



MONDI STANDARD

For controlled production areas

1. Construction readiness

1.1 Floors

- Floors must be sloped to drainage channels
- Floor finish of ceramic tiles or other easy to clean material must be used
- Drainage channels must be protected against entry of pests
- Drainage channels must be easily accessible for cleaning



1. Construction readiness

1.2 Walls / wall penetrations

- Ceramic tiles on the walls up to the height 1,5m
- Penetrations properly sealed and protected against intrusion of rodents
- Windows
 - secured against insects
 - where there is a risk of damage to the product, based on probability and risk of contamination, the glass windows must be protected against breakage

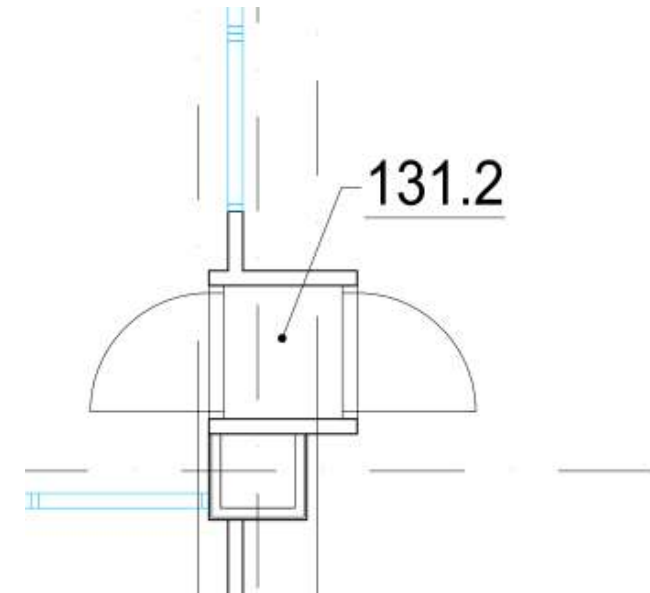


1. Construction readiness

1.2 Walls / wall penetrations

- Entry into the controlled area through the two doors (airlock)
- Entrances for material transport
 - through the two doors (airlock)
 - Speed doors
 - during the vehicle passage only one door may be opened (alternating operation)

Pedestrian airlock



1. Construction readiness

1.3 Suspended ceilings

- Suspended ceilings to be constructed, completed and maintained so as to avoid the risk of contamination
- Ceilings must be accessible for cleaning and inspection of pests if not fully closed

Use of PUR material in structures is prohibited

Walkable ceiling with pipes / ducts



Suspended ceiling – ceiling tiles

2. Production/process management

2.1 Access to controlled area

- Access to the locker rooms, changing rooms and toilets
 - may not be directly from the production, process and storage areas
 - suitable entry to these areas is through a corridor, vestibule, etc.
- Access to the controlled area will be secured by a key card system
- The building must be adequately protected against the entry of pests through all doors, windows, channels, ducts or pipes



2. Production/process management

2.2 Cleanliness control

- In controlled areas must not accumulate dirt
- Where there is a danger of damage to the product, based on the probability and the risk of contamination by glass, all bulbs, fluorescent tubes, including electric insect traps must be adequately protected
- The areas must allow effective cleaning, rodent control, fumigation and disinfection
- Cleaning of equipment must be done in accordance with the operating rules
- Traps for flying insects must be used



3. Requirements for technical equipment



3.1 General requirements

- When planning a new production facility, Risk Analysis – FMEA will be performed
- Equipment must be designed for the intended purposes and must minimize the risk of product contamination
- Equipment must be made of suitable materials and in accordance with the corresponding design in order to ensure efficient cleaning and maintenance
- All production (technical) equipment must be regularly maintained and cleaned to avoid contamination of the product and reduce the risk of failures
- Periodically check the micro biological and chemical quality of water, steam, ice, air, compressed air or other gases, which come into direct contact with the packaging
- Water used for product processing or cleaning must be potable or properly cleaned to avoid contamination

3. Requirements for technical equipment



3.2 Technical requirements

- Switchboards and equipment located in production areas to be mounted onto the platform with a height of 150 mm
(for wet cleaning purposes)
- Switchboard ingress protection IP54 or IP65
- LV, HV substations and transformer stations to be placed at a height 100 mm above the terrain; if not possible, use a door with a threshold height min. 50 mm
- Ensure appropriate and adequate ventilation
 - controlled areas in overpressure
 - moisture removal from the process
- Adequate natural or artificial lighting based upon calculations
- Data transfer to a central control system

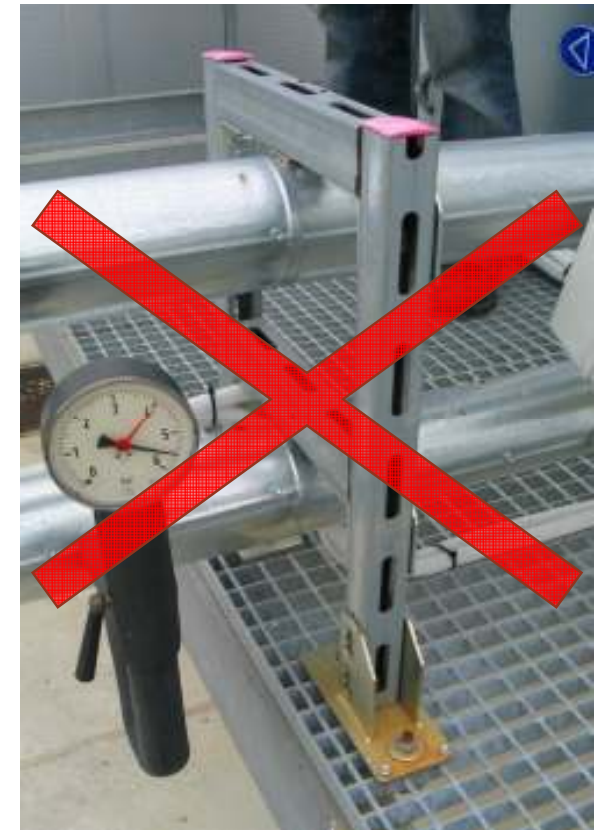


3. Requirements for technical equipment



3.2 Technical requirements

- Pipe hangers
 - Must be made of closed profiles easy to clean
 - Threaded rods must be covered with washable material
- Thermal insulation of piping
 - Of mineral wool protected with metal sheeting
 - Use of PUR material is prohibited



4. External facilities



- External storage of raw materials must be protected against the risk of contamination of raw materials
- External storage - tanks, silos and any inlet pipes with openings to the exterior must be properly secured to prevent unauthorized access

5. Legislation



- All equipment and installations must comply with
 - Czech Sational Standards
 - Decree on hygiene requirements for products intended for contact with food
 - BRC Standards
 - European standards
 - Internal directives MONDI

