

**FRAME AGREEMENT FOR EQUIPMENT PURCHASE****Appendix 3a Quality and Food Safety requirements****Requirements for the Suppliers of production Equipment****1. General requirements:**

- a) All equipment must be suitable for intended use.
- b) All equipment shall be constructed of appropriate materials. The design and placement of equipment shall ensure it can be effectively cleaned and maintained.
- c) Production equipment must be designed so that no hygienic risk arises.
- d) Equipment must be tolerant to purposed production conditions, washing and disinfection.
- e) Processing water must have an easy and hygienic exit to the drains.
- f) Surfaces and joints must be smooth and easy to clean and disinfect.
- g) Equipment which is in direct contact with food shall be suitable for food contact and meet legal requirements where applicable.
- h) Screws and bolts must not have any contact with products.
- i) Lubricants are not to be in contact with the product. All lubricants must be approved for food use and must be composed of substances that do NOT support microbial growth.
- j) Blue belt conveyors must be used, if not otherwise agreed in writing
- k) Wires and cables must be suitable for the intended use and tolerate the conditions. Wires and cables must be designed and installed in a way which prevents accumulation of dirt and water and allows sufficient cleaning.

**2. Hygienic design and cleanability****2.1 General Hygiene**

The Supplier must design the equipment in a way which allows proper access for cleaning and disinfection including disassembly when needed. The design of the equipment must also allow visual and microbiological checks for cleanliness. The conveyors must be designed to minimize the possibility of accumulation of dirt and water. In case the washing system is not in the scope of the project, the Supplier must design the conveyors in a way which allows installation of washing nozzles inside the conveyors.

The supplier must deliver washing and maintenance instructions for all equipment in local language before delivery.

**2.2 Materials**

Supplier must ensure the production equipment is made of appropriate, non-absorbing, non-porous and non-toxic materials; stainless steel is preferred. Glass materials shall always be avoided, if glass material is not avoidable the risk assessment shall be documented by the Supplier. Materials intended to be in contact with un-packaged food must be suitable for food contact. A declaration of conformity for food contact use shall be delivered for all equipment, spare parts and materials meant for food contact by the Supplier.

The Supplier must ensure the materials in contact with food products must satisfy the conditions set down in the relevant Directives. The machinery must be designed and constructed in such a way that these materials can be cleaned before each use. Where this is not possible disposable parts must be used.

All surfaces in contact with foodstuffs products, other than surfaces of disposable parts, must:

- o be smooth and have neither ridges nor crevices which could harbour organic materials. The same applies to their joints.
- o be designed and constructed in such a way as to reduce the projections, edges and recesses of assemblies to a minimum.
- o be possible for liquids, gases and aerosols deriving from food products as well as from cleaning, disinfecting and rinsing fluids to be completely discharged from the machinery (if possible, in a 'cleaning' position).
- o be designed and constructed in such a way as to prevent any substances or living creatures, in particular insects, from entering, or any organic matter from accumulating in areas that cannot be cleaned.
- o be designed and constructed in such a way that no ancillary substances hazardous to health, including the lubricants used, can come into contact with food products.

### **2.3 Tolerance for cleaning conditions**

Supplier must ensure the equipment tolerates the required washing conditions:

- High pressure washing.
- High temperatures
- Chlorinated alkaline and acidic detergents.
- Per acetic acid and alcohol-based disinfectants.

### **2.4 Access**

When in scope the Supplier must design the equipment and processing areas enabling safe and easy access under, inside and around it for cleaning and maintenance purposes. Where the equipment is permanently sited, it shall be properly mounted to the floor.

### **2.5 Preventing foreign objects**

The supplier shall design the equipment in a way which prevents products to be contaminated by any foreign objects. All materials must be durable and tolerate normal production and cleaning conditions. All screws and bolts etc. must tolerate normal vibration and positioned in a way which prevents them contaminating the products. Only stainless-steel mirrors are allowed.

#### ***Related documents to be fulfilled:***

- *CEN/TR 15623 - Food processing machinery - Route map - Materials for food area*
- *EN 1672-1 - Food processing machinery - Basic concepts - Part 1: Safety requirements*
- *Finland: SFS-EN 1672-2 + A1 - Food Processing machinery. Basic concepts. part 2: Hygiene requirements*
- *EU legislation on food contact materials including, but not limited to EC No 1935/2004, EC No 882/2004 (please see the HKScan instructions for food contact materials)*
- *EHEDG – Hygienic equipment design criteria*
- *EHDEG - Hygienic Design Principles for Food Factories*