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