



**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB 12695-2016

**National food safety standard - Specifications for Production
Sanitation of Drinks**

食品安全国家标准 饮料生产卫生规范

(English Translation)

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Table of Contents

Foreword...	3
1 Application Scope...	4
2 Terms and Definitions...	4
3 Site Selection and Factory Environment...	4
4 Plant and Workshop...	4
5 Facilities and Equipment...	5
6 Hygienic Management...	8
7 Food Materials, Food Additives and Food Related Products...	8
8 Food Safety Control for Production Process...	9
9 Inspection...	11
10 Storage and Transportation of Products...	11
11 Product Recall Management...	12
12 Training...	12
13 Management System and Personnel...	12
14 Record Keeping and File Management...	12
Appendix A...	13

Foreword

This Standard replaces GB 12695-2003, Good Manufacturing Practice of Drink Factory.

Compared with GB 12695-2003, the major changes of this Standard are as follows.

- the standard name is changed into "National Food Safety Standard - Specifications for Production Sanitation of Drinks";
- the framework of the standard is modified;
- the terms and definitions are modified;
- the requirements for plant and workshop are modified;
- the requirements for facilities and equipment are modified;
- the requirements for food materials, food additives and food related products;
- the requirements for the food safety control of the production process are

emphasized and the major measures for controlling biological, chemical and physical contamination are made;

- the inspection requirements are modified;
- the requirements for product recall, personnel and training are added;
- the requirements for record keeping and file management;
- Annex A "Microbiological Monitoring Procedure Guide for the Production Process of Drinks" is added.

National Food Safety Standard -

Specifications for Production Sanitation of Drinks

1 Application Scope

This Standard specifies the basic requirements and management guidelines for sites, facilities and personnel during material purchase, processing, packaging, storage and transportation and others in the production process of drinks.

This Standard applies to the production of drinks except packaged drinking water; it does not apply to drinks which are made and sold on site.

2 Terms and Definitions

For the purposes of this document, the terms and definitions defined in GB 14881-

3 Site Selection and Factory Environment

As specified in Article 3 of GB 14881-2013.

4.2 Plant and workshop are usually designed including general work zones, quasi-

clean work zones and clean work zones. All zones shall be segregated by effective means to prevent cross contamination. General work zones include raw material handling zones, warehouses, outer packing zones and so on; quasi-clean work zones usually include sterilization zones, batching zones, packaging container cleaning and sterilization zones and so on; clean work zones include filling protective zones of liquid drinks or inner packing zones of solid drinks. The specific zoning shall be subjected to

the product characteristics, production process and the requirements of production process for cleanliness.

4.3 Generally, the enterprise of liquid drinks shall provide water treatment zones, batching zones, filling protective zones, packing zones, warehouses of raw and auxiliary materials and packing materials, warehouses of finished products, testing laboratories and so on, and the enterprise producing concentrates (juices and pulps) for the food industry shall provide raw material cleaning zone (which shall be segregated from the subsequent procedures by effective means). Generally, the sterilization facilities.

5.2.4.5 If air shower facilities are provided, they shall be cleaned and maintained on
a regular basis.

5.2.5.1 Storage facilities shall be provided in accordance with the quantity of products
produced, storage requirements, circulating period of circulating containers and product testing period; storage facilities include owned warehouses and rented warehouses.

5.2.5.2 When materials of different natures are stored in the same warehouse, they
shall be separated or segregated from each other (e.g. they are stored by sorts, shelves and zones) and marked with visible signs.

5.2.5.3 Provide refrigeration (freezing) warehouses if necessary, refrigeration
(freezing) warehouses shall be provided with devices for correct display of temperature and humidity in warehouses.

5.3.1 Provide equipment in accordance with the production capacity and actual
process. The equipment for the production of liquid drinks generally includes water treatment equipment, batching equipment, filter equipment (for products needing to be

filtered), sterilization equipment (for products needing to be sterilized), automatic filling and capping (sealing) equipment, manufacturing date marking equipment, cleaning and sterilization equipment of tools and instruments; the equipment for the production of solid drinks generally include. mixing and batching equipment, baking equipment (if there is a baking process), drying and dehydration equipment (if there is a wet manufacturing process), packing equipment, manufacturing date marking equipment and so on.

5.3.2.1 The use of fully automatic equipment is encouraged as filling and capping (sealing) equipment to prevent cross contamination and operators directly contacting food to be packed.

5.3.2.2 Production equipment shall be marked clearly with the operating status and

maintained and verified on a regular basis. The handling of installation, maintenance of equipment shall not be detrimental to the quality of products. The equipment shall be verified or confirmed to ensure all properties can meet the technological requirements. The equipment which is out of normal use shall be marked conspicuously.

5.3.2.3 Examine whether the equipment is in the normal status before production

each time to prevent the occurrences which influences the safety of products; in case liquids, water and other ingredients and food additives which are used in proportioning, their characteristics shall be verified before use to ensure there are no abnormalities.

8.2.5 Syrup shall be filtered to remove impurities after dissolving; the syrup prepared

shall be used immediately after preparation.

8.2.6 Temperature and time shall be under strict control for the storage of semi-

finished products; the semi-finished products shall be used immediately after preparation. When production is delayed for some reason, the semi-finished products