they*** comply with ***defined*** requirements. ***This shall take into account at a minimum:*** • ***the service requirements,*** • ***the supplier's status (according to its assessment)*** • ***the impact of the service on the finished products.***	4.4.1	The company shall control purchasing processes to ensure that all externally sourced materials (raw materials, including packaging materials) and services, which have an impact on product safety and quality, comply with requirements. Where a company chooses to outsource any process that may have an impact on product safety and quality, the company shall ensure control over such processes and fulfil requirements 4.4.8
	Deleted	4.4.2	Purchased products and services shall conform to current specifications and contractual agreements.
	Merged in 4.4.1	4.4.3	The purchased products and services shall be checked in accordance with the existing specifications. The schedule of these checks shall take into account the product requirements, supplier status and the impact of raw materials on the finished product.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.4.3	A procedure for ***the sourcing of raw materials, semi-finished products and packaging material, and the*** approval and monitoring of suppliers (internal and external) ***shall be documented, implemented and maintained. This procedure shall contain at a minimum:*** • ***raw materials and/or supplier´s risks,*** • ***required performance standards (e.g. certification, origin, etc.),*** • ***exceptional situations (e.g. emergency purchase),*** ***and based on risks, additional criteria, for instance:*** • ***audits performed by an experienced and competent person,*** • ***testing results,*** • supplier reliability, • complaints, • ***supplier questionnaire.***	4.4.4	There shall be a procedure for approval and monitoring of suppliers (internal and external), outsourced production and sub-processes. In case of any kind of outsourced production, the customer shall always be informed.
4.4.4	***Where a company outsources a part of the product processing and/or primary packing and/or labelling, it shall have it documented in the product safety and quality management system and ensure control over such processes to guarantee that product safety and product quality are not compromised.***	4.4.8.1	Control of outsourced processes shall be identified, risk assessed and documented within the product safety and quality management system.
4.4.5	***When required by the customer, there shall be evidence that the customer has been informed and has agreed to such outsourced process.***		**NEW**
	Merged in 4.4.3	4.4.5	The approval and monitoring procedure shall contain clear assessment criteria such as: audits, certificates of analysis, supplier reliability and complaints, as well as required performance standards based on documented evaluation of possible risks.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.4.6	***An agreement shall be documented and implemented covering the outsourced processes and describing any arrangements made in connection with it including in-process controls, testing and monitoring plans.***		**NEW**
	Merged in 4.4.9	4.4.6	The results of supplier´s assessment shall be reviewed regularly. There shall be records of the reviews and of the actions taken as a consequence of assessment.
	Deleted	4.4.7	There shall be records to identify which raw material including packaging and semi-finished products are sourced from each supplier.
4.4.7	***Suppliers of outsourced processes shall be approved through:*** • ***certification against IFS HPC or equivalent,*** ***or*** • ***documented supplier audit performed by an experienced and competent person, which shall include at a minimum, requirements for product safety, quality and legality,*** ***or*** • ***in case of a private label (e.g. retailer brand), the customer is expressively accepting other conditions.***	4.4.8.3	Based on risk assessment, the company shall regularly audit the subcontractor, by using an audit checklist covering IFS HPC requirements (including e.g. relevant documented risk management system, control plan, traceability system, crisis management, etc.). Documents of such checks shall be available.
		4.4.8.4	The audits/checks performed at the subcontractor shall be performed by a qualified auditor/inspector.
4.4.8	The company shall check the products ***on*** receipt from its subcontractor ***based on a documented sampling plan.***	4.4.8.5	If relevant, the company shall check at receipt the products coming from its subcontractor.
4.4.9	***The sourcing of materials and supplier audits shall be reviewed at least once within a 12-month period or whenever significant changes occur. Records of the reviews and the consequential actions of the audit shall be documented.***		**NEW**

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
	Deleted	**4.4.8**	**Outsourced production (if applicable)**
	See 4.4.4 /4.4.8	4.4.8.1	Control of outsourced processes shall be identified, risk assessed and documented within the product safety and quality management system.
	See 4.4.4 /4.4.8	4.4.8.2	A contract shall exist between the company and its subcontractor.
	See 4.4.4 /4.4.8	4.4.8.3	Based on risk assessment, the company shall regularly audit the subcontractor, by using an audit checklist covering IFS HPC requirements (including e.g. relevant documented risk management system, control plan, traceability system, crisis management, etc.). Documents of such checks shall be available.
	See 4.4.4 /4.4.8	4.4.8.4	The audits/checks performed at the subcontractor shall be performed by a qualified auditor/ inspector.
	See 4.4.4 /4.4.8	4.4.8.5	If relevant, the company shall check at receipt the products coming from its subcontractor.
4.5	**Factory exterior**	**4.5**	**Factory location**
	Deleted	**4.5.1**	**Site security**
	Deleted	4.5.1.1	Senior management shall ensure that hazards related to site security (fire, explosions, electrical devices, flooding) are identified and preventive measures are managed.
	Deleted	4.5.1.2	The production and storage areas of the site shall be effectively secured by controlled access in order to prevent unauthorized entry.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
	Deleted	**4.5.2**	**Factory exterior**
4.5.1*	***Potential adverse impact on product safety and quality from*** the factory environment (e.g. ground, air) shall be investigated. ***Where risks have been identified, measures shall be documented, implemented and reviewed for*** effectiveness (e.g. extremely dusty air, strong smells) ***at least once within a 12 month period or whenever significant changes occur.***	4.5.2.1	The company shall investigate to what extent the factory environment (e.g. ground, air) may have an adverse impact on product safety and product quality. In each case, appropriate measures shall be established. The effectiveness of the established measures shall be periodically reviewed (examples: extremely dusty air, strong smells).
4.5.2	The factory exterior shall be clean, tidy and maintained ***in good condition.***	4.5.2.2	The factory exterior shall be sustainable maintained, clean and tidy. The external condition of the premises shall be considered within the internal audit process.
4.5.3	All grounds within the site ***shall be clean, tidy and maintained in a way to prevent contamination.*** Where natural drainage is inadequate, a suitable drainage equipment shall be installed.	4.5.2.3	All grounds within the site shall be in good condition. Where natural drainage is inadequate, a suitable drainage equipment shall be installed.
4.6	**Plant layout and process flows**	**4.5.3**	**Plant layout and process flow**
4.6.1	***Site*** plan(s) covering all buildings ***shall be documented and shall describe, maintained at a minimum the process flow of:*** • finished products, • packaging materials, • raw materials, • ***semi finished products including rework,*** • waste, • personnel, • water.	4.5.3.1	Plans clearly describing internal flows of finished products, raw materials including packaging materials, waste, personnel, water, etc. shall be in place. A site map covering all buildings of the facility shall be available.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.6.2	The process flow from receipt of goods to dispatch, shall be ***implemented and maintained, reviewed and where necessary, modified to ensure that the microbiological, chemical and physical*** contamination ***risks of*** raw materials, packaging materials, semi-finished, rework and finished products are avoided. The cross-contamination risks shall be minimized through effective measures.	4.5.3.2	The process flow, from receipt of goods to dispatch, shall be organized so that a contamination of raw materials including packaging materials, semi-processed, rework and finished products is avoided. The risk of cross-contamination shall be minimized through effective measures.
4.6.3	Where relevant, products shall not be produced, stored and filled on the same equipment as products with another intended use unless ***validated results*** are available that there is no negative effect ***on the products.***	4.5.3.3	Where relevant, products shall not be produced, stored and filled on the same equipment as products with another intended use, unless evidence is available that there is no negative effect on the personal care products.
4.6.4	***Based on risks,*** areas sensitive to microbiological, ***chemical and physical hazard(s) shall be designed and operated to ensure product safety is not compromised.***	4.5.3.4	If production areas are identified as microbiologically sensitive (e.g. clean room technology), a positive air pressure equipment shall be installed. Assessment of the level of the microorganisms shall be performed at risk based intervals.
4.6.5*	Where relevant for laboratories: • location of laboratories at the factory shall not affect product safety, • microbiological laboratory shall be physically separated from chemical laboratory.	4.5.4.1.9	Where relevant, for laboratories: • location of laboratories at the factory shall not affect product safety, • microbiological laboratory shall be physically separated from chemical laboratory, • suitable equipment and environment shall be available for all tests performed. **(last part of the requirement located in 5.6.2)**

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.7	**Production and storage premises**	**4.5.4**	**Buildings and facilities**
4.7.1	**Constructional requirements**	**4.5.4.1**	**Buildings and internal structures**
4.7.1.1	All ***premises*** used in the manufacture and storage of products shall be designed, constructed ***and maintained*** to allow unobstructed installation, ease of maintenance, efficient pest control and easy cleaning of the equipment, as well as compliance with all relevant legislation.	4.5.4.1.1	All buildings used in the manufacture or storage of products shall be designed and constructed in order to allow unobstructed installation, ease of maintenance, efficient pest control and easy cleaning of the equipment, as well as compliance with all relevant legislation.
4.7.1.2	***Premises*** where the products are prepared, treated, processed and stored shall be designed and constructed so that product ***safety and quality*** is ensured.	4.5.4.1.2	Rooms where the products are prepared, treated, processed and stored shall be designed and constructed, so that product compliance and product safety is ensured.
4.7.2	**Walls**		**NEW**
4.7.2.1	Walls shall be constructed to meet production requirements in a way to prevent contamination to reduce condensation and mold growth, and to facilitate cleaning.	4.5.4.1.3	Walls shall be constructed to prevent the accumulation of dirt, to reduce condensation and mold growth, and to facilitate cleaning.
4.7.2.2	***The surfaces of walls shall be maintained in a way to prevent contamination and easy to clean. Based on risks they shall be impervious and wear-resistant to minimize product contamination risks.***		**NEW**
4.7.3	**Floors**		**NEW**
4.7.3.1	Floors shall be easy to clean and designed and constructed to meet production requirements (e.g. mechanical loads, cleaning materials, etc.).	4.5.4.1.4	Floors shall be in good condition and shall be designed to meet production requirements (e.g. mechanical loads, cleaning materials, etc.) and to facilitate cleaning and disinfection, where required.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.7.4	**Ceilings/overheads**		
4.7.4.1	Ceilings (or, where no ceilings exist, the inside of roofs) and overhead fixtures (including piping, cableway, lamps, etc.) shall be designed, constructed and maintained to minimize the accumulation of dirt and condensation and shall not pose any physical and/or microbiological contamination risks.	4.5.4.1.5	Ceilings (or, where no ceilings are fitted, the undersides of roofs) and overhead fixtures (incl. piping, cables, lamps) shall be suitable for the process and shall be designed and constructed to minimize the accumulation of dirt, the detachment of paints or other coating materials, condensation and mold growth. Ceilings and overheads shall be designed to facilitate cleaning and prevent product contamination.
4.7.4.2	***Where false ceilings are used, access to the vacant area shall be provided to facilitate cleaning, maintenance and inspection for pest control.***		**NEW**
4.7.5	**Windows and other openings**		**NEW**
4.7.5.1	Windows and other openings shall be designed and constructed to avoid the accumulation of dirt and shall be maintained in a way to prevent contamination.	4.5.4.1.6	Windows and other openings shall be designed and constructed to avoid the accumulation of dirt and shall be maintained in good condition.
4.7.5.2	***Where there are contamination risks, windows and roof glazing shall remain closed and fixed during production.***		**NEW**
4.7.5.3	***Where windows and roof glazing are designed to be opened for ventilation purposes, they shall be fitted with easily to clean pest screens or other measures to prevent any contamination.***		**NEW**
4.7.6	**Doors and gates**		**NEW**
4.7.6.1	Doors and gates shall be ***maintained in a way to prevent contamination and*** easy to clean. ***Based on risks, they shall be constructed to avoid:*** • ***splintering parts,*** • ***flaking paint,*** • ***corrosion.***	4.5.4.1.7	Doors and gates shall be in good condition and easy to clean.
4.7.6.2	***Plastic strip curtains separating areas shall be maintained in a way to prevent contamination and easy to clean.***		**NEW**

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.7.7	**Drainage system**		**NEW**
4.7.7.1	Drainage ***systems*** shall be ***easy to clean and*** designed to ***minimize product contamination risks (e.g. entry of pests, transmission of odour or contaminants).*** The hygienic disposal of waste water shall be ensured.	4.5.4.1.8	Drainage equipment shall be designed to facilitate cleaning and to minimize the risk of product contamination (e.g. adverse impact, ingress of pests, environment impact etc.). The hygienic disposal of waste water shall be ensured.
4.7.7.2	***Water or other liquids shall reach drainage using appropriate measures without difficulties. Puddles shall be avoided.***		**NEW**
4.7.8	**Lighting**	**4.5.4.2**	**Lighting, air conditioning/ ventilation**
4.7.8.1	All working areas shall have the ***levels of light according to the activities carried out.***	4.5.4.2.1	All working areas shall have adequate lighting.
4.7.8.2	***Based on risks,*** all lighting equipment and electric fly killer units shall be protected. The factory areas where this clause shall apply: • handling of unpackaged products ***and raw materials,*** • storage of raw materials including packaging materials, • changing rooms. This does not preclude that other areas shall not have protected lighting equipment or electric fly killer units.	4.5.4.2.2	Based on documented evaluation of possible risks, all lightning equipment and electric fly killer units shall be protected. The factory areas where this clause applies are, as a minimum: • handling of unpackaged products, • storage of raw materials, including packaging materials, • handling of raw materials, • changing rooms. This does not preclude that other areas cannot have protected lighting equipment or electric fly killer units.
4.7.9	**Air conditioning/ventilation**		**NEW**
4.7.9.1	Natural and/or artificial ventilation ***covering process/product needs*** shall exist in all areas.	4.5.4.2.3	Adequate natural and/or artificial ventilation shall exist in all areas
4.7.9.2	If ventilation equipment is installed, filters and other components shall be easily accessible ***and monitored,*** cleaned or replaced ***as necessary.***	4.5.4.2.4	If ventilation equipment is installed, filters and other components which require cleaning or replacement shall be easily accessible.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.7.9.3	***Air conditioning equipment and artificially generated airflow shall not compromise product safety and quality.***		**NEW**
4.7.9.4	Dust extraction equipment shall be ***designed, constructed and maintained*** in areas where considerable amounts of dust are generated.	4.5.4.2.6	Dust extraction equipment shall be installed in areas where considerable amounts of dust are generated.
4.7.10	**Water**	**4.5.4.3**	**Water quality**
4.7.10.1*	A ***water monitoring program shall exist covering*** all process waters (e.g. water used in the facilities, for cleaning activities, used as an ingredient, etc.). The testing of all process waters shall incorporate at a minimum: • chemical, physical and microbiological specifications, • ***frequency,*** • ***method of water treatment depending on product requirement (e.g. deionization, distillation, etc.).*** Special consideration shall be given after periods of no water consumption (e.g. after a weekend or holiday period) ***and when the stagnation of water cannot be avoided.*** The risk assessment shall address this topic.	4.5.4.3.1	All process waters (including water used as an ingredient) shall be tested regularly for compliance with chemical, physical and microbiological specifications. Special attention shall be paid after periods of no water consumption (e.g. after a weekend or holiday period). The risk assessment shall address this topic. The company shall demonstrate the effectiveness of its water treatment and usage.
4.7.10.2	A water monitoring program shall verify that the water treatment is adequate and effective on a risk-based ***sampling*** plan.	4.5.4.3.2	A water monitoring program (especially in the case of cold mixing operations) shall verify that the water treatment is adequate and effective on a risk based plan.
4.7.10.3	Recycled water which is used in the process shall not pose a contamination risk. Records of compliance testing shall be available.	4.5.4.3.3	Recycled water which is used in the process shall not pose a contamination risk. The water shall comply with applicable legal requirements for potable water; records of compliance testing shall be available.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.7.10.4	***If applicable, different process water quality shall be clearly distinguished throughout the site and shall not pose a risk of contamination.***		**NEW**
4.7.11	**Compressed air**		**NEW**
4.7.11.1	The quality of compressed air ***that comes in direct contact with the product or packaging intended to be in contact with the product*** shall be monitored ***based on risks.*** Compressed air shall ***not pose*** contamination risks.	4.5.4.2.5	The use of air in the production (e.g. compressed air supply) shall avoid contamination and be based on a process and product risk assessment
4.8	**Cleaning and disinfection**	**4.6**	**Cleaning and disinfection**
4.8.1	Risk based cleaning and disinfection schedules shall ***be validated, documented*** and implemented. These shall specify: • objectives, • responsibilities, • the products used and their instructions for use, • ***methods of cleaning (including dosage of cleaning and disinfection chemicals),*** • the areas ***and timeslots*** for cleaning and disinfection, • documentation requirements, • ***cleaning in place (CIP) criteria, if applicable,*** • hazard symbols (if necessary).	4.6.1	Based on documented evaluation of possible risks, cleaning and disinfection schedules shall be available and implemented. These shall specify: • objectives • responsibilities • the products used and their instructions for use • the areas to be cleaned and/or disinfected • cleaning frequency • documentation requirements • hazard symbols (if necessary). Those schedules shall be documented.
4.8.2	***Defined methods for monitoring shall be adequately documented and implemented. Monitoring records for cleaning and disinfection shall be available.***		**NEW**
4.8.3	***Cleaning and disinfection activities shall be documented and implemented and shall result in effectively cleaned premises, facilities and equipment.***		**NEW**
4.8.4	Only ***competent*** personnel shall perform cleaning and disinfection ***activities.*** The personnel shall be trained and retrained to carry out the cleaning schedules.	4.6.2	Where relevant, only qualified personnel shall be allowed to undertake cleaning and disinfection. The personnel shall be trained and retrained to carry out the cleaning schedules.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.8.5	The effectiveness of the cleaning and disinfection measures shall be verified. ***The verification shall rely on a risk-based sampling schedule and shall consider one or several actions like for example:*** • ***visual inspection,*** • ***rapid testing,*** • ***analytical testing methods.*** Resultant actions shall be documented.	4.6.3	Based on documented evaluation of possible risks, the effectiveness and safety of the cleaning and disinfection measures shall be verified, validated for equipment and documented according to a sampling schedule by using appropriate procedures. Resultant corrective actions shall be documented.
4.8.6	Cleaning and disinfection ***activities*** shall be ***reviewed and modified*** according to any changing circumstances (e.g. construction work, new products, new machines, changes of climate etc.). Where necessary, the cleaning and disinfection schedules shall be adapted.	4.6.4	Cleaning and disinfection measures shall be validated according to any changing circumstances (e.g. construction work, new products, new machines, changes of climate etc.). Where necessary, the cleaning and disinfection schedules shall be adapted.
4.8.7	Current safety data sheets (SDS) and instructions for use shall be always available on-site for chemicals and cleaning agents. Personnel responsible for cleaning and ***disinfection activities*** shall be able to demonstrate their knowledge of such instructions.	4.6.5	Current safety data sheets (SDS) and instructions for use shall be available for chemicals and cleaning agents. Personnel responsible for cleaning shall be able to demonstrate their knowledge of such instructions, which shall always be available on site.
4.8.8	Cleaning utensils and chemicals shall be clearly identified, used and stored appropriately to avoid contamination or unintended use.	4.6.6	Cleaning utensils and chemicals shall be clearly identified, used and stored appropriately, to avoid contamination or unintended use.
4.8.9	If relevant, the cleaning of production tools shall be carried out at specific locations or specific time periods separated from the production process. If this is not possible, these operations shall be controlled as to not affect the product safety and quality.	4.6.7	The cleaning of production tools shall, if relevant, be carried out at specific locations or specific time periods separated from the production process. If this is not possible, these operations shall be controlled as to not affect the product safety and quality.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.8.10	Where a company hires a third-party service provider for cleaning and disinfection activities ***in production areas, all above-mentioned requirements shall be documented in the service*** contract.	4.6.8	Where a company hires a third-party service provider for cleaning and disinfection activities, all requirements specified within section 4.6 shall be clearly defined in the respective contract.
4.9	**Waste management**	**4.7**	**Waste disposal**
4.9.1	A waste management procedure shall be ***documented***, implemented ***and maintained*** to ***prevent*** cross contamination.	4.7.1	A waste management procedure shall exist and shall be implemented to avoid cross contamination.
4.9.2	All ***local*** legal requirements for waste disposal shall be met.	4.7.2	All current legal requirements for waste disposal shall be met.
4.9.3	***Product waste and other waste shall be removed from areas where product is handled. The accumulation of waste shall be avoided.***		**NEW**
4.9.4	Waste collection ***areas and*** waste containers (incl. compactors) shall be ***maintained tidy, clean to minimize pest attraction,*** and where necessary disinfected. Waste containers shall be clearly marked, suitably designed and in a good state of repair.	4.7.3	Waste collection containers and, where existing, compactors shall be clearly marked, suitably designed, in good state of repair, easy to clean, and where necessary disinfected.
4.9.5	Waste shall be collected in separate containers in accordance with the intended means of disposal. Such waste shall be disposed by authorized third-parties only. Records of waste disposal shall be kept by the company. Whenever possible, destruction of waste shall be intended to avoid re-use of ***non-compliant*** products.	4.7.4	Waste shall be collected in separate containers in accordance with the intended means of disposal. Such waste shall be disposed by authorized third parties only. Records of waste disposal shall be kept by the company. Whenever possible, destruction of waste shall be intended to avoid re-use of unfit products.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.10	**Foreign material risk mitigation**	**4.8**	**Risk of foreign materials**
4.10.1	***The products being processed shall be protected against physical contamination, which includes but is not limited to:*** • ***environmental contaminants,*** • ***oils or dripping liquids from machinery,*** • ***dust spills.*** ***Special consideration shall also be given to product contamination risks caused by:*** • ***equipment and utensils,*** • ***pipes,*** • ***walkways,*** • ***platforms,*** • ***ladders.*** ***If for technological characteristics and/or needs, the products cannot be protected, control measures shall be implemented.***		**NEW**
4.10.2*	***Based on risks***, procedure(s) shall be ***documented, implemented and maintained*** to prevent contamination with foreign material.	4.8.1	Based on hazard analysis and risk assessment, procedures shall be in place to avoid contamination with foreign material. Contaminated products shall treated as non conforming products.
4.10.3	In areas where raw materials, ***semi-finished and finished products*** are handled the use of wood shall be ***avoided.*** Where the ***presence*** of wood cannot be avoided the risks shall be controlled ***and the wood shall be clean and pose no risks to product safety.***	4.8.2	In all areas, e.g. handling of raw materials including packaging materials, processing and storage, where risk assessment has identified the potential for product contamination, the use of wood shall be excluded. Where the use of wood cannot be avoided, the risk shall be controlled.
4.10.4	Where metal and/or other foreign material detectors are required, they shall be installed to ensure ***maximum*** efficiency of detection to ***prevent*** subsequent contamination. ***Detectors shall be subjected to maintenance to avoid malfunction at least once within a 12-month period, or whenever significant changes occur.***	4.8.3	Where metal and/or other foreign material detectors are required, they shall be installed to ensure efficiency of detection, in order to avoid subsequent contamination.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.10.5	The accuracy of ***all equipment and methods designed to detect and/or eliminate foreign materials*** shall be specified. ***Functionality tests of such equipment and methods shall be carried out at least at the start and end of production as well as at every product changeover.*** In case of malfunction or failure, ***the impact on products and processes shall be assessed.***	4.8.4	The accuracy of detectors shall be specified. Checks of proper function of detectors shall be carried out regularly. In case of malfunction or failure of foreign material detector, corrective actions shall be defined, implemented and documented.
4.10.6	Potentially contaminated products shall be isolated. Access and actions for further handling or ***testing*** for these isolated products shall be carried out only by authorized personnel.	4.8.5	Potentially contaminated products shall be isolated. Access and actions for further handling or checking for these isolated products shall be carried out only by authorized personnel according to defined procedures. If product's contamination is confirmed, those shall be treated as non-conforming products.
4.10.7	A glass and brittle material procedure shall be implemented taking into account preventive and corrective measures; ***the procedure shall include reference to procedures in the event of glass or brittle material breakage.*** Where a risk assessment has identified a potential for product contamination, the presence of brittle material (including glass) shall be excluded or if this is not possible, the risk shall be managed.	4.8.6	A procedure for glass and brittle material management shall be implemented, taking into account preventive and corrective measures as well as the recording of glass breakages. Where a risk assessment has identified a potential for product contamination, the presence of glass and brittle material shall be excluded or, if this is not possible, the risk shall be managed.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.11	**Pest monitoring and control**	**4.9**	**Pest monitoring / pest control**
4.11.1*	***Risk based*** pest control ***measures*** shall be ***documented, implemented and maintained.*** They shall comply with local legal requirements and shall take into account at a minimum: • factory environment (potential ***and targeted*** pests), • ***type of raw material / finished products,*** • site plan with area for application (bait map), • ***constructional designs susceptible for pest activity, for example ceilings, cellars, pipes, corners,*** • identification of the baits on site, • responsibilities, in-house/ external, • agents used and their instructions for use and safety, • frequency of inspections, • ***rented storage if applicable.***	4.9.1	The company shall have a pest control system in place which is in compliance with local legal requirements, taking into account, as a minimum: • the factory environment (potential pests) • site plan with area for application (bait map) • identification of the baits on site • responsibilities, in-house/external • used products/agents and their instructions for use and safety • the frequency of inspections. The pest control system shall be based on documented evaluation of possible risks.
	Merged in 4.11.7	4.9.2	The company shall have qualified and trained in-house staff and/ or employ the services of a qualified external provider. Where an external provider is used, the activities required on site shall be specified in a written contract.
4.11.2	Pest control inspections and resulting actions shall be documented. Implementation of actions shall be monitored and recorded. ***Any infestation shall be documented and control measures taken.***	4.9.3	Pest control inspections and resulting actions shall be documented. Implementation of actions shall be monitored and recorded.
4.11.3	Baits, traps and insect exterminators shall be fully functioning, sufficient in number, ***designed for purpose***, placed in appropriate positions ***and used in a way*** to avoid contamination.	4.9.4	Baits, traps and insect exterminators shall be functioning, in sufficient numbers and placed in an appropriate position. They shall be constructed and positioned as not to cause any contamination.
4.11.4	Incoming deliveries shall be ***inspected*** on arrival for the presence of pests. ***Any findings shall be recorded.***	4.9.5	Incoming deliveries shall be checked on arrival for the presence of pests. Any infestation shall be documented and control measures taken.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
	Merged in 4.7.5.3	4.9.6	If windows pose a risk of a source of contamination like ingress of pests, windows and roof glazing shall remain closed and fixed during production. If they are designed to be opened for ventilation purposes, they shall be sealed by easy removable pest fences or other measures in order to avoid any contamination.
4.11.5	Based on risks, external doors and gates shall be designed to prevent the ingress of pests; if possible, they shall be self-closing.	4.9.7	Based on risk assessment, external doors and gates shall be designed to prevent the ingress of pests; if possible, they shall be self-closing.
4.11.6	***The effectiveness of the pest control measures shall be verified, including trend analysis to allow timely appropriate actions. Records of this verification shall be available.***		**NEW**
4.11.7	***Where a company hires a third-party service provider for pest control, all above mentioned requirements shall be documented in the service contract. A person at the company shall be appointed and competent to monitor the pest control activities. Even if the pest control service is outsourced, responsibilities for the necessary actions (including ongoing supervision of pest control activities) shall remain within the company.***		**NEW**
4.12	**Receipt and storage of goods**	**4.10**	**Receipt of goods and storage**
4.12.1	All incoming goods including packaging materials ***and labels***, shall be checked ***for compliance*** against specifications and a determined ***risk-based monitoring plan.*** The ***inspection plan shall be justified by risk assessment. Records of those inspections shall be available.***	4.10.1	All incoming goods, including packaging materials, shall be identified and checked for conformity against specifications/other legally required documentation and to a determined control plan. The control plan shall be risk based. Test results shall be documented.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.12.2	***A system shall be implemented and maintained*** to ensure storage conditions and locations of raw materials including packaging materials, semi-***finished*** and finished products correspond to product ***specifications and shall not have any negative impact on other products.***	4.10.2	The storage conditions and locations of raw materials including packaging materials, semi-processed and finished products as well as working materials shall in each case correspond to product requirements, shall not be detrimental to other products and shall minimize cross contamination.
	Merged in 4.2.1.3	4.10.3	Where relevant, for semi-finished products, maximum duration for storage shall be defined. When this duration is reached, the semi-finished product shall be re-evaluated before use.
4.12.3	Outdoor storage shall be kept to a minimum. Where ***products*** are stored outside it shall be ensured that there is no risk of contamination or adverse effect on product safety and quality.	4.10.4	Outdoor storage shall be kept to a minimum. Where goods are stored outside, hazard analysis and risk assessment shall be undertaken in order to ensure that there is no risk of contamination or adverse effect on quality and product safety.
4.12.4	When raw materials including packaging materials are repacked the new label shall contain the relevant information as on the original label.	4.2.1.4	When raw materials including packaging materials are repacked the new label shall contain the relevant information as on the original label.
4.12.5	***All*** products shall be identified. Use of products shall be undertaken in accordance with the principles of First In / First Out and/or First Expired / First Out, and in accordance with relevant industry best practices.	4.10.6	Products shall be clearly identified on receipt and when stored. Use of products shall be undertaken in accordance with the principles of First In / First Out and/or First Expired / First Out, in accordance with relevant industry best practices.
4.12.6	Periodic inventory shall be performed to ensure stock reliability. Any significant discrepancy shall be investigated and corrective action taken.	4.10.7	Periodic inventory shall be performed to ensure stock reliability. Any significant discrepancy shall be investigated and corrective action taken.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.12.7	Where a company hires a third-party storage service provider, the service provider shall be subject to IFS Logistics Requirements. If the third-party service provider is not certified to IFS Logistics, all relevant requirements equivalent to the company's own warehousing practices shall be fulfilled and this shall be defined in the respective contract.	4.10.8	Where a company hires a third-party storage service provider, the service provider shall be subject to IFS Logistics requirements. If the third party service provider is not certified to IFS Logistics, all relevant requirements equivalent to the company's own warehousing practices shall be fulfilled and this shall be clearly defined in the respective contract.
4.13	**Transport**	**4.11**	**Transport**
4.13.1	***The transport vehicles used to transport goods shall be in good condition and shall protect the products from adverse weather conditions and external influences.*** The conditions inside the vehicle for example: • absence of strange smells, • high dust load, • adverse humidity, • pests, • mould, • ***vehicle integrity,*** ***shall be checked and documented before loading and unloading to ensure compliance with the defined conditions.***	4.11.1	Before loading transport vehicles, their condition (e.g. absence of strange smells, high dust load, adverse humidity, absence of contamination, pests, mold) shall be checked and actions taken, if necessary. At the raw materials and packaging materials receipt, checks shall be made in order to assess that transportation has taken place under in good conditions.
	Deleted	4.11.2	In case of transport of dangerous goods, the company shall ensure that all the relevant legislative requirements are fulfilled.
4.13.2	***Procedures to prevent contamination during transport (as well as internal transport) including loading and unloading shall be documented, implemented and maintained.***		**NEW**
4.13.3	***Risk-based*** hygienic requirements for all transport vehicles ***including tank trucks*** and equipment used for loading/unloading (e.g. hoses of silo installations) shall be ***implemented***. There shall be records of the ***measures*** taken.	4.11.3	Adequate hygienic requirements for all transport vehicles and equipment used for loading / unloading (e.g. hoses of silo installations) shall exist. There shall be records of the actions taken.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.13.4	Loading and unloading areas shall have equipment in place to protect transported products from external influences.	4.11.4	Where relevant, loading and unloading areas shall have equipment in place to protect transported products from external influences.
	Merged in 6.1	4.11.5	Security of transport vehicles shall be appropriately maintained.
4.13.5	Where a company hires a third-party transport service provider all the requirements specified within section 4.13 shall be defined in the respective contract or the service provider shall be subjected to IFS Logistics Requirements ***or equivalent standard.***	4.11.6	Where a company hires a third-party transport service provider all the requirements specified within section 4.11 shall be clearly defined in the respective contract or the service provider shall be subject to IFS Logistics requirements.
4.14	**Maintenance and repair**	**4.12**	**Maintenance and repair**
4.14.1	A ***maintenance plan*** shall be documented, ***implemented*** and maintained that covers all critical equipment (including transport) for compliance with product requirements. This applies both to internal maintenance activities ***and service providers. The plan shall include responsibilities, priorities and due dates.***	4.12.1	An adequate system of maintenance shall be in place. This system shall be maintained and documented, covering all critical equipment (incl. transport) for compliance with product requirements. This applies both for internal and external maintenance activities.
4.14.2	Product requirements and prevention of contamination shall be ensured during and after maintenance and repair work. Records of maintenance and repair work and of corrective actions taken shall be kept.	4.12.2	Product requirements and prevention of contamination shall be ensured during and after maintenance and repair work. Records of maintenance and repair work and of corrective actions taken shall be kept.
4.14.3	All materials used for maintenance and repair shall be fit for the intended use ***and not pose contamination risks.***	4.12.3	All materials used for maintenance and repair shall be fit for the intended use.
4.14.4	Failures ***and malfunctions of premises*** and equipment (incl. transport) ***essential for product safety and quality shall be identified***, documented and reviewed to ***enable prompt actions and to improve the maintenance plan.***	4.12.4	Failures of plant and equipment (incl. transport) covered by the maintenance system shall be documented and reviewed so as to adapt the maintenance system accordingly.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.14.5	Temporary repairs shall be carried out so that product requirements are not affected. Such work shall be documented, and a short-term deadline set for eliminating the fault.	4.12.5	Temporary repairs shall be carried out so that product requirements are not affected. Such work shall be documented and a short-term deadline set for eliminating the fault.
4.14.6	Where a company hires a third-party maintenance and repair service provider, all the company require-ments regarding material, equipment ***and operational rules*** shall be defined, documented, and maintained ***in the service contract, to prevent any product contamination.***	4.12.6	Where a company hires a third-party maintenance and repair service provider, all the company specified requirements regarding material and equipment shall be clearly defined, documented and maintained.
4.15	**Equipment**	**4.13**	**Equipment**
4.15.1	Equipment shall be suitably designed and ***defined*** for the intended use. Before commissioning, it shall be validated that the product ***and customer*** requirements are complied with. Consumables used for equipment should not affect the ***product safety and*** quality of the product.	4.13.1	Equipment shall be suitably designed and specified for the intended use. Before commissioning, it shall be verified that the product requirements are complied with. Consumables used for equipment should not affect the quality of the product.
4.15.2	***Where relevant for product safety, evidence for conformity shall be in place to demonstrate that equipment, utensils and other materials in contact with the product are suitable for the intended use.***		**NEW**
4.15.3	Equipment shall be ***located to allow effective*** cleaning, ***disinfection*** and maintenance operations.	4.13.2	Equipment shall be designed and locationed so that cleaning and maintenance operations can be effectively performed.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.16	**Traceability**	**4.14**	**Traceability**
4.16.1*	**KO N° 4:** A traceability system shall be ***documented, implemented and maintained*** that enables the identification of product lots and their relation to batches of raw materials and packaging in direct contact with product and intended or expected to be in direct contact with product. The traceability system shall incorporate all relevant records of: • ***receipt,*** • ***processing at all steps,*** • ***use of rework,*** • ***distribution.*** Traceability shall be ensured ***at all stages and*** documented until delivery to the customer.	4.14.1	**KO N° 4:** A traceability system shall be in place which enables the identification of product lots and their relation to batches of raw materials, packaging in direct contact with product, packaging intended or expected to be in direct contact with product. The traceability system shall incorporate all relevant receiving processing and distribution records. Traceability shall be ensured and documented until delivery to the customer.
	Merged in 4.16.3	4.14.2	Downstream traceability records (from production sites to the customers) shall be available. The timeframe for producing these records for review shall be compliant with customer's requirements.
4.16.2	***The company shall ensure that the used packaging and labelling correspond to the product being packaged and comply with agreed customer product specifications. This shall be regularly checked and documented.***	4.14.3	Traceability shall be in place to identify the relationship between batches of final products and their labels.
4.16.3	The traceability system shall be tested at least ***once within a 12-month period or whenever significant changes occur. The test samples shall verify the complexity of the company's product range. The test records shall demonstrate*** upstream and downstream traceability (from delivered products to raw materials and vice versa). ***The traceability of the finished products shall be performed within four (4) hours maximum.***	4.14.4	The traceability system shall be tested on a periodic basis at least annually and each time traceability system changes. The test shall verify downstream and upstream traceability (from raw materials to delivered products and vice versa), including quantity checking. Test results shall be recorded.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
	Merged in 4.17.1	4.14.5	Based on documented evaluation of possible risks, on legal requirements and on customer specifications, traceability shall be ensured at all stages, including work in progress, post treatment and rework.
4.16.4	It shall be possible to identify at all times all major equipment used for the production of finished product (containers of raw materials and of semi-finished products, mixers, filling lines, etc.).	4.14.6	Where relevant, at all times it shall be possible to identify all major equipment used for the production of finished product (containers of raw materials and of semi-finished products, mixers, filling lines, etc.).
4.16.5	If required by customer ***and/or law***, identified samples representative of the manufacturing batch shall be stored appropriately and kept until expiration date of the finished product, and if necessary, for a determined period beyond this date. ***For products which have no shelf life, the storing duration shall be justified, and this justification shall be documented.***	4.14.7	If required by customer, identified samples representative of the manufacturing batch shall be stored appropriately and kept until expiration date of the finished product and, if necessary, for a determined period beyond this date ("sample bank").
4.17	**Allergen risk mitigation**		**NEW**
4.17.1	***Information about*** allergens requiring declaration shall be available. The company shall have a continuously maintained system ***to demonstrate*** all raw materials containing allergens used at its premises ***are known*** and identifies all blends and formulas to which such raw materials containing allergens are added.	4.2.1.5	Where relevant, raw material specifications identifying allergens requiring declaration shall be available. The company shall maintain a continuously up to date listing of all raw materials containing allergens used at its premises, which also identifies all blends and formulas to which such raw materials containing allergens are added.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
4.17.2*	***Risk based measures shall be implemented and maintained from receipt to dispatch, to ensure that potential cross contamination of products by allergens is minimized. The potential cross contamination risks shall consider at a minimum:*** • ***environment,*** • ***transport and storage,*** • ***raw materials,*** • ***allergen precursors,*** • ***production process.*** ***Implemented measures shall be monitored.***		**NEW**
4.17.3	***Finished products containing allergens requiring declarations, shall be declared in accordance with legal requirements and/or customer requirements.***		**NEW**
4.18	**Product defence**		**NEW**
4.18.1	***A product defence procedure and plan shall be implemented in relation to assessed threats. This shall encompass at a minimum:*** • ***identification of critical areas and/or practices and policy of access by employees, visitors and contractors,*** • ***transport vehicles,*** • ***IT,*** • ***legal requirements, if applicable,*** • ***any other appropriate control measure.*** ***The product defence plan shall be well known and established within the company and shall be reviewed annually and upon changes.***		**NEW**
4.18.2	***The responsibilities for the product defence shall be defined. The responsible person(s) shall have full commitment from the senior management.***		**NEW**

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
5	**Measurements, analyses and improvements**	**5**	**Measurements, analyses, corrective actions and management of incidents**
5.1	**Internal audits**	**5.1**	**Internal audits**
5.1.1	An effective internal audit ***program*** shall be ***documented, implemented and maintained*** and shall ***ensure*** that all the requirements of the IFS Standard are ***assessed within a 12-month period and its execution shall not exceed 15 months.*** The company shall have a risk assessment ***in place where activities critical to product safety and quality shall be audited more frequently.*** It shall also apply to off-site storage locations owned or rented by the company.	5.1.1	Effective internal audits shall be conducted according to a defined agreed audit program and shall cover at least all requirements of the IFS HPC Standard. Scope and frequency of internal audits shall be determined by risk assessment. This is also applicable for off-site storage locations owned or rented by the company.
	Merged in 5.1.1	5.1.2	Internal audits shall be carried out at least once a year in all departments.
5.1.2	The auditors shall be competent and independent from the audited department.	5.1.3	The auditors shall be competent and independent from the audited department.
5.1.3	Internal audits shall be documented and results communicated to the senior management and to the persons responsible for the concerned activities. Compliances, deviations and non-conformities shall be documented and communicated to the relevant persons.	5.1.4	Audit results shall be communicated to the senior management and to responsible persons of concerned department. Necessary corrective actions and a schedule for implementation shall be determined, documented and communicated to every relevant person.
	Merged in 5.1.3	5.1.5	It shall be documented, how and when the corrective actions resulting from the internal audits shall be verified.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
5.2	**Site inspections**	**5.2**	**Factory inspections**
5.2.1	***Site*** inspections shall be planned and carried out ***for topics, for example:*** • ***constructional status of production and storage premises,*** • ***external areas,*** • product control ***during processing,*** • hygiene ***during processing and within the infrastructure,*** • foreign material hazards, • personal hygiene. ***The frequency of inspections shall be based on risks and on the history of previous results.***	5.2.1	Regular factory inspections shall be planned and carried out to assess criteria such as product control, hygiene, foreign material hazards, personal hygiene, and housekeeping. Any deviation and the associated corrective actions shall be documented.
5.3	**Process validation and control**	**5.3**	**Manufacturing process validation and control**
5.3.1	The criteria for process validation and control shall be defined. ***Process parameters (temperature, time, pressure, chemical properties, etc.) which are essential to ensure the product safety and quality shall be monitored, recorded continuously and/or at defined intervals and secured against unauthorized access and/or change.***	5.3.1	The criteria for process validation and control shall be clearly defined. All processes critical to product safety and product compliance shall be validated.
5.3.2	Processing operations shall be carried out in accordance with processing control documentation and shall include: • suitable equipment, • composition of the product, • list of all raw materials identified according to relevant documents indicating batch numbers and quantities, • detailed processing operations for each stage, such as addition of raw materials, temperatures, mixing times, sampling and semi-finished product transfer. Where applicable, a batch number shall be assigned.	5.3.2	Processing operations shall be carried out in accordance with processing control documentation, and shall include: • suitable equipment, • composition of the product, • list of all raw materials identified according to relevant documents indicating batch numbers and quantities, • detailed processing operations for each stage, such as addition of raw materials, temperatures, mixing times, sampling and semi-finished product transfer. Where applicable, a batch number shall be assigned.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
	Merged in 5.3.1	5.3.3	In circumstances where the control of process and working environment parameters (temperature, time, pressure, chemical properties etc.) is essential to ensure the product requirements are met, such parameters shall be monitored and recorded continuously and/or at appropriate intervals.
5.3.3	The company shall ensure that in the event of changes to processing methods, equipment, and product formulation (including rework and packaging material), process characteristics are reviewed ***to assure*** that product requirements are complied with. If relevant, customers shall be informed accordingly.	5.3.4	The company shall ensure that in the event of changes to processing methods, equipment and product formulation (including rework and packaging material), process characteristics are reviewed in order to assure that product requirements are complied with. If relevant, customers shall be informed accordingly.
5.3.4	All rework operations shall be validated, monitored and documented. These operations shall not affect the product ***safety and quality.***	5.3.5	Where relevant, all rework operations shall be validated, monitored and documented. These operations shall not affect the product requirements.
5.3.5	Procedures shall be ***documented, implemented and maintained*** for prompt notification, recording and monitoring of equipment malfunction and process deviations.	5.3.6	There shall be appropriate procedures for prompt notification, recording and monitoring of equipment malfunction and process deviations.
5.3.6	If substantial ***process*** modifications occur a revalidation shall be carried out.	5.3.7	Process validation shall be performed using the collected data that is relevant for product safety and the processes. If substantial modifications occur, a revalidation shall be carried out.
5.4	**Calibration, adjustment and checking of measuring and monitoring devices**	**5.4**	**Calibration, adjustment and checking of measuring and monitoring devices**
5.4.1	Measuring and monitoring devices required to ensure compliance with product ***safety and product quality shall be identified and recorded. Their calibration status shall be recorded. Measuring and monitoring devices shall be legally approved if required by current relevant legislation.***	5.4.1	The company shall identify the measuring and monitoring devices required to ensure compliance with product requirements. These devices shall be listed on a document and clearly identified.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
5.4.2	All measuring devices shall be checked, ***monitored***, adjusted and calibrated ***at defined, recognized standard/methods and within relevant limits of the process parameter values.*** The results shall be documented.	5.4.2	All measuring devices shall be checked, adjusted and calibrated, under a monitoring system, at specified intervals and in accordance with defined recognized standard/ methods. The results of these checks, adjustments and calibrations shall be documented. Where necessary, corrective actions on devices and on processes and products shall be carried out.
5.4.3	All measuring devices shall be used exclusively for their defined purpose. ***Where the results of measurements or the status of the device indicate a malfunction, the device in question shall be immediately repaired or replaced. Where malfunction has been identified, the impact on processes and products shall be assessed to identify whether non-conforming products have been processed.***	5.4.3	All measuring devices shall be used exclusively for their defined purpose.
	Merged in 5.4.2	5.4.4	The calibration status of the measuring devices shall be clearly identified (labelling at the machine or on a list of test devices).
5.5	**Quantity control monitoring**	**5.5**	**Quantity checking (quantity control / filling quantities)**
5.5.1*	The frequency and methodology of quantity checking shall be implemented and maintained to meet legal requirements ***(including destination country/ies)*** and customer specifications.	5.5.1	The frequency and methodology of quantity checking shall be determined so that the legal requirements and customer specifications, or if relevant, guidelines for nominal quantity are met.
5.5.2	Compliance criteria ***to control*** lot quantity ***shall be defined.***	5.5.2	A procedure shall exist to define compliance criteria for lot quantity checking.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
5.5.3	***Monitoring*** shall be implemented and recorded according to a sampling plan which ensures a proper representation of the manufacturing lot. ***Results of these checks shall be compliant with defined criteria for all products ready to be delivered.***	5.5.3	Checks shall be implemented and recorded, according to a sampling plan which ensures a proper representation of the manufacturing lot.
	Merged in 5.5.3	5.5.4	Results of these checks shall be compliant with defined criteria for all products ready to be delivered.
	Deleted	5.5.5	If relevant, all equipment used for final checking shall be legally approved.
5.6	**Product testing and environmental monitoring**	**5.6**	**Product analysis (including quality checks)**
5.6.1	There shall be procedures ensuring that all specified product requirements are met, including legal requirements, performance and specifications. Results of microbiological, physical and chemical analysis required for that purpose shall be available.	5.6.1	There shall be procedures ensuring that all specified product requirements are met, including legal requirements, performance and specifications. Results of microbiological, physical and chemical analysis required for that purpose shall be available.
5.6.2	Suitable equipment and environment shall be available for all tests performed.	4.5.4.1.9	**Last part of the requirement**
5.6.3	Analyses which are relevant for product safety, quality and legality shall preferably be performed by laboratories with appropriate accredited programs/methods (ISO/IEC 17025). If the analyses are performed ***internally*** or by a laboratory ***without*** the appropriate accredited programs/methods, the results shall be ***cross-checked by laboratories accredited to these programs/methods (ISO/IEC 17025) at least once within a 12-month period, or whenever significant changes occur.*** The company shall be able to demonstrate that the results are reliable.	5.6.2	Analyses, which are relevant for product safety and legality, shall preferably be performed by laboratories having appropriate accredited programs/methods (ISO 17025). If the analyses are performed by a factory internal or a laboratory not having appropriate accredited programs/methods, the company shall be able to demonstrate that the results are reliable.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
5.6.4	Documented evidence shall exist which ensure the reliability of the internal analysis results, on the basis of official and non-official recognized analytical methods.	5.6.3	Documented evidence shall exist, which ensure the reliability of the internal analysis results, on the basis of official and non-official recognized analysis methods.
5.6.5*	***Testing and monitoring plans*** for internal and external analyses ***shall be riskbased to ensure that product safety, quality, legal and specific customer requirements are met.*** The plan shall cover at a minimum: • raw materials, • semi-finished products (if applicable), • finished products, • ***packaging materials,*** • ***contact surfaces of processing equipment (if appropriate),*** • ***relevant parameters for environmental monitoring.*** ***The testing plan shall include the*** frequency ***of the tests and the tolerance associated*** to the specification limits.	5.6.4	A control plan shall be drawn up for internal and external analysis, based on documented hazard analysis and risk assessment and based on additional information regarding product quality (e.g. complaints). This plan shall cover raw materials, semi-processed and finished products and this plan shall include the types of tests, their frequency and critical limits which are linked to the specification limits. The test results shall be documented.
5.6.6	The results shall be reviewed regularly and trends identified. ***Immediate corrections shall be implemented for any*** unsatisfactory results, or where such trends indicate unsatisfactory results. ***When unsatisfactory trends are identified, the impact on processes and products as well as the need for actions shall be assessed.***	5.6.5	The analytical results shall be reviewed regularly and trends identified. Appropriate measures shall be introduced promptly for any unsatisfactory results, or where such trends indicate unsatisfactory results.
5.6.7	When relevant, sampling of raw materials and of bulk product shall be performed in an appropriate manner and by authorized personnel.	4.10.5	When relevant, sampling of raw materials and of bulk shall be performed in an appropriate manner and by authorized personnel.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
5.6.8	Where internal analyses ***or controls*** are undertaken, ***these shall be carried out in accordance with defined procedures by competent and approved personnel.***	5.6.6	Where internal analysis is undertaken, qualified and trained personnel shall be in place, as well as appropriate equipment and premises.
5.6.9	Results of checks on finished products including rework material shall be reviewed by authorized personnel to verify the conformity of the finished and semi-finished products with the acceptance criteria. ***Appropriate corrective actions shall be undertaken for any unsatisfactory results.***	5.6.7	Results of checks on finished products including rework material shall be reviewed by authorized personnel in order to verify the conformity of the finished and semi-finished products with the acceptance criteria.
5.6.10	***For monitoring of the*** quality of the finished product, organoleptic tests shall be carried out. These tests shall be in accordance with specifications and related to the impact on respective parameters of product characteristics. The results of these tests shall be documented.	5.6.8	Where relevant, for verification of finished product quality, organoleptic tests shall be carried out regularly. These tests shall be in accordance with specifications and related to the impact on respective parameters of product characteristic. The results of these tests shall be documented.
5.6.11	***The testing and monitoring plans shall be regularly reviewed and updated, based on results, changes to legislation or issues that may have an impact on product requirements.***	5.6.9	Based on any internal or external information on product risks which may have an impact on product safety and/or quality, the company shall update its control plan and/or take any appropriate measure to control impact on finished products.
5.6.12	***In-process controls shall not compromise product requirements.***		**NEW**
5.7	**Product release**	**5.7**	**Product quarantine (blocking/ hold) and product release**
5.7.1	A procedure for quarantine ***(blocking/hold) shall be documented, implemented and maintained to ensure that only*** raw materials including packaging materials, semi-finished and finished products, and packaging materials complying with product and customer requirements, are processed and dispatched.	5.7.1	A procedure shall be in place for the quarantine and release of all raw materials including packaging materials, semi-processed and finished products, processing equipment. The procedure shall ensure that only products and materials conforming to product requirements are processed and dispatched.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
5.8	**Management of complaints from authorities and customers**	**5.8**	**Management of complaints from authorities and customers**
5.8.1*	A ***procedure*** shall be ***documented, implemented and maintained for the management*** of product complaints ***(including any written notification from the competent authorities, if relevant)***, and shall take into account specific procedures (e.g. undesirable effects).	5.8.1	A system shall be in place for the management of product complaints and, when relevant, shall take into account specific procedures (e.g. undesirable effects).
5.8.2	All complaints shall be ***recorded, readily available and*** assessed by competent staff. Where it is justified, actions shall be taken immediately.	5.8.2	All complaints shall be assessed by competent staff. Where it is justified, appropriate actions shall be taken immediately.
5.8.3	Complaints shall be analysed with a view to implementing ***actions*** to avoid the recurrence of deviations and non-conformity.	5.8.3	Complaints shall be analysed with a view to implementing preventive and corrective actions which avoid the recurrence of the non-conformity.
5.8.4	The results of complaint data analysis shall be made available to the relevant responsible persons including the senior management.	5.8.4	The results of complaint data analysis shall be made available to the relevant responsible persons and to the senior management.
5.9	Management of product recall, product withdrawal and incidents	5.9	Management of incidents, product withdrawal and product recall

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
5.9.1*	**KO Nº 5:** An effective procedure shall be ***documented, implemented and maintained for the management*** of recalls, withdrawals, incidents and potential emergency situations with an impact on product safety, quality, and legality. It shall include at a minimum: • the assignment of responsibilities, • the training of the responsible persons, • ***the decision-making process,*** • the nomination of a person authorized by the company and permanently available ***to initiate the necessary process in a timely manner,*** • ***an up-to-date*** alert contact list ***including*** customer information, sources of legal advice (if necessary), and contacts availability, • a communication plan including customers, ***authorities, and where applicable*** consumers.	5.9.1	A documented procedure shall be defined for management of incidents and of potential emergency situations that impact product safety, legality and quality. This procedure shall be implemented and maintained. This includes as a minimum: the nomination and training of a crisis team, an alert contact list, sources of legal advice (if necessary), contacts availability, customer information, and a communication plan, including information to consumers.
		5.9.2	Updated emergency contact details (such as names and phone numbers of suppliers, customers and competent authorities) shall be available. A person of the company, who has the authority to initiate the incident management process, shall be permanently available.
		5.9.3	The company shall assign the responsibility (ies) for the external communication (crisis management, authorities and communication with media) to specific personnel.
		5.9.4	**KO N° 5:** There shall be an effective procedure for the withdrawal and recall of all products, which ensures that involved customers are informed, as soon as possible. This procedure shall include a clear assignment of responsibilities.
5.9.2	The procedure shall be subject to internal testing for recall/withdrawal, ***by covering the end-to-end process, at least once within a 12-month period and its execution shall not exceed 15 months. The outcome of the test shall be reviewed for continuous improvement.***	5.9.5	The feasibility, effectiveness and timeliness of implementation of the withdrawal procedure shall be subject to regular internal testing, based on documented evaluation of possible risks, but carried out at least once a year. This shall be carried out in a manner to ensure the effective implementation and operation of the procedure.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
5.10	**Management of non-conforming products**	**5.10**	**Management of non-conformities and non-conforming products**
5.10.1	A procedure shall be ***documented, implemented and maintained*** for the management of all non-conforming raw materials, semi-finished products, finished products, processing equipment ***and packaging materials.*** This shall include at a minimum: • ***defined responsibilities,*** • isolation/quarantine procedures, • risk assessment, • identification ***including*** labelling, • decision about the further usage like release, rework/***reprocessing***, blocking, quarantine, rejection/ disposal.	5.10.1	A procedure shall exist for the management of all non-conforming raw materials including packaging materials, semi-finished and finished products and processing equipment. This shall include, as a minimum: • isolation/quarantine procedures, • risk assessment, • identification (e.g. labelling), • decision about the further use (e.g. release, destruction, rework/ post-treatment, blocking, customer information, rejection/ disposal).
5.10.2	The ***procedure*** for the management of non-conforming products shall be understood ***and applied*** by all relevant employees.	5.10.2	The responsibilities for the management of non-conforming products shall be clearly identified. The procedure for the management of non-conforming products shall be understood by all relevant employees.
5.10.3	Where non-conforming products ***are identified***, immediate ***actions*** shall be taken to ensure that ***product safety and*** product ***quality*** requirements are complied with.	5.10.3	Where non-conformities are present, immediate corrections shall be taken to ensure that product requirements are complied with.
5.10.4	***Finished products (including packaging) that are out of specification*** shall not be placed on the market ***under the corresponding label unless a written approval of the brand owner is available.***	5.10.4	Out of specification finished goods or finished goods that do not meet other legal and/ or customer requirements are not allowed to be placed on the market. In case of private labels, exceptions shall be agreed in writing with the contract partners.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
5.11	**Management of deviations, non-conformities, corrections and corrective actions**	**5.11**	**Corrective actions**
5.11.1	A procedure for ***the management of corrections and corrective actions*** shall ***be documented, implemented and maintained*** for the recording analysis ***and communication to the relevant persons of deviations and*** non-conformities and ***non-conforming products, with the objective to close*** the non-compliances and avoid recurrences ***by corrections and/or*** corrective actions. ***This shall include a root cause analysis at least for deviations and non-conformities related to safety, legality and/or recurrence of deviations and non-conformities.***	5.11.1	A procedure shall be in place for the recording and analysis of the non-conformities with the objective to avoid recurrences by preventive actions and/or corrective actions.
5.11.2*	**KO N° 6:** Corrective actions shall be formulated, documented and ***implemented*** as soon as possible to avoid further occurrence ***of deviations and*** non-conformity. The responsibilities and the timescales for corrective actions shall be defined. The documentation shall be securely stored and easily accessible.	5.11.2	**KO N° 6:** Corrective actions shall be clearly formulated, documented and undertaken, as soon as possible to avoid further occurrence of non-conformity. The responsibilities and the timescales for corrective actions shall be clearly defined. The documentation shall be securely stored, and easily accessible.
5.11.3	The ***effectiveness*** of the implemented ***corrections and*** corrective actions shall be ***assessed, and the results of the assessment documented.***	5.11.3	The performance of the implemented corrective actions shall be documented and the effectiveness shall be validated.
	Deleted	**6**	**Product defense (optional chapter)**
	Merged in 4.18		**Note:** this chapter is only applicable: • to companies which produces or exports goods in countries which are subjected to product defence legislation • in case of specific customer request. For the other companies, the chapter shall be assessed as not applicable by the auditor (N/A).

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
	Deleted	**6.1**	**Senior Management Responsibility**
	Merged in 4.18	6.1.1	The company shall have a documented product defence procedure in place to address product defence risk from products and establish, implement and maintain a system to reduce or eliminate the identified risk.
	Merged in 4.18	6.1.2	A product defence assessment shall be conducted annually or upon changes that affect product integrity.
	Merged in 4.18	6.1.3	Responsibilities for product defence shall be clearly defined. Those responsible shall be key staff or shall have access to the senior management team.
	Merged in 4.18	6.1.4	Senior Management shall have an internal communication system to inform and update staff about relevant security issues.
	Deleted	**6.2**	**Site security**
	Merged in 4.18	6.2.1	Based on the product defence procedure and legal requirements, the senior management should define and communicate the areas in which authorized personnel are allowed to access.
	Deleted	**6.3**	**Visitor and personnel security**
	Merged in 4.18	6.3.1	Visitor policy shall contain aspects of product defence.
	Deleted	6.3.2	Employee hiring and employment termination practices shall consider security aspects as permitted by law.
	Deleted	6.3.3	The company shall incorporate product security awareness, including information on how to prevent, detect, and respond to tampering or other malicious, criminal, or terrorist actions or threats, into training programs for staff, including temporary, contract, and volunteer staff. The training shall regularly take place and shall be documented.

IFS HPC v3 N° of Req.	IFS HPC v3 Requirement *new in v3 in semibold-italic*	IFS HPC v2 N° of Req.	IFS HPC v2 Requirement
	Deleted	**6.4**	**Documentation requested by legislation**
	Deleted	6.4.1	If legislation makes registration or on-site inspections necessary, evidence shall be provided.
	Deleted	6.4.2	A documented procedure shall exist for managing external inspections and regulatory visits (if applicable). Relevant personnel shall be trained to execute the procedure.

IFS publishes information, opinions and bulletins to its best knowledge, but cannot take any responsibility for any mistakes, omissions or possibly misleading information in its publications, especially in this document.

The owner of the present document is:

IFS Management GmbH
Am Weidendamm 1 A
10117 Berlin
Germany

Managing Director: Stephan Tromp
AG Charlottenburg
HRB 136333 B
VAT-N°: DE278799213

Bank: Berliner Sparkasse
IBAN number: DE96 1005 0000 0190 0297 65
BIC-/Swift-Code: BE LA DE BE

The English version is the original and reference document.

IFS Documents are available online via:
www.ifs-certification.com

ifs-certification.com