AIB International

GMP Inspection Results Report

Consolidated Standards for Inspection: Food Contact Packaging Manufacturing Facilities

Contacts	**US Office:**
	1201 Bakers Way PO Box 3999, Manhattan, KS 66502-3999 Phone: (785) 537-4750 • (800) 633-5137
	UK Office:
	AIB International UK-LTD Riverbridge House Fetcham Grove Guildford Rd Leatherhead, Surrey, KT22 9AD, UK Phone: +44 (0) 1372 365 788
	China Office:
	AIB Food Technical Consulting Co., Ltd. Heyuan Central Enterprise Center Room 909 No. 2993 Gong He Xin Road Shanghai 200072 China Phone: +86-021-60959606
Website	https://www.aibinternational.com/

The AIB International Consolidated Standards for Inspection are statements that represent key requirements that a facility must meet in order to keep products manufactured, processed or handled in a facility wholesome and safe. The Standards reflect what an inspector would expect to see in a facility that maintains a food-safe processing environment.

This report details the findings from an AIB International inspection against the Consolidated Standards. The document contains the following sections:

Document Section	Description
Score and Rating	• Description of the facility • Category scores and total score • Rating
Participant Names	Personnel from the facility who accompanied the inspector
Location Matrices	Two matrices which categorize findings by Category and Risk
Findings with Risk	Descriptions and recommendations related to all findings
Additional Comments	Comments made by the inspector that have no risk assessment
Standards without identified Risks or Findings	Standards that are applicable to the inspected facility, but based on random review and observation samplings at the time of the inspection, the facility appears to be meeting requirements
Standards Not Applicable	Standards that are not applicable to the inspected facility

Score and Rating

Inspection Information:

Facility Name	VPK Packaging Limited
Facility Address	Ham Road, Chelston Business Park Wellington, England TA21 9JG United Kingdom
Products Produced or Stored	A wide range of customized, corrugated packaging solutions from standard boxes, shelf-ready packaging, corrugated trays, wrap around trays, corrugated sheets to customized boxes.
Location ID	3926

Standard Used	Food Contact Packaging Manufacturing Facilities
Date(s) of Inspection	23-Sep-2025, 24-Sep-2025
Audit Type	Scored GMP Inspection
Announcement Type	Announced
Terminated	No
Audit Number	AO-042810

Scope	The flexographic printing, die-cutting, folding, slotting and gluing of fiberboard for use with food, beverages, dairy, and pharmaceutical products. The die-cutting of LDPE film coated fiberboard.
Variations From Expected Scope	At the last audit, the rooftop was under CDM for re-coating purposes, so the area could not be inspected due to safety concerns. This has now been completed. The area was inspected and found to be clean and well maintained.

Score

Category	Minor Issues Noted (180-195)	Improvement Needed (160-175)	Serious (140-155)	Unsatisfactory <= 135	Score
Operational Methods and Personnel Practices	0	0	0	0	200
Maintenance for Food Safety	1	0	0	0	180
Cleaning Practices	0	1	0	0	175
Integrated Pest Management (IPM)	1	0	0	0	195
Adequacy of the Prerequisite and Food Safety Programs	0	2	0	0	170
Total Score					**920**

Participant Names

Name	Role	Opening Meeting	Inspection	Closing Meeting
Matthew Langmaid	Compliance Manager	Yes	Yes	Yes
Ernest Manning	Conversion Lead Team Leader	Yes	Yes	Yes
Saulius Kristinaitis	Corrugator Lead Team Leader	Yes	Yes	Yes
Charlie Ducker	HSE Manager	Yes	-	Yes
Mircea Covaciu	Manufacturing Manager	Yes	-	Yes
Paul Hill	Plant Manager	Yes	-	Yes
Mariusz Ruminski	Warehouse Manager	Yes	-	Yes
Samuel Yensu	Auditor	Yes	Yes	Yes

Findings by Location and Category

Locations	Operational Methods and Personnel Practices	Maintenance for Food Safety	Cleaning Practices	Integrated Pest Management	Adequacy of Prerequisite and Food Safety Programs	Totals by Location
Production	0	1	2	0	0	3
Program Review	0	0	0	0	2	2
Warehouse	0	0	1	1	0	2
Totals by Category	0	1	3	1	2	7

Findings by Location and Risk

Locations	Minor Issues Noted	Improvement Needed	Serious	Unsatisfactory	Totals by Location
Production	1	2	0	0	3
Program Review	0	2	0	0	2
Warehouse	1	1	0	0	2
Totals by Category	2	5	0	0	7

Findings with Risk

#	Risk	Standard	Standard #	Requirement #	Location	Finding	Recommendation
1	Improvement Needed	Non-Product Zone and Support Area Cleaning	3.9	3.9.1.10	Warehouse	A considerable amount of general debris was evident inside the left and right hand side metal plates behind the large door in the paper reel storage area. The area had been cleaned according to records reviewed; 22 September 2025. However, it was obvious that the area had not been done to the required standard.	The general debris should be removed, and improved cleaning completed. Personnel undertaking cleaning activities in the area should be briefed on the level of cleaning required.
2	Improvement Needed	Non-Product Zone and Support Area Cleaning	3.9	3.9.1.10	Production	Product related residue together with general debris was evident inside the stereo cylinder section of the Evol machine. This section of the machine was hard to reach, and so could have been missed at the last cleaning activity. Accumulation of product related debris was evident around the drive sections of the DRO 1628 NT RS machine. This area was hard to reach and so had not been cleaned to the required level.	The product related debris should be removed, and improved cleaning completed.
3	Improvement Needed	Non-Product Zone and Support Area Cleaning	3.9	3.9.1.10	Production	A medium level of dust was evident inside the framework that was mounted on top of reel unwind section of the Agnati corrugator. This debris had not been removed from the frame	The debris should be removed from the equipment, and improved cleaning completed.

						during the last cleaning activity.	
4	Improvement Needed	Cleaning Program	5.11	5.11.1.3	Program Review	Cleaning schedules were developed and implemented. However, cleaning issues that were either program omissions or presented potential contamination risks and relating to product zones cleaning/periodic cleaning, non-product zone cleaning of equipment and structures were identified. Details of recommendations are in the report.	The site's cleaning program should be revised. Post-cleaning verification activities should then be improved to identify those areas that had not been cleaned to the required level of standard.
5	Improvement Needed	Approved Supplier Program	5.20	5.20.1.2	Program Review	The approved supplier list posted on a section of the wall in the reel intake area was not current and accurate. A total of 5/27 supplier's FSC Certification had expired.	A current and accurate list of approved and non-approved suppliers based on product safety and economically motivated adulteration risks.
6	Minor Issues Noted-Severe	Lubrication Management	2.11	2.11.1.1	Production	A couple of oil leaks were evident around sections of the drive motor bearing that had been mounted at the side of the lower stacking section of the Agnati corrugator. This observation was further away from the product zone.	Personnel undertaking lubrication activities should be reminded to enure that any access grease is removed from equipment following maintenance activities.
7	Minor Issues Noted	Interior Rodent Monitoring Devices	4.10	4.10.1.4	Warehouse	In the paper reel storage warehouse, there were two internal rodent monitoring devices, namely #3 and#4 at that had been moved away from their original locations.	Personnel should be reminded of the correct positions of rodent boxes to ensure that the devices remain effective.

Additional Comments

#	Standard	Standard #	Requirement #	Comment
1	Storage Practices	1.3	1.3.1.3	Clear, unrestricted perimeters were provided at floor-wall junctions to ensure adequate access for cleaning, inspection, and pes control activities. These were noted in the reel and finished products warehouses.
2	Bulk Material Handling	1.9	1.9.1.1	The only bulk material received was wheat starch. The outside receiving line or cap for this bulk dry ingredient was locked. The inlet for Starch-Mylbond 210 was seen to be locked. The starch was delivered into a double skinned silo of 50T storage capacity.
3	Bulk Material Handling	1.9	1.9.1.3	Two seals were applied to the rear of the bulk starch truck. These were recorded and checked against the delivery note. The supplier of the SADABOND 210 starch powder (modified wheat starch) was SEDAMYL. COA was received for each bulk load. An example of COA (lot #: 8200016296) dated 23 September 2025 was reviewed. % Moisture=10.2% (10-13), pH=8.0 (6.5-8.5), Viscosity (mPa.s)=3700 (3000-5000), Alkali sensnsity (mPa.s)=< 100 (0-100).
4	Finished Product Transportation	1.25	1.25.1.6	Delivery routes were optimized by multi-dropping. Most of the finished products were secondary packaging. Only one customer received food contact finished product. This customer had indicated clearly via email dated 26 June 2023 that there was no significant risk to them due to the type of materials supplied and that the materials were also supplied within the UK. During loading, each truck had a load ''checker'' who takes photographs of the completed load as evidence that the finished products on the truck were untampered.
5	Lubricants	2.12	2.12.1.2	In the maintenance workshop, lubricants were labelled, segregated, and stored in a designated, secure area. It was also noted that food grade and non-food grade lubricants were kept separate from each other.
6	Equipment and Utensil Construction	2.14	2.14.1.1	There was minor damage to a small section of the outfeed conveyor belt of BOBST 160-S convertor. The damaged belt had been captured, and documented. The site would monitor the belt for further deterioration until repair is completed. The damage should be repaired to prevent further deterioration in condition.
7	Insect Light Traps	4.11	4.11.1.7	The pest controller documents the types and quantities of insects found in the light traps and uses the information to identify and eliminate the source of activity. Trending was also completed. Risk or action levels were suitably defined.
8	Insect Light Traps	4.11	4.11.2.1	The most recent fly killer service with tube change was on 14 April 2025.
9	Bird Management	4.13	4.13.1.1	Birds were managed by exclusion with nets. For example, the reel intake area.

10	Accountability	5.1	5.1.1.1	Generally, Operational Methods and Personnel Practices were managed well and found to be satisfactory. The site's product incoming and shipping procedures were satisfactorily implemented. Raw materials and finished product storage were well managed and there was enough distance from the wall to stored products. Clear, unrestricted perimeters were provided at floor-wall junctions to ensure adequate access for cleaning, inspection, and pes control activities. These were noted in the reel and finished products warehouses. The operators were suitably well-trained and demonstrated hygiene practices properly.
11	Accountability	5.1	5.1.1.2	The site held the following external accreditations / certifications: BRCGS Packaging Materials Issue 6, AIB The AIB International Consolidated Standards for Inspection Food Contact Packaging, ISO14001 : 2015, FSC, SEDEX, and ECO Vadis.
12	Training and Education	5.3	5.3.1.5	There was a written procedure for developing and delivering training and education to all personnel to include product safety, product defence, pest control, and allergen awareness among others. There was also a training matrix in place to ensure that all employees are trained to the required standard.
13	Self-Inspections	5.4	5.4.1.2	This site schedules and conducts self-inspections of the entire facility and outside grounds at least weekly. Examples of completed inspections (BOBST DRO 94.12% for July 2025, BOBST #2, 100% for June 2025) were reviewed on the iAuditor App. A scoring system was used for grading. All persons completing audits wee suitably trained.
14	Integrated Pest Management (IPM) Program	5.5	5.5.1.1	The site's pest control program was managed by an external company called Vergo Pest Management Limited. Vergo was a member of BPCA with registration #: M15/279 that expires on 28 February 2026. Training records for all Technicians, including the Field Biologist, were on file. Certificate of employers' lability insurance was current; expiring on 29 September 2025. This was issued by QBE. The most recent biologist visit or facility assessment was completed on 04 September 2025. The pest control map was last updated on 11 June2025. There was a pesticide/product usage log in place. Nara blocks and Detex Blox. These were non-toxic chemicals.

15	Customer Complaint Program	5.6	5.6.1.1	Customer complaint & CAPA program implemented. A complaint tracker was in place. There was a total complaint of 112 Y2D. All complaints were catalogised and trended. Top 3 complaints were glueing, print quality, case quality. 4 complaints were outstanding pending completion.
16	Chemical Control Program	5.7	5.7.1.2	Chemical control program, P1102, in place. Chemical awareness was part of the site's induction training. Inks used for printing were prepared by an external company called Flint. MSDSs for all inks were on file. All print chemicals conformed to Regulation (EC) No: 1907/2006 (REACH), Annex II UK. An approved chemical list was also in place.
17	Microbial Control Program	5.8	5.8.1.1	There was a microbial control program that was part of the HARA study. The site assessed the types of microbiological risks/likely pathogens and determined testing that is to be completed for Listeria spp, Coliforms, Enterobacteriaceae, Yeast & Mould, Salmonella spp. Swab testing was completed annually. An example of the last round of test was completed on 29 October 2024. The testing was completed by Southern Microbiological Services, SMS (UKAS #: 1922).
18	Allergen Control Program	5.9	5.9.1.1	No intentional allergens were included in the ink formulations. An allergen statement dated 25 June 2025 was in place, and was available upon request by customers. Allergens were also included as part of the HARA. Wheat starch was used for glueing. It was determined that, the worst case scenario would be the total migration of gluten from the corrugated board into the food. In relation to EU Directive 1935/2004, the maximum risk of wheat gluten in corrugated board can be assessed with the assumption of total migration.
19	Glass, Brittle Plastics, and Ceramics Program	5.10	5.10.1.3	There was a program of inspection in place. Inspections were scheduled and completed monthly. Records from May 2025, June 2025, July 2025 were reviewed.
20	Food Defense Program	5.15	5.15.1.2	The site had a written vulnerability assessment, which was performed by person(s) trained in Product Defence. Vulnerability assessment was reviewed on a defined frequency or when significant changes occur. The assessment looked at: raw materials group, threat/vulnerability, controls to prevent, likelihood of occurrence, likelihood of detection, risk, extra controls required. The site was 100% fenced with 24h security monitoring. There was a gatehouse in place. CCTVs were installed in sensitive areas. The inlet for starch-SEDABOND 210 with a 50T storage capacity in the double skinned silo was locked.
21	Traceability Program	5.17	5.17.1.4	The most recent traceability exercise was completed on 18 August 2025. It took 2hrs:30min to complete the trace.

22	Recall/Withdrawal Program	5.18	5.18.1.1	The site had a serious customer complaint relating to glass contamination on the bed of a delivery lorry after it had been loaded. RCA, CAPA had been suitably completed.
23	Hazard Analysis Critical Control Points (HACCP)	5.22	5.22.1.6	The site's HARA was completed at least annually or when there is a significant change. The most recent HARA review, happened in October 2024.
24	Water Quality	5.25	5.25.1.2	The site had a safe and/or potable water supply from an approved source, The water supplier was Wessex Water.
25	Water Quality	5.25	5.25.1.3	Documentation of the results of water testing was on file. The last round of water testing was completed on 01 September 2025 for L8. This was done by Houseman Environmental.
26	Testing Requirements	5.26	5.26.1.1	The site completes migration testing on only one food contact product every 2 years. The last one was done in 17 January 2025.
27	Label Verification Program	5.27	5.27.1.1	No physical labels were on the actual products. Only finished product labels were printed. There was a procedure, Pallet Labels detailed in PO603 dated August 2022.

Standards Without Identified Risks or Findings

Based on random review and observation samplings at the time of the inspection, the facility appears to be meeting the requirements of the following Standards:

Standard	Standard #
Receipt/Rejection of Dry Goods	1.1
Storage Practices	1.3
Storage Conditions	1.4
Raw Material/Packaging/Finished Product Inventory	1.5
Pallets	1.6
Dust Collection and Filtering Devices	1.8
Bulk Material Handling	1.9
Processing Aids	1.11
Material Transfer	1.12
Foreign Material Control Devices	1.15
Waste Material Disposal	1.16
Ingredient Containers, Utensils, and Tools	1.17
Workspace Arrangement	1.19
Cross-Contamination Prevention	1.23
Finished Product Transportation	1.25
Hand Washing Facilities	1.26
Washrooms, Showers, Locker Rooms, and Other Welfare Areas	1.27
Personal Hygiene	1.28
Work Clothes, Changing Facilities, and Personnel Areas	1.29
Personal Items and Jewelry Control	1.31
Health Conditions	1.32
Non-Facility Personnel	1.33
Waxes, Sealants, Adhesives, and Inks	1.40
Facility Location	2.1
Outside Grounds and Roof	2.2
Layout	2.3
Floors	2.4
Drains	2.5
Walls	2.6

Ceilings and Overhead Structures	2.7
Glass, Brittle Plastics, and Ceramics Control	2.8
Air Makeup Units	2.9
Pest Prevention	2.10
Lubricants	2.12
Cross-Contamination Prevention	2.13
Equipment and Utensil Construction	2.14
Temporary Repair Materials	2.15
Equipment Calibration	2.16
Compressed Air/Product Contact Gases	2.17
Transporting Equipment	2.18
Maintenance Shop/Parts Storage	2.19
Hand Washing Facilities Design	2.20
Bulk Systems, Unloading Areas, and Loading Areas	2.21
Cleaning	3.1
Cleaning Compounds and Sanitizers	3.2
Cleaning Tools and Utensils	3.3
Cleaning Methods/Equipment	3.4
Daily (Housekeeping) Cleaning	3.5
Operational Cleaning	3.6
Periodic Cleaning Tasks/Product Zone Cleaning	3.7
Maintenance Cleaning	3.8
Clean-Out-of-Place (COP) Systems	3.11
Facility Assessment	4.1
Scope of Service	4.2
Credentials and Competencies	4.3
Pesticide Documentation	4.4
Pesticide Application Documentation	4.5
Trend Analysis	4.7
Monitoring Device Documentation	4.8
Exterior Rodent Monitoring Devices	4.9
Insect Light Traps	4.11
Bird Management	4.13
Wildlife Management	4.14

Identified Pest Activity	4.15
Accountability	5.1
Support	5.2
Training and Education	5.3
Self-Inspections	5.4
Integrated Pest Management (IPM) Program	5.5
Customer Complaint Program	5.6
Chemical Control Program	5.7
Microbial Control Program	5.8
Allergen Control Program	5.9
Glass, Brittle Plastics, and Ceramics Program	5.10
Preventive Maintenance Program	5.12
Receiving and Shipping Program	5.13
Regulatory Affairs and Inspections Program	5.14
Food Defense Program	5.15
Traceability Program	5.17
Recall/Withdrawal Program	5.18
Non-Conforming Product Program	5.19
Hazard Analysis Critical Control Points (HACCP)	5.22
Water Quality	5.25
Testing Requirements	5.26
Label Verification Program	5.27

Standards Not Applicable

Standard #	Standard
1.7	Carry-over and Rework
1.20	Single-Service Containers
1.24	Cans, Bottles, and Rigid Packaging
1.34	Glass Container Breakage
2.23	Wastewater Treatment and Sewage Disposal
4.6	Pesticide Control
4.12	Pheromone Monitoring Devices
5.24	Positive Hold and Release Procedures