

Summary of contrast and revision of JFS-C Standard Documents (Ver. 3.0/Ver. 3.1)

JFS-C V.3.0: JFS-C Standard Document Ver. 3.0 and Supplemental Requirements
 JFS-C V.3.1 Draft: JFS-C Standard Document Ver. 3.1

Red text: Main additions, corrections, etc.

JFS-C V.3.0
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JFS-C V.3.1
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Number	Item	Explanatory text etc.	Number	Item	Explanatory text etc.	Summary of Major Revisions
1.2	Scope of application	Manufacturing sector of chemical products (including biochemical products) (K) K: Manufacture of chemical products (including biochemical products) (Manufacture of additives, vitamins, minerals, cultures, flavors, enzymes, processing aids, etc.) In addition, chemical products here means a chemical product (including a biochemical product) related to food.	1.2	Scope of application	Manufacturing sector of chemical products (including biochemical products) (K) K: Manufacture of chemical products (including biochemical products) (Production of chemical products (including biochemical products) and cultures used as food ingredients or processing aids in food production.) In addition, chemical products here means a chemical product (including a biochemical product) related to food.	·Compatibility with JFS-B standard Ver.3.0 standard
1.3	Structure of this Standard Document	Explanation regarding (*2) ~ (*5)	1.3	Structure of this Standard Document	Explanation regarding (*2) ~ (*5)	·Move the description (P4→P2)
		(*2) Codex Alimentarius Commission "GENERAL PRINCIPLES OF FOOD HYGIENE" CXC 1-1969, Rev. 2020			(*2) Codex Alimentarius Commission "GENERAL PRINCIPLES OF FOOD HYGIENE," CXC 1-1969, Rev. 2022.	·Correction of notation due to revision of cited standards
						·Item number changes due to each revision
1.4	Exclusion from Application of Requirements	(Reference) Category is as shown in the table below: List of JFS Standard Document Sectors The following sectors apply to this JFS (Food Safety Management) Standard Document.	1.4	Exclusion from Application of Requirements	(Reference) Category is as shown in the table below: Sector list by GFSI The following sectors apply to this JFS (Food Safety Management) Standard Document. ※Of the sectors presented by GFSI, the sectors covered by this standard document are enclosed in a box.	·Compatibility with JFS-B standard Ver.3.0 standard
	("K" in the table)	Manufacture of chemical products (including biochemical products) (Manufacture of additives, vitamins, minerals, cultures, flavors, enzymes, processing aids, etc.)		("K" in the table)	Manufacture of chemical products (including biochemical products) (Production of chemical products (including biochemical products) and cultures used as food ingredients or processing aids in food production.)	·Compatibility with JFS-B standard Ver.3.0 standard

FSM			FSM			Summary of Major Revisions
Number	(Data) Item	Requirement	Number	(Data) Item	Requirement	
FSM 1	Top Management Responsibility	Top management shall establish a clear organizational structure which unambiguously defines the job functions, responsibilities, directing and reporting structure and information sharing of at least the personnel whose activities affect food safety. Top management shall appoint personnel responsible for the operation of the organization's food safety management system.	FSM 1	Top Management Responsibility	Top management shall establish and operate a clear organizational structure which unambiguously defines the job functions, responsibilities, directing and reporting structure and information sharing of at least the personnel whose activities affect food safety. There shall also be evidence that employees are made aware of them. Top management shall appoint personnel responsible for the operation of the organization's food safety management system.	·Compatibility with GFSI GMaP
FSM 4	Compliance with food safety laws	When developing a food safety management system, the organization shall develop, implement and maintain detailed procedures to ensure that all processes and operations that have an effect on food safety are in compliance with the laws of both the country of manufacture and the intended country of sale.	FSM 4	Compliance with food safety laws	When developing a food safety management system, the organization shall develop, implement and maintain detailed procedures to ensure that all processes and operations that have an effect on food safety are in compliance with the laws of both the country of manufacture and the intended country of sale. In addition, records of implementation shall also be maintained.	·Compatibility with GFSI GMaP
FSM 7	Food Defense	The organization shall document, implement, and record assessment procedures to identify potential and overt threats to food defense and prioritize response to those threats. The organization shall document and implement a food defense plan that specifies the actions that the organization implements to mitigate the identified food defense threat. This plan shall cover GMP and shall be incorporated into the food safety management system.	FSM 7	Food Defense	The organization shall document, implement, and record assessment procedures to identify potential and overt threats to hazards of intentional food contamination by persons within or outside the organization and prioritize response to those threats. The organization shall document and implement a food defense plan that specifies the actions that the organization implements to mitigate or exclude the identified food defense threat. This plan must include GMP and be incorporated into the food safety management system. The organization shall also establish access controls for areas where food defense vulnerabilities have been identified. The organization shall establish and implement procedures for responding to possible intentional contamination of product.	·Compatibility with JFS-B standard Ver.3.0 standard ·Compatibility with GFSI GMaP
FSM 8	Food Fraud Prevention	The organization shall document, implement, and record assessment procedures to identify potential and overt tampering with records and labeling of products and intentional dilution, and prioritize food fraud mitigation measures. The organization shall develop a documented plan that specifies the measures the organization implements to mitigate the identified threats of food fraud. This plan shall cover the GMP and shall be incorporated into the food safety management system.	FSM 8	Food Fraud Prevention	The organization shall document, implement, and record assessment procedures to identify potential and overt food fraud vulnerabilities such as tampering with records and labeling of products and intentional dilution, and prioritize food fraud mitigation measures. The organization shall develop a documented plan that specifies the measures the organization implements to mitigate the identified threats of food fraud. This plan shall cover the GMP and shall be incorporated into the food safety management system.	·Additional corrections to the notation
FSM 9.1	Documentation procedures	The organization shall have documented procedures in place to formulate, implement and maintain the documented information (including records) needed to demonstrate the effective operation of its food safety management systems and process controls.	FSM 9.1	Documentation procedures	The organization shall document, implement, and maintain documentation procedures to manage the documented information (including records) necessary for effective operation of the food safety management system and explicit control of the process. In addition, the organization shall keep records necessary to prove the implementation of food safety management, determine an appropriate storage period, and store them.	·Additional corrections to the notation ·Compatibility with GFSI GMaP
FSM 10	Specification Control of Purchased or Provided Items and Services	For all purchased or provided input items and services (including raw materials and ingredients, utilities and services (e.g. electricity, water, transportation, maintenance)) that have an effect on the safety of final product, the organization shall ensure that documented specifications are prepared, maintained, securely retained and readily accessible when needed. The organization shall evaluate the risks and set the confirmation items (confirmation of inspection certificate, condition, temperature, display, etc.) on the items to be purchased or provided. In addition, the organization shall define and implement a review process that includes the handling of changes in specifications and the frequency of regular reviews.	FSM 10	Specification Control of Purchased or Provided Items and Services	For all purchased or provided input items and services (including raw materials and ingredients (including containers and packaging materials), equipment and tools , utilities, and services (e.g. electricity, water, transportation, maintenance)) that have an effect on the safety of final product, the organization shall ensure that documented specifications are prepared, maintained, securely retained and readily accessible when needed. The organization shall evaluate the risks and set the confirmation items (confirmation of inspection certificate, condition, temperature, display, etc.) on the items to be purchased or provided. In addition, the organization shall define and implement a review process that includes the handling of changes in specifications and the frequency of regular reviews.	·Compatibility with GFSI Benchmark Requirements Part III JII Subsector

FSM 11	Procedures and Instructions	The organization shall establish, implement and maintain effective procedures and instructions in all processes and activities that affect food safety. In addition, these procedures and instructions shall be understandable by personnel in different languages.	FSM 11	Procedures and Instructions	The organization shall establish, implement and maintain effective procedures and instructions in all processes and activities that affect food safety. In addition, these procedures and instructions shall be understood by personnel who use different languages.	·Additional corrections to the notation
FSM 12	Resource Management	Top management shall determine and provide, in a timely manner, the qualified resources (including human resources, facilities and work environment, equipment, systems for operating business sites (including communication technology and transportation), means of measurement and traceability, intellectual property management, etc.) that meet the standards required to implement, maintain, and improve the food safety management system.	FSM 12	Resource Management	Top management shall determine and provide, in a timely manner, the qualified resources (including human resources, facilities and work environment, equipment, systems for operating sites (including communication technology and transportation), means of measurement and traceability, intellectual property management, etc.) that meet the standards required to implement, maintain, and improve the food safety management system.	·Corrections to the notation
FSM 13.1	Purchasing	The organization shall control purchasing procedures to ensure that all externally sourced raw materials, packaging materials, and services that have an effect on food safety conform to stipulated specifications, as well as legal and regulatory requirements related to food safety. In addition, these purchasing procedures shall also apply to raw materials, packaging materials, and services purchased from the organization's group companies.	FSM 13.1	Purchasing	The organization shall control purchasing procedures to ensure that all externally sourced raw materials, packaging materials, services, and equipment and tools that have an effect on food safety conform to stipulated specifications, as well as legal and regulatory requirements related to food safety. In addition, these purchasing procedures shall also apply to raw materials, packaging materials, services, and equipment and tools purchased from the organization's group companies.	·Compatibility with GFSI Benchmark Requirements Part III JII Subsector
FSM 13.2	Supplier Performance	The organization shall establish, implement and maintain procedures for the evaluation, approval and continual monitoring of suppliers, which have an effect on food safety. Supplier evaluation shall include measures for food defense and to prevent food fraud. When accepting raw materials, packaging materials, and services from unapproved suppliers in an emergency (such a natural disaster), the organization shall confirm that the products meet the required specifications by an evaluation, inspection, visit, etc. before use. The organization shall maintain evaluation, approval and monitoring records for suppliers.	FSM 13.2	Supplier Performance	The organization shall document , implement, and maintain procedures for the evaluation, approval, and continual monitoring of suppliers, which have an effect on food safety. Supplier evaluation shall include measures for food defense and to prevent food fraud. When accepting raw materials, packaging materials, and services from unapproved suppliers in an emergency (such a natural disaster), the organization shall confirm that the products meet the required specifications by an evaluation, inspection, visit, etc. before use. Results of survey, evaluations, approvals, and follow-ups with suppliers shall be maintained.	·Compatibility with JFS-B standard Ver.3.0 standard ·Additional corrections to the notation ·Compatibility with GFSI GMaP
FSM 14	Traceability	The organization shall establish, implement and maintain appropriate tracing procedures covering all processes from supplier (at least one step before) to recipient (at least one step after) to ensure product identification. Documented procedures shall be verified at least once a year by trace testing to ensure that they are working effectively, and the verification results shall also be recorded.	FSM 14.1	Traceability	The organization shall establish, implement, and maintain appropriate tracing procedures covering all processes from supplier (at least one step before) to recipient (at least one step after) to ensure product identification. These procedures must include procedures (e.g., labeling) to continuously identify the product throughout the manufacturing process and throughout distribution. To ensure traceability, at least the following shall be recorded: ●Record of all externally procured raw materials (including containers and packaging materials), products, or services ●Records to identify batches, semi-finished products, work-in-progress, recycled products, reworked products, finished products and packaging throughout the manufacturing process ●Records of all product suppliers and recipients ●If the procedure has been updated, record it	·Compatibility with JFS-B standard Ver.3.0 standard ·Compatibility with GFSI GMaP
			FSM 14.2	Traceability verification	The organization shall verify the documented procedures for implementing and maintaining traceability through traceability test at least once a year to ensure that they are functioning effectively. The results of verification shall also be recorded.	·Compatibility with GFSI GMaP
FSM 16	Allergen Management	The organization shall develop and implement allergen management plans and maintain them appropriately. The plans shall include a risk assessment of allergen crosscontamination and control measures to be implemented to reduce or eliminate the risk of cross-contamination. In addition, the plans shall ensure that products that are shipped and sold are labeled according to the allergen labeling regulations in the country where they are to be sold.	FSM 16	Allergen Management	The organization shall document and implement allergen management plans and maintain them appropriately. The allergen management plans shall include: ●Control procedures to properly assess the risk of allergen cross-contact and, based on that assessment, reduce, or eliminate the risk of cross-contact. ●Procedures for handling raw materials (including containers and packaging materials), semi-finished products, work in progress, reworked products, and final products to prevent cross-contact with allergens during all processes from manufacturing to shipping. ●Cleaning procedures and verification procedures for areas that come into contact with food ●Procedures for identifying and displaying allergens that shall be controlled in all processes from manufacturing to shipping The plan shall also ensure that all products containing or potentially containing allergens that are shipped and offered for sale are labeled in accordance with the laws and regulations of the country to which they are expected to be shipped, and appropriate customer requirements.	·Compatibility with JFS-B standard Ver.3.0 standard ·Compatibility with GFSI GMaP
FSM 17	Control of Measuring and Monitoring Devices	The organization shall identify measuring and monitoring devices that are parameters critical to ensure food safety. In addition, the specified equipment and devices shall be calibrated regularly. The calibration shall be traceable by the relevant national or international standards and methods.	FSM 17	Control of Measuring and Monitoring Devices	The organization shall identify measuring and monitoring devices that are parameters critical to ensure food safety. In addition, the specified equipment and devices shall be calibrated regularly. This calibration shall be performed in accordance with national or international standards concerned, or by a reasonably accepted traceable method. The organization shall take appropriate action when equipment and devices are found to be inaccurate, and these actions shall be recorded.	·Compatibility with JFS-B standard Ver.3.0 standard ·Compatibility with GFSI GMaP
FSM 19.1	Analysis and Testing	The organization shall establish, implement, and maintain procedures to ensure the analysis of raw materials, semi-finished products, finished products, manufacturing environments, etc. that affect food safety. The analysis and testing shall be conducted by a competent analysis institution or testing laboratory institution using appropriate sampling and analytical / testing methods. The testing that has a significant effect on food safety shall be conducted in accordance with the applicable requirements of ISO/IEC 17025.	FSM 19.1	Analysis and Testing	The organization shall establish, implement, and maintain procedures to ensure the analysis of raw materials, semi-finished products, finished products, manufacturing environments, etc. that affect food safety. The analysis and testing shall be conducted by a competent analysis institution or testing laboratory institution using appropriate sampling and analytical / testing methods. The testing that has a significant effect on food safety shall be conducted in accordance with the applicable requirements of ISO/IEC 17025. In addition, the organization shall establish and implement analysis and testing procedures (methods, standards, etc.) to confirm that the product meets product specifications within its shelf life.	·Compatibility with GFSI GMaP
FSM 21	Complaint Handling	The organization shall establish, implement, and maintain complaint handling and complaint data management procedures. Control procedures shall include analyzing complaints, evaluating the magnitude of the impact threatening food safety, and implementing corrective action as necessary.	FSM 21	Complaint Handling	The organization shall document, implement, and maintain a system of management to respond to complaints and utilize complaint data to identify, correct, and manage omissions and deficiencies in food safety efforts. Control procedures shall include analyzing complaints, evaluating the magnitude of the impact threatening food safety, and implementing corrective action as necessary. Additionally, organization must record and maintain complaints, investigation results, and corrective actions.	·Compatibility with JFS-B standard Ver.3.0 standard ·Compatibility with GFSI GMaP
FSM 22	Serious Incident Management	The organization shall establish, implement and maintain an effective management procedure of serious incidents. The incident management procedure shall cover planning for product withdrawal and product recall as required, and be regularly tested for all products it supplies. The effectiveness of the incident management procedure shall be verified at least once a year, and the results shall be recorded.	FSM 22.1	Serious Incident Management	The organization shall document serious food incident management procedure, implement it in the event of an incident, and maintain it in effect at all times to ensure that they can respond in the event of a serious incident. This procedure shall also describe the methods for product withdrawal and product recall and include tests to ensure that product recalls are carried out reliably. It shall also include systems and procedures for providing necessary information to customers, consumers, and relevant authorities. Incidents that occur shall be recorded and evaluated.	·Compatibility with JFS-B standard Ver.3.0 standard ·Compatibility with GFSI GMaP

			FSM 22.2	Verification of food incident management procedure	The organization shall verify the effectiveness of its food incident management procedure by conducting tests at least annually on products supplied by the organization to ensure that product recalls are implemented, and maintain records of the verifications.	•Compatibility with GFSI GMaP
			FSM 23.1	Management of product specifications	The organization shall document and maintain specifications for raw materials (including packaging materials), semi-finished products, work in progress, remanufactured products, reworked products, and finished products. The organization shall have a system for communicating changes to product specifications both internally and externally. The organization shall designate a person responsible for managing product specifications.	•Compatibility with GFSI GMaP
FSM 23	Product Release	The organization shall establish and implement appropriate procedures for product release.	FSM 23.2	Product Release	The organization shall document, implement and maintain appropriate procedures for product release (shipping). Product release procedures shall include steps to ensure that the final product meets specifications.	•Compatibility with JFS-B standard Ver.3.0 standard •Compatibility with GFSI GMaP
FSM 24	Identification of nonconformities and control of nonconforming products	The organization shall establish, implement and maintain effective procedures to identify nonconformities that have an effect on food safety and to clearly identify, control, discard and rework nonconforming products resulting from nonconformities in order to prevent misuse and mis-shipment.	FSM 24	Identification of nonconformities and control of nonconforming products	The organization shall document, implement, and maintain effective procedures for raw materials (including containers and packaging materials), semi-finished products, work in progress, recycled products, reworked products, and final products to identify nonconformities affecting its food safety and to clearly identify, control, dispose of, and rework nonconforming products resulting from such nonconformities in order to prevent misuse and mis-shipment of nonconforming products affecting food safety. The organization shall also determine who will be responsible for managing nonconforming products.	•Additional corrections to the notation •Compatibility with GFSI GMaP
FSM 25	Corrective Action	The organization shall establish procedures for the determination and implementation of corrective actions in the event of any nonconformities arising relating to food safety. In case of deviation or violation, the organization shall identify the root cause, take measures to prevent recurrence, and review the effectiveness for the series of corrective actions.	FSM 25	Corrective Action	The organization shall define, implement, and maintain the document of procedures for the determination and implementation of corrective actions in the event of any nonconformities arising relating to food safety. In case of deviation or violation, the organization shall identify the root cause, take measures to prevent recurrence, and review the effectiveness for the series of corrective actions.	•Compatibility with JFS-B standard Ver.3.0 standard
			FSM 26	Change management	The organization shall document, implement, and maintain procedures to evaluate the impact to the necessary extent in advance when changes occur in all processes and operations (including equipment and devices) that affect the safety of the final product. The organization shall also determine who will be responsible for change management.	•Addition of new requirements •Compatibility with GFSI Benchmark Requirements Part III JII Subsector
FSM 26	Utilization of Kaizen suggestions from personnel	The organization shall establish and implement a system to properly utilize food safety Kaizen suggestions from personnel.	FSM 27	Utilization of Kaizen suggestions from personnel	The organization shall establish and implement a system to properly utilize food safety Kaizen suggestions from personnel.	•Change item number

HACCP			HACCP			
HACCP Step 1	HACCP Team Assembly	A HACCP team shall be assembled with competent staff.	HACCP Step 1	HACCP team assembly and identification of the scope of application	HACCP team shall be assembled with competent staff, and the scope of application of the HACCP system and applicable GMPs shall be identified. The scope shall be documented what products and processes are covered by which HACCP plan.	•Added "Identification of HACCP system application scope" (quoted from CODEX GPFH2020)
HACCP Step 3	Identification of Intended Use	Intended use of the product and target consumers shall be clearly described in a written document.	HACCP Step 3	Identification of Intended Use	Intended use of the product and target users (consumers) shall be clearly described in a written document.	•Corrections to the notation
HACCP Step 6 (Principle 1)	Hazard Analysis	The HACCP team shall list all of the hazards that are reasonably likely to occur in each process steps, conduct an analysis, and identify any necessary measures to control them. Hazards shall include allergens where required.	HACCP Step 6 (Principle 1)	Hazard Analysis	The HACCP team shall list all the hazards that are reasonably likely to occur in each process steps. Potential hazards in each process shall be identified, the critical hazards shall be identified, and all measures to control them must be considered. Hazards shall include allergens, if necessary.	•Compatibility with JFS-B standard Ver.3.0 standard
HACCP Step 8 (Principle 3)	Establishment of Critical Limits	Critical limit(s) shall be stipulated for each CCP.	HACCP Step 8 (Principle 3)	Critical Limits	Validated critical limit(s) shall be stipulated for each CCP.	•Compatibility with JFS-B standard Ver.3.0 standard
HACCP Step 11 (Principle 6)	Verification	Verification procedures shall be established to confirm whether the defined handling (HACCP Plans) is carried out as specified and to judge whether it is necessary to modify the defined handling. Verification shall be carried out considering the design of equipment, change in processing method and technology development in the manufacturing process.	HACCP Step 11 (Principle 6)	Establish HACCP plan validation and verification procedures	HACCP plan shall be validated prior to implementation. Verification procedures shall be established to confirm whether the defined handling (HACCP Plans) is carried out as specified and to judge whether it is necessary to modify the defined handling. Verification shall be carried out considering the design of equipment, change in processing method and technology development in the manufacturing process.	•Compatibility with JFS-B standard Ver.3.0 standard

GMP			GMP			
GMP 2	Factory premise environment	The organization shall establish and maintain appropriate standards for the grounds of their workplaces to prevent pollution and produce safe products.	GMP 2	Factory premise environment	The organization shall establish and maintain appropriate standards for the area around and on the premises of the business so that contamination can be prevented, and safe products can be made accordingly. These Standards shall include the management of waste and unnecessary materials on the premises.	•Compatibility with JFS-B standard Ver.3.0 standard •Additional corrections to the notation •Compatibility with GFSI GMaP
GMP 3	Design, construction, layout of business site and work and product flow lines	The organization shall design, construct and maintain the factory buildings and facilities (storage area, raw material and product handling area, preparation area, packaging and storage area, etc.) of the business site both outside and inside the plant to minimize food safety risks. In addition, the equipment layout and the flow lines of people, goods, and work shall be designed to meet the intended purpose and minimize food safety risks.	GMP 3	Design, construction, layout of business site and work and product flow lines	The organization shall design, construct and maintain the factory buildings and facilities (storage area, raw material and product handling area, preparation area, packaging and storage area, etc.) of the business site both outside and inside the plant to minimize food safety risks. In addition, the equipment layout (including drainage system and lighting) and the flow lines of people, goods, and work shall be designed to meet the intended purpose and minimize food safety risks. The organization shall set the lighting necessary for food safety to an appropriate level of illuminance. Additionally, the organization shall ensure that facilities and equipment that come into contact with food are constructed and made of materials that allow for appropriate maintenance, cleaning, and disinfection.	•Compatibility with GFSI GMaP
GMP 4	Physical, chemical and biological product contamination risks and isolation	The organization shall clarify that all hazard factors (physical, chemical (including allergens), and biological) for each process have been identified based on consistency checks between the process flow created by the HACCP team and the site. The frequency of occurrence and the magnitude of the consequences of the identified hazards shall be evaluated and appropriate control measures shall be set for each. Procedures shall be established and documented to control identified hazards other than critical control points (CCPs) that are difficult to manage effectively with a general hygiene control program to prevent contamination of raw materials (including packaging materials), semi-finished products, work-in-process, rework and finished products, and crosscontamination. The organization shall regularly review these procedures and keep them in effect.	GMP 4.1	Cross-contamination (including allergen cross-contact) and isolation	The organization shall prevent physical, chemical (including allergens), biological contamination, and cross-contamination (including allergen cross-contact) of raw materials (including containers and packaging materials), semi-finished products, work in progress, reworked products, and finished products. The necessary control measures, including isolation, shall be established to cover all aspects of food safety, and these procedures shall be documented and maintained effectively through periodic review.	•The existing GMP 4 was divided into GMP 4.1 and GMP 4.2 and the structure was reviewed (with the aim of clarifying the requirements of GMP 4). •Additional corrections to the notation

			GMP 4.2	Control of hazards that require enhancement	The organization must establish control measures for hazards that require particularly enhanced controls, other than CCPs, document those procedures as necessary, and maintain them effectively through periodic review.	<ul style="list-style-type: none"> The existing GMP 4 was divided into GMP 4.1 and GMP 4.2 and the structure was reviewed (with the aim of clarifying the requirements of GMP 4). Compatibility with JFS-B standard Ver.3.0 standard Additional corrections to the notation
GMP 5	Personnel Facilities	Personnel facilities, including washbasins and toilets, and applicable shared facilities shall be provided, designed, and utilized to minimize food safety risks.	GMP 5	Personnel Facilities	The organization shall design, install, and manage personnel facilities, including changing rooms, washbasins and toilets, and applicable shared facilities to minimize food safety hazards including allergens. The organization shall separate toilets and areas where food and drinks are stored and consumed such as cafeterias, and break rooms, from areas where food is manufactured, packaged, and stored.	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard Additional corrections to the notation Compatibility with GFSI GMAP
GMP 6.1	Personal hygiene criteria for personnel	The organization shall develop, implement and maintain hygiene criteria that evaluate and document product-specific risks to minimize food safety risks. The criteria shall include provisions of hand washing and toilet facilities, ways and frequency of hand washing, medical screening procedure to identify conditions impacting food safety, proper protective clothing, rules on the clothing and shoes, rules on accessing production area, ways of food handling, and control measures for foreign materials. These hygiene criteria shall also be understandable by personnel in different languages.	GMP 6.1	Personal hygiene criteria for personnel	The organization shall establish, implement, and maintain appropriate hygiene standards that be assessed and documented product-specific hazards to minimize food safety hazards, for its employees in accordance with the laws and regulations of the countries in which they work. The criteria shall include provisions of hand washing and toilet facilities, ways and frequency of hand washing, medical screening procedure to identify conditions impacting food safety, proper protective clothing, rules on the clothing and shoes, rules on accessing production area, ways of food handling, and control measures for foreign materials, and management procedures and reporting system in the event of an infected person that poses food safety risks. These hygiene criteria shall also be understood by personnel who use different languages.	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard Compatibility with GFSI GMAP
GMP 6.3	Health management of personnel	The organization shall develop, implement and maintain health care procedures that evaluate and document product-specific risks to minimize food safety risks. These shall include procedures for personnel suspected of illness to promptly report illness or symptoms to their superiors according to the laws and regulations of the country in which personnel are working.	GMP 6.3	Health management of personnel	The organization shall develop, implement and maintain health care procedures that evaluate and document product-specific risks to minimize food safety risks. These shall include procedures for personnel suspected of illness to promptly report illness or symptoms to their superiors according to the laws and regulations of the country in which personnel are working. The organization shall also determine who will be responsible for managing personnel with health conditions.	<ul style="list-style-type: none"> Compatibility with GFSI GMAP
GMP 6.4	Application to non-business personnel and visitors	The organization shall ensure that GMP 6.1, 6.2, and 6.3 are well known to personnel who have an impact on food safety, and apply them to contractors and visitors without exception.	GMP 6.4	Application to subcontractors and visitors	The organization shall ensure that GMP 6.1, 6.2, and 6.3 are well known to personnel who have an impact on food safety, and apply them to subcontractors and visitors without exception.	<ul style="list-style-type: none"> Additional corrections to the notation
GMP 7	Training	All personnel shall be trained in their appropriate language on food safety (including management, culture, HACCP, GMP), and there shall be a system for each personnel to deepen their understanding, implement, and maintain food safety in their respective work. In addition, there shall be a system to improve comprehension by repeating the training as necessary after evaluating competence.	GMP 7	Training	The organization shall ensure that all personnel, including new personnel, be trained in their appropriate language on food safety (including management, culture, HACCP, GMP), and be a system for each personnel to deepen their understanding, implement, and maintain food safety in their respective work. The organization shall keep records of the implementation of education and training. Additionally, the system for retraining as necessary shall be documented and implemented. This education and training shall enable employees to recognize their role in food safety and the significance of their efforts. In addition, there shall be a system to improve comprehension by repeating the training as necessary after evaluating competence.	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard Additional corrections to the notation Compatibility with GFSI GMAP
GMP 8	Housekeeping, cleaning, sterilization and disinfection	The organization shall identify product-specific risks based on a hazard analysis and establish, implement and maintain documented organization, cleaning, sterilization and disinfection procedures. In addition, the organization shall also verify that procedures that can minimize product-specific risks are working effectively. Cleaning tools, cleaning agents and disinfectants shall be suitable for their intended use and stored appropriately. Food safety information on potentially harmful chemicals shall be obtained and confirmed.	GMP 8	Housekeeping, cleaning, sterilization and disinfection	The organization shall identify product-specific risks based on a hazard analysis throughout all processes and stages and establish, implement, and maintain documented organization, cleaning, sterilization, and disinfection procedures. In these procedures, the organization shall include steps to verify that product-specific risks have been minimized. Cleaning tools, cleaning agents and disinfectants shall be suitable for their intended purpose, clearly identified and stored in areas separated from areas where food is manufactured, packaged, and stored. Food safety information on potentially harmful chemicals shall be obtained and confirmed.	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard Compatibility with GFSI GMAP
GMP 11	Air and water management	The organization shall define the required quality criteria according to the application, and regularly monitor and record the air, high-pressure gas, and water (including ice and steam) used in food production in order to minimize the effect on food safety. If water not intended for use in food production and water that has been used and is still acceptable in contact with food is applied to food production, it shall be controlled to prevent it from being contaminated with water for food production.	GMP 11	Air and water management	The organization shall establish application-specific standards and regular monitoring procedures for air, high-pressure gas, and water (including ice and steam) used in food production to minimize impacts on food safety, and the records shall be kept. If water not intended for use in food production and water that has been used and is still acceptable in contact with food is applied to food production, it shall be controlled to prevent it from being contaminated with water for food production.	<ul style="list-style-type: none"> Compatibility with GFSI GMAP
GMP 12	Waste Management	The organization shall establish adequate systems for segregation, collection and disposal of waste (including waste water). The flow lines of waste shall be established so as not to cause cross-contamination of food. Locations and containers for placing waste shall be controlled to prevent attraction of pests or growth of harmful organisms/micro-organisms.	GMP 12	Waste Management	The organization shall establish adequate systems for segregation, collection and disposal of waste (including wastewater). The flow lines of waste shall be established so as not to cause cross-contamination of food. Locations and containers for placing waste shall be controlled to prevent attraction of pests or growth of harmful organisms/micro-organisms. Containers for storing waste materials (including by-products not suitable for food use) shall be clearly distinguished from other containers.	<ul style="list-style-type: none"> Compatibility with GFSI GMAP
GMP 13	Pest control	The organization shall establish, implement and maintain procedures to control or remove food safety risks caused by pests (pests and vermin) on the premises and in the facilities. These procedures shall be implemented using the following cycle. <ol style="list-style-type: none"> Understanding of the pest outbreak situation and formulation of monitoring plans. Implementation of pest control and invasion prevention. Pest monitoring and dissemination of results to personnel. The organization shall establish procedures for eliminating pests and vermin as necessary.	GMP 13	Pest control	The organization shall establish, implement and maintain procedures to control or remove food safety risks caused by pests (pests and vermin) on the premises and in the facilities. These procedures shall be implemented using the following cycle. <ol style="list-style-type: none"> Understanding of the pest outbreak situation and formulation of monitoring plans. Implementation of pest control and invasion prevention. Pest monitoring and dissemination of results to personnel. The organization shall establish procedures for eliminating pests and vermin as necessary. If chemicals are used, handling procedures shall be established to ensure that food is not affected. Pest control shall be carried out by persons with the necessary competence.	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard Compatibility with GFSI GMAP
GMP 15	Transport	The organization shall establish a system to ensure that containers and vehicles, including contracted vehicles, used for the transportation of raw materials and ingredients (including packaging materials), partially processed products, works in progress, reworks, and finished products (including packed fresh products in final packaging) are suitable for the intended use, maintained in good repair and clean.	GMP 15	Transport	The organization shall establish a system to ensure that containers and transportation vehicles, including contracted vehicles, used for the transportation of raw materials and ingredients (including packaging materials), partially processed products, works in progress, recycled products, reworks, and finished products (including packed fresh products in final packaging) are suitable for the intended use, maintained in good repair and clean, protected from contamination, and transported within its intended temperature range.	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard

GMP 17	Stock Management	The organization shall establish, implement and maintain a system to use raw materials and ingredients (including packaging materials), partially processed products, work in progress, reworks, and finished products in a designated order and within the defined expiry period, and shall store these materials under the proper conditions to avoid contamination and deterioration.	GMP 17	Stock Management	The organization shall establish, implement and maintain a system to use raw materials and ingredients (including packaging materials), partially processed products, work in progress, recycled products, reworks, and finished products in a designated order and within the defined expiry period, and shall store these materials under the proper conditions to avoid contamination and deterioration. Storage facilities and equipment shall be designed to allow food to be stored under appropriate storage conditions.	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard Compatibility with GFSI GMAp
GMP 18	Devices and Tools	Devices and tools shall be suitably designed and selected for the intended uses and shall be used, maintained and stored so as to minimize food safety risks.	GMP 18	Equipment and Tools	The organization shall suitably design and select equipment and tools for the intended uses and shall use, maintain, and store so as to minimize food safety hazards.	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard Correction of notation
GMP 19	Maintenance	A system of planned maintenance covering all items of equipment which are critical to product safety shall be established. Maintenance activities shall not represent food safety risks.	GMP 19	Maintenance	The organization shall document and implement a system for systematic maintenance of all facility and equipment critical to product safety. Maintenance activities shall be performed in such a way that they do not pose a food safety risk. This system shall include procedures (such as cleaning, washing, and sterilization procedures) for returning the food production facility to a state capable of producing food after maintenance activities. Maintenance activities shall not represent food safety hazards. All materials used for maintenance shall be suitable for the intended purpose.	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard Compatibility with GFSI GMAp

Annex 1
● List of documented information explicitly required by the standard (see FSM 5)

					<ul style="list-style-type: none"> FSM 1: Records that top management has made employees aware of the defined organizational structure (at least the duties, responsibilities, instruction/reporting system, and information sharing for employees in charge of activities that affect food safety). FSM 3: Management review by top management. FSM 4: Records of implementation of food legal compliance procedures. FSM 5: Elements of the food safety management system that are deemed necessary by the organization. FSM 6: Food Safety Policy and Goals. FSM 7: <ul style="list-style-type: none"> Assessment procedures for prioritizing responses to threats to food defense. Food Defense Plan. FSM 8: <ul style="list-style-type: none"> Evaluation procedures for assigning predominance to food deception reduction measures. Food Deception Prevention Plan. FSM 9.1: <ul style="list-style-type: none"> Information documentation procedure. Records required to prove the implementation of food safety management. FSM 10: Specifications of what is being purchased or supplied. FSM 13.2: Supplier evaluation/approval/monitoring records. FSM 13.3: Documents related to the management of outsourced processes. FSM 14.1: <ul style="list-style-type: none"> Documented procedures for implementing and maintaining product tracing. The following records are required to ensure traceability: <ul style="list-style-type: none"> Identification of all externally procured raw materials (including containers and packaging materials), products, or services. Records to identify batches, semi-finished products, work in progress, refurbished products, reworked products, finished products and packaging throughout the manufacturing process. Record of purchasers and shipping destinations for all products supplied. If the procedure has been updated, record it. FSM 14.2: Trace test verification results. FSM 16: Allergen management plan. FSM 17: Records of actions taken if equipment or devices is found to be inaccurate. FSM 21: Management mechanism for handling complaints and utilizing complaint data. FSM 22.1: <ul style="list-style-type: none"> Food incident management procedure. Record of incidents that have occurred. FSM 22.2: Product recall test verification results. FSM 23.1: Specifications of products (raw materials (including containers and packaging materials), semi-finished products, work in progress, recycled products, reworked products, and final products). FSM 23.2: Product release (shipping) procedures. FSM 24: Procedures for identifying nonconformities that impact food safety and for clearly identifying, managing, disposing of, and reworking resulting nonconforming products. FSM 25: Procedures for determining and implementing corrective actions when nonconformities impacting food safety occur. FSM 26: Procedures to assess, to the extent necessary, the impact of changes that may impact food safety in advance. HACCP Step 12: Documents and records required for HACCP plan (Step 12 requires documentation of all documents and records required for the HACCP plan.) (Principle 7) GMP 4.1: Necessary control measures/methodological procedures, including isolation, aimed at preventing contamination and cross-contamination (including cross-contact). GMP 4.2: Procedures for control measures/methods for hazards that require enhanced control (as appropriate). GMP 6.1: Personal hygiene standards for employees, etc. GMP 6.3: Health management procedures for employees, etc. GMP 6.4: Documents related to GMP 6.1 and GMP 6.3 applied to contracted businesses and visitors. GMP 7: <ul style="list-style-type: none"> Record of education/training implementation. System for re-education (if necessary). GMP 8: Documented procedures for organizing, cleaning, and sanitizing/disinfecting. GMP 9: Records of product rework. GMP 10: Business site patrol/inspection results. GMP 11: Monitoring records of air, high pressure gas, and water (including ice and steam) used in food production. GMP 19: Systems for systematically maintaining all equipment and devices important to product safety. 	<ul style="list-style-type: none"> Addition of list of documented information explicitly required by the standard (see FSM 5)
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Annex			Annex 2			
Definition of terms			Definition of terms			
			1	Allergen cross-contact	The unintentional incorporation of an allergenic food, or ingredient, into another food that is not intended to contain that allergenic food or ingredient. (Cited from Codex General Principles of Food Hygiene 2020: (Reference) Japan Food Hygiene Association 2021 Translation First Edition)	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard (Some notation corrections)
5	hazard	A biological, chemical or physical material in, or condition of, food with the potential to cause an adverse health effect. (Cited from the definition in the Codex General Principles of food hygiene)	5	Hazard	A biological, chemical, or physical agent in food with the potential to cause an adverse health effect. (Cited from Codex General Principles of Food Hygiene 2020: (Reference) Japan Food Hygiene Association 2021 Translation First Edition)	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard (Some notation corrections)
6	critical limit	Criterion which separates acceptability from unacceptability. (Cited from Codex Alimentarius Commission CAC/RCP 1-1969 Annex: Hazard analysis and critical control point (HACCP) system and guideline for its application)	6	Critical limit	A criterion, observable or measurable, relating to a control measure at a CCP which separates acceptability from unacceptability of the food. (Cited from Codex General Principles of Food Hygiene 2020: (Reference) Japan Food Hygiene Association 2021 Translation First Edition)	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard (Some notation corrections)
8	verification	Confirmation, through the provision of objective evidence, that specified requirements have been fulfilled. Note 1 to entry: The objective evidence needed for a verification can be the result of an inspection or of other forms of determination such as performing alternative calculations or reviewing documents. Note 2 to entry: The activities carried out for verification are sometimes called a qualification process. Note 3 to entry: The word "verified" is used to designate the corresponding status. (Cited from the definition in ISO 9000:2015)	8	Verification	The application of methods, procedures, tests, and other evaluations, in addition to monitoring, to determine whether a control measure is or has been operating as intended. (Cited from Codex General Principles of Food Hygiene 2020: (Reference) Japan Food Hygiene Association 2021 Translation First Edition)	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard (Some notation corrections)
			9	Cross-contamination	When people or objects (raw materials, packaging materials, semi-finished products, finished products, carts, etc.) are moved between different sanitary areas, they can bring in bacteria or other contaminants that can contaminate food.	<ul style="list-style-type: none"> Postscript
11	CCP (critical control point)	Controls can be applied and are essential steps to prevent or eliminate food safety hazards, or bring food safety hazards to acceptable levels. (Cited from Codex Alimentarius Commission CAC/RCP 1-1969 Annex: Hazard analysis and critical control point (HACCP) system and guideline for its application)	12	CCP (Critical control point)	A step at which a control measure or control measures, essential to control a significant hazard, is/are applied in a HACCP system. (Cited from Codex General Principles of Food Hygiene 2020: (Reference) Japan Food Hygiene Association 2021 Translation First Edition)	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard (Some notation corrections)
13	correction	Action to eliminate a detected nonconformity. Note 1 to entry: A correction can be made in advance of, in conjunction with or after a corrective action. Note 2: As terms with the same notation but different meanings in this Standard Document: Modification, which is the act of revising documents, records, and items to be stated, and Rework, which is the act of remedying a product in process. (Refer to the definition in ISO 9000:2015)	14	Correction	Action to eliminate a detected nonconformity. (Cited from the definition of ISO 22000:2018 3.9) Note 1: Corrections may occur prior to, in conjunction with, or after corrective action. Note 2: Modifications include, for example, rework and rerating.	<ul style="list-style-type: none"> Compatibility with JFS-B standard Ver.3.0 standard

			16	Disinfection	Reduction by means of biological or chemical agents and/or physical methods in the number of viable microorganisms on surfaces, in water or in air to a level that does not compromise food safety and/or suitability. (Cited from Codex Alimentarius Commission CXC 1-1969 (Revised in 2022.) GENERAL PRINCIPLES OF FOOD HYGIENE)	•Postscript
15	food	All substances that are processed, semi-processed or unprocessed with the intention of human consumption. Note to entry: Food includes all substances used for manufacturing, preparation and processing of beverages, chewing gums and foods. However, it does not include substances used solely for cosmetics, cigarettes and drugs.	17	Food	Substance (ingredient), whether processed, semi processed or raw, which is intended for consumption, and includes drink, chewing gum and any substance which has been used in the manufacture, preparation or treatment of "food" but does not include cosmetics or tobacco or substances (ingredients) used only as drugs. (Cited from the definition of ISO 22000:2018 3.18)	•Compatibility with JFS-B standard Ver.3.0 standard
			21	Food fraud	A collective term encompassing the deliberate and intentional substitution, addition, tampering or misrepresentation of food, food ingredients, feed, food packaging or labelling, product information or false or misleading statements made about a product for economic gain that could impact consumer health. (GFSI BENCHMARKING REQUIREMENTS VERSION 2020.1 / PART IV GLOSSARY OF TERMS)	•Postscript
			22	Food fraud mitigation plan	The process of defining requirements regarding when, where, and how to mitigate deceptive practices identified by the food mitigation vulnerability assessment. The plan developed defines the measures and checks necessary to effectively mitigate the identified hazards.	•Postscript
			23	Food incident management procedure	A procedure for appropriate response and management in the event of food safety problems to prevent it from escalating.	•Postscript
			27	Sector, Sub-sector	Scope of certification.	•Compatibility with JFS-B standard Ver.3.0 standard
22	corrective action	Action to eliminate the cause of a nonconformity and to prevent recurrence. Note to entry: There can be more than one cause for a nonconformity. (Cited from the definition in ISO 9000:2015)	28	Corrective action	Any action taken when a deviation occurs in order to re-establish control, segregate and determine the disposition of the affected product, if any, and prevent or minimize reoccurrence of the deviation. (Cited from Codex General Principles of Food Hygiene 2020: (Reference) Japan Food Hygiene Association 2021 Translation First Edition)	•Compatibility with JFS-B standard Ver.3.0 standard (Some notation corrections)
24	rework	Indicates the action to be taken when returning to the manufacturing flow a product that complies with the requirements for products that have deviated from the regular series of processes, including final products, semi-finished products, work-in-process, and raw materials in all processes. Rework includes the action of returning a product from a series of processes to an upstream process for reworking, and the action of returning a product to a process again without processing.	30	Rework	[When indicating an act]. Indicates the action to be taken when returning to the manufacturing flow a product that complies with the requirements for products that have deviated from the regular series of processes, including final products, semi-finished products, work-in-process, and raw materials in all processes. Rework includes the action of returning a product from a series of processes to an upstream process for reworking, and the action of returning a product to a process again without processing. [When indicating an item]. Indicates clean, unadulterated food that has been removed from processing at any point up to and including final packaging for reasons other than insanitary conditions or that has been successfully reconditioned by reprocessing and that is suitable for use as food or a food component. (Adapted from Codex Alimentarius Commission CXC 80-2020 (Adopted in 2020) CODE OF PRACTICE ON FOOD ALLERGEN MANAGEMENT FOR FOOD BUSINESS OPERATORS)	•Postscript •Additional corrections to the notation
25	top management	Person or group of people who directs and controls an organization at the highest level. Note 1 to entry: Top management has the power to delegate authority and provide resources within the organization. Note 2 to entry: If the scope of the management system covers only part of an organization, then top management refers to those who direct and control that part of the organization. (Cited from the definition in ISO 9000:2015. Note 3 to entry is not included in the definition of "top management" in this document.)	31	Top management	Person or group of people who directs and controls an organization at the highest level. Note 1 to entry: Top management has the power to delegate authority and provide resources within the organization. Note 2 to entry: If the scope of the management system covers only part of an organization, then top management refers to those who direct and control that part of the organization. (Cited from the definition of ISO 22000:2018 3.41)	•Compatibility with JFS-B standard Ver.3.0 standard
			32	HACCP plan	Documentation or set of documents, prepared in accordance with the principles of HACCP, to ensure control of significant hazards in the food business. (Cited from Codex General Principles of Food Hygiene 2020: (Reference) Japan Food Hygiene Association 2021 Translation First Edition)	•Compatibility with JFS-B standard Ver.3.0 standard (Some notation corrections)
27	flow diagram	Diagrams constructed to show all the process steps for specified product.	34	Flow diagram	A systematic representation of the sequence of steps used in the production or manufacture of food. (Cited from Codex General Principles of Food Hygiene 2020: (Reference) Japan Food Hygiene Association 2021 Translation First Edition)	•Compatibility with JFS-B standard Ver.3.0 standard (Some notation corrections)
28	document	Information and the medium on which it is contained. Example: Record, specification, procedure document, drawing, report, Standard Document Note to entry: The medium can be paper, magnetic, electronic or optical computer disc, photographic or master sample, or combination thereof. (Cited from the definition in ISO 9000:2015. Notes 2 and 3 to entry are not included in the definition of "document" in this document.)	35	Document	Information and the medium on which it is contained. Example: Record, specification, procedure document, drawing, report, Standard Document Note to entry: The medium can be paper, magnetic, electronic or optical computer disc, photographic or master sample, or combination thereof. (Cited from the definition of ISO 22000:2018 3.13)	•Compatibility with JFS-B standard Ver.3.0 standard
29	nonconformities	Non-fulfilment of a requirement. (Cited from the definition in ISO 9000:2015)	36	Nonconformities	Non-fulfilment of a requirement. (Cited from the definition of ISO 22000:2018 3.28)	•Compatibility with JFS-B standard Ver.3.0 standard
31	management system	Set of interrelated or interacting elements of an organization to establish policies and objectives, and processes to achieve these objectives. (Cited from the definition in ISO 9000:2015)	38	Management system	Set of interrelated or interacting elements of an organization to establish policies and objectives, and processes to achieve these objectives. (Cited from the definition of ISO 22000:2018 3.25)	•Compatibility with JFS-B standard Ver.3.0 standard