



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

GB 31603-2015

**National food safety standard - General Health Code for
Production of Food-contacted Materials and Products**

食品安全国家标准 食品接触材料及制品生产通用卫生规范

(English Translation)

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1 Application Scope

This Standard specifies the basic health requirements and management guidelines for the sites, facilities and personnel of all links of the production of all kinds of food- contacted materials and products, including purchase of raw and auxiliary materials, processing, packaging and transportation.

This Standard applies to the production of all kinds of food-contacted materials and products. This Standard shall be used as the basis if it is necessary to make a special health specification for a certain food-contacted material or product.

2 Basic Requirements

2.1

The whole production process and final products shall not be harmful to human health and cause any change in the characteristics of food.

2.2

The whole production process shall be as specified in relevant national laws, regulations and standards. The use of raw and auxiliary materials shall be reduced as much as possible, provided that the intended purpose can be achieved.

2.3

The enterprise shall establish, implement and comply with an effective safety control system to ensure the raw and auxiliary materials, semi-finished products and finished products meet the corresponding food safety requirements.

2.4

The product marking shall be as specified in relevant national laws, regulations and standards.

3 Factory Environment

3.1

The factory shall be kept an appropriate distance from toxic, hazardous pollution sources.

3.2

The roads in the factory shall be hardened. The environment inside and outside shall be clean and tidy. The air, water and site in the manufacturing area shall meet the production requirements.

3.3 The overall layout of production, administrative, domestic and supplementary

areas of the enterprise shall be reasonable to prevent cross contamination.

3.4 The enterprise shall make and implement pest control measures as appropriate to prevent propagation of insect pests.

4 Plant

4.1

The plant shall be well arranged in accordance with the production process and health requirements. The operating areas shall be divided appropriately in accordance with the cleanliness requirements for different production areas. Hierarchical health management shall be carried out for the manufacturing workshops and public places within the plant.

4.2

The plant area shall be compatible with the production capacity. There shall be sufficient space and site for the storage of equipment, materials and products in order to meet the requirements of production and operation.

4.3

The wall and floor surfaces of the manufacturing workshops and storerooms shall be smooth to reduce dust accumulation for the convenience of cleaning; for the products being processed and final products which are in direct contact with food without cleaning, the

ceiling of the manufacturing workshops shall be convenient for cleaning and disinfection, whose structure prevents condensate water dripping directly.

4.4 The production and operation in the same manufacturing workshop or adjacent

manufacturing workshops shall not cause cross contamination. When products of different health requirements are produced within a common production area, the health properties of all products shall be ensured. Appropriate space shall be provided between equipment and equipment or equipment and wall, for the convenience of operation.

5.1 Facilities

5.1.1

The facilities for health, ventilation, transportation and conveying shall be provided which match with the production capacity and health requirements. They shall be well maintained.

5.1.2

The facilities for water supply and drainage shall be provided as appropriate.

5.1.3

The water tanks, floor drains and other devices provided for the production area shall not cause pollution to products.

5.1.4

Sufficient cleaning facilities shall be provided. The workshops with special health requirements shall be provided with appropriate disinfection facilities and disinfected periodically. For the products being processed and final products which are in direct contact with food without cleaning, the manufacturing workshops and storerooms shall be provided with facilities including disinfection, dust prevention and insect prevention and shall not cause pollution to products.

5.1.5

The facilities for waste disposal shall be provided to prevent causing pollution to products. The requirements for the discharge of waste water, waste gas and waste materials, noise pollution and health and other aspects shall meet the relevant national regulations.

5.1.6

The products being processed and final products which are in direct contact with food without cleaning shall meet the following requirements.

-- Changing rooms shall be provided at the entrance of the manufacturing workshops. The size of changing rooms shall match with the number of production personnel. Work clothes shall be separated from individual clothes and other articles.

-- The facilities for changing shoes (or wearing shoe cover) or disinfecting work shoes shall be provided at the entrance of the manufacturing workshops. If the disinfection facilities for work shoes are provided, their specifications and dimensions shall meet the disinfection requirements.

-- The facilities for handwashing, disinfection and dust extraction shall be provided at the entrance of the manufacturing workshops.

5.1.7

It is recommended that the measures specified in 5.1.6 should be taken for the manufacturing workshops of other products.

5.1.8 The changing rooms and facilities in the manufacturing workshops for changing

shoes, handwashing, disinfection and dust extraction shall be managed by special personnel, which shall be cleaned and disinfected in time and kept in clean condition to prevent causing pollution to products.

5.1.9 Appropriate, convenient toilets and handwashing facilities shall be provided for staff. Toilets shall be partitioned from the manufacturing workshops and kept clean.

5.1.10 Adequate natural lighting or artificial lighting shall be provided in the plant. The production areas with special requirements for the intensity of illumination can be provided with local lighting.

5.1.11 The manufacturing workshops whose production process is subjected to temperature and humidity shall be provided with temperature-humidity regulating and monitoring facilities.

5.2.1 Production equipment matching with production capacity and necessary

inspection equipment shall be provided.

5.2.2 The design, type, layout and installation of production equipment shall meet the production requirements, which shall be convenient for use, maintenance, servicing and cleaning.

5.2.3 Production equipment and tools shall be used and maintained correctly to prevent causing pollution to products during the production process. Maintenance and servicing shall be carried out periodically.

6 Personnel