



# New Foreign Bodies Guideline

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## EHEDG Guidelines



DOC No.XX

**GUIDELINE FOREIGN BODIES GUIDELINE**

Month 2022

# EHEDG and F.O.

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- No specific EHEDG guideline about F.O. control
- Main guidelines focus on microbiological hazard
- In 2016, the working group was launched with more than forty participants and in fact a core team less ten members

# Some members

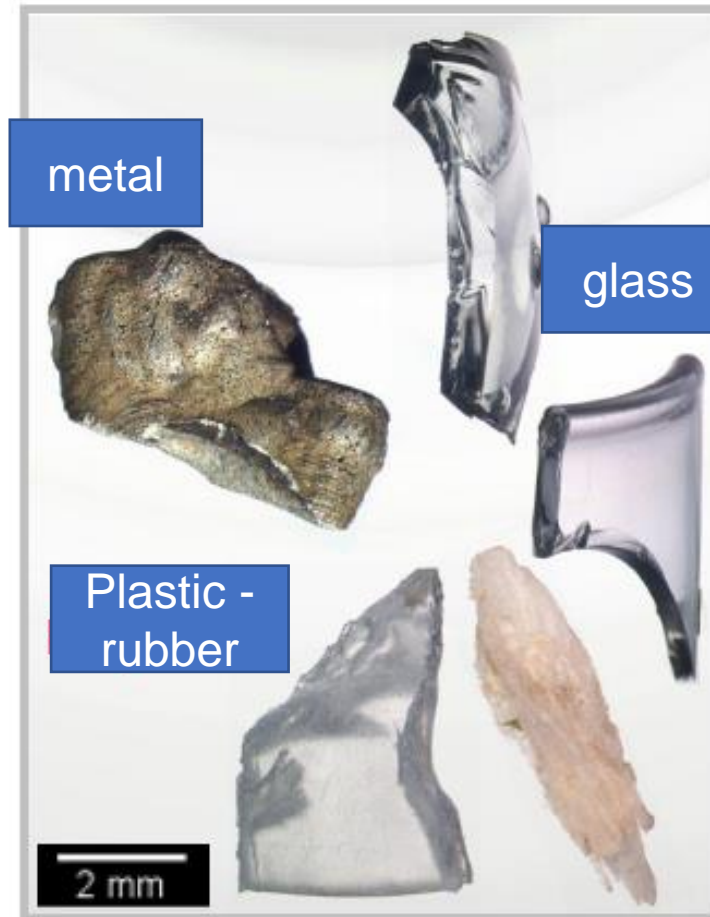
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For example :

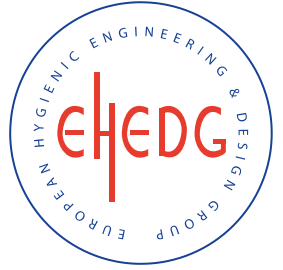
DOCEOR
Ammeraal Beltech Holding BV
Minebea Intec Aachen GmbH & Co. KG
Tetra Pak Processing System
NESTLE
Sidel Group
Diversey
Volta Belting Technology
CTCPA
Detectamet Inc
GROUPE BEL
M&S
SUNTORY BEVERAGE & FOOD EUROPE
CAMPDEN BRI
Cargill Meats Europe
Florette Food Service France
EAST BALT BAKERIES (BIMBO)
APIA Technologies

# Foreign objects, a main hazard



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Initially the contents of the guideline focused on hygienic design, but this was supplemented by other topics to give a 360° approach to this problem.

# Summary

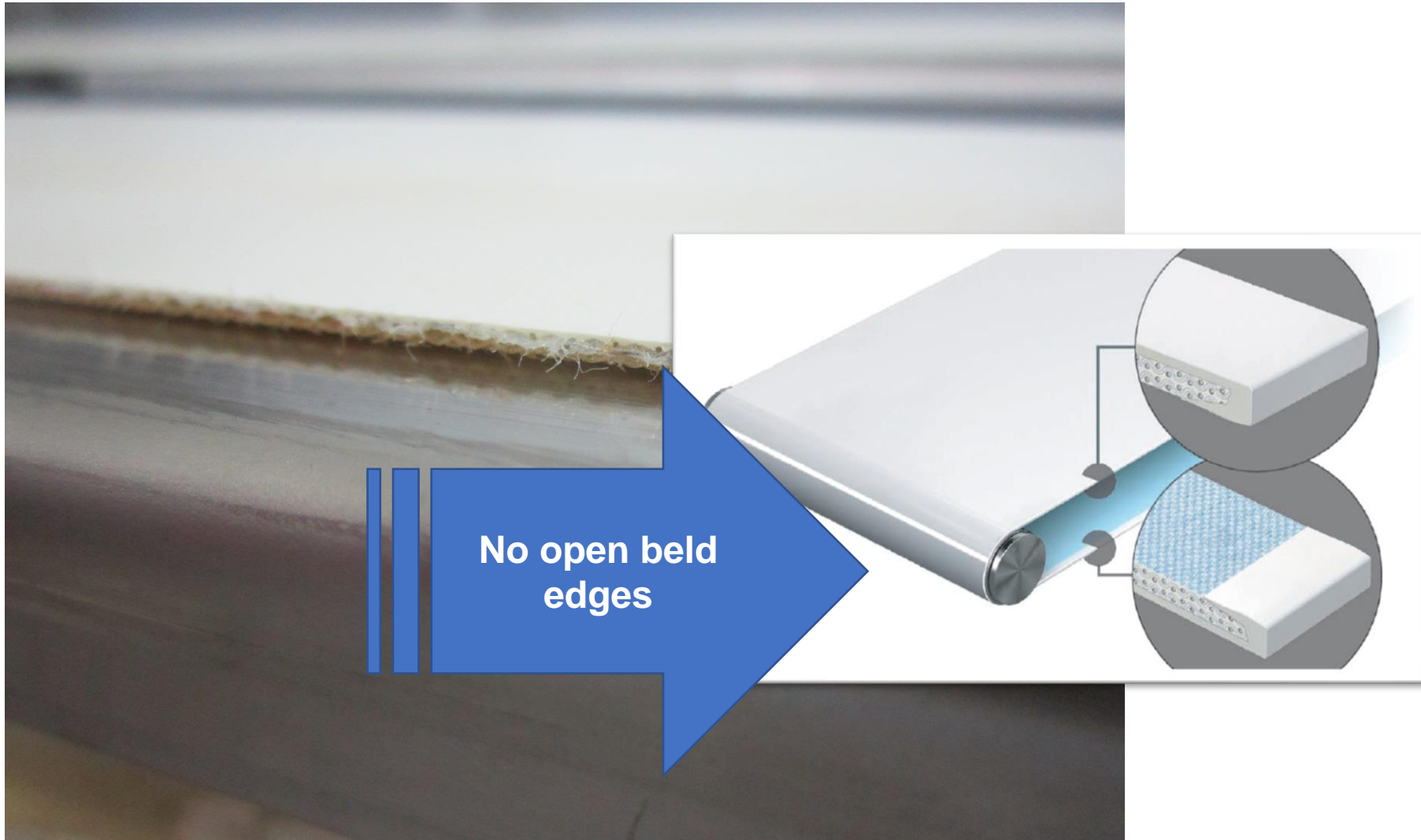
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- General quality and food safety culture
- Management of incoming materials
- Prevention of contamination from equipment in contact
- Common hygienic design criteria
- Specific hygienic design criteria for closed equipment
- Specific hygienic design criteria for open equipment
- Prevention of contamination from environment
- Process aids & utilities
- Control & Mitigation measures
- Specific design if you have brittle container or issue from packaging
- Holistic overview of entire line

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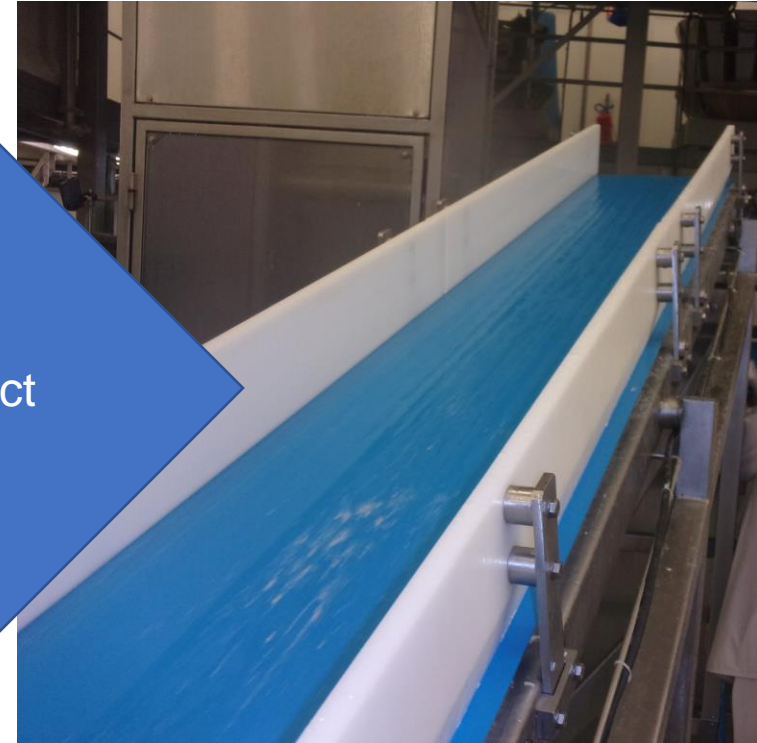
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## Hygienic design



No screw in  
product contact  
area





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## Supplier & conditions of use



Where possible use easy open bags. This reduces the risk of plastic contamination, and provides ease of opening for the individual opening the bag.

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## Brush



Figure 7





Figure 8

## 7.10.1 Rinse / Wash

Rinsing and washing equipment uses water to remove soil, leaves and other small particles from crops and fruits. For specific applications de-stoners are applied before using a wash / rinse phase to get rid of stones and other heavier objects.

There are two main types of rinsers / washers: drum washers and conveyor washers. In a drum washer, the product flows inside the drum, which is usually tilted so the product flows by gravity. Water is added from the top and the extraneous matter leaves the drum at the bottom, together with the excess water. A conveyor washer usually consists of a supply conveyor, a tilted plate with openings to get rid of the extraneous matter and excess water and an exit conveyor belt.

	
Figure 1 - drum washer	Figure 2 - conveyor washer

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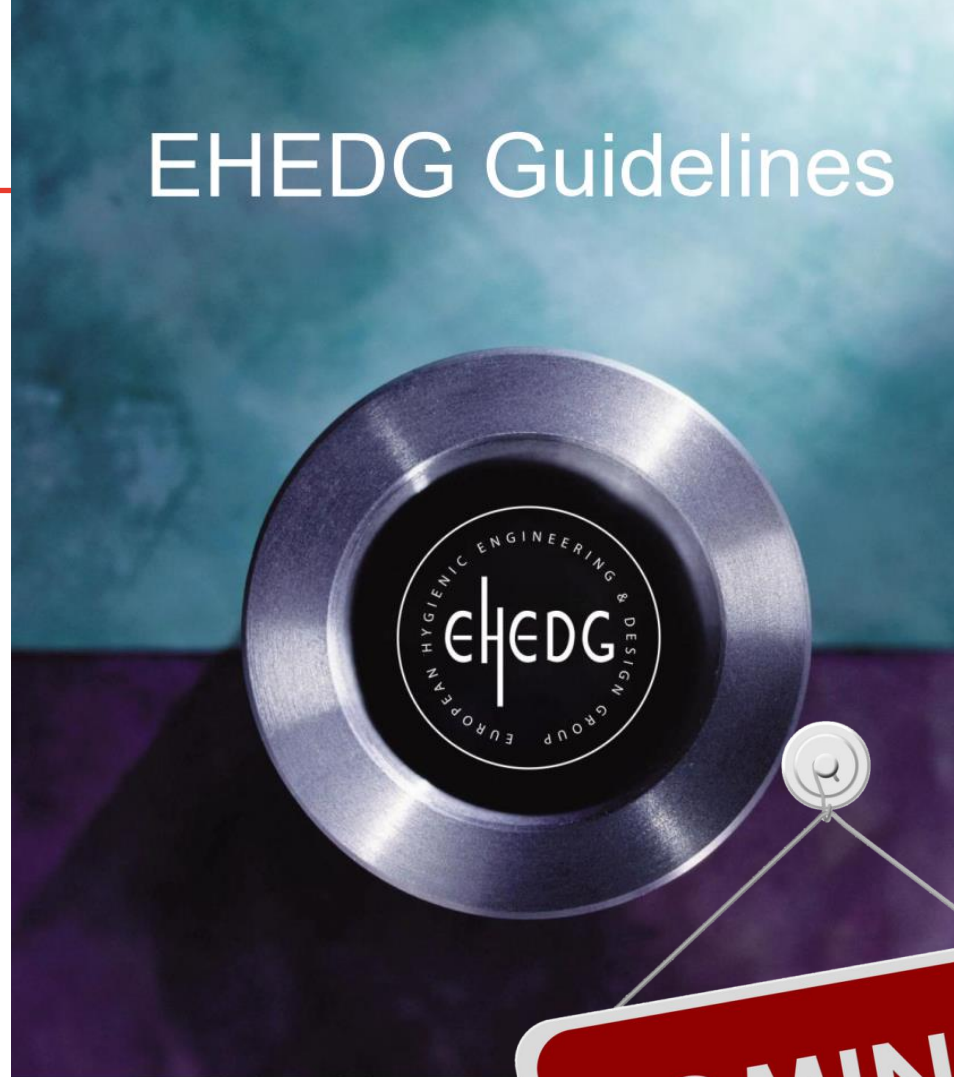


## 7.10.9.4 Detection comparison

Challenge		Metal Detector	X-ray
Contaminants	Metal (Stainless-Steel, Ferrous, Non-Ferrous)	✓	✓
	Glass, Stone, Bone, Rubber, Dense Plastic	X	✓
	Aluminium	✓	X
Product Conditions	Salty / wet / high moisture content	X	✓
	Temperature	X	✓
Packaging Type	Foil Trays	X	✓
	Packaging containing metal or metallised film	X	✓
	Ceramic Containers	X	✓
Process	Conveyorised (packaged or bulk flowing)	✓	✓
	Gravity Fed / Freefall	✓	✓
	Pipeline / Pumped	✓	✓



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**COMING  
SOON**

