



KINGDOM OF BAHRAIN

Ministry of Health

Food Safety Guidelines

FOOD CONTROL SECTION
PUBLIC HEALTH DIRECTORATE

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Subject	Page no
Introduction	4
Section1 - Objectives	4
Section2 - Scope	5
Section3 - Definitions	5
Section4 - Registration and Licensing	8
Section5 - Facilities Design and Facilities	9
Section6 - Operating Control	18
Section7 - Facilities: Maintenance and health conditions	24
Section8 - Facilities: Personal Hygiene	28
Section9 - Transport	30
Section10 - Product Information and Consumer Awareness	33
Section 11- Training	35

Introduction:

Due to the importance of health systems in determining food safety, manufacturers (food facilities), structural, operational and sanitary requirements of facilities, licensing procedures, approval of facilities, storage and transportation requirements of food items, a significant role in determining food safety, the Food Control Section is keen to issue this guide to food establishments for food control. This guide contains many requirements that are a general basis for food production in appropriate and proper conditions, but the approved legislation relating to food safety and safety shall not be ignored. Food establishments must apply the health practices outlined in this guide to:

- Ensuring food safety.
- Provide clear information to the consumer by placing food labels that meet the approved requirements.
- Providing information to the consumer to ensure food safety such as:
- Storage method - preparation method... Etc.

Section 1 - Objectives:

- ❑ Achieving food safety and viability by providing establishments with basic principles of food safety that must be applied throughout all stages of production.
- ❑ Food manufacturing establishments must take full responsibility for food safety and safety.
- ❑ Food establishments are committed to an approach based on pollution risk analysis and critical control point, as a way to enhance food safety.

- Provide guidance for the implementation of specific rules that may be necessary for specific workshops of processing, manufacturing, or food commodities, in order to enhance safety requirements in these areas.

Section 2- Scope:

These requirements apply to local food establishments in the Kingdom of Bahrain and to foreign food establishments that wish to export their products to the Kingdom of Bahrain.

Section 3- Definitions

Establishment for food

Any establishment that handles food excluding home kitchens.

Hygiene

Removing dirt, food residues, dirt, greases and other unacceptable materials.

Contaminants:

Any biological, chemical, foreign or other substance that unintentionally added to food, which may harm food safety.

Pollution

Exposure of food or food environment's to contamination

Disinfection or Sanitization:

Reducing the number of microorganisms to safe limits using chemical or physical disinfectants without causing harm to food safety.

Food safety conditions:

All necessary requirements and procedures to ensure food safety and viability at all stages of production.

Hazards:

Any biological, chemical or physical substances found in food or in the circumstances, surrounding them, which may cause a harmful effect on health.

Risk analysis and critical control points:

A system for identifying, assessing and controlling important sources of risk for food safety.

Food handler:

Any person who deals directly or indirectly with packaged or unpackaged foods, food equipment's, tools, or food-in contact surfaces and is required to comply with food safety requirements.

Food safety:

Ensuring that food does not cause harm to consumer when prepared and/or consumed according to food use.

Safe food:

Ensuring that food is acceptable for human consumption

Raw food production:

Stages of raw food chain, for example, harvesting, slaughtering, milking, and fishing.

Packing:

The process of placing one or more foodstuffs encapsulated in another.

Packaging container:

The process of placing food in package or container so that there is a direct connection between that food and that package or container, provided that material is used consider suitable for contact with food.

Manufacturing food:

Any action that would substantially change the initial product, including heating, smoking, processing, drying or a combination of such processes.

Manufactured products

Raw foodstuffs resulting from processing or manufacturing a non-processed product, and those products may contain necessary ingredients to add certain properties to those products.

Primary products:

Products that are produced primarily and have no manufacturing process, including agricultural products, livestock breeding, land hunting and sea fishing.

Cross contamination:

Harmful microbes transmitted from food traders, raw foods, insects, pests or surfaces to food intended for direct consumption.

Safe food practices:

Requirements and measures necessary to control risks to ensure the safety of food for human consumption at all stages of the food chain, taking into account the expected use of food.

Environmental and health requirements:

Mandatory environmental and health regulations, controls or guidelines that must be introduced in food trading, in accordance with the conditions of procedures specified by the technical regulations.

Inspection:

Food inspection and control in circulation during the stages of the food chain to ensure that it complies with regular requirements for food safety.

Public health specialist:

The qualified person according to the nature of the task assigned to it in the work of food control safety.

Judicial officer

Is an employee who has the right to enter facilities and factories to ensure that there is no harm to the public health and has the right to inspect and withdraw samples and to verify the relevant certificates and documents. In order to control the violations and edit the records of the judicial control.

Section 4 - Registration and Licensing:

- Food establishment owner shall not operate or display its products in markets unless obtained licenses or approvals by Department of Public Health.
- Any person, whom engages in food activities without licensing, considered to be in violation and is subject to the penalties under the act of Public Health Law.
- Violation of the authorized activities is prohibited by the Department of Public Health (food control section), otherwise legal action will be taken against violators.

- No changes can be made to the previous approved sketch and plans of food establishment, nor the addition of new production lines or devices, without the formal approval by Food Control Section.
- The license for food premises is valid for one year from the date of issuance,
- Nevertheless, Food Control Section may suspend license at any time in the event of violations of approved food safety legislations.
- The license of the local establishment to must be display in an apparent location.
- The Ministry of Health determines the payable fees in regard of registration and licensing requirements of the local establishment.

Section 5 – Establishment’s Design and Facilities:

When constructing a food establishment, consideration must be taken to location, equipment, facilities, and plans designed to:

- Minimize pollution.
- Its design allows for proper maintenance, cleanliness and disinfection, and reducing air pollution.
- Surfaces and materials, particularly those that are in contact with food, must not be toxic and, if necessary, made of highly durable materials that are easy to maintain and clean.
- Available adequate facilities, as the case may be, for controlling temperature, humidity, and other similar measures.
- Have effective protection against insect entry and shelter.

5.1 Site

5.1.1. Constructed site of the facility

Must be established away from:

- Environmentally polluted areas and industrial activities that pose a serious threat to food contamination.
- Flood-prone areas unless adequate preventive measures are taken.
- Areas that cannot be cleared effectively from solid and liquid residues.
- Areas at risk of insect infection.

5.2 Buildings and rooms

5.2.1 Design

- facility design must allow easy movements of workers and food handling and transportation between work areas in a streamlined way to prevent food to cross-contamination.
- Easy maintenance and cleaning work and reducing air pollution.
- prevent insects and pests' entry.
- The interior design of food establishments should allow good practices of food safety, including the prevention of cross-contamination of food during and between operations.

5.2.2 Structures and interior equipment

Facilities must be built properly and with highly durable materials, so that they are easy to maintain, clean as well as disinfect, and the following specific conditions must be observed to protect food safety and viability:

- Floors and walls must be made of smooth, non-porous, water-resistant, fire-resistant, light-colored, non-toxic, non-cracked, and the ceilings should be easy to clean and fire resistant and not made of asbestos, and the floors should have a suitable tendency for running water for easy cleaning.
- Shop floors should be higher than the main road floors, and the height of roofs and concrete bridges should not be less than 2.7 meters from the floor level to the lowest height.
- Provide proper ventilation and lighting that suits activity (preparation, cooking, or storage).
- Provide means to prevent rodents and insects on doors, windows, and access, and conclude a contract to pest control.
- Doors must be of fire-resistant material and a self-contained shutter must be installed, especially outside doors. air-curtains or plastic curtains must be installed on sliding doors or automatic doors.
- The property must not be open directly to housing and is not allowed to be a shelter or used for housing directly or indirectly.
- Wood and paper materials are not allowed in the facility structure.
- The construction and finishing of ceilings and upper fittings should be in a way that reduces the fall and condensation of fumes and the accumulation of dirt.
- Direct food contact worksurfaces are made of good and durable materials, easy to clean, to maintain and to disinfect, soft, does not absorb liquids, does not affect food, and not affected by normal operating conditions like detergents and disinfectants.
- The stairs should be made of metal materials or reinforced cement with a washable and clean surface and its interior is solid and does not allow dirt and dust accumulation under the stairs, and

not be helical design in a narrow space. stairs must be strong, stable and to allow the user to carry materials and tools on the stairs without danger.

5.2.3 Temporary and mobile markets, vending machines and mobile food processing and vending vehicles

include market stalls, street mobile food processing and sales vehicles, and temporary markets such as festivals, where food is traded. These facilities should be located, designed, and constructed in consideration to:

- Avoid exposing food to contamination and insects (to a reasonable practical extent).

Therefore, in applying these special conditions and requirements, consider

the pollution risks associated with these facilities for adequate control to ensure food safety and viability.

5.3 Equipment

5.3.1 General considerations

- All materials, equipment and equipment must be in contact with food:
- Designed in a manner that is easy to clean and disinfect effectively, and adequate cleaning and disinfection must be repeated to avoid any contamination, except for non-reusable containers.
- Made of materials that help keep them in good condition and are usable to minimize pollution, except for non-reusable containers and containers.
- Bowls, plates, and nylon used in the packaging and delivery of food meet the requirements of GSO specifications and standards.

- Allow maintenance to take place.
- The order and distribution of equipment in work areas must be distributed over the workspace so that there is no overlap in the work.
- In cases where chemical additives are used to prevent corrosion of equipment and containers, they must be used with good practices.

5.3.2 Food control and equipment monitoring

In addition to the general conditions referred to in paragraph 5.3.1, equipment used in cooking, heating, cooling or freezing should be designed to achieve:

- To bring food to the required temperature as quick as possible.
- Effective maintenance of this equipment, considering food safety and shelf life.
- The design of this equipment allows temperature monitoring and control.
- If necessary, such equipment should have the means to monitor and control humidity, ventilation and other factors that may have a detrimental effect on food safety and viability. These conditions are intended to ensure that:
 - ❑ Harmful or unwanted microorganisms are disposed of, or the toxic substances they produce, or to reduce their risk level to a safe level, or to eliminate them and stop their growth.
 - ❑ Monitoring based on risk analysis and critical control point.

5.3.3 Waste collection containers and non-edible materials

Waste collection containers, by-products, non-edible or harmful containers should be:

- Properly manufactured
- Made from non-liquid-carrying materials.

In the case of containers used to store harmful substances, they should be:

- Marked.
- Sealable to prevent food contamination.

5.4 Utilities:

5-4-1 Water supply requirements

- Drinking water must be from a healthy and certified source.
- An adequate supply of drinking water with suitable facilities for storage, distribution, and temperature control, if necessary, must be available to ensure food safety.
- Non-potable water systems should be marked and not connected to drinking water systems to ensure the two networks water is not mixed.
- Drinking water must be as stipulated in the Gulf Standard for Drinking Water (for example, non-potable water (used for example in firefighting, steam production, refrigeration and other similar purposes that do not lead to food contamination) should have a separate distribution network.
- Water or ice in contact with food must be made from potable water or clean water when used to cool whole fish products, and ice must be manufactured, processed, and stored under requirements that maintain it from contamination.

5.4.2 Waste disposal systems

- Must provide adequate drainage and waste disposal systems and must be designed and built in a way to avoid the risk of food contamination or drinking water supplies.
- Sewages should be connected to the main sewer network or connected to a traditional drainage system in areas far from public sewage services.
- Installation of sewage pipes 3 cm from the wall.

5.4.3 Hygiene

- Adequate facilities must be provided to clean food, tools, and equipment, properly designed and such facilities must provide adequate supplies of drinking water and hot and cold water.
- The food-washing facilities should be separate from hand washing facilities

5.4.4 Personal hygiene facilities and toilets:

Personal hygiene facilities should be provided to ensure an appropriate degree of personal hygiene and avoid food contamination and should include:

- hand washed-in, hot and cold water or water temperature control.
- Toilets are properly designed from a health point of view and do not open directly to preparation, cooking, or storage areas, but away from them.
- Staff changing rooms.

These facilities must be suitable in terms of location, design and commensurate with the number of staff.

5.4.5 Temperature control

- Depending on the nature of food processes, adequate heating, cooling, and cooking facilities must be provided, food is stored in refrigerators, freezers. food temperatures are monitored and controlled to ensure food safety.
- Devices (electric or gas fuel) must be provided to store cooked food until they are delivered and served at a temperature of at least 63 °C.
- Provide a chilling and freezing refrigerator to store meat, chicken, and fish, installed with a temperature thermometer.
- Food items should be displayed and kept in a good environment suitable for the same food, dry foods must be kept in a room temperature and in a dry place, chilled food should be displayed between 4-7°C and stored frozen materials at temperatures of at least -18°C. The equipment must meet the requirements of GSO specifications and standards.

5.4.6 Air and ventilation quality

Should provide adequate means of natural or mechanical ventilation, especially for the following purposes:

- Reducing food contamination with air pollutants, such as spray substance and contaminants that condense into the air.
- Control the surrounding air temperature.
- Control the permeable odors that may affect the smell and taste of food.
- Control of humidity to ensure food safety.
- Ventilation systems should be designed and constructed in way to secure air passing from contaminated areas to clean areas. ventilation systems should be maintained and cleaned regularly.

5.4.7 Lighting

- Must provide adequate natural and industrial sources of light so that these facilities can be properly managed if necessary.
- The colors resulting from industrial lighting must not be misleading and must be sufficient for the nature of operation.

5.4.8 Storage

- Food items must be stored orderly, in an accessible manner and easy to read their food labels, without being stacked randomly, causing it to be damaged by weights.
- Adequate food storage facilities must be provided.
- Storage facilities should be designed and constructed in a way that helps to:
 - ❑ adequate maintenance and cleanliness.
 - ❑ Avoid ingress and pests sheltering.
 - ❑ Effectively protect food from contamination during storage.
 - ❑ Reduce food damage by controlling temperature and humidity.

Storage room requirements:

- Provide shelves and metal bases to lift dry food and refrigerators with Hight of 30 cm wide open sides to facilitate cleaning underneath or provide wheeled bases that make it easier to move to complete the cleaning and inspection process and to prevent the accumulation of dirt under neath these devices.

- Separate detergents and pesticides from foods to ensure that they are not contaminated even accidentally, keeping chemicals with scents away from food items and entirely separate warehouses should be provided.
- Apply a system for managing inventory and keeping food statements, entry dates and expiration dates.
- To keep appropriate distance between food items and walls to allow air to pass through and easy cleaning.
- Preventing food storing in corridors and stairs.

Section 6 - Operating Control

Objectives:

Production of safe food by reducing the risk of food contamination by taking the necessary preventive measures to ensure the safety and suitability of food at the operating stages by controlling contamination hazards.

6.1 Control the risk of food contamination

- Food plant operators must control contamination hazards by applying systems such as the Risk Analysis System and Critical Control Points (HACCP), which should:
 - ❑ Identify steps that are critical to food safety in their operations.
 - ❑ Implement effective control measures in those steps.
 - ❑ Monitoring control measures to ensure their continued effectiveness.
 - ❑ Review control measures from time to time, and when there is a change in operations.

- These systems should be applied to entire food chain rings to control food safety throughout their shelf life, following appropriate design and processing methods.
- Control measures can be simple, such as ensuring the safety of the periodic calibration equipment of the stock, or the proper distribution of food in refrigerated display units. In some cases, it may be appropriate to seek expert advice and to retain documents detailing this.
- The risk analysis system, critical control point and guidelines must include a food safety system model.

6.2 Key aspects of food safety control systems

6-2-1 Control time and temperature

Failure to adequately control food temperatures is one of the most common causes of food-borne diseases and food spoilage. These controls include cooking time and temperature, refrigeration, processing, and storage.

Systems must ensure effective temperature control, specifically if temperature is critical to food safety.

- Temperature control systems should consider:
 - ▣ Nature of food, such as water content activity, PH level, and the possible initial level of microorganisms and species in food.
 - ▣ The specified shelf life of the products.
 - ▣ Processing and packing methods.
 - ▣ Products using method, i.e. whether it will need to be cooked or processed, or is ready to eat.
- These systems should also determine the possible limits in change of time and temperature.
- Temperature recorders should be checked regularly and testing their accuracy.

6.2.2-Specific steps of operations

Other steps affecting food hygiene can include, for example:

- ❑ Cooling.
- ❑ Heating.
- ❑ Exposure to radiation.
- ❑ Drying.
- ❑ Chemical preservation.
- ❑ Packing in vacuum packs or adjusting the weather conditions for filling.

6.2.3 Microbiological and other properties

Systems outlined in paragraph 6.1 provide an effective way to ensure food safety. In using the microbiological, chemical, or physical specifications of any food control system, these specifications should be based on scientific principles and specifying the following:

- Monitoring measures.
- Methods of analysis.
- Procedure limits.

6.2.4 Microbiological cross contamination

Pathogens can be transmitted from food to food, either by direct contact or by individuals dealing with food, food-contact surfaces or through the air. Therefore, must consider the following:

- Separate raw and unprocessed food from ready-to-eat foods, either by placing them elsewhere or finding a time interval between them, washing thoroughly before processing, and disinfect if needed.

- Restricting or regulating access to food processing places. Where the risk of contamination is high, access to processing premises should be through changing rooms. staff may be required to wear clean protective clothing including special shoes and wash their hands before entering.
- Clean surfaces, tools, and equipment's thoroughly, and disinfect when it is necessary, after processing raw food, especially meat and poultry.

6.2.5 Physical and chemical contamination

- Systems should be developed to prevent contamination of food with foreign substances, such as glass fragments and metals that may come from machines, dust, harmful fumes, and unwanted chemicals.
- In manufacturing and processing processes, sensitive devices should be used to detect and dispose of these materials.

6.3 Terms of the incoming material

- No food premises accepts any raw food items, or any food ingredients known to contain parasites, microorganisms, pesticides, animal drug residues or toxic substances, or contains biodegradable or exotic substances that cannot be reduced to the usual level that can be stored and/or processed.
- Inspection and storage of raw food materials or ingredients before processing.
- There is nothing wrong with conducting laboratory tests on food to determine its safety for use. Only safe raw food items or safe ingredients should be used.
- The inventory management system must be applied in stores so that statements showing the type and validity of food are kept.

6.4 Packaging

- The packaging and materials from which it is made provide adequate protection for food products to reduce contamination and prevent damage.
- Allow food labels to be placed on product properly.
- Be made of materials that have no toxic effects and do not pose any threat to food safety in storage and use conditions.
- Reusable packaging must be sufficiently durable, easy to clean, and can be disinfected if necessary.

6-5 water

6.5.1 In case of water contact with food

- Drinking water should be used only for washing and processing food.
- Other types of water are used in the following processes:
 - ▣ Steam boilers, firefighting and other similar purposes so that water is not in contact with food.
 - ▣ In certain processes, such as refrigeration and cleaning of food drop-off sites, in condition this does not pose any risks to food safety (e.g., the use of clean seawater).
- Reusable water should be treated and retained in a condition that does not pose any threat to food safety. Treated Water should be carefully monitored. Untreated water may be reused as well as water from steaming or drying food, provided that its use does not pose any risks to food safety.

6.5.2 Water added to food

Only drinking water is used to avoid food contamination.

6.5.3 Water used in ice making and steam production

- Ice must be made from water in accordance with section 5.4.1 conditions.
- Production, processing and storage of ice and steam must be in good practices to prevent contamination.
- Direct Steam in contact with food or surfaces that come into contact with food should not pose any risk to food safety.

6.6 Management and supervision

The type of management and supervision required depends on the following:

- The size of the facility.
- Activities nature
- Types of food

Managers and supervisors should therefore have sufficient knowledge of principles and good practices that ensure food hygiene, so that they are able to detect potential dangers of hazards, take appropriate preventive and corrective measures, and ensure effective monitoring and supervision.

6.7 Documents and records

Obtaining records and documents can enhance confidence in the efficiency of the food safety monitoring system.

6.8 Measures to withdraw food from markets

- Managers should ensure effective measures are in place to deal with any threats to food safety, and allow for quick withdrawal of any suspected food from the market.

If any food products are withdrawn from the market and pose a direct health risk, the following should be:

- ❑ The safety of other products produced under the same conditions, which may pose a similar risk to consumers' health, should be assessed, and may need to be withdrawn from the market. The public's warning should be considered if necessary.
- ❑ Products withdrawn from the market must be placed under control until they are disposed of, used for purposes other than human consumption, or are decided to be fit for human consumption, or recycled in a manner that ensures their safety.

Section 7 - Facilities: Maintenance and health requirements

Objectives:

Establish effective systems to achieve the following purposes:

- ❑ Ensure adequate and appropriate maintenance and cleanliness.
- ❑ Pest control.
- ❑ Waste disposal.
- ❑ Monitoring the efficiency of maintenance and sanitation operations.

All this is to facilitate effective and sustained control of the risks of food contamination, insects and other factors that may lead to food contamination.

7.1 Maintenance and hygiene

7.1.1 General considerations

Facilities and equipment should be kept in good condition, maintenance and repairs should be carried out to achieve:

- Facilitate all sanitation measures.
- Facilities should operate as intended, especially at critical stages.
- Prevent food contamination with metal particles, paint husks, residues, and chemicals.
- Cleaning should lead to the removal of food residues and dirt that may be a source of contamination.

The necessary cleaning materials and methods depend on the nature of the activity. It may be necessary to perform a disinfection after cleaning.

- Care should be considered when using chemical detergents, to be used in accordance with the product's instructions, and stored away from food and in easily identifiable containers to avoid the risk of food contamination.

7.1.2 Cleaning process and methods

Cleaning can be performed in one or more physical ways, such as heat, scraping, air pressure, suction or other methods that avoid water use, and chemical methods that use detergents, alkalis or acids.

Cleaning steps:

- Remove waste from surfaces.
- Use a detergent solution to disassemble dust and conjoined bacteria.
- Rinsing with water (requirements in section 4), to remove dust and detergent residues.

- Dry cleaning, or other appropriate methods for removing and collecting residues and waste.
- Disinfection, if necessary.

7.2 Hygiene programmers

- Ensure cleaning and disinfection programmers are properly applied in all parts of facility including cleaning tools also.
- Clean-up and disinfection programmers should be subject to continuous and effective monitoring, to ensure their suitability and efficiency, and, if necessary, to ensure:
 - ❑ Places, equipment, and tools to be cleaned.
 - ❑ Responsibility for every action.
 - ❑ The method of cleaning and the number of times.
 - ❑ Monitoring methods.

These programmers should be developed in consultation with specialist advisers.

7.3 Insect Control Systems

7-3-1 General Considerations

Insects pose a serious threat to food safety. Insects infestation can occur where there are places for them to breed and there is food supplies to live on and therefore:

- Apply good hygiene to avoid an environment that helps the presence and spread of insects.
- Inspection of incoming substances and their well-being can reduce the risk of infection and thus reduce the need for pesticides.

7.3.2 To prevent entry of insects

- Buildings must be repaired and maintained continuously so that they are in a state of preventing insects from entering and eliminating potential breeding sites.
- Holes and openings under doors, cesspools, and other places where insects may enter should be sealed.
- Open windows should be covered with a soft net that reduces the problem of insects entering
- Animals and birds must be kept away from the premises of food processing factories and laboratories.

7.3.3 Insect shelter and spread

- The presence of food and water encourages the sheltering and spread of insects and therefore the following should be:
 - Keep food sources on which insects can feed in airtight containers, and/or stack them away from the ground and away from the wall.
 - Keep all areas clean inside and outside the facilities.
 - Keep rejected and damaged materials in airtight containers that are not penetrated by insects.

7.3.4 Monitoring and inspection

- monitoring and inspection

7.3.5 PEST Control

- Insects vastation should be dealt immediately, without adverse effects on food safety.

- Chemical, physical, or biological controls should be carried out without causing any harm to food safety.

7.4 Waste management

- Waste should be removed and stored away from food.
- Waste should not be allowed to accumulate in food receiving areas, storage, workplaces, and surrounding areas.
- Waste storage should be kept clean to the appropriate extent.

7.5 Monitoring the level of efficiency

Correction systems should be monitored for efficiency and validated from time to time, by pre-operational inspection, as well as by biological analyzes of the food environment and surfaces in contact with it, reviewed, and adjusted regularly in line with changing conditions.

Section 8 - Facilities: Personal Hygiene

Objectives:

Preventing food contamination by people who handle food directly or indirectly by:

- Maintain an appropriate degree of personal hygiene.
- Hygienic practices and proper food handling.

Individuals who do not maintain personal hygiene, suffer from certain diseases or health conditions, or who behave inappropriately can contaminate food and transmit diseases to customers.

8.1 Hygiene requirements

- Everyone working in the food trading industry should maintain a high degree of personal hygiene.
- Adhere to the special uniform for workers, with a head covering.
- Refrain from smoking in work areas.
- Refrain from eating, drinking, and spitting while working in work areas.
- Food handler must put a waterproof bandage on any wound or scratch on the exposed parts of the body.
- A medical examination must be passed before starting work for new employees and those returning from travel.
- The medical examination certificate is valid for 24 months from the date of its issuance and must be kept at the main premises and is available during inspection by authorities.
- People with diarrhea, vomiting, colds, and skin ulcers are not allowed to work in the shop.
- In the event of suspicion of a sick worker who may cause food contamination, the public health specialist has the right to immediately subject him to a medical examination and stop working until his safety is proven.
- Workers must be registered with same establishment, and a copy of this record must be presented in the branch in which he works.
- The worker must perform the work assigned to him or the work compatible with the registered in the health file.

Section 9 - Transportation

Objectives:

Control measures must be taken during the transportation process, such as the type of transportation, the containers used to preserve food, and the conditions in which the food is transported, based on the type of food, to ensure the following:

- a) Food should not be contaminated.
- b) Preserving food from spoilage or damage.
- c) Preventing the growth of pathogenic microbes or their excretion of toxins in food.

Scope: includes all types of vehicles used to transport or deliver cooked, ready-made, chilled or hot foodstuffs.

Include

- Motorcycles and bicycles.
- Vehicles with an electric or mechanical engine.
- Hand transported containers.

First: Registration requirements:

1. The vehicle must be registered under a shop licensed to engage in food handling activity and registered in the health record.
2. Registration of the bike or vehicle in the shop licensing register.
3. Registration of the food trader or the driver of the vehicle in the shop licensing register.

Second: Technical Requirements:

1. Requirements for the container used for food:

i. To be made of materials that do not transfer to foodstuffs.

ii. To be thermally insulated.

iii. To isolate stored materials from the outside environment.

iv. It has a thermometer and a timer.

v. The cooled materials are separated from the hot ones.

vi. It should be made of materials that are easy to clean and sterilize.

Third: Procedural requirements:

Conditions used to establish procedures for transporting and delivering food

1. A record is kept in which all consignments are recorded, the type of vehicle and the time of their departure

2. A paper shall be attached to the sent request with the time the request was processed and given to the customer.

9.1 Requirements

The means of transport and containers in which food is transported in bulk shall be designed in such a way that:

- Not causing contamination to food or packaging.
- It is possible to clean it effectively, and disinfect it when necessary.
- Allow food to be separated effectively from each other and from non-food items during transport.
- To provide effective protection from pollution, including dust and fumes.
- It should be possible to maintain temperature, humidity, weather conditions inside, circulation of cold air inside, and other conditions necessary to protect food from harmful or unwanted microbial growth and from spoilage that may make it unfit for consumption.
- To allow checking of temperature, humidity, and other conditions inside.

9-2 Use and maintenance

Means of transport and containers in which food is transported must always be of an appropriate level of validity and in good condition. When the same means of transport or containers are used to transport different foodstuffs or non-food items, the following should be done:

- Carrying out effective cleaning and disinfection operations, when necessary, between each load and the next.
- The means of transport and containers for transporting food without filling must be intended for this purpose only and written on them that they are intended for transporting foodstuffs only.

9.3 Display food in the market

- Food must be presented in suitable packages that do not affect the safety of food and be in conformity with the approved Gulf specifications and standards.
- The necessity of adhering to what is stipulated in the Gulf standards specification for prepacked food labels, and the obligation to mention the general requirements, mandatory data, and the way they are displayed on food packages, taking into consideration the specific Gulf standard specifications for each food product.
- The clarity of the product's food label, the shape of the packaging and the advertising materials, including the packaging materials used, the way they are coordinated, their display mode, and the information and data provided about them through any advertising medium, must be considered so that they meet the approved conditions and standards and do not mislead consumers.
- About the applicable requirements regarding the food label, food contact materials and validity periods, the following specifications must be taken into consideration:

GSO150-1/2013, GSO150-2/2013, GSO9/2013, GSO1863/2013

Section 10 - Product Information and Consumer Awareness

10.1 Identifying product batches

- Fixed marks must be placed specifying the production date, the operational number and the expiry date, and the general principles set by the Gulf standards should be applied to this, as identifying the

batch number of products facilitates their withdrawal from the market when necessary, and this may help in organizing the inventory cycle effectively.

10.2 Information on products

All food products must have sufficient information to enable the next person in the food chain to handle, display, store, prepare and use them properly and correctly.

10.3 Labeling of data (food label)

The data must be written and displayed on the food label in accordance with the Gulf standard specifications so that these cards contain clear instructions and data that enable the next person in the food chain to deal with it, display, store, prepare and use it in a proper and optimal manner, and the general principles set by the Gulf standard specifications are applied in this.

- The product's food card, packaging format, advertising materials, including packaging materials used, the format, display status and information provided by any advertising device should not mislead consumers.

Regarding the requirements in food card, the following specifications must be considered GSO150-1/2013, GSO150-2/2013, GSO9/2013, GSO1863/2013

10.4 Consumer awareness

Health education programs must cover the general aspects of food safety to enable the consumer to understand the importance of the information written on the products, to follow the instructions accompanying them, and to make informed choices.

11.1 Awareness and responsibility

Training is essential for general food hygiene and therefore:

- All individuals should be aware of their role and responsibility to protect food from contamination or damage.
- That food handlers have the necessary knowledge and skills that enable them to handle food in a healthy manner.
- Awareness of those who deal with high-impact hygiene chemicals, or other potentially harmful chemicals, about the proper handling of these materials.

11.2 Training programs

Factors to consider regarding the level of training required include:

- The nature of food that individuals deal with, especially the extent of its ability to withstand the growth of pathogenic organisms or microorganisms that cause spoilage.
- The way food is handled and packaged, including the possibility of its exposure to contamination.
- The level of food processing or preparation before final consumption.
- The conditions in which the food will be stored.
- The expected length of time before consumption.

11.3 Awareness and supervision

From time to time the following should be done:

- Evaluate the effectiveness of training and awareness programs.
- Carrying out routine supervision and follow-up operations to ensure the efficient application of related measures.
- Managers and supervisors of food operations should have the necessary knowledge of the principles and foundations of food hygiene practices so that they can judge potential contamination risks and take the necessary actions to correct the deficiencies.

1.4 Update Training programs

- Training programs should be reviewed and updated.
- Systems should be in place to ensure that food handlers are kept informed of all measures necessary to maintain food safety and suitability.