

Organisation Details			
Organisation	General Mills Inc.		
Registered Legal Name (if different)	NA		
Site Registration Number	NA		
Address	8000 Audubon Rd.		
City	Chanhassen, Minnesota		
Postcode	55317		
Country	United States		
Client Representative	Michelle Sandy	E-mail	michelle.sandy@genmills.com
Site Food Safety Team Leader	Nathan Johnson	E-mail	nathan.johnson@genmills.com

CB Name and Location	SGS United Kingdom Ltd
Accreditation Body:	UKAS
Audit Language	English

Audit Type	Audit type
Audit Complexity	Combined
Additional Standards included in this audit	Costco Addendum

Audit Team

Auditor Number	First Name	Last Name	Role	FCC	Date	Hours	Minutes
588	Karen	Javier	Lead auditor		15/01/2020	8	0
588	Karen	Javier	Lead auditor		16/01/2020	8	0
319	Hwee Sian	Te	Lead auditor		19/02/2020	8	0
319	Hwee Sian	Te	Lead auditor		20/02/2020	8	0
319	Hwee Sian	Te	Lead auditor		21/02/2020	8	0

Deviation from audit plan?	No
Deviation from Audit Planning Matrix?	No

Audit Objectives	To determine conformity of the management system, or parts of it with audit criteria and its: <ul style="list-style-type: none"> - ability to ensure applicable statutory, regulatory and contractual requirements are met, - effectiveness to ensure the client can reasonably expect to achieve specified objectives, and - ability to identify as applicable areas for potential improvement.
Audit Criteria	ISO22000:2018, ISO/TS 22002-1 and FSSC additional requirements The defined processes and documentation of the management system developed by the organization Statutory/regulatory requirements (as applicable) Customer requirements (as applicable)

Audit Scope	Site: manufacturer of frozen unbaked products, frozen baked products, frozen cookie, frozen batters refrigerated baked goods packaged into either cans, poly lined cases, plastic pails, and individual pouches/trays used for food service and retail markets. Head office: Responsibilities and authority, crisis management, purchasing and selection of suppliers (including service providers); design and development, specifications (ingredients, packaging, end products); external laboratories selection, customer complaints and feedback; exports; regulatory; food Safety programs development; validation of control measures, food fraud and food defence, labels, internal audits (V/CQE), contracted warehousing and packaging material development.
Exclusions	No

Scope verified?	Yes
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Select Food Chain Category and Sector

<input checked="" type="checkbox"/> CI	<input checked="" type="checkbox"/> CII	<input checked="" type="checkbox"/> CIII	<input checked="" type="checkbox"/> CIV	<input type="checkbox"/> DI	<input type="checkbox"/> DIIa	<input type="checkbox"/> DIIb	<input type="checkbox"/> E	<input type="checkbox"/> GI	<input type="checkbox"/> GII	<input type="checkbox"/> I	<input type="checkbox"/> K
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Food Sector(s)	C3a, C3b
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Number of FTE	475	Number of shifts	3	Number of employees per shift	50	Number of HACCP studies	4
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Total time on-site (in hours)	Corporate: 16; Site: 24
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Deviation from planned audit time?	No
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Previous audit details

Audit Type		Surveillance - Unannounced	
Start Date	8/1/2019	End Date	10/1/2019
Non-conformances raised at previous audit have been closed?	Yes	No non-conformances raised for the head office at previous audit. Total 10 Minor non-conformances were raised in previous audit. The corrective actions for the non-conformances were reviewed in this audit and closed.	
Please describe any changes since the previous audit	Generally, no significant changes noted within the last twelve months for activities facilitated by the head office except that the organization has elated to transfer certification of all sites to SGS. No significant changes in the management team and products produced, new product was added to existing production lines. FSQ Manager is the interim Food Safety Team Leader. Management system had been updated to meet the requirements of FSSC 22000 Version 5.		

Executive Summary

Audit Summary	<p>General Mills, Inc. - Chanhasen belongs to the GM group. The facility was established in 1989. The activities carry out at the facility include the production of frozen unbaked products, frozen baked products, frozen cookie, frozen batters refrigerated baked goods packaged into either cans, poly lined cases, plastic pails, and individual pouches/trays used for food service and retail market. Finished products are shipped to Distribution Center for delivery to customers. There are 11 production lines, production operation in 3 shifts</p> <p>This is the surveillance audit using process-based audit approach, focusing on significant aspects, risks and objectives required by the standard(s). A sampling process was used, based on the information available at the time of the audit.</p> <p>The audit team concludes that the organization has established and maintained its management system in line with the requirements of the standard and demonstrated the ability of the system to systematically achieve agreed requirements for products or services within the scope and the organization's policy and objectives.</p>		
Please confirm that the audit objectives have been fulfilled	Yes		

Number of nonconformities

Critical Nonconformities	0
Major Nonconformities	0
Minor Nonconformities	9

Audit Recommendation

Certification maintained

Summarise any recalls or withdrawals since the last audit:

There was no product recall/withdrawal since last audit.

Legal compliance evaluation, statutory, regulatory and other requirements:

Scientific and regulatory affairs handled by General Mills Inc.'s Innovation, Technology and Quality division. All regions of distribution, manufacture and sale have been taken into account. Site registration and compliance are to be further verified during individual site audits.

Use of logos

The organization does not use the FSSC logo or certification mark in any form.

Key processing steps and Control measures:

During the audit the control of the following key processing steps and operational prerequisite programs (oPRPs) and CCP(s) were verified. All oPRPs and CCP's should be verified.

Control measure	Short description (process step)	Food safety hazards to be controlled	Monitoring procedure and critical limit	Verified during audit
CCP: Metal detections	All production lines. Finished products are passing through metal detector.	Metal contamination	Monitoring on detection and rejection of metal detector is monitored by passing the test pieces at start of the shift, end of the run, start of the run, when changeover, end of the shift. Critical limit: able to detect and reject the test piece	Yes
CCP: Labelling	Various types of packaging materials/label used, monitoring was carried out to confirm correct label is used. Types of packaging/labelling as below: Line 22: case forming, Line 21: labelling and case forming; Line 27: pail labelling/coding, Line 01: can labelling and can scanning; Line 26: can labelling. Tube forming/printing; Line 16: pail labelling/coding; Line 12: tray forming (for SAMs only), case packing; Line 11: tray forming, Line 16: case labelling, Line 23: labelling, case forming, Line 9: pouch wrapper and case former	Undeclared Allergen	The monitoring includes document the series number from physical packaging and compare the packaging BMN/series number against label list to ensure match; monitor at start of shift/start-up, end of shift, start of run, end of run and check every case of labels for BMN for BMN verification. For processing lines installed with can scanner, monitoring was carried out by passing one incorrect bar code packaging over scanner and pass one blanks bar codes over scanner and ensure detection and rejection.	Yes
CCP: Allergen Clean	Allergen clean for the processing lines producing products with different types of allergens: Line 23: Unbaked, Line 16: Cookies Pads, Muffin Pucks, Cookie Pails, Line 26: Tubeset Muffin Batters, Line 01, Line 27 Muffin Batter Pails, Line 21: unbaked frozen, Line 22, Unbaked frozen,	Cross contact with allergen not present in the formula	Monitoring on allergen clean following the changeover matrix	Yes
oPRP: Sanitation clean - post oven	Post oven sanitation for processing lines producing baked products: Line 9: French Toast and waffles, Line 11 Baked Brownies; Line 12: Biscuits	Post oven micro contamination	Sanitation clean-post oven for baked production lines: frequency of sanitation is not exceeded monthly.	Yes

oPRP: egg tote temperature	Egg tote temperature is monitor at the processing line using pasteurized eggs: Line 16: Pads-Pucks; Line 21: unbaked frozen	Micro growth due to temperature abuse.	Monitoring on egg tote temperature at the start of the shift, end of the tote, end of the shift and end of use. Critical limit: 40F or less	Yes
				Yes