

WELCOME

Issue 7: One year on

Landmark live webinar exploring
key themes and trends.



Your presenters today



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What we will cover today

Statistics

Review of findings

Review of reports

Live Q&A

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Key stats



Issue 7 audits started 28 April 2025

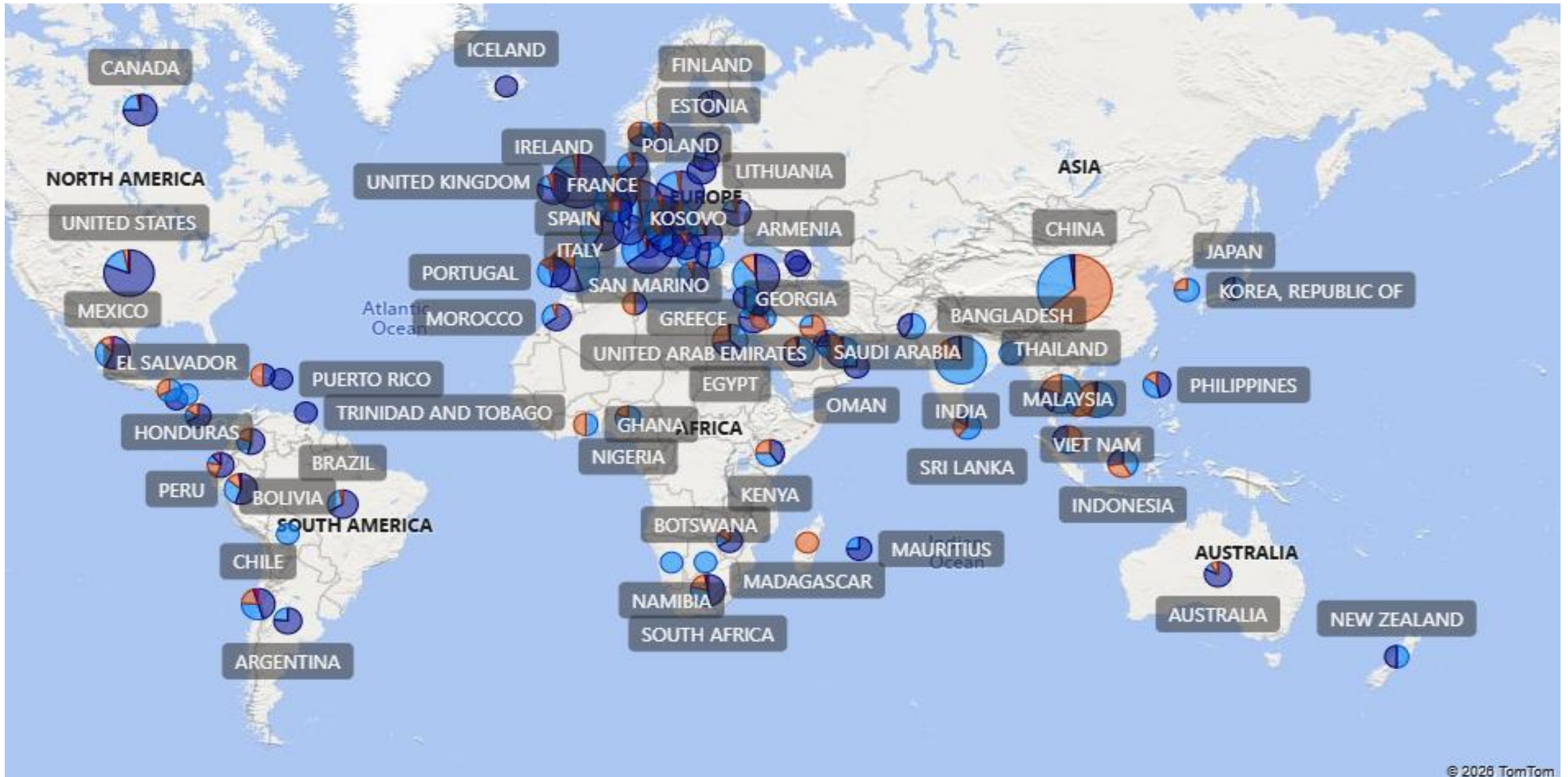
6,751 sites currently certificated, across 94 countries

Almost 38,000 non-conformities raised (excl. modules)

Over 900 of these NCs were Major non-conformities

14 Fundamental/Critical non-conformities were raised (excl. modules)

Geographical spread



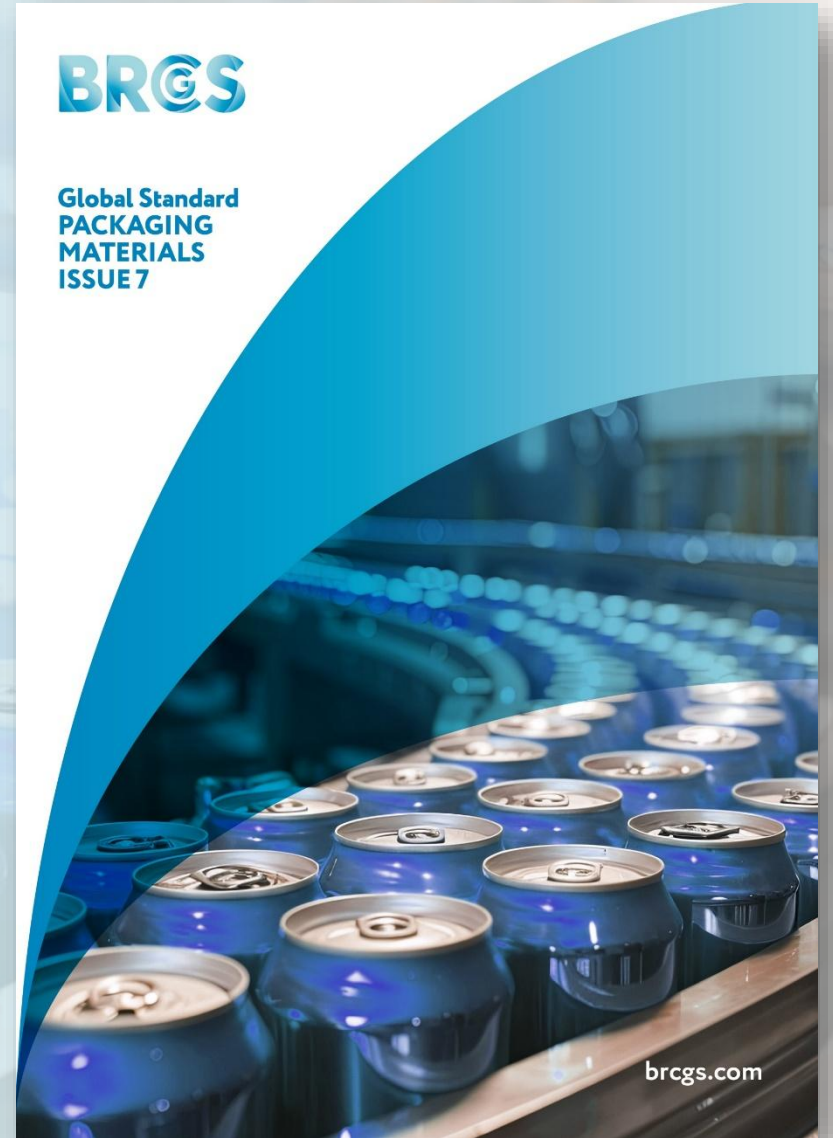
Key markets

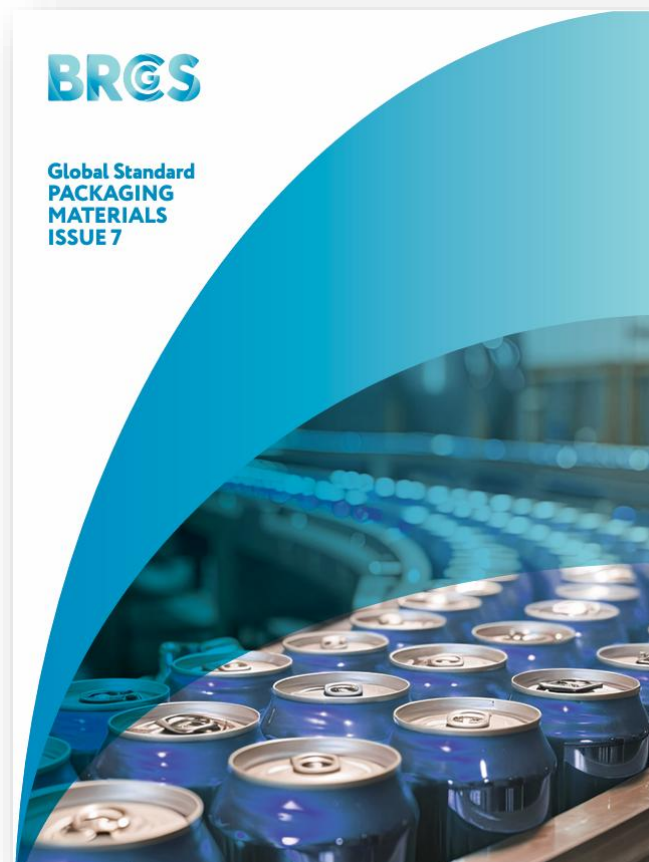


Country	No. of certificates
China	1409
United Kingdom	605
India	421
Spain	401
Italy	398
USA	390
Poland	338
Turkey	300
Germany	269
France	207

A review of key findings

- Critical/Fundamental non-conformities
- Major non-conformity trends
- Minor non-conformity trends





Poll

If you represent a site, did you attend Issue 7 training?



Critical & Fundamental non-conformities?



Section	Critical	Fundamental	Comments
1		2	1.1 (senior management commitment)
2		2	2.0 (HARA)
3		6	5x 3.5 (internal audits) 1x 3.10 (traceability)
4	1	1	Critical: 4.11 (insect infestation – observed) Fundamental: 4.8 (hygiene & housekeeping)
5		1	5.4.5 (manufacturing process control)
6		1	6.1.1 (training)
7		0	

Where are the Major non-conformities being found?



Section		%
1	Senior management commitment	21
2	Hazard analysis and risk assessment	8
3	Product safety and quality management	20
4	Site standards	34
5	Product and process control	14
6	Personnel	3
7	Requirements for traded products	0

The Top 5 Major non-conformities



Clause	Requirements
1.1.8	Overdue reaudit
3.10.1 / 3.10.2 / 3.10.3	Traceability
4.9.2.1	Sharps & metal control
1.1.3 #	Confidential reporting system
1.1.10	Root causes of previous audit NCs addressed

= was a new requirement in issue 7

Where are the Minor non-conformities being found?



Section		%
1	Senior management commitment	8
2	Hazard analysis and risk assessment	9
3	Product safety and quality management	21
4	Site standards	39
5	Product and process control	12
6	Personnel	10
7	Requirements for traded products	1

The Top 10 Minor non-conformities

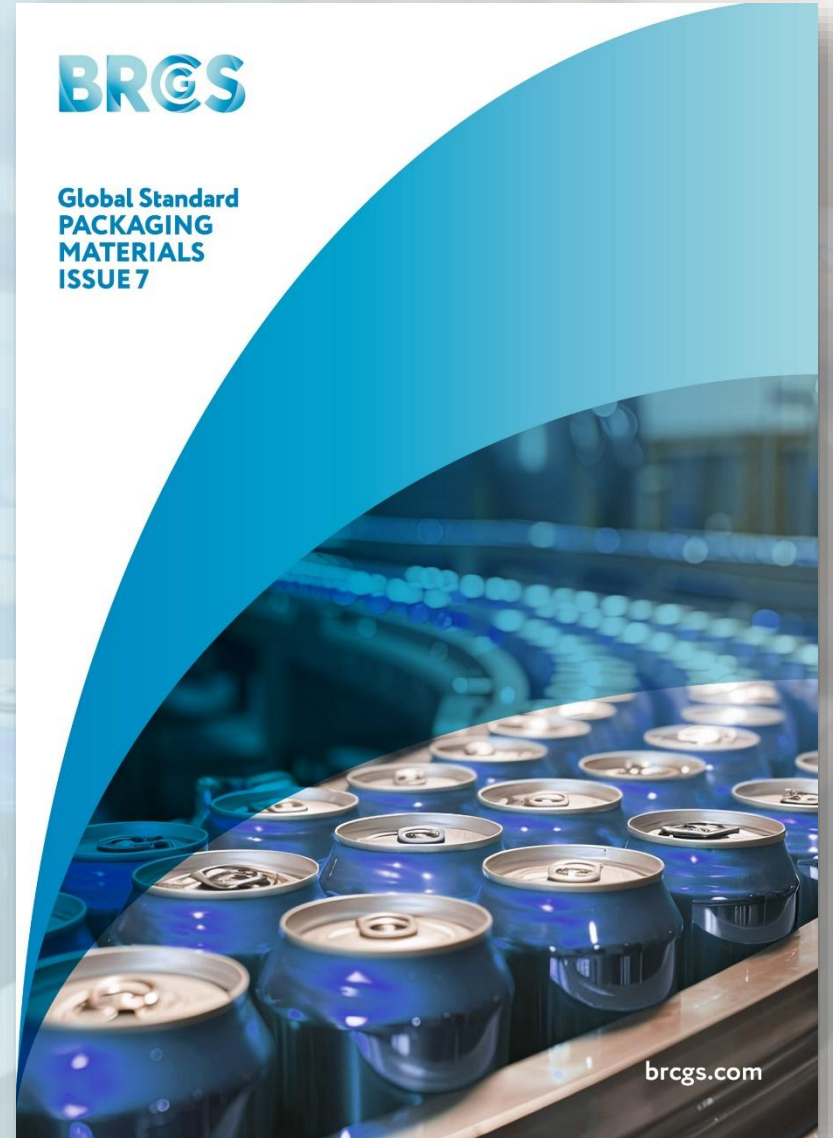


Clause	Requirements
4.8.1 / 4.8.2	Housekeeping standards and cleaning procedures
4.7.3 / 4.7.4	Maintenance hand back and temporary repairs
4.11.4 / 4.11.5	Pest control devices and pest proofing
4.9.3.1	Control of chemicals
3.7.2	Vulnerability RA
2.4.1	HARA flow diagram
1.1.2	Quality culture
3.10.2	Traceability
3.5.1	Internal audit schedule
2.5.1	HARA RA

A review of enquiries

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Single-use disposable products

- What is covered under the scope of packaging materials versus consumer products?
- What are the criteria for determining if the packaging materials standard can be used?
- What is meant by 'predominantly producing packaging materials (at least 70% by volume)'?

Product categories

- Which category does re-packing fit in?
- Where do mixed materials fit – such as metallised film, paper - plastic laminates, and paper cups (inner barrier)?
- Would the rPET cleaning process be category 8?
- Does the Standard cover items for non-food customers?

Appendix 2 Manufacturing categories

Manufacturing categories are used to categorise the sites and ensure that auditors selected to conduct the audit are sufficiently competent to understand the processes carried out at the site.

Manufacturing category	Scope of manufacturing category and typical key processes
Glass manufacture and forming	Key processes include: • raw materials to finished product of glass containers from one furnace through independent section machines to cold end lacquer(s) • further processes for extra furnaces. Any print/decoration is an additional key process. Typical manufacturing techniques include: • blow and blow • press and blow • extrusion of ampoules • forming and firing of ceramic bottles, jars or decanters.
Paper-making and conversion	Pulp to sheet or web, or conversion of sheet or web-fed paper where no printing operations take place (printing activities are additional key processes). Any print/decoration is a further key process. Key processes include: • manufacture of paper from raw materials (e.g. tree/pulp) to sheet or web (e.g. board, liner, carton board) • die-cutting, folding and gluing (erecting), and corrugating (from pulp) to corrugated sheet/reel • conversion of paper sheet into bags or sacks (including stitching) • manufacture of self-adhesive label stock (label and carrier/substrate) • die-cutting of sheet or web (including corrugated) to pads or fitments • moulding of pulp (of any source) into trays or fitments • manufacture of spirally wound tubes (including trimming and cutting) • manufacture of single use paper products e.g., drinking straws, napkins, plates, bags, cups, lids, trays and liners.
Metal-forming	Smelting of raw materials into aluminium, steel or tin, and conversion of those

Supplier approval



- Our supplier blow moulds bottles on site – what approval is needed?
- Is plate maker for a printer a services supplier?
- We buy through an agent – who needs supplier approval?
- Our supplier is not GFSI certified, is ISO9001 ok?
- Do we need to declare our suppliers to our customer?
- What auditor approval is needed for clause 3.6.2?
- Can our contract laundry wrap our garments in recycled plastic?

Outsourcing

- Many queries about specific scenarios, and if they can be / are classed as an outsourced process.
- Is 3rd party management of a warehouse a service or an outsourced process?
- A contractor/supplier makes printing plates for a packaging producer – is this an outsourced process?

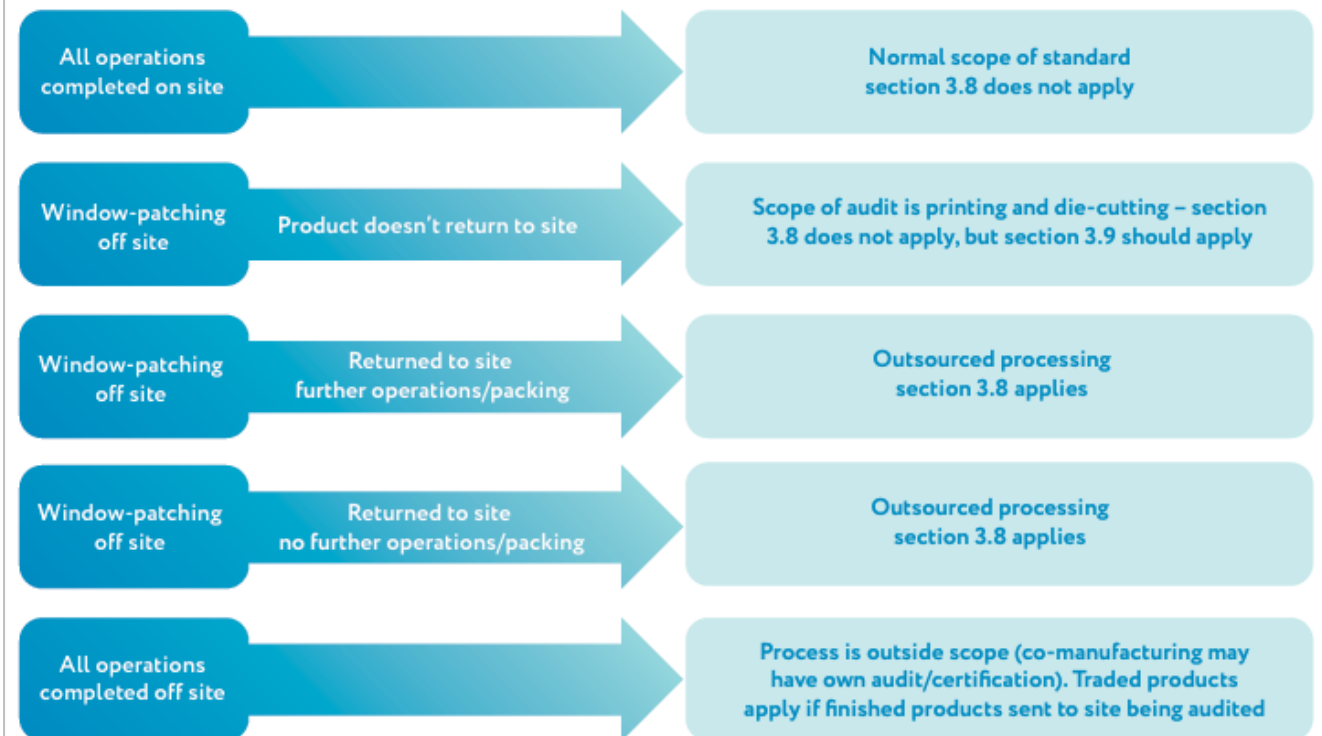
From the Interpretation Guide.....

Figure 1 Example of a simple manufacturing process



A number of different manufacturing models exist for this product, as shown in Figure 1. These affect the scope and applicability of the Standard.

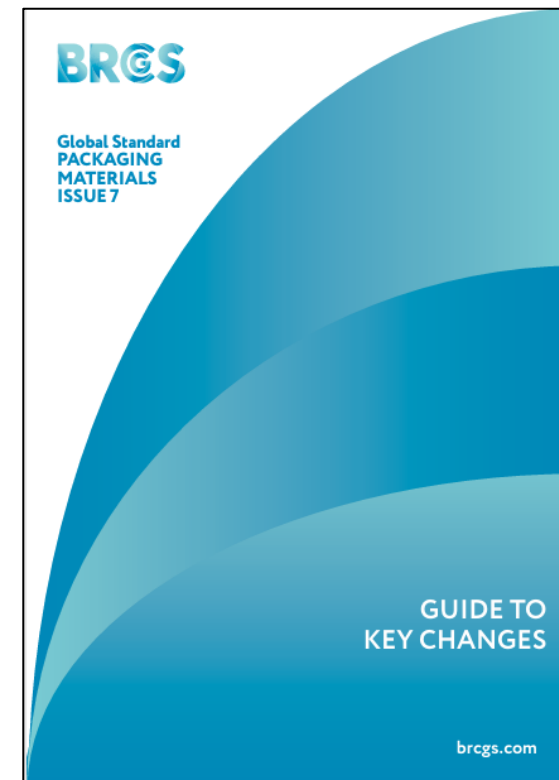
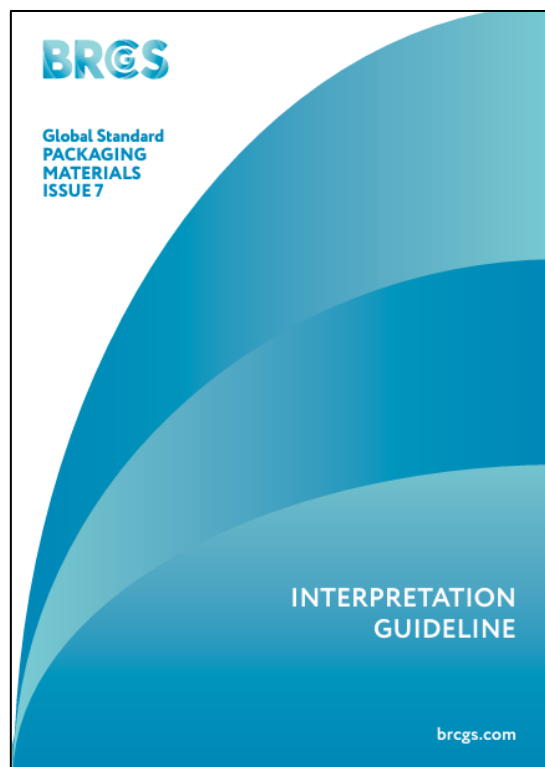
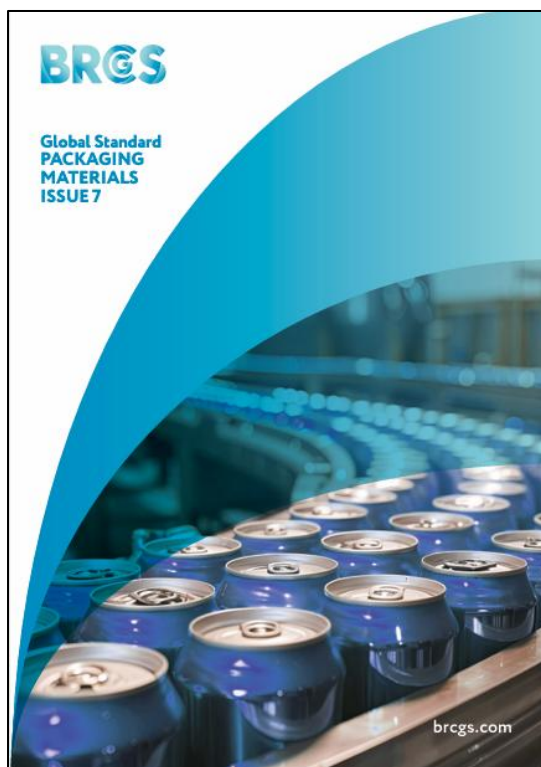
Figure 2 Different types of manufacturing models



Traceability

- What traceability is required for secondary and tertiary packaging?
- Is completion within 4-hours mandatory for the traceability test?





Pre-registered questions



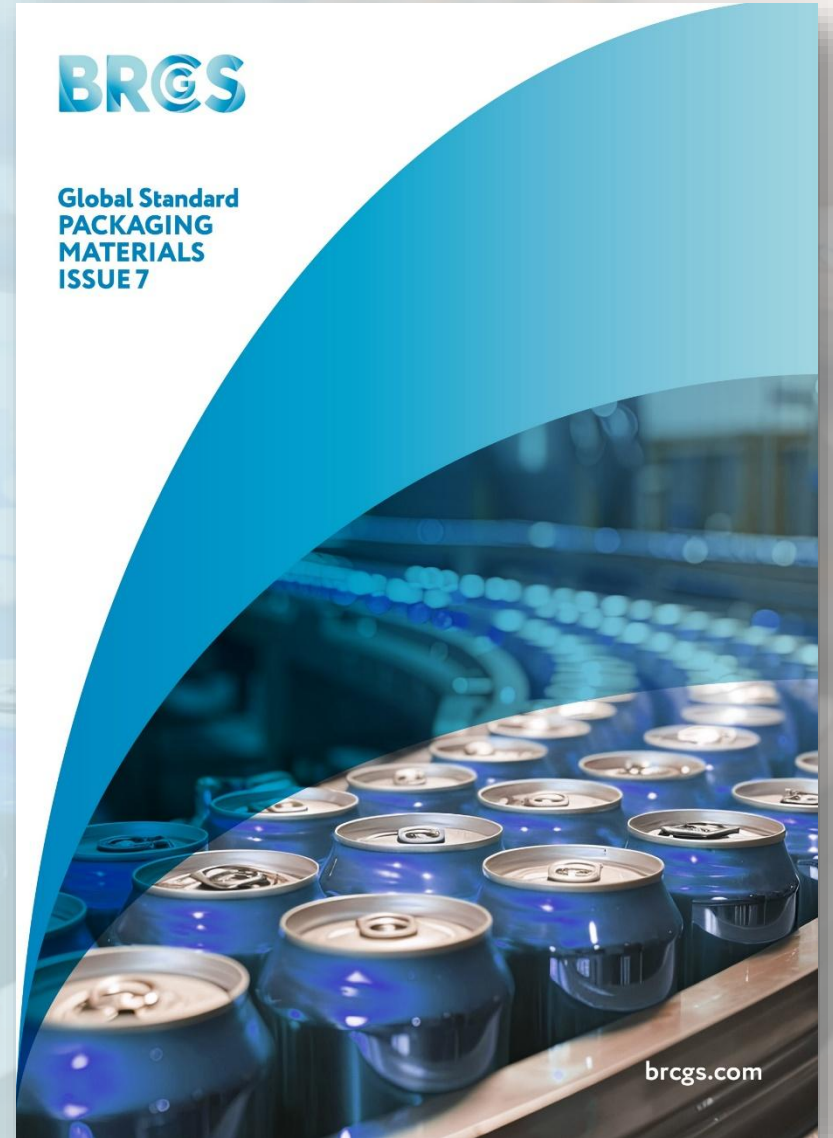
We have selected a few to answer here:

- What is best practice for measuring product safety culture?
- I would like to understand the concept of the declaration of conformity for packaging, and the regulations.
- Can we use risk assessment training instead of specific HARA training?
- Must PRPs in HARA be validated, or is periodic verification with evidence of effectiveness sufficient?

Questions

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