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INTEGRATION OF FOOD SAFETY MANAGEMENT SYSTEMS –
"DOING MORE WITH LESS"

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CONTENT

- Trophy Foods – an introduction

- The Evolution of Food Safety Management Systems

- Audits and Auditing – Challenges

- The Integration Journey

- Comparison and Integration

- Benefits and Drawbacks

- GFCP Challenges

- Ongoing Developments

- Summary

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TROPHY FOODS – AN INTRODUCTION

- **Established in 1967, now operating from 3 facilities**

- **"Trophy" is an established brand in Canada**

- **Trade as "Redland Food Corp." in the USA**

- **Primarily manufacture and pack retailer private label for all major Canadian retailers and some USA based companies**

- **All sites have common processes and "unique" processes**

- **Manufacturing scope covers BRC Categories – 5, 15, 16, 17**

- **Buffalo, USA - most recent location (May 2015)**

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GLUTEN-FREE SANS GLUTEN

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FOOD SAFETY EVOLUTION

- **HACCP/FSEP Recognition**   **2005-2008**
- **(Canadian Food Inspection Agency - Food Safety Enhancement Program)**

- **HACCP Accreditation**   **2008-2010**

- **GFSI-BRC Certification**   **2011- present:**

    Calgary   AA+
    Mississauga   A+
    Buffalo   A

AUDITS AND AUDITING – CHALLENGES

- **3 main issues:**

- Time

- Knowledge

- Money

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CURRENT CERTIFICATIONS

- **BRC Global Standard for Food Safety**

- **GFCP (Gluten Free Certification Program)**

- **Kashruth Council of Canada Certification Program (Kosher)**

- **COR Canada's Organic Regulation**

- **DVUP (Direct Verifiable User Program)**

- **NON GMO Certified**

- **GPFHCL** (General Principles of Food Hygiene , Composition and labeling)

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SITE AUDITS

Standard/ Program	Certification/ Inspection Body	Frequency
BRC	SAI Global	Annual (unannounced)
COR	Pro-Cert Organic	Annual
GFCP	SAI Global	Annual
DV	ABC Approved Auditor	Annual
Kosher	Kashruth Council of Canada	Quarterly
Non GMO	SCS Global Services	Annual
GPFHCL	CFIA	Annual

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THE INTEGRATION JOURNEY

- **The FSQMS had to be suitable for the Company**

- **Key and common elements within standards**

- **Determine the backbone**

- **Identity how they integrate**

- **Confirm which standard was most demanding**

- **Confirm the default requirement**

THIS TAKES TIME

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Area (List based on BRC Issue 7)	Organic	Kosher	GFCP	FSEP	DV	Non-GMO
Senior Management Commitment						
Management Commitment			2.2.1	2.2.1		B4 (pg 3)
				2.2.1 - FSEP Manual		
Organisational Structure				N/A		
The Food Safety Plan/HACCP						
HACCP			2.2.2 to 2.2.7 & 3.2 to 3.5	2.2.2 to 2.2.7 & 3.2 to 3.5	X	S VII B
				2.2.2 - 2.2.7 • 3.2 - 3.5 - FSEP Manual		
PRP's			3.1.1.1 to 3.1.1.7	3.1.1.1 to 3.1.1.7	X	
				3.1.1 - FSEP Manual		
Food Safety and Quality Management System						
Food Safety & Quality Manual						S VII A
Document Control				3.4.1 - FSEP Manual		
Record Completion & Maintenance	4.4	2.a/b	3.1.4	3.1.4	X	
				3.1.4 (PRPs) • 3.2.7.5 (CCPs) • 3.2.8.4 (PCs) - FSEP Manual		
Internal Audit			4.2.3	4.2.3		
				* In 4.2.3 - FSEP Manual		
Supplier Approval		2.b.1	B.2.1.1 & B.2.1.3 & G.1.1.2 & G.1.1.4	B.2.1.1 & B.2.1.3 & G.1.1.2 & G.1.1.4	X	
				B.2.1.1 • B.2.1.3 • G.1.1.3 • G.1.1.4		
Specifications		4	B.2.1.4 & B.2.1.1	B.2.1.4 & B.2.1.1		S V E & VII A
				B.2.1.1 • B.2.1.4 • G.1.1.2		
Corrective Actions			3.1.3	3.1.3	X	S VII C
				3.1.3 (PRPs) • 3.2.7.3 (CCPs) • 3.2.8.2 (PCs) - FSEP Manual		
Control of Nonconforming Product			3.1.3	3.1.3	X	S VII C
				B.2.1.2 • ** in 3.1.3 (PRPs) • ** in 3.2.7.3 (CCPs) • 3.2.7.3.1 • 3.2.7.3.2 - FSEP Manual		
Traceability	4.4	2.e	F.1.1.1	F.1.1.1	X	A2 (pg 3) & S IV A
				B.2.1.3 • B.2.1.3 • F.1.1.1 • F.1.2.1 • G.1.1.6		
Complaint Handling				F.1.1		
Incidents/Recall/ Withdrawal		10	3.1.1.6	3.1.1.6	X	
				F.1.1.1		
Customer Focus				N/A		
Site Standards						
External Standards			A.1.1.1	A.1.1.1		
Security				A.1.1.1		
				A.2.1.1		
Layout, Product Flow & Segregation	8.3.9 / 10	2.g.2	A.2.1.1	A.2.1.1	X	A3 (pg 2) & S VI B
				A.2.1.1 • D.2.1.1 • 3.2.3 • 3.2.4 - FSEP Manual		
Building Fabric			A.2.1.1 & A.2.1.2	A.2.1.1 & A.2.1.2		
				A.2.1.1 • A.2.1.2 • A.2.2.1 • A.2.2.2 • A.2.3.1		
Utilities – Water & Air			A.4.1	A.4.1	X	
				A.2.3.3 • A.4.1 • G.1.1.2		
Equipment		5	C.1.1.1	C.1.1.1	X	
				C.1.1.1		
Maintenance			C.1.2.1	C.1.2.1		
				C.1.2.1		
Staff Facilities			A.3.1	A.3.1		
				A.3.1.1 • A.3.1.2 • A.3.2.1 • A.3.2.2		
Chemical and Physical Controls						
Chemical				B.2.1.1 • B.2.2.3 • D.2.1.1 • G.1.3		
Metal				G.2.1.1		
Glass			D.2.1	D.2.1		
Wood				G.2.1.1		
Foreign Body Detection				G.2.1.2		
Housekeeping & Hygiene	8.3.8	5.a.1 / 6.a	E.1.1	E.1.1	X	S VI B
				A.2.1 • E.1.1.1 • G.1.1.9		
Waste/Waste Disposal			A.2.4	A.2.4		
				A.2.4.1		
Management of Surplus Food/Animal Feed				N/A		
Pest Control	8.4		E.2.1	E.2.1		
				E.2.1		
Storage Facilities		2.c.2	B.2.2	B.2.2		
				A.4.1.6 • B.2.1.2 • B.2.2.1 • B.2.2.2 • B.2.1.4		
Dispatch & Transport	8.5		B.1.1	B.1.1		
				B.1.1.1 • B.1.1.2		
Product Control						
Product Design & Development		8		G.1.1.1		
Product Labelling	10 / 11	7	F.1.2	F.1.2		A5 (pg 3)
				F.1.2.1 • G.1.1.3 • G.1.1.4 • G.1.1.7		
Management of Allergens	10.2.4		G.1.1	G.1.1		
				G.1.1		
Product Authenticity, Claims, Chain of Custody				N/A		X
Product Packaging		3.b	B.2.1.1	B.2.1.1		
				B.2.1.1 • B.2.2.2		
Product Inspection & Laboratory Testing				A.4.1.2 • B.2.1.1 • B.2.1.3 • B.2.1.4 • E.1.1.1 • G.1.1.9 • G.1.2 • G.1.3 • G.2.1.1 • 3.2.7.2 (CCPs) - FSEP Manual		A1 (pg 2) & S V
Product Release				B.2.1.4		
Process Control						
Control of Operations			3.2.8	3.2.8		
				C.1.2 • G.1.1 • G.1.2 • G.1.3 • 3.2.7 (CCPs) • 3.2.8 (PCs) - FSEP Manual		
Labelling and Pack Control			F.1.2.1	F.1.2.1		S VII B
				F.1.2.1		
Quantity Control			C.1.2.2	C.1.2.2 • F.1.1.1	X	
Calibration			C.1.2.2	C.1.2.2	X	
				C.1.2.2		
Personnel						
Training			D.1.1.1 & D.2.1.1	D.1.1.1 & D.2.1.1		S VII A
				D.1.2.1		
Personal Hygiene			D.2.1.1	D.2.1.1		
				D.1.1.1 • D.2.1.1		
Medical Screening			D.2.1.1	D.2.1.1		
				D.2.1.1		
Protective Clothing			D.2.1.1	D.2.1.1		
				D.2.1.1		
Additional Comments					DV does not prescribe a standard but complies with 7 CFR Part 981. We have used an "X" mark to indicate the areas audited. All DV requirements were satisfied with current BRC procedures.	

COMPARISON AND INTEGRATION

BRC	FSEP
Management Commitment	**2.2.1**
Organisational Structure	**2.2.1 - FSEP Manual**
HACCP	**2.2.2 to 2.2.7 & 3.2 to 3.5**
	2.2.2 - 2.2.7 • 3.2 - 3.5 - FSEP Manual
PRP's	**3.1.1.1 to 3.1.1.7**
	3.1.1 - FSEP Manual

COMPARISON AND INTEGRATION

		Non GMO
Record Completion & Maintenance	3.1.4 • 3.2.7.5 • 3.2.8.4	
Supplier Approval	B.2.1.1• B.2.1.3 • G.1.1.2 • G.1.1.4	S V E & VII A
Specifications	B.2.1.1 • B.2.1.4 • G.1.1.2	S VIII C
Corrective Actions	3.1.3	
Control of Nonconforming Product	3.1.3 • 3.2.7.3 • 3.2.8.2	S VIII C
	F.1.1.1	
Traceability	B.2.1.1 • B.2.1.3 • F.1.1.1 • F.1.2.1 • G.1.1.6	A2 (pg 3) & S IV A

BENEFITS AND DRAWBACKS

Pro's	*Con's*
Single system-All sites **Confidence** **Easy to manage** **Makes training more effective** **Allows for future acquisition and integration**	**Technically demanding** **Time demanding** **Requires regular review/update**

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GFCP– CHALLENGES

- **3 main issues:**

- Knowledge! - Supplier Understanding

- Knowledge! - Raw Material Sourcing

- Knowledge! - Customers, Regulators, Consumers

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ONGOING DEVELOPMENTS

- ## USA:
  **Food Safety Modernisation Act -
  Food Safety Preventative Controls**

- ## Canada:
  Safe Food For Canadians Act

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SUMMARY

- **Commit to the program (Integration and GFCP)**

- **Plan the work - everyone needs to be involved**

- **Execute and stay with it - It will take time**

- **Review the program - make sure it works for you**

- **Evolve in line with business, customer, standards and regulatory requirements**

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- **Thank you**

- **Questions?**

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