

ISO 22002-4:2025-07 (E)

Prerequisite programmes on food safety - Part 4: Food packaging manufacturing

Contents		Page
Foreword		v
Introduction		vi
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Construction and layout of buildings	2
4.1	Boundaries of the site/facility	2
4.2	Environment	2
4.3	Construction and layout	2
5	Design and layout of facilities and workspaces	2
5.1	General	2
5.2	Internal structures and fittings	2
5.3	Location of equipment	2
5.4	Storage of food, packaging materials, ingredients and chemicals	2
6	Utilities	2
6.1	General	2
6.2	Water, ice and steam	2
6.3	Air and ventilation	2
6.4	Compressed air and other gases	2
6.5	Light	3
7	Pest control	3
7.1	General	3
7.2	Pest control programmes	3
7.3	Preventing access	3
7.4	Harbourage and infestations	3
7.5	Monitoring and detection	3
7.6	Control and eradication	3
8	Waste, FLW management and recycling	3
8.1	General	3
8.2	Recycling and/or reuse of materials	3
8.3	Waste containers	3
9	Equipment suitability and maintenance	3
9.1	General	3
9.2	Equipment capability	3
9.3	Maintenance	4
10	Management of purchased materials	4
11	Storage, including warehousing, and transport	4
11.1	Storage and warehousing	4
11.2	Dispatch	4
11.3	Transport	4

12	Measures for prevention of contamination	4
12.1	General	4
12.2	Chemical contamination	4
12.3	Physical contamination	5
12.4	Migration	5
13	Cleaning and disinfection	5
13.1	General	5
13.2	Cleaning agents and tools	5
13.3	Cleaning and disinfection programmes	5
14	Personal hygiene and employee facilities	5
14.1	General	5
14.2	Hygiene facilities	5
14.3	Designated eating areas	5
14.4	Workwear and protective clothing	6
14.5	Health status	6
14.6	Personnel cleanliness	6
14.7	Personnel behaviour	6
14.8	Visitors and external providers	6
15	Product and consumer information	6
16	Food defence and food fraud	6
16.1	General	6
16.2	Food defence	6
16.3	Food fraud prevention	6
17	Rework usage	6
	Bibliography	7