Regulations on health requirements for the stores of meat, poultry and products preparation, processing and sale

1440 - 2019

Agency of municipal affairs - foodstuffs general department
In the name of Allah the Clement and Merciful
Regulations on health requirements for the stores of meat, poultry and products preparation, processing and sale

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Meat of all types and shape is one of the main nutritional groups of importance for body building as a major source of protein necessary for cell synthesis, in addition to other components such as mineral salts, vitamins, fats etc. that the human body needs for growth and performance of vital functions. With the rapid development of the meat industry new forms are introduced to meet the consumer’s desire and style which implied using the human hand or machine to processing the red meat or poultry to create new forms. This also implied the use of flavoring additives and conservatives to preserve it for longer periods. Seen that among the common meat forms in the Kingdom that the consumer prefers: fresh, chilled and frozen meat and poultry, seasoned poultry, minced meat, minced poultry, meat fingers, meat burger, sausage, meat mortadella. It’s understood that meat products are perishable due to eventual contamination during stages of production and handling through various sources (microbial, chemical and physical), therefore the ministry has found it expedient to include some updated health requirements regulations to become “regulations on health requirements for meat and poultry stores and products”.

This regulations include three main sections: the first section deals with the general requirements for such stores which represent the mandatory conditions for issuing the professional license while the second section represents the special requirements that are fundamental conditions to be strictly observed during operation and the third section deals with the manpower health requirements that should be applied with complete care in order to guarantee the human safety and security.

While the agency of municipal affairs requires the operators of facilities and stores to comply with this regulations in view of safeguarding the safety and health of the consumer it looks forward to having opinions and suggestions on its website www.momra.gov.sa

With our best compliments.
Regulations on health requirements for the stores of meat, poultry and products preparation, processing and sale

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Chapter 1
Scope and Definitions
Article (1): Scope

Articles and terms of these regulations apply to the stores of meat & poultry products sale, preparation and processing and products (luncheon “mortadella”, burger, sausage, kofta, pastrami, ground and seasoned meat and poultry) and the fresh, chilled and frozen meat & poultry selling stores either independent ones or attached to super markets.

Article (2): Definitions

Enforcement of the provisions of this regulation implies knowledge of the meanings shown next to each of the following terms:

Red meat:

The parts valid for human consumption of the mammals slaughtered in the approved slaughterhouses such as cow, buffalo, sheep, goat and camel.

Poultry meat:

The parts valid for human consumption of the domesticated birds slaughtered in the approved slaughterhouses such as chicken, turkey, ducks, geese, guinea fowl, pigeons and quail.

Edible parts and entrails:

Edible parts of the domesticated birds slaughtered inside an approved slaughterhouse such as cow, buffalo, sheep, goat and camel.

Carcass nutritional leftovers:

Parts of the carcass not classified as meat but still edible including lungs (except lungs of scalded animals) and excluding ears, skin, fur, head, nose, mucous membranes, windpipe, cartage, veins, genital system, udder, urinary bladder and guts.

Automated boneless meat:

A meat of a dough-like consistency often obtained by machine through submitting the bones of edible carcass to high pressure
leading to separation of meat from bones through determined holes.

**Boneless chicken meat:**
A meat product of separating and removal of most of the bones and cartilages attached to skeletal muscular tissues of the carcass by manual or mechanical means.

**Boneless meat:**
A meat cured with saline solution containing edible salt, sugar, nitrate and nitrite salts for the same of preservation, flavor and color fixation.

**Foreign substances:**
Any substance not making part of the product origin.

**Condiments:**
These are the seeds, roots or stalks that give the foodstuff different flavors. Some of which has a preservative content as it contains aromatic oils.

**Burger meat:**
A food product prepared from boneless and cartilage less red meat or chicken meat minced with one or more additive. It is prepared in units similar in shape, size and thickness and preserved refrigerated or frozen.

**Coated burger:**
The various shapes of burger meat coated with a mixture of breadcrumbs, corn or wheat flour.

**Luncheon meat (Mortadella):**
A food product prepared from animal meat (authorized under Islamic sharia), chicken or a mixture of both along with authorized additives after being cooked by heat treatment (at the adequate temperature to ensure safety and edibility under the ordinary transport and storage circumstances) and it may be smoked.

**Chicken sausages:**
A product prepared from one or more types of boneless
refrigerated or frozen chicken meat minced with spices and other authorized ingredients stuffed into various shapes of natural or synthetic casings.

**Chilled Chicken sausages:**
Cooled sausages preserved at -0.5 - ±1°C.

**Frozen Chicken sausages:**
Sausages frozen at a degree not exceeding -35 °C such that the thermal center of the product reaches -18°C in the shortest possible time after placing in the freezing room.

**Cooked Chicken sausages:**
Thermally treated sausages at adequate temperature and time then preserved by cooling or freezing.

**Smoked Chicken sausages:**
Chilled, frozen or cooked sausages after being cured by one of the smoking methods for the purpose of produce the desirable color or flavor.

**Natural casings:**
Intestines of animals slaughtered under Islamic sharia that have been cleaned and attached fats removed and treated in a suitable way to render it edible.

**Synthetic casings:**
Safe synthetic casings made of nutritional grade materials to be removed before eating.

**Pastrami:**
Meat cuts of beef, buffalo or camel that have been salted, seasoned, dried and coated with a mixture of ground garlic, ground fenugreek, salt and condiments.

**Kofta:**
Products prepared by grinding chilled or frozen meat or chilled or frozen ground meat with added condiments, spices, oil, lemon and shaped in balls or fingers or discs either cooked or partially cooked.
Chilled kofta:
Products prepared by grinding chilled or frozen meat or chilled or frozen ground meat with added condiments, spices, oil, lemon and shaped in balls or fingers or discs either cooked or partially cooked.

Frozen kofta:
Kofta products that have been frozen at -35°C such that the thermal center of the product reaches -8°C in the shortest possible time.

Domesticated birds:
Any pet birds such as chicken, turkey, duck, goose, guinea fowl, pigeon or quail.

Entire chicken meat:
Slaughtered edible chicken, exsanguinated, without head, legs, feather, down, viscera and the oil gland.

Chicken cuts:
Chicken parts such as breasts, thighs, wings or chicken halves, defined as follows:
Breasts:
Include sternum and ribs distributed on its both sides along with the surrounding muscles.

Thighs:
Thighs bones, legs bones and fibula with the surrounding muscles and it shall be cut from the knee joint.

Quarters:
Resulted by dividing the half into two quarters so that one quarter is a thigh and the other is a breast.

Halves:
Include half of the body and resulted by the process of cutting the body longitudinally from the middle of the sternum at the interior and the middle of the back bone at the posterior.
Secondary Parts (parts of parts):
Include the slices and the wings composed after cutting from two or three joints or middle of wing, head of wing or parts hereof.

Freezing Burns (severe dryness):
Great loss in moisture that is shown by change of the natural color of the surface area to the white or yellow color whereas it extends to the depth under the surface and is difficult to remove without damaging the natural appearance of the product.

Halal slaughtering:
To pronounce the Basmallah and praise Allah then slash the throat and trachea and jugulars to completely exsanguinate the animal.

Packaged meat:
A product prepared from chilled or frozen cuts or ground beef, buffalo, camel, mutton and packed in suitable thermally treated packages.

Chilled seasoned meat:
Chilled meat to be prepared from the red meat, ostrich or broilers that are seasoned using foodstuffs, spices and additives either in liquid or dry form with the aim of acquiring a specific taste or flavor or for tenderness.

Ostriches:
Undomesticated birds or non-flying domesticated capable of running that belong to family ratite.

Broilers:
Chicken special farmed for meat production.

Rabbits:
Domesticated mammals raised for meat, slaughtered and exsanguinated with removed non-edible head, skin, feet, viscera.

Bulking agents:
Materials that increase the bulk of the nutritional product without affecting remarkably its energy content.
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**Emulsifiers:**
Agents that help in forming or preserving the consistency of a mixture composed of two or more non-miscible phases such as oil and water.

**Colorants:**
Any material to give color the foodstuff. Food color is important as it lavishes the food with a sense of comfort during consumption and satisfies the consumer. Colorants are added as the natural food loses color due to exposure to light, air, heat, humidity or during storage.

**Natural nutritive sweeteners:**
Non-synthesized natural carbohydrate sugars such as sucrose, glucose, fructose or mixture thereof.

**Natural flavors:**
Materials obtained from raw materials (animal or vegetal) in its natural state or by treatment with physical, microbiological or enzymatic means.

**Edible entrails:**
Edible parts such as the liver after removing the gallbladder, the heart and clean gizzard.

**Chilled chicken:**
Edible slaughtered chicken preserved by cooling subject to applicable standard specifications (0 - +5°C).

**Frozen chicken:**
The preservation product reserved for human feeding of the edible whole or parts of males and female chicken, non-layer hens, as being fresh and entire by freezing methods after cleaning and removal of entrails, legs, gizzard, heads immediately after slaughtering.

**Cooling conditions:**
A confined environment ranging from 0 - 5 °C.
Chilled and frozen chicken store:
An establishment equipped for intake and display and sale of chilled or frozen chicken and its parts packed and wrapped.

Slaughterhouse:
A municipality approved and registered establishment operating in slaughtering, examination and preparation of specific animals destined for human consumption.

Post-slaughtering inspection:
Any measure or test conducted by a veterinarian on the whole carcass in order to determine the validity for human consumption.

Carcass:
The animal body after slaughtering and preparation.

Fresh meats:
Non-cured meats, with the exception of cooling, for the sake of preservation in addition to preventive packaging and which maintain its natural properties.

Chilled meats:
The fresh meats as cooled immediately after slaughtering and preparation up to a temperature of -0.5 - ±1°C within 36 hours at most.

Meat health:
All the necessary controls and arrangements to guarantee safety and validity of meats at all phases of food chain.

Minced Meat:
Boneless meat converted into small particles.

Fresh Eggs (Table Eggs):
The eggs in their natural state (with the shell) recently laid by hens and not subjected to any treatment that may change their natural ingredients and they are suitable to human consumption directly. This doesn’t include incubated eggs.
Package:

Means any suitable container in which eggs can be packed to keep them intact and facilitate their circulation. It shall be made from suitable materials and in a way that doesn’t allow pollution of the product. The small package means the one that contain thirty eggs or less.

Package Center:

The entity licensed to collect eggs from farms and producers in order to undertake the process of graduation descriptively and weightily and packaging into small packages and sending them to retailers or sale complexes.

Marketing:

Sale, circulation, display or storage and transport for the purpose of sale.
Chapter 2
General Requirements
Article (3): General

Articles from 4 to 10 are considered general and binding conditions to obtain the operating license and practice for the stores of preparation, processing and selling of meat and poultry and products and departments of supermarkets.

Article (4): Location and surface area

4.1. Location

Provisions of clause 4.1 “location” in article 4 “Location and surface area” of the Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities provided the store is locate on the ground floor.

Surface area:

a. The total surface area of the stores should not be less than the minimum limit given in the Ministry’s electronic portal such that it shall allow operating without hustle or stacking of machinery, equipment and manpower with due workflow and ease of operations performed on the premises.

b. It’s strictly forbidden to change the premises space either by increase or decrease without changing the object of the store unless upon the approval of the competent authority.

Article (5): The building

5.1. Building design and structures:

All Provisions of clause 5.2 Building design and structures of article 5 of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

5.2. Construction and finishing materials:

Provisions of clause 5.2 Construction and finishing materials of article 5 of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.
5.3. Flooring:
Provisions of clause 5.3 flooring of article 5 of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

5.4. Internal roads and paths:
Provisions of clause 5.4 Internal roads and paths of article 5 of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

5.5. Walls:
Provisions of clause 5.5 Walls of article 5 of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

5.6. Ceilings:
Provisions of clause 5.6 Ceilings of article 5 of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

5.7. Windows (if any):
Provisions of clause 5.7 Windows (if any) of article 5 of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

5.8. Doors:
Provisions of clause 5.8 Doors of article 5 of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

5.9. Superstructures (preparation and processing stores):
Provisions of clause 5.9 Superstructures (preparation and processing stores) of article 5 of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

5.10. Stairs and lifts (if any):
Provisions of item 5.10 Stairs and lifts (if any) of article 5 “Regulations
on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

**Article (6): Amenities and services**

**6.1. Water source (Drinking water):**

Provisions of the clause (6.1) water source of article (6) Amenities and services of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply

**6.2. Vapor supplies (if used in the production operations):**

Provisions of the clause (6.2) Vapor supplies (if used in the production operations) of article (6) Amenities and services of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply

**6.3. Sanitary drainage:**

Provisions of the clause (6.3) Sanitary drainage of article (6) Amenities and services of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply

**6.4. Electric wiring:**

Provisions of the clause (6.4) Electric wiring of article 6 Amenities and services of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply

**6.5. Lighting:**

Provisions of the clause 6.5 Lighting of article 6 Amenities and services of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

**6.6. Ventilation:**

Provisions of the clause (6.6) Ventilation of article 6 Amenities and services of the “Regulations on general health requirements for the
food preparation, processing and sale stores & public health related facilities” shall apply.

6.7. **personal hygiene amenities:**

**a. Hand washing basins, water closets, cloth changing places**
(fresh, chilled and frozen meat and poultry stores and stores for processing of ground and seasoned meat and poultry):

1. The water closets should not open directly to the work area and should be equipped with self-closing door made of aluminum or any other anti-rust and anti-erosion material and be firmly fixed. It should be equipped with exhaust fan, foot operated flush tank and hand washing basin.
2. The appropriate and well maintained hand washing basins shall be located near the work area to encourage the workers to washing their hand upon finishing preparation of order and before starting a new order provided it shall be equipped with sensor operated taps, liquid soap, disinfectant, high absorbent paper tissues or hot air dryers or both.
3. The water closet should be equipped with waste basket, liquid soap, high absorbent paper tissues or hot air dryers or both.
4. It should be equipped with hand washing basin with sensor, foot, knee or elbow operated tap provided the water shall of of adequate pressure and temperature.
5. Monitor regularly the hand disinfectants the to provide the appropriate concentration for confirmed effectiveness.
6. Place the sign “wash hands” above the hand washing basin and in the work area wherever appropriate.
7. Provide the appropriate changing room for the workers to be equipped with lockers.

**b. Water closets, hand washing basins and shower cubicles and manpower waiting room (stores of meat and poultry products preparation and processing):**
Provisions of the clause (6.7) Water closets, hand washing basins and shower cubicles and manpower waiting room of article 6 Amenities and services of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

6.8. Waste disposal:

Provisions of the clause (6.8) Waste disposal of article 6 Amenities and services of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

Article (7): Store departments

In view of ensuring production workflow and to avoid contamination of foodstuffs, volume of work and number of guests, the premises shall be divided into the departments shown in the following table according to activity:
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<td>Fresh, chilled and seasoned meat outlet</td>
<td>Administration, accounting and reception including: (b, c, d, e) + primary materials reception division (d, e, f, g, h) + meat and poultry cutting, mincing and seasoning space (a, b, c, d, e, f) + display space (a, c) + warehouse (b, d, e) + preparation and processing department (a, b, c) + packing and wrapping department (a, b, c).</td>
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<tr>
<td>Fresh meat store</td>
<td>Administration, accounting and reception including: (b, c, d, e) + primary materials reception division (d, e, f, g, h) + display space (a) + warehouse (b, d, e) + equipment washing department (a, b, c) + preparation and processing department (a, b, c).</td>
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<tr>
<td>Frozen meat store or cold store</td>
<td>Administration, accounting and reception including: (b, c, d, e) + display space (g) + warehouse (c, d, e) + equipment washing department (a, b, c) + preparation and processing department (a, b, c).</td>
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<tr>
<td>Fresh, chilled and seasoned poultry and table eggs stores</td>
<td>Administration, accounting and reception including: (b, c, d, e) + display space (b, c, d, e, f, h) + meat and poultry cutting, grinding and seasoning space (a, b, c, d) + warehouse (b, d, e) + equipment washing (a, b, c) + preparation and processing department (a, b, c) + packing and wrapping department (a, b, c).</td>
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<tr>
<td>Minced meat or poultry preparation and processing stores</td>
<td>Administration, accounting and reception including: (a, b, c) + primary materials reception division (a, b, c) + production line + final products warehouse (a, b) + warehouse (a, b, c, d, e) + equipment washing (a, b, c) + laboratory (a, b, c) + meat and poultry products display room (a, b, c, d, e, f, g, h).</td>
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<tr>
<td>Other meat or poultry preparation and processing stores</td>
<td>Administration, accounting and reception including: (a, b, c) + primary materials reception division (a, b, c) + production line + warehouse (a, b, c, d, e) + equipment washing department (a, b, c) + preparation and processing department (a, b, c) + packing and wrapping department (a, b, c) + laboratory (a, b, c) + meat and poultry products display room (a, b, c, d, e, f, g, h) + final products warehouse (a, b).</td>
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<td>Display, sale, cutting and seasoning of frozen meat or poultry</td>
<td>Administration, accounting and reception including: (a, b, c) + raw materials reception division (a, b, c) + display space (b, c, g, h) + space for cutting and mincing or seasoning meat and poultry (a, b, c, d, e, f, g) + warehouse (b, c, d, e) + equipment washing department (a, b, c) + preparation and processing department (a, b, c) + grilling section.</td>
</tr>
<tr>
<td>Display, sale and cutting of poultry and vegetables</td>
<td>Administration, accounting and reception (a, b, c, d, e) + raw materials reception division (a, c, d, h) + display space (b, c, h, i) + space for cutting and mincing or seasoning meat and poultry and cutting vegetables (a, c, d, g, i, j) + warehouse (a, b, c, d, e) + equipment washing department (a, b, c) + preparation and processing department (a, b, c) + packaging and wrapping section (a, b, c).</td>
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1. Administration, accounting and suppliers and guests reception department shall be: separated from the other stores departments and shall be:
   a. Equipped with necessary equipment (offices and cabinets) necessary for the management of the stores of preparation, processing and reception of suppliers, guests … etc.
   b. Equipped with an adequate number of easy chairs fabricated from heavy duty material being non-absorbent of water and anti-rust with smooth surfaces for easy cleaning.
   c. Place stickers sized at least 10 x 15cm in suitable locations showing “No Smoking”.
   d. It should be locate in the front of the store and equipped with tools and installations such as sorting tables … etc. as required.
   e. Beware not to expose the received fresh, chilled or frozen meat or poultry or eggs or vegetables to weather conditions such as direct sunlight, rain, environmental pollutants such as smokes dust, insects and rodents.

2. Department for reception of primary materials:
   a. It should be located at the front of the stores and equipped with the tools and equipment necessary for reception operations such as reception scales, sorting tables, thermometer … etc. provided it shall be well ventilated and illuminated and applying good health practices.
   b. The department shall be equipped with electric hoists to move the raw materials from the trucks to the warehouse taking care not to allow access of vehicles inside the warehouse under any circumstances.
   c. Beware not to expose the raw materials upon receiving to weather conditions such as direct sunlight, rain, and environmental pollutants such as smoke, dust and insects.
   d. It shall be Equipped with mason built counter with a heavy duty one-piece marble top for easy cleaning and to prevent accumulation of pollutants.
e. It shall be equipped with adequate number of tools and equipment used for cutting and removal of bone or grinding mean and weighing.

f. Separate the cutting and bone removal space from the space of meat display with a glass partition subject to the provisions of article 13 glass partitions of the regulations on health requirements for restaurants, kitchens and similar facilities.

g. Provide overhead structures fitted with hooks to hoist the carcasses in view of preparation, cutting … etc.

h. It shall be equipped with a healthy and good means for honing the cutting equipment provided the tools shall be washed after honing to prevent contaminating meat and poultry.

3. Display area:

a. Upright or horizontal refrigerator with transparent glass display regulated at 0 - 4 °C for display of carcasses or meat cuts provided the type of meat and carcasses shall be tagged and be mounted on mobile stands made of anti-rust material and provided with a thermometer.

b. Horizontal refrigerator for display of whole chicken of various weights, chicken parts or the edible giblets. Temperature should not exceed 0°C and it should be mounted on anti-rust mobile platforms.

c. Horizontal freezer for display of whole chicken of various weights, chicken parts or the edible giblets. Temperature should not exceed -18°C and it should be mounted on anti-rust mobile platforms.

d. Vertical refrigerator with its temperature ranging between (4 C to 10 C) with transparent glass window to keep and display table eggs; provided that it must be lifted on movable bases and made of stainless materials and provided with a thermometer.

e. A part of the display space shall be equipped with shelves made of stainless materials lifted above the ground by (30 cm) to display eggs; provided that the temperature shall be between (11 C to 15 C).

f. Self service area of meat and poultry should be supplied only with packed meat and poultry products.
g. The frozen meat stores or cold stores should be equipped with electric saw for cutting frozen meat without defrosting along with supplying other required tools and equipment.

h. Part of the display space shall be equipped with a vertical refrigerator with shelves and the temperature may not be less than (zero C – 10 C) according to the standard specification approved for each item.

i. All requirements stated in clause (Display and Sale section) of article (7) Store Sections in Regulations on Health Requirements for Vegetables and Fruit Stores must be fulfilled.

4. Meat and poultry cutting and grinding or seasoning space:
   a. It shall be equipped with a set of tools such as cutting boards, knives, containers … etc. as required.
   b. It shall be equipped with a cabinet for keeping the seasoning materials that should be kept in a specific temperature.
   c. It shall be equipped with a refrigerator with a temperature ranging between zero and 4 °C mounted on mobile anti-rust platform.
   d. Good manufacture practices as to temperature, humidity, ventilation … etc. as well as good health practices should be observed.
   e. It shall be equipped with meat and poultry grinding machines of suitable capacity and power. In case of employing frozen meat there should be used an electric saw and meat crusher and grinder to grind the frozen meat without defrosting in order to preserve its properties particularly the color.
   f. Grand stores shall be equipped with a ground meat and poultry packing machine into final packages.
   g. The refrigerators shall be equipped with UV lamps for continuous sterilization to prevent microbial growth.
   h. Ground meat and poultry stores shall be equipped with pumped cool air tunnel freezer of a temperature not exceeding -35°C.
   i. A section shall be dedicated to cutting vegetables, provided that it shall fulfill all requirements stated in clause (2) sorting, cleaning and cutting.
of article (7) Store Sections in Regulations on Health Requirements for Vegetables and Fruit Stores must be fulfilled and it must be separated from vegetables display and sale section by a glass partition.

j. A section shall be dedicated to cutting poultry and it shall be separated by a glass partition from poultry display and sale; provided that it shall be fitted with all equipment according to the work need.

5. Warehouse:

It shall be subdivided into smaller stores as required provided all general and special requirements of nutritional warehouses shall apply as follows:

a. Dry foods warehouse: foods shall be stored at the room temperature (25°C) without the need for special preservation means.

b. Cold store: it shall be equipped with adequate number of refrigerators of high cooling capacity fitted with thermometer fixed on its external wall for easy reading and mounted on anti-rust mobile stands. For preserving foods against spoilage at the range of 0 - 4°C and meats at -0.5 - ± 1°C.

c. Freezing store: it shall be equipped with one or more freezers fitted with thermometer fixed in a suitable location on its external wall for easy reading and mounted on anti-rust mobile stands. For preserving foods that require a temperature of -18°C.

d. Janitorial warehouse: where shall be stored the cleaning and decontamination tools, detergents and disinfectants, with dedicating separate cabinets for storing materials used in pest control (pesticides in original packing) or other materials hazardous to health.

e. Equipment and spare parts warehouse:

1. All foodstuffs related spare parts shall be stored in a clean and dry environment separated from the flooring on anti-rust anti-erosion metal racks installed at 30 cm away from the wall and flooring.

2. Conveyor belts or invalid equipment shall be stored in a separate space pending disposal.

3. Store lubricants authorized for use in nutritional facilities in the
correct manner to prevent contamination.

6. Equipment washing department:
   a. Connected to the cooking department with swivel door.
   b. It shall be strictly forbidden to wash equipment or workers’ hands in the basins of this department.
   c. All equipment shall be dried after cleaning and decontamination with high absorbent paper towels or by hot air devices then placed in its dedicated locations provided it shall be rinsed right before usage.

7. Preparation and processing department:
   a. It shall be connected to the display department in the sell stores or to the production line in the meat and poultry products preparation and processing stores.
   b. It shall be equipped with professional equipment such as electric grinder, electric saw, meat products slicing machines, knives, cutting boards … etc as required.
   c. It shall be equipped with adequate number of stainless steel tables, basins, refrigerating and freezing appliances and waste containers.

8. Grilling Section
   Clauses (b, c, d) of the sub-clause (6) cooking section of article (8) facility sections in Regulations on Health Requirements for Restaurants, Kitchens and the like.

9. Production line in the meat and poultry products preparation and processing stores:
   It shall be divided into secondary departments according to the manufacture stage undertaken and the type of product.

10. Packaging and wrapping department:
    a. It shall be equipped with automatic, semi-automatic and manual packaging and wrapping equipment adapted to the production capacity and with adequate number of scales, packaging and wrapping materials … etc. as required.
    b. The surfaces of the packaging and wrapping tables should be of one-
Regulations on health requirements for the stores of meat, poultry and products preparation, processing and sale

piece of smooth marble or from seamless stainless steel to ensure easy cleaning and decontamination.

c. Good manufacture practices as to temperature, humidity, ventilation … etc. as well as good health practices should be observed.

11. Laboratory (if any in the meat and poultry products preparation and processing stores):
   a. A store lab shall be set up and furnished with the instruments and devices necessary for quality sampling (microbiological and chemical) provided it shall be run by qualified, trained and experienced lab analysis professionals.
   b. Inspect raw materials to determine its compatibility with the relevant approved standard specifications.
   c. Inspect samples of the final product to ensure validity for human use subject to approved standard specifications.

12. Meat and poultry products showroom:
   a. It shall be furnished with one or more heavy-duty and smooth counters with one-piece marble top or similar materials for ease of cleaning and decontamination.
   b. It shall be equipped with adequate number of scales made from anti-rust materials and a set of equipment such as product slicing machine to customer required thickness and other packaging machines as required.
   c. Provide adequate number of horizontal refrigerators and freezers fitted with glass screens and shelves for showing meat and poultry products provided it shall be mounted on anti-rust mobile frames and equipped with internal easy to read thermometers.
   d. Each item shall be displayed in a specific location and the packages shall be arranged inside the refrigerator according to production date and reserving a refrigerator for packages prepared for customer in order to prevent products spoilage and damage.
   e. Maintain the refrigerators away from heat sources and avoid disconnecting power source for whatever reason as long as it’s loaded
with meat and poultry products and avoid accumulation of frost and defrost it regularly to maintain the cooling efficiency of the refrigerators.

f. It shall be strictly forbidden to load the refrigerator above its rated storage capacity in order to maintain the cooling efficiency and quality of coolness rotation inside the refrigerator.

g. It shall be furnished with cabinets with internal racks for preserving packaging and wrapping materials taking care to keep it always wrapped

h. good health practices as well as good manufacture practices as to temperature, humidity, ventilation … etc. should be observed in order to prevent meat contamination, spoilage and damage.

13. Final products warehouse:

It shall be located at the back end of the preparation and processing stores and be reserved for storing final products ready for distribution provided all general and special requirements of foodstuffs warehouses shall apply.

Article (8): Equipment

1. Provisions of article 7 Equipment of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

2. Avoid using wooden handle knives in cutting meat and poultry, instead use plastic handles for ease of cleaning and decontamination.

3. Provide adequate number of pressurized plastic cutting boards and avoid wooden ones.

Article (9): operation, maintenance and calibration

Provisions of article 8 Operation, maintenance and calibration of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

Article (10): Safety and security

Provisions of article 9 Safety and security of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.
Chapter 3
Special requirements
Article (11): General

The set of additional controls to be observed in meat and poultry products preparation, processing and display stores starting from receiving raw materials till display and sale of meat and poultry products to guarantee high quality products safe for the consumer and compatible with approved standard specifications.

Article (12): Fresh, chilled and frozen meats

12.1. Properties of Fresh, chilled and frozen meats

a. The carcass shall be free from giblets, headless, members removed, kidneys grease removed while tail stump may be maintained to identify the animal.
b. It should be produced from animals slaughtered under Islamic sharia law inside authorized slaughterhouses.
c. The carcass as well as its parts shall retain all characteristic properties and be free from contusions, colored specks and any other indication of spoilage.
d. The meat should be consistent (not molly) shiny and free from undesirable odors.
e. Preservatives, tenderizers and colorants are not allowed except the meat stamp colors.
f. There should be no free liquid inside the chilled meat package.
g. There should be no indications of loss in the vacuuming level in case of vacuum packaging or loss in gases in case of inert gas packaging of chilled meats.
h. Frozen meats should not show any sign of defrost or re-freezing, contamination or bad handling.
i. The frozen meats should be free from frostbites.

12.2. Transport:

a. Transport means should protect meats against dust, insects and other contamination sources. Open deck transport means are not allowed.
b. The transport means should be lined with anti-rust, impermeable and heavy duty material in case the transport period exceeds 30 minutes, refrigerated means should be used.

c. Refrigerated transport means: the following shall apply:
   1. The vehicle should be isolated from inside and outside to guarantee cooling subject to approved technical standards.
   2. It should be equipped with tools for hanging the carcasses to be made from anti-rust materials provided carcasses are sufficiently separated to ensure good ventilation of the cooled carcasses and meats during transit.
   3. The inner coat should be of stainless steel and smooth for the purposed of cleaning and decontamination.
   4. Provide a high cooling capacity unit to ensure reaching the required temperature such that it shall not exceed 1 - 4 °C with a temperature indicator in the driver’s cabin and periodic calibration and produce proof thereto (calibration certificate from authorized operator).
   5. It should be permanently equipped with temperature recorder and to keep such record for a while for reference.
   6. The doors should fitted with rubber frames and plastic curtains to prevent leakage.
   7. To provide adequate number of protected lighting units inside the transport means and prevent workers to sit between the meats.
   8. To provide transport means for which the temperature of the cargo compartment shall not exceed -18°C to transport frozen carcasses and meats.

d. To start the cooling unit well before loading the carcasses in order to cool down the space in advance.

e. It’s strictly forbidden to stop the cooling unit during loading, on the road or during unloading.
f. Avoid using the transport means for other purposes and always maintain it cleaned and decontaminated.
g. Avoid laying the carcasses on the flooring or letting the workers to sit between the carcasses in the cooling chamber.

12.3. Packaging and wrapping:

a. The packaging and wrapping materials should be tough, entire, healthy and shall not cause any change in the meat property or transmit any substances harmful to human health or contaminate it with any undesirable substance. Further, it should not contained any recycled materials.
b. Packaging or wrapping or both should ensure complete protection of the meats.
c. Packages or wrappers should not be reused.
d. Frozen meat should further be packed with kraft paper or polyethylene or any other appropriate material. In case of chopped meat, it should be packed in waxed carton packages or lined with polyethylene or any other appropriate material.

12.4. Storage:

a. Fresh meat shall be hooked and the various carcasses and unpacked cuts shall be shrouded in clean white linen cloth or arranged on suitable anti-erosion tables in such a way to ensure good ventilation of the meats and to prevent the liquid seeping from one cut to other cuts, and meats should not come in contact with the walls, ceiling or flooring.
b. Carcasses should not come in contact with the cold room walls and should not be stored on the cold room and be arranged inside the cold room distinct compartments based on slaughtering date.
c. Avoid overloading the cold room with carcasses exceeding the rated capacity from the manufacturer in order to maintain the cooling efficiency and ensure good cooling distribution.
d. Avoid disconnecting the cold room for any reason whatsoever.
as long as it’s loaded with carcasses and an emergency generator should be on standby.
e. Carcasses should be rotated based on FIFO method.
f. The relative humidity inside the meat cooling chamber should be in the range 90-95%.
g. The temperature of the cooled meat should not exceed -0.5 - ±1°C either for the cuts or carcasses and enough space should be allowed in-between to ensure good ventilation of the cooled meats.
h. The temperature of the frozen meat should not exceed -18°C.
i. Fluctuation in temperature in the cold chamber should not exceed ±2°C.

12.5. Display and sale:
All requirements as provided for in clause 12.1 of this regulation shall apply in addition to the following:

a. Avoid mixing fresh meats with chilled or frozen ones or defrosting the frozen meat and sell as fresh or chilled.
b. All the carcasses of each type shall be displayed in its own refrigerators separate from other types with placing a tag showing meat type (fresh local, chilled or frozen) or imported (chilled, frozen and country of origin).
c. It’s strictly forbidden to cut or process and display minced meat which should be done only at the presence of the customer.
d. Stamps of the fresh and chilled meats should indicate the basic data subject to the applicable regime in the Kingdom.
e. As for the frozen meats it should be indicated the slaughtering or freezing date as well as the expiration date.

Article (13): Chilled and Frozen Poultry and Fresh Eggs
13.1. Properties of frozen poultry:

a. It should be from entire chicken free from diseases particularly those transmissible to man.
b. It should be slaughtered in an authorized slaughterhouse under the Islamic sharia subject to the applicable standard specifications.
c. The period between slaughtering and storage should not exceed four hours.
d. The meat should be uniformly divided on the chicken particularly the breast and above breast bone.
e. Chicken shall be received from producers or suppliers either whole, in parts or boneless for sale to the customer.
f. Receive the slaughtered and completely exsanguinated chickens packaged and wrapped in specialty plastic bags either whole or in parts.
g. It should be clean and free from feather, down and non-edible giblets.
h. It should be free from different spoilage features such as change in color, bad odors or fractures.
i. The weight of a whole broiler should be 550 – 1800 gm. with a tolerance of ±50 gm.
j. The area of tear zones should not exceed 30 mm in diameter in the breast and thighs and 45 mm elsewhere.
k. Color speck (change in color) space resulting from contusions should not exceed 25 mm in diameter in the breast and thighs and 60 mm elsewhere.
l. Cleaned giblets should be placed in a clean pouch, made of a material authorized for this purpose, inside the chicken stomach cavity.
m. Authorized clearance in the chicken weight should be ±5% of the package weight.

13.2. Properties of the local frozen chicken:
   a. It should be produced from entire units free from infectious diseases and valid for human consumption.
b. It should be slaughtered under the Islamic sharia subject to the applicable standard specifications in an authorized slaughterhouse and be completely exsanguinated.
c. It should be clean and free from feather, down and non-edible giblets.
d. The weight of a whole broiler should not be less than 500 – 1700 gm. with a tolerance of ±50 gm.
e. Preservatives, tenderizers and flavoring agents and traces hydrogen peroxide are strictly forbidden.
f. It should be headless, oil gland and legs (at the point of jointing the thigh) removed, provided its outer surface is dry and free from viscosity, fungal growth and fractures.
g. Extruded fluid percentage should not exceed 5% of the frozen unit weight.
h. Chicken and its parts shall retain all natural distinctive properties and be free from rancidity, spoilage signs and any harmful substances.
i. Glandular tissues (edible giblets) such as the liver, heart and gizzard should be placed in a separate pouch made of authorized material.
j. Whole chicken and parts should be packed immediately after the first cooling taking place after slaughtering and cleaning and kept at 5°C at most for not more than 24 hours.
k. Chicken is frozen immediately after packaging at a temperature not exceeding -30 °C provided the temperature of the tissues shall read -18 °C within 90 minutes.

13.3. Fresh Eggs (Table Eggs):

a. Eggs shall be from intact hens free from diseases especially those infectious to human and shall be in conformity with the approved standard specification approved as valid for human consumption.
b. The fresh eggs must be clean viz the shell may not be contaminated by garbage, insects, worms or any microbiological or chemical pollutants or any foreign materials. Fresh eggs may be washed and shaken (b, c) before packaging with water containing disinfectant such as chlorine to kill microbes and it shall be dried by fans. It may also be sprayed or submerged in a mineral oil (paraffin oil); provided that the eggs shall be circulated in a way that ensure it is not polluted.

c. The eggs shall be sorted before packaging to eliminate damaged or cracked eggs or eggs with internal defects.

13.4. Packaging and wrapping:

a. Bags used for packaging shall be made of healthy authorized materials, moisture barrier, hermetically sealed and shall not affect or contaminate the chicken. It must have at least one transparent side.

b. The packaged chicken shall be placed in suitable moisture barrier containers providing protection during handling or storage provided that the contents of a single chilled or frozen pack shall be similar in size and weight.

c. The following data shall be inscribed on the outside of the package “in Arabic and another language” by indelible non-harmful ink:

1. Packing weight.
2. Production date and expiration date (day/month/year).
3. The phrase “made in KSA” for local products and the country of origin in case of frozen imported chicken.
4. Product type (chilled, local frozen, imported frozen), storage temperature.
5. Manufacturer name, trademark, address and telephone number.
6. The phrase “slaughtered under Islamic sharia” in case imported
and the phrase “with edible giblets” if any.

7. The chilled chicken packages shall be stamped “chilled” in green and “frozen” in red for frozen ones.

d. The plates and boxes used in packaging the fresh eggs shall be in conformity with the approved standard specification; provided that they shall be clean, durable and made from suitable materials and not to convey to the eggs any undesirable smells and to be used once only.

e. The sorted eggs shall be arranged in cartons prepares specifically for eggs and in plates each of which contains (30, 12 or 6 eggs) so that the convex end shall be to the bottom and the wide end to the top.

f. The plates shall be arranged in boxes of carton tightly closed and an empty plate shall be placed on the top before closing the box.

g. The following details shall be shown on the small packages with caps even if those packages were inside other bigger ones:

1. Number of eggs, date of production, date of expiry in a non-symbolic manner (day – month – year).

2. Item (quality degree “AA, A, B, C”; weight) and storage conditions

3. Name and address of packaging center or the producing farm.

4. A seal shall be affixed on eggs to show the production date and expiry date in a non-symbolic manner so that the seal must be in blue color for the locally produced eggs and green for eggs incoming from GCC countries and red for eggs imported from other countries; provided that the seal must contain the name of the manufacturing company.

13.5. Transport:

a. The transport means should be mechanically cooled in the range of 0 - +5°C upon transporting chilled chicken and not
exceeding -18 °C upon transporting frozen ones.
b. All surfaces of the transport means coming in contact with the chicken containers anti-erosion, smooth and easy to clean and decontaminate.
c. The transport means should be clean, dry and not previously used for transporting other than processed chicken.
d. It shall be inscribed on the sides of the transport means the manufacturer’s name, address, telephone number and the brand name.
e. It’s strictly forbidden to use open deck transport means for chilled processed chicken.
f. All the workers operating the transport means should hold a valid medical certificate.
g. Loading/ unloading of the transport means should not hustle the traffic.
h. The doors of the chilled or frozen transport means shall be fitted with plastic curtains to maintain stability of the chicken temperature inside the transport means.
i. Cargo compartment should be pre-cooled well before loading at 0°C and avoid turning off the cooling unit during loading and unloading.
j. Transport and distribution of fresh eggs must be in refrigerated or thermally insulated containers; provided that the temperature must not exceed (10 C).

13.6. Storage:

a. Storage shall be undertaken such that the product shall be protected against mechanical damage and spoilage.
b. Chilled or frozen chicken should not be stored in quantities in excess of the storage capacity of the refrigerator.
c. The chilled chicken should be stored at 0 - 5°C and frozen one at -18°C and relative humidity of 90%.
d. Fluctuation of the refrigerator’s temperature should not exceed ±2°C.

13.7. Display and sale:

a. Use chilled display refrigerators for showing chilled chicken given the temperature shall not exceed 0°C or -18°C for frozen chicken.
b. It’s strictly forbidden to display frozen chicken in the chilling refrigerators to avoid defrosting or vice versa and sell it as is.
c. Chicken shall be displayed such that to avoid stacking inside the refrigerator or freezer in order not to affect its temperature which may expose it to damage, spoilage and change of properties.
d. Chicken shall be cut and seasoned only before the customer and no seasoned or processed poultry shall be displayed at the store.
e. Fresh eggs must be kept and displayed for sale in a temperature between (4 C to 10 C) for (90 days) and between (11 C – 15 C) for (30 days).

Article (14): Display, Sale and Cutting of Poultry and Vegetables

14.1. Properties of poultry and vegetables

a. All the clauses stated in article (13) chilled and frozen poultry and fresh eggs hereof must be fulfilled.
b. All the clauses stated in article (12) Receiving of Vegetables and Fruit in the Regulations on Health Requirements for Vegetables and Fruits Sale Stores.

14.2. Packaging and wrapping for poultry and vegetables

a. All the details stated in clause (13.4) Packaging and wrapping of article (13) chilled and frozen poultry and fresh eggs hereof.
b. All the clauses stated in article (15) packaging and wrapping in the Regulations on health requirements for vegetables and fruit sale stores.

14.3. Storage of poultry and vegetables

All that is stated in clause (13.6) of article (13) chilled and frozen
poultry and fresh eggs hereof shall be fulfilled.

14.4. Transport of poultry and vegetables
   a. All that is stated in clause (13.5) of article (13) chilled and frozen poultry and fresh eggs hereof shall be fulfilled.
   b. All clauses stated in article (16) Transport in Regulations on health requirements for vegetables and fruit sale stores hereof shall be fulfilled.

14.5. Display and Sale of Poultry and vegetables
   a. All that is stated in clause (13.7) of article (13) chilled and frozen poultry and fresh eggs hereof shall be fulfilled.
   b. All clauses stated in article (18) Display and sale in Regulations on health requirements for vegetables and fruit stores

14.6. Poultry and vegetables cutting
   a. It is not permitted to use raw materials with marks of damage or spoil or expired or from unknown sources.
   b. Cutting of poultry must be in front of customers and according to their requests. Precutting is strictly forbidden.
   c. The temperature of poultry cutting section must not exceed (15 C) and good manufacturing and health practices must be followed.
   d. All clauses stated in article (13) processing vegetables and fruit in cutting and retail stores of the Regulations on health requirements for vegetables and fruit sale stores must be fulfilled.
   e. Suitable packs and materials of wrapping must be used for packaging and wrapping all cut poultry and vegetables; provided that they may not conflict with the approved standards issued for the packs used in packaging poultry and vegetables.
Article (15): Display, Cutting and seasoning of frozen meat and Poultry

15.1. Properties of frozen meat and poultry
   a. All the details stated in clause (15.1) Used meat and poultry – b. frozen meat and poultry hereof must be fulfilled.
   b. All details stated in clause (13.2) properties of local frozen poultry of article (13) properties of chilled and frozen poultry and fresh eggs hereof shall be fulfilled.

15.2. Packaging and Wrapping of frozen and meat and poultry
   a. All details stated in clause (12.3) Packaging and wrapping of article (12) fresh, chilled and frozen meat hereof must be fulfilled.
   b. All details stated in clause (13.4) Packaging and wrapping of article (13) chilled and frozen poultry and fresh eggs hereof must be fulfilled.

15.3. Transport of frozen meat and poultry
   a. Sub-clauses (a, b, c “1, 3, 5, 6, 7, 8”, d, e, f) of clause (13.2) of article (12) fresh, chilled and frozen meat hereof shall be fulfilled.
   b. Meat and poultry may not be placed on the ground of the means of transport. They shall be fixed in place to prevent mechanical damage resulting from movement.
   c. All details stated in clause (13.5) of article (13) chilled and frozen poultry and fresh eggs.

15.4. Storage of frozen meat and poultry
   a. The stirage refrigerator may not be overloaded with frozen meat in a way exceeding its capacity approved and recommended by the manufacturing party to keep the efficiency of the freezing process and the quality and distribution of coolness inside.
   b. The meat shall be circulated based on the rule of first-in first-out; provided that the temperature during storage may not
exceed (-18 C).

The electrical current may not be disconnected for whatever reason as long as it is loaded with frozen meat; provided that fluctuation in temperature may not exceed (±2 C). A generator shall be available to be used in case of electricity disconnection.

d. All the details stated in article (13.6) of article (13) chilled and frozen poultry and fresh eggs hereof shall be fulfilled.

15.5. Display and sale of frozen meat and poultry

a. It is strictly forbidden to display and sell fresh and chilled meat or poultry

b. It is strictly forbidden to previously cut or season meat or poultry as this should be done before clients only.

c. Slaughtering or freezing date and date of expiry of frozen meat must be indicated.

d. There shall be a sign in an apparent place in the store written on it types of circulated frozen meat (cow, sheep or camels or poultry, their sources, imported (country of origin) or local.

e. Freezers must be used to display the meat and poultry; provided that the temperature may not exceed (-18 C) mounted on movable bases made of stainless materials and should be displayed in a way that prevents piling so that their temperature is not affected.

15.6. Cutting and seasoning of frozen meat and poultry

a. All clauses stated in article (18) use of frozen foodstuff in the Regulations on health requirements for restaurants, kitchens and the like shall be fulfilled.

b. Clauses (1, 2, 3) of article 16 processing and seasoning of meat and poultry hereof shall be fulfilled.

15.7. Packaging and wrapping of cut and seasoned meat and poultry

The clauses (4, 5) of article (16) processing and seasoning of meat and poultry hereof shall be fulfilled.
Article (16): Preparation and seasoning of meats and poultry

1. Avoid using primary materials that show signs of damage and spoilage, expired or of unknown origin.
2. All additives such as salt, vinegar, ground spices, yoghurt and garlic should comply with the relevant applicable standard specifications.
3. Preparation, processing and seasoning of meats and poultry should be done only at the customer request.
4. The seasoned meats shall be packed in clean and entire nutritional grade packages free from foreign substances and of known components with no recycled materials; provided that the type of meat, its storage method and validity period must be indicated according to the approved standard and the validity period may not exceed the validity period of the meat from which it was processed.
5. The seasoned meats shall be preserved in a cold environment between 0 - 4 °C away from heat sources and contamination until being received by clients according to their request.

Article (17): Preparation and sale of minced meats and poultry

17.1. Employed meats and poultry

a. Fresh meats and poultry

1. Fresh meats employed in processing ground meats should be clean and free from signs of damage and spoilage maintaining its natural properties such as color, odor, texture and valid for human consumption subject to the applicable standard specifications.
2. Fresh meats should be slaughtered at one of the established slaughterhouses and stamped with the slaughterhouse stamp provided all data of the stamp shall be legible such as name of the slaughterhouse, date of slaughtering, secret code of the slaughterhouse and meat type.
3. Fresh meats should be slaughtered at one of the established slaughterhouses provide that the label’s data shall be legible.
4. The storage temperature for fresh meat should not exceed 0°C.
b. **Frozen meat and poultry:**

1. The meat and poultry should be compatible with applicable standard specifications provide the period since slaughtering does not exceed 120 days for the meat and not more than half the shelf life for chicken.
2. Meat should meet the data on the food label and should not be imported from a restricted origin.
3. Meat and poultry should maintain all its natural properties and be free from foreign odors that indicate a change in its natural properties.
4. Meat and poultry should be free from free liquid and was not defrosted during any of the handling stages and its storage temperature does not exceed -18°C.

**17.2. Transport of processed meat and poultry:**

All requirements provided for in sub clause 12.2 and sub clause 13.4 of this regulation shall apply.

**17.3. Ground meat and poultry:**

a. All used materials should comply with the applicable standard specifications.

b. It’s strictly forbidden to prepare or display for sale any ground meat product of a dead or sick animal or slaughtered outside the established slaughterhouses or from corrupt meats.

c. It should not contain mucosal tissues, reproductive system members, urinary bladder, udder, lung, pluck or any parts from the heat or entrails or any other parts often not making part of the human diet.

d. The ground meat should be free from splinters, foreign substance, cartilage, tendon ligaments and clotted blood.

e. It should be a product of grinding one type of meat and mixing meat types is restricted.

f. It should be kept away from flies, insects, rodents and other
environments pollutants such as dust, smokes and odors.
g. The processing temperature should not exceed 10°C upon preparing the product.
h. In case of preparing ground meat or poultry from frozen meat or poultry, the grinding should be done at -4°C while if the meat or poultry was completely defrosted, it shall not be valid for producing ground meat and should not be refrozen.
i. It shall be preserved at the appropriate cooling temperature (between zero and one degree under freezing point) or freezing temperature (not exceeding -18°C).
j. It’s strictly forbidden to add colorants, preservatives, vegetal starch, vegetal fibers or any non-animal proteins except products where soya protein is added.
k. The fat particles should be homogeneous in the final product.
l. Fat may be added to the good carcasses meat with the purpose of modifying the percentage of fat to ground meat provided that the fat should be of the same type of meat employed for grinding. Condiments and spices may be added subject to good manufacturing.
m. It shall be restricted to handle the ground meat outside of the authorized stores. Cooling or freezing transport means shall be used to transport ground meat from the processing location to the display for sale locations in case of the stores operating only in preparing ground meat.

17.4. Packaging and wrapping:
Ground meat may be packed directly upon preparation in packages of various shapes and weights. The package should meet the following requirements:
a. It should not be harmful to health, may not contaminate the contents, hermetically sealed, not interacting with the packed meat and may not change its natural properties such as color,
odor, taste or texture.
b. Packages should not absorbing or permeable to water or water vapor particularly in the frozen meat packages. Inner packages should be place in waxed carton package and be quickly frozen such that the temperature inside the package records. -18°C.
c. It should be indicated on the ground meat package all the required data such as: store name, address, telephone number, type or meat or poultry use in processing (fresh or frozen), fats percentage, additives, net weight upon packaging, production date and expiration date (day/month/year) and the phrase “product of Kingdom of Saudi Arabia”.

17.5. Display and storage:
a. Packages shall be arranged inside the refrigerator according to production date to prevent spoilage.
b. Avoid storing processed ground meat in the same compartment with fresh, chilled or frozen meat.
c. Avoid using the scales of the store for any other purposes or materials other than ground meat.
d. Avoid frost ice accumulation and defrost it periodically to maintain the cooling efficiency of the refrigerator and keep the refrigerator away from heat sources and avoid disconnecting the power for any reason whatsoever as long as it’s loaded with meat. Avoid placing the ground meat packages on the cold room flooring.

Article (18): Preparation and processing of kofta

18.1. Employed meats:

Fresh or refrigerated kofta is made from beef, buffalo, camel, chicken or goat and should meet the following:
a. The meat should be free from bone, cartilage, connective tissues and entire and free from signs of damage and spoilage, not contaminated and maintain all its natural properties.
b. The employed meat should be from a known source and meeting the applicable standard specifications for human consumption.

c. Avoid defrosting frozen meat by any mean before grinding, instead it should be ground directly as frozen using special grinder in order to keep all meat features particularly the color.

d. It’s strictly forbidden to employ pork or lard or any of its products in the processing.

**18.2. Additives:**

a. All additives should comply with the relevant applicable standard specifications.

b. Some binding and bulking materials may be added at the proportions provided for in the applicable standard specification given it shall be expressly indicated in the datasheet.

c. No preservative or colorants may be added and ascorbic acid shall be allowed as anti-oxidant.

**18.3. Meat storing:**

All requirements provided for in sub clause 12.4 of this regulations shall apply.

**18.4. Preparation and processing:**

a. Mix and stir the kofta meat ingredients thoroughly to obtain a homogeneous mixture such that single ingredients shall not be distinct by naked eye.

b. The mixture if is to be molded in different shapes such as fingers or balls by using suitable forming machines.

c. Upon producing the chilled meat kofta it shall be quickly cooled to -1 °C and stored cold at a temperature not exceeding -1°C.

d. Upon producing the frozen meat kofta it should be frozen immediately.

e. Different types of meat should not be mixed.

f. Mucosal tissues, reproductive system members, urinary bladder, udder, lung, pluck or any parts from the heat or entrails or any
other parts often not making part of the human diet shall be employed.
g. Manufacturing area temperature should not exceed 10°C during preparation of the products and the temperature of the manufactured meat should not exceed -4°C.

18.5. Packaging and wrapping:
a. The package should be clean, brand-new, not previously used and comply with the applicable standard specifications and further it should be strong and sturdy to withstand the storing, transport and handling.
b. It should be manufactured from materials safe to health.
c. It should not interact with the packaged material and shall maintain its physical and chemical properties.
d. It should be impermeable, attractive and adapted to the preservation method (refrigeration, freezing).
e. There should be a datasheet on the product indicating all the product data in Arabic language in a legible and indelible font. Such datasheet should be firmly fixed.

18.6. Final product:
It shall meet the provisions of the applicable standard specifications to include:
a. It should be free from rancidity and undesirable odors and foreign substances.
b. The final product shall maintain its distinctive taste and odor and be of consistent texture and free from signs of damage and spoilage or any free liquid.

18.7. Storage:
a. Chilled products shall be preserved at a temperature of 0.5 - ±1°C.
b. Frozen products shall be preserved at a temperature of -18°C.
c. All requirements provided for in the applicable standard specification regarding chilled and frozen foodstuffs shall apply.
18.8. Transport:
   a. A suitable refrigerated transport means should be used such that the temperature shall not exceed 0.5 ±1°C or a freezer transport means where the temperature shall not exceed -18°C/
   b. The transport means shall not be used to transport any other material that may contaminate the Kofta.
   c. All the workers operating the transport means should hold a valid medical certificate.
   d. All requirements provided for in sub clause 12.2 of this regulation shall apply.

Article (19): Burger preparation and processing

19.1. Employed meat:
   Burger is made from beef, buffalo, camel, chicken or goat and should meet the following:
   a. The meat should be free from bone, cartilage, connective tissues, fat and any non-edible parts.
   b. The employed meat should be from a known source and meeting the applicable standard specifications for human consumption.
   c. It shall be entire and free from signs of damage and spoilage and not contaminated and keeping all its natural properties.
   d. It’s strictly forbidden to employ pork or lard or any of its products.
   e. It’s strictly forbidden to defrost frozen meat by any means before grinding, instead it should be ground directly as frozen using special grinder in order to keep all meat features particularly the color

19.2. Additive materials:
   a. All additives should comply with the relevant applicable standard specifications and preservatives or colorants are restricted.
   b. Some binding and bulking materials may be added at the
proportions provided for in the applicable standard specification
given it shall be expressly indicated in the datasheet.

19.3. Meat storing:
All requirements provided for in sub clause 18.7 of this regulation
shall apply.

19.4. Processing:
a. Mix and stir the burger meat ingredients thoroughly to obtain a
   homogeneous mixture such that single ingredients shall not be
   distinct by naked eye.
b. It’s strictly forbidden to mix different types of meat in the
   mixture and employed type of meat should be indicated on the
   final product package.
c. Burger disks shall be placed automatically into two packages,
   one with 50 gm. disks and the other with 100 gm disks.
d. Use non-absorbent paper between the burger disks provided
   such paper is clean, entire, not contaminated and brand-new and
   which shall not affect the final product.
e. Packing and wrapping disks should be done quickly then the
   product is refrigerated or frozen.

19.5. Packaging and wrapping materials:
All requirements provided for in sub clause 18.5 of this regulation
shall apply.

19.6. Final product:
It should be compliant with the provisions of the applicable standard
specification namely:
a. It should be free from foreign materials, bones, cartilage,
   entrails, feather and hair.
b. All the units should be similar in shape, size and weight.
c. It should be of solid consistency, free from damage and spoilage
   signs and free from free liquids.
d. Fat percentage shall not exceed 15% in chicken burger and 20%
in beef burger.
e. Meat percentage shall not be less than 70% by mass in the product free from binding and bulking materials and not less than 65% of the weight with added binding and bulking materials.

19.7. Storage:
Beef burger shall be stored frozen at a temperature not less than -18°C.

19.8. Transport:
a. Use a transport means suitable for transporting frozen foodstuffs at a temperature not exceeding -18°C for the frozen product and 4.4°C or less for the refrigerated product.
b. Avoid using the transport means for other material that may contaminate the burger.
c. All the workers operating the transport means should hold a valid medical certificate.
d. All requirements provided for in the relevant applicable specifications regarding transport of chilled and frozen foodstuffs shall apply.

Article (20): Luncheon meats preparation and processing

20.1. Used meat:
All the requirements provided for in sub clause 18.1 of this regulation shall apply.

20.2. Additives:
a. It should be compliant with relevant standard specifications and free from signs of damage and spoilage.
b. Binding and bulking materials may be added provided it shall be expressly indicated in the datasheet.
c. Used emulsifying salts should be of nutritional grade, i.e. clean and free from harmful impurities and compliant with approved standard specification.
d. It’s strictly forbidden adding any preservative or colorant.
20.3. Meat storage:
All the requirements provided for in sub clause 18.7 of this regulation shall apply.

20.4. Manufacturing:

a. Mix and stir the beef mortadella meat ingredients thoroughly to obtain a homogeneous mixture such that single ingredients shall not be distinct by naked eye.

b. The meat shall be of only one type and mixing various types is restricted.

c. It’s strictly forbidden adding any fatty material from any source other than animal fats of the same employed meat.

d. Meat percentage should not be less than 80% of the mass.

e. Bulking materials (starch) shall not exceed 3.5% in mass.

f. Table salt shall not exceed 3% in mass.

g. The fat percentage in the final product shall not exceed 25% in mass.

h. Packages used should be authorized, heavy-duty, sturdy, withstand thermal treatment for long time, should not be harmful to health, shall not contaminate the packed material and shall not interact with it, and shall not change its physical or chemical properties.

i. In case of using colored synthetic packages, the colors should be stable and of nutritional grade authorized for use and not harmful.

j. Provide adequate number of pressure packing machines for packing and air vacuuming. There should be not air pockets in the mixture during packaging to avoid explosion of the package during cooking or thermal treatment.

k. It should be equipped with ovens for cooking the luncheon mixture. Cooking is done directly after packaging at a suitable temperature and duration to ensure the heat reaches all the parts until full cooking.
l. In case of beef luncheon mixed with meat, the same type of meat shall be chopped into small cubes and be poached before mixing with other ingredients and packing in packages. 
m. The product should be cooled directly after cooking to stop the heat effect and to maintain the physical properties and the color. This process is done by a using a cold water shower preferably in a separate location of the store isolated with curtains. 
n. The water used in cooling should be compliant with the approved standard specification. 
o. Inspect the packages in order to exclude the damaged packages and those non-marketable. 
p. Luncheon meat may be cut into slices and be marketed packed or wrapped. 

20.5. Packaging and wrapping of beef luncheon slices: 
   a. The package should be clean, brand-new, not used previously and compliant with the approved standard specification. 
   b. It should be made from non-harmful materials. 
   c. It should not interact with the packaged material and shall preserve its physical and chemical properties. 
   d. It should be impermeable to water and air-tight. 
   e. It should not contaminate the packaged material. 
   f. It should be suitable with the preservation method (chilling, freezing). 
   g. It should be heavy-duty, sturdy and withstand the storage, transport and handling. 
   h. It should be attractive. 
   i. There should be a datasheet on the product indicating all the data in Arabic language and in a legible and indelible font. 
   j. Regarding canned luncheon beef: 
      1. The can should be internally coated with a paint suitable for packing meats.
2. The internal surface of the can should be free from black spots or erosion.

**20.6. Luncheon meat properties:**

It shall be compliant with the approved standard specification including but not limited to the following:

a. The product should be of homogeneous consistency and liable for cutting and free from spoilage signs such as undesirable odors.
b. Meat percentage shall not be less than 90% by mass in the product free from binding and bulking materials and not less than 80% otherwise.
c. The product should be free from synthetic colorants, pork, lard and products.
d. The employed meat shall be of only one type having the distinctive flavor of such type.

**20.7. Storage of the final product:**

a. Packaged luncheon meat shall be refrigerated provided that the thermal center of the product shall not exceed 5°C.
b. Packaged luncheon meat shall be stored at 25°C and if chilled at 5°C if the original packing is opened.

**20.8. Transport:**

a. Suitable transport means shall be used provided that the thermal center of the canned or packed luncheon meat shall not exceed 5°C and not more than 25°C for canned ones.
b. Avoid using the transport means for other material that may contaminate the luncheon.
c. All the workers operating the transport means should hold a valid medical certificate.
d. All requirements provided for in the relevant applicable specifications regarding transport of chilled and frozen foodstuffs shall apply.
Article (21): Pastrami preparation and processing

21.1. Employed meat:
   a. The meat should be boneless, free from bone, cartilage and connective tissues.
   b. It shall be processed preferably from major muscles of the fore or hind parts of the carcass.
   c. Fats in meat should not exceed 6% by mass provided visible fats shall be removed.
   d. Employed fresh meat should be from a known source and meeting the applicable standard specifications.
   e. It shall be entire and free from signs of damage and spoilage and not contaminated and keeping all its natural properties.
   f. Meat should be entire and free from damage and spoilage sings, non-contaminated and having all its natural properties.
   g. It’s strictly forbidden to employ pork or lard or any of its products.
   h. Frozen meat should be valid for human consumption, compliant with approved standard specifications and free from signs of damage and spoilage and free liquids.
   i. Frozen meat kept in refrigerators should be defrosted at a temperature not exceeding 4°C for a period of 8 hours.
   j. Avoid using the bathtubs connected to sewerage in defrosting meat, re-freezing the meat or any part thereof once defrosted.

21.2. Seasoning materials:
   Materials used for manufacturing pastrami should be compliant with relevant approved standard specification.

21.3. Pastrami (the final product):
   a. The percentage of the casing to meat should not exceed 18% of the final weight of marketed meat mass.
   b. The casings should be entire, uniform and cover all the meat mass without cracking.
c. It should be free from damage and spoilage signs, mold and fungal growth and any other harmful material.
d. The produced pastrami shall have the distinctive taste and odor.
e. Color should be ping and it shall be free from dark or brown color that indicates meat spoilage.
f. Certain natural flavors may be used in pastrami manufacturing.
g. It should be ripe and free from free liquids and from colorants.
h. The percentage of red meat shall not be less than 94% and total fat shall not exceed 6%.
i. Humidity should not exceed 50% by mass and table salt (sodium chloride) shall not exceed 8% by mass.

21.4. Packaging and wrapping:

a. Packages should be clean, entire, transparent and non-contaminating.
b. The packaging and wrapping materials shall be made from healthy items, not affecting the physical and chemical properties of the packaged pastrami.
c. It’s recommended to conduct packaging under vacuum.
d. Datasheet should be placed on pastrami packages subject to the specification of packaged food card.

21.5. Storage, transport and display:

a. Ordinary pastrami shall be stocked in dry and well ventilated warehouses at room temperature (25°C) pending marketing within its shelf life.
b. Upon cutting or removal of casing, pastrami should be stocked at a temperature not exceeding 4°C.
c. Transport pastrami at room temperature not exceeding (25°C).
d. Transport should be done by means that protect the product against mechanical damage and spoilage and not used for transporting any other toxic or harmful materials.
e. All the workers operating the transport means should hold a valid medical certificate.

Article (22): Sausage preparation and processing

22.1. Employed meat:

All the requirements provided for in sub clause 19.1 of this regulation shall apply.

22.2. Additives:

a. All additives such as salt, spices, yoghurt … etc. should be valid, non-contaminating, non-harmful and comply with the relevant applicable standard specifications.

b. Certain bulking materials such as breadcrumbs, potatoes starch, potatoes flour, rice starch, ground rice, bread, corn flour may be added at the proportions provided for in the approved specification.

c. Certain binding agents such as skimmed milk, caseins, whey powder, egg protein, wheat gluten, soya proteins may be added at the proportions provided for in the approved specification.

d. Certain authorized antioxidants, emulsifying salts and preservatives and some organic acids and smoking solutions may be added at the proportions provided for in the approved specification.

22.3. Meat storage:

All the requirements provided for in sub clause 18.3 of this regulation shall apply.

22.4. Manufacturing:

a. Mix and stir the sausage meat and other ingredients thoroughly to obtain a homogeneous mixture.

b. Natural casings may be used provided it shall be entire, non-contaminated and valid for human consumption having all its natural properties and washed extensively.

c. In case of using synthetic casings in packing, it should be
compliant with the specifications and be of the edible type (collagen) and recommended for use which does not cause any harm either to the producer or consumer.
d. Non-edible synthetic casings may be used such as cellophane provided such shall be indicated on the product card and be removed before consumption.
e. It shall not be allowed to add any other fats or oils from any other source except that used for manufacturing.
f. In case of smoking the sausages, a good smoke producing wood should be employed and it’s recommended to use the doneness ovens equipped with a smoker generating unit. It’s strictly forbidden to use the chemical taste additives while natural smoking liquids shall be allowed under good production.
g. Regarding the cooked sausages or cooked and smoked ones the store should be equipped with a refrigerating system for cooling the final product after cooking by using pumped water spray. The water used should be compliant with the applicable specification and the cooling area should be fitted with plastic curtains to limit spreading of cooling water beyond cooling area.
h. In case of using frozen poultry in manufacturing the product, the grinding process should be conducted at a temperature not exceeding -4°C.

22.5. Packaging and wrapping:
Sausages shall be packaged in vacuumed packages or under the atmospheric pressure and the package should meet the following:
a. It should be clean, brand-new, of attractive shape and not previously used and be compliant with the approved specification.
b. It should healthy, non-interacting with the packaged material and shall preserve its physical and chemical properties.
c. It should be impermeable to water and air-tight.
d. It should be suitable with the preservation method (chilling, freezing).

e. Shelf life shall depend on the manufacturing conditions, thermal treatment and preservation temperature subject to the applicable standard specification as follows:

<table>
<thead>
<tr>
<th>Type</th>
<th>packaging conditions</th>
<th>storage temperature</th>
<th>Shelf life</th>
</tr>
</thead>
<tbody>
<tr>
<td>Non-cooked chilled</td>
<td>Ordinary</td>
<td>-5 : +1°C</td>
<td>3 days</td>
</tr>
<tr>
<td>cooked chilled</td>
<td>Ordinary</td>
<td>-5 : +31°C</td>
<td>14 days</td>
</tr>
<tr>
<td>cooked chilled</td>
<td>Air vacuum</td>
<td>-5 : +1°C</td>
<td>51 days</td>
</tr>
<tr>
<td>cooked frozen</td>
<td>Ordinary</td>
<td>-18°C</td>
<td>9 months</td>
</tr>
</tbody>
</table>

To note that the shelf life of the chilled or frozen final product prepared from chilled or frozen meat shall not exceed the remaining shelf life of chilled or frozen meat effective date of slaughtering.

f. There should be a datasheet on the product indicating all the product data in Arabic language in a legible and indelible font.

22.6. Sausage features:

It shall be compliant with the applicable standard specifications including but not limited to the following:

a. The weight percentage of table salt should not exceed 3%.
b. The product should be free from foreign substances, impurities, undesirable odor and taste.
c. The total fat content in the final product should not exceed 15% by mass.
d. The product should be free from synthetic colorants.

22.7. Storage and transport of the final product:

a. Storage and transport shall be through means that shall protect the product against mechanical damage and spoilage.
b. Non-thermally treated or chilled cooked sausages shall be preserved at a temperature of -0.5 - ±1°C.
c. Chilled cooked sausage canned under vacuum shall be stored at a temperature not exceeding -0.5 - ±1°C.
d. Frozen cooked sausage shall be stored at a temperature not exceeding -18°C.
e. Transport shall be secured by suitable means not previously used to transport any toxic or harmful materials providing the necessary temperature as required.
f. All controls regarding storage and transport of chilled and frozen foodstuffs as provided for in the approved standard specifications shall apply to the warehouses and transport means.

Article (23): Public hygiene

Provisions of article 10 Public hygiene of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

Article (24): Pest control

Provisions of article 11 Pest control of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

Article (25): Handling customer complaints

1. A system should be set up to handle the complaints related to the products.
2. Appropriate action should be undertaken to address the problem severity and frequency in an effective and diligent manner.
3. Build on the information in the complaints as much as possible to introduce continuous improvements to the product safety, legal obligations and the quality as provided for in the approved standard specification and trying to avoid recurrence.
Article (26): Licensing

Provisions of article 12 Licensing of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

Article (27): Health control record

Provisions of article 13 Health control record of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.
Chapter 4
Manpower requirements
Article (28): Practice license

a. Workers operating in the field of handling foods shall hold certificates issued by the authorized competent health authorities indicating they are free from diseases transmissible to food.

b. Such licenses are issued upon clinical inspection and necessary examinations undergone by the workers and after vaccination against some epidemic diseases as may be agreed upon between the ministry of health and this ministry as provided for in article 14 Practice license of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities”.

Article (29): Professional license validity

The validity or the professional license is one year to be immediately renewed upon expiration by following the aforementioned steps.

Article (30): Infectious diseases and injuries

Provisions of article 16 infectious diseases and injuries of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

Article (31): Awareness

Provisions of article 17 Awareness of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

Article (32): Personal hygiene and health practices

Provisions of article 18 Personal hygiene and health practices of the “Regulations on general health requirements for the food preparation, processing and sale stores & public health related facilities” shall apply.

Article (33): Visitors related precautions

All visitors to the food processing premises should observe all the practices of the food handlers including hand washing, hair covering, wearing masks and gloves and should refrain from any activity that may contaminate poultry and products.
Chapter 5
Monitoring enforcement of the regulations
Article (34): Monitoring enforcement of the regulations

The ministry of municipal and rural affairs shall be of competence in monitoring these regulations in the stores of preparation and processing of meat and poultry.