



Food Safety Assurance Unit, May 2024

Technical Expectations – Food Suppliers using PP Woven Bags

Purpose

The purpose of this document is to establish the requirements WFP expects from food suppliers packing commodities in PP woven bags.

Conditions of the document are used for the audit purposes and technical assessment. Not complying with these requirements may generate critical, major or minor observations and/or suspension of the supplier.

Requirements

1. *Compliance with WFP specifications and contract conditions*
Supplier must incorporate all requirements of WFP specifications and contract conditions in its QM system.
2. *Packaging material reception*
 - Food suppliers shall source PP woven bags from packaging suppliers that meets WFP requirements.
 - Packaging material shall have certificate of analysis and food contact material certificate declaring material is food grade in accordance with EU law Regulation (EC) No 1935/2004, (EU) No 10/2011 and (EU) No 2023/1442 or FDA law Regulation included in the 21 CFR regarding food contact. WFP must be consulted if certificate of compliance for food contact material is provided against a local regulation.
 - For every lot of PP woven bags received from packaging suppliers, Food suppliers should use ISO 2859 (Sampling procedures for inspection by attributes) to sample required number of bags to confirm the following parameters meets WFP requirements. Food suppliers shall determine number of bags to be checked for each analysis below after sampling.
 - Dimensional analysis (cm).
 - Empty bag weight (g).
 - Quality of heat cut or hemming of bag mouth.
 - Grammage of bags (g/m²).
 - Print quality using tape test¹.
 - Bottom stitch quality (dots per inch, height of first and second stitch to bottom of bag).
 - Tensile strength value on CoA meets WFP requirement (g/denier).
 - Tape width (mm).
 - Warp and weft density.
 - Food suppliers must check marking on bags meets contractual requirements.
 - Recommended shelf life of bag to be provided by the packaging supplier. Similarly, clear definition of storage conditions to preserve packaging integrity and properties before productions should be provided by packaging supplier and applied by food manufacturer in its premises. Shelf life of packaging and storage conditions must be reflected in raw material packaging specifications available at food manufacturer premises.
3. *Control during packing process*
 - Weight of filled bags must be checked every 2 hours on 10 bags.
 - Food suppliers shall carry out visual inspection of top stitch and perform drop test at every 2 hours on 5 samples to confirm quality is okay to prevent leakage of products during packing process.

¹ Tape test for print quality - <https://docs.wfp.org/api/documents/WFP-0000159285/download/>.



- Quality of print and traceability details inkjet on bags must be checked on 10 samples every 4 hours before warehouse storage.
- Monitor the tension of needle and quality of top stitch.

4. Batch definition + Coding/Labeling + Traceability

- Batch size limitation

Production Capacity	Batch Size
<100 MT/day	1 week of production, or 500 MT, whichever is lower
100-500 MT/day	1 day of production
> 500 MT/day	1 shift (8 hours) of production

- Marking on the product shall facilitate traceability up to the level specified above (week, day or a shift).
- Technical solution as using ink jet printer with food grade ink are acceptable for daily/per shift/weekly change of the traceability information.

5. Annexes

- Packaging - PP Woven bag with or without PE inner liner specification: <https://docs.wfp.org/api/documents/WFP-0000140775/download/>
- Capacity and dimension of bag: <https://docs.wfp.org/api/documents/WFP-0000138723/download/>
- Technical Expectations – PP Woven Bag Manufacturers: <https://docs.wfp.org/api/documents/WFP-0000160256/download/>

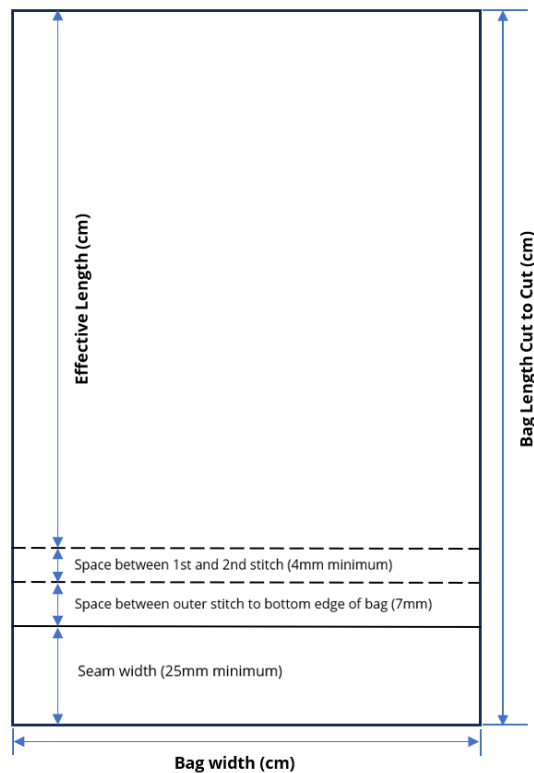


Figure 1: Bag dimension requirements