



SUMMARY OF CHANGES
USDA HARMONIZED GAP AND GAP PLUS+ STANDARDS

Introduction

The U.S. Department of Agriculture’s (USDA) Agricultural Marketing Service (AMS) has updated the content of the USDA Harmonized Good Agricultural Practices (GAPs) Standards. These changes include the updates to the Harmonized Combined Standard hosted by International Fresh Produce Association (IFPA), which were finalized May 2023.

The Produce GAPs Harmonization Initiative is an all-industry effort that develops food safety GAPs standards and audit checklists for pre-harvest and post-harvest operations that are applicable to all fresh produce commodities, all sizes of on-farm operations, and all regions in the United States. The Initiative is a collaborative effort on the part of growers, shippers, produce buyers, government agencies, audit organizations, and other stakeholders. USDA incorporated the Produce GAPs Harmonized Food Safety Standard into its GAPs food safety audit program in 2011. AMS provides voluntary GAPs audit services to the specialty crops industry that verify that fresh fruits and vegetables are produced, packed, handled, and stored as safely as possible to minimize risks of microbial food safety hazards.

USDA has updated the Harmonized and Harmonized GAP Plus+ audit programs for the 2024 audit season. The revised USDA Harmonized GAP and GAP Plus+ Audit standards will go into effect on May 1, 2024.

In general, throughout the standard the word “personnel” has been replaced with “employees and workers”. In the cold storage requirements, the language has been changed from “for food safety” to “by the food safety plan”. Table 1. below summarizes the changes for each requirement in the standard, defining what was added, replaced, or removed from each requirement. If a requirement is not listed in the table then no change was made from the previous version.

Table 1. Summary of Changes to Harmonized Standard

Table with 2 columns: Section, Changes. Row 1: G-1.1, ADDED: and food safety culture, Everyone in the organization shall understand the policy and be aware of their role in ensuring that this is met (e.g., through training initiatives, communication efforts, feedback to management,

Section	Changes
G-1.1	<p>performance measurements related to food safety). The policy shall be communicated in a language understood by employees and workers. The policy shall be signed by senior management, and includes a date when the policy was created and any dates of revision.</p> <ul style="list-style-type: none"> <li>• observes that it includes a proactive approach to promoting food safety culture,</li> <li>• and made accessible to all employees and workers</li> <li>• and includes a date when the policy was created or revised.</li> </ul> <p>REPLACED: “observes” with “reviews” REMOVED: observes that it</p>
G-1.2	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• on-site and remote, including a list of alternatives authorized to act in absence of designated individuals.</li> <li>• On-site</li> </ul>
G-1.3	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• corrective action</li> <li>• resulting from employees and workers</li> <li>• and trains or retrains</li> </ul> <p>REPLACED: “disciplinary” with “corrective action” REMOVED: “or its communication”</p>
G-2.1	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• and</li> <li>• physical and biological hazards</li> <li>• products and</li> </ul> <p>REMOVED: “biological including radiological and physical hazards and radiological”</p>
G-2.2	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• And when changes that affect the operation occur.</li> <li>• Changes that affect the operation occur (e.g., purchase of new packing equipment, changes management, new product type),</li> <li>• Auditor shall review documentation that the food safety plan is reviewed and revised at least annually, or when changes that affect the operation occur.</li> <li>• Operation reviews the food safety plan at least annually or when changes that affect the operation occur.</li> </ul>

Section	Changes
G-2.2	<p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “a change is made that might affect food safety”</li> <li>• “auditor reviews last food safety plan review”</li> <li>• “operation reviews food safety plan and documents review”</li> </ul>
G-2.2.a	REMOVED
G-2.3	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• soil amendments, and alternative growing media, soil-less media, and substrates.</li> <li>• Primary and</li> <li>• to ensure that materials will not serve as a potential source of contamination (e.g., obtaining Certificate of Analysis for soil amendments).</li> <li>• Have</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “and service providers”</li> </ul>
G-2.4 NEW	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Operation has an approved services program for all services which may impact the safety of the product.</li> <li>• Operation has and maintains a current list of approved service providers which could impact the safety of the product such as portable sanitation unit servicers, equipment technicians, or field workers. All approved service providers are provided at minimum the operation’s food safety policies for proper restroom use and handwashing, illness policies, and other policies relevant to the service provider’s job (e.g., food safety practices during equipment maintenance).</li> <li>• Auditor verifies a list of approved service providers is maintained and current. Auditor verifies that all services received from alternate sources have been provided food safety policies and procedures prior to work occurring</li> <li>• Operation develops an approved services program and maintains a current list. Operation develops a procedure for accepting services from alternate providers. Operation ceases utilizing service providers who have not been provided the operation’s food safety policies.</li> </ul>

Section	Changes
G-2.4.a	ADDED: <ul style="list-style-type: none"> <li>• Record “R”</li> <li>• And service providers</li> <li>• And service providers which have an effect on food safety.</li> </ul>
G-2.3.b	REMOVED
G-2.3.c	REMOVED
G-3.1	ADDED: <ul style="list-style-type: none"> <li>• Employees and workers have access to the most current version of the operation’s documents and records of procedures as related to the employee’s job responsibilities.</li> <li>• employee’s and worker’s job responsibilities</li> <li>• and up to date.</li> <li>• Operation provides employees and workers with the most up-to-date versions of documents and records of procedures as related to the employee’s and worker’s job responsibilities.</li> </ul>
G-3.3.a	ADDED: <ul style="list-style-type: none"> <li>• They shall be stored for the time required to meet customer requirements, or for a period exceeding the shelf-life of the food if customer requirements are not available.</li> </ul>
G-4.1	ADDED: <ul style="list-style-type: none"> <li>• Employees and workers shall be trained to notify a designated individual if a food safety risk is identified. All concerns are promptly considered, and when appropriate to the circumstance, acted upon.</li> <li>• Employees and workers (at least annually), and retraining when deficiencies are identified, and as required by prevailing regulation</li> </ul> REMOVED: <ul style="list-style-type: none"> <li>• “and as needed”</li> </ul>
G-4.2	ADDED: <ul style="list-style-type: none"> <li>• has sufficient on the job training/experience or has</li> </ul> REMOVED: <ul style="list-style-type: none"> <li>• “by job experience”</li> </ul>
G-5.1	ADDED: <ul style="list-style-type: none"> <li>• laboratory or laboratory participating in a proficiency testing program using scientifically valid methods</li> </ul>

Section	Changes
G-5.1	<ul style="list-style-type: none"> <li>• At a minimum, laboratory procedures are scientifically valid methods and in accordance with prevailing regulation.</li> <li>• only GLP or laboratories participating in a proficiency testing program and scientifically valid methods are used</li> <li>• or non-accredited and not scientifically valid</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “validated methods”</li> <li>• “consistent in accordance with accredited methods”</li> <li>• “validated methods are used”</li> <li>• “non validated”</li> </ul>
G-5.2	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• and records kept.</li> <li>• that includes test frequency and procedures for food safety.</li> <li>• All results for microbiological testing, including lab reports or certificates of analysis, required in the operation’s food safety plan shall be recorded and the records maintained for two years or as required by prevailing regulation.</li> <li>• test records for at least two years</li> </ul>
G-5.3	REMOVED
G-5.3 (formerly G-5.4)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• written policy describing</li> <li>• policy and actions</li> <li>• (i.e., test and hold).”</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “required, test”</li> <li>• “written testing procedure that includes test frequency, sampling, test procedures”</li> <li>• “procedures”</li> </ul>
G-6.1	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• And</li> <li>• Prevailing</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “and non transporter.”</li> <li>• “applicable”</li> </ul>
G-6.2	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Records check</li> </ul>
G-7.1	ADDED:

Section	Changes
G-7.1	<ul style="list-style-type: none"> <li>• Operation shall have written procedures that detail each step of the recall process including tasks and responsibilities. Written procedures detail communication with customers about recalled products, including how to withdrawal, return, dispose, or divert the affected product. Verification procedures shall document that the recall was conducted effectively.</li> <li>• Auditor shall review documentation of the recall program and written procedures</li> <li>• Operation develops a recall program including written procedures</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “the recall program shall have a designated recall team. A mock recall exercise shall be performed at least annually at the operation being audited. The mock recall shall include the trace back and trace forward exercise and shall be completed to applicable regulations.”</li> <li>• “Auditor reviews records of most recent mock recall performed at the operation.”</li> <li>• “operation develops recall team and recall plan, and tests the plan for effectiveness.”</li> </ul>
G-7.1.a	REMOVED
G-7.2 NEW	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• The recall program shall have a designated recall team.</li> <li>• Operation has an established recall team and keeps up-to-date contact information for the internal and external individuals involved in the operation’s recall activities (e.g., key company employees, legal counsel, regulatory agencies, insurance agent, media spokesperson).</li> <li>• Auditor reviews operation’s established recall team contact information.</li> <li>• Operation develops a recall team and keeps up-to-date contact information for all team members.</li> </ul>
G-7.3 NEW	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• A mock recall exercise shall be performed at least annually at the operation being audited.</li> <li>• The mock recall shall include a trace back and trace forward exercise for a hypothetical product on the market and include involvement by designated recall team members as established by the recall program.</li> <li>• Auditor reviews records of most recent mock recall exercise performed at the operation.</li> </ul>

Section	Changes
G-7.3 NEW	<ul style="list-style-type: none"> <li>• Operation develops a written recall plan, performs a mock recall exercise, and keeps records.</li> </ul>
G-8.1	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Action</li> <li>• (e.g., root cause analysis exercise)</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “and preventative action”</li> <li>• “root cause analysis (e.g., 5 whys ) and follow up”</li> </ul>
G-8.1.c	REMOVED
G-8.2	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Hold and release</li> <li>• Disposition must be documented (e.g., if the product was released, destroyed, donated, redirected).</li> <li>• and their disposition.</li> <li>• Product release procedure is being followed and release records are kept.</li> <li>• or released</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• clearly</li> </ul> <p>REPLACED:</p> <ul style="list-style-type: none"> <li>• “logs” with “records”</li> </ul>
G-9.1	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• annually</li> </ul>
G-10.3	<p>REPLACED:</p> <ul style="list-style-type: none"> <li>• “servicing” with “serviced”</li> </ul>
G-10.7	<p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “major”</li> </ul>
G-10.8	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Handwashing shall be monitored by visible observation when possible and/or confirming use of handwashing resources such as towels and soap to verify adequate handwashing is occurring.</li> </ul>
G-10.11	<p>REPLACED:</p> <ul style="list-style-type: none"> <li>• “Regulatory Requirements” with “Prevailing regulation”</li> </ul>
G-10.12	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Protective</li> </ul>

Section	Changes
G-10.12	<ul style="list-style-type: none"> <li>• Or taken into restrooms</li> </ul>
G-10.13	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• false nails or eyelashes, watches, personal electronics (e.g., ear buds), or other items (including decorations that may fall from clothing and become a physical hazard)</li> </ul>
G-10.17	<p>REMOVED:</p> <ul style="list-style-type: none"> <li>• Written</li> </ul>
G-10.19	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• and from entering produce handling areas.</li> <li>• Written</li> <li>• Foodborne</li> <li>• and from entering produce handling areas where direct or indirect contamination could occur (e.g., shared use of tools by workers) until their condition no longer presents a risk to public health.</li> <li>• Written</li> <li>• Workers and visitors</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “field”</li> </ul>
G-10.19.a	REMOVED
G-10.20	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Bandages or other coverings for cuts, sores, or lesions shall not pose a physical hazard to produce.</li> </ul>
G-10.21	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• and implement</li> </ul>
G-11.1 (formerly F-2.1 and P-2.1)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Pesticides and other</li> <li>• including</li> </ul>
G-11.2 (formerly F-2.2 and P-2.2)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• the maximum residue limit (MRL)</li> <li>• origin or intended country of</li> <li>• and communication with buyers about potential countries where product is intended to be sold</li> <li>• is grown and</li> <li>• the auditor will review the operation’s compliance with agricultural chemical restrictions for the country where the produce was grown.</li> </ul>



Section	Changes
G-11.2 (formerly F-2.2 and P-2.2)	<p>REPLACED:</p> <ul style="list-style-type: none"> <li>• “traded” with sold/distributed</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• If product is intended for export,</li> <li>• Entry</li> <li>• This item is not applicable</li> </ul>
G-11.3 (formerly F-2.3 and P-2.3)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• The responsible person(s) must be able to prepare the required application mix according to the label instructions.</li> <li>• Auditors shall verify agricultural chemical mixes are prepared properly by interviewing the responsible person(s), if available.</li> </ul>
G-11.5 (NEW)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Use of water treatment agricultural chemicals shall comply with label directions and prevailing regulation.</li> <li>• Agricultural chemicals used to manage water quality, including sanitizers and disinfectants, must be registered for such use as required by prevailing regulation, and used in accordance with label directions including application rates, worker protection standards, personal protection equipment, container disposal, storage, and all requirements specified for the chemical or compound. Chemicals that are not registered antimicrobial pesticides may be permitted for use if allowed under regulations of the prevailing agency. Records of water treatment are maintained, and include crop, date and location of application, chemical used, application rate and method.</li> <li>• Auditor reviews agricultural chemical use records for evidence of compliance with approved uses or label directions.</li> <li>• Operation develops and maintains agricultural chemical use records and maintains evidence of proper use of each chemical use. Affected product is evaluated for potential contamination and disposition. Retraining is performed and documented.</li> </ul>
G-11.7 (formerly F-8.7 and P-6.3)	<p>REPLACED:</p> <ul style="list-style-type: none"> <li>• “approved for their intended” with “appropriate for”</li> <li>• “approved” with “labeled”</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• Or sanitizing</li> </ul>
G-11.8 (NEW)	<p>ADDED:</p>

Section	Changes
G-11.8 (NEW)	<ul style="list-style-type: none"> <li>• Compressed air or other gases that contact food or food contact surfaces must be maintained in a manner that does not serve as a potential source of product contamination.</li> <li>• Compressed air or other gases that are used in produce handling equipment, contact produce directly, or used in the process to clean food-contact surfaces must be properly maintained and inspected regularly. Compressed air or other gases must be properly stored and handled according to the label or manufacturer's instructions. When the food safety plan indicates that microbial or chemical testing is required to minimize potential food safety risks, documentation of test results and corrective actions are kept. Records of compressed air and gas system maintenance is documented.</li> <li>• Auditor reviews records of maintenance and testing results (when required by the food safety plan) of the compressed air or gas system. Auditor observes the appropriate use, storage, and/or handling of the compressed air or other gases used in contact with food and food contact surfaces.</li> <li>• Operation develops records to document maintenance and test results of compressed air and other gas systems that contact food or food contact surfaces. Retraining is performed and documented.</li> </ul>
G-12.1 (formerly G-11.1)	ADDED: <ul style="list-style-type: none"> <li>• growing and</li> </ul>
F-2.a	REMOVED
F-2.1.a	REMOVED
F-2.1.b	REMOVED
F-2.1.c	REMOVED
F-2.1.d	REMOVED
F-2.3.a	REMOVED
F-2.4.a	REMOVED
F-2.1 (formerly F-3.1)	ADDED: <ul style="list-style-type: none"> <li>• type of water source (e.g., surface, ground, reuse)</li> </ul>
F-2.2 (formerly F-3.2)	ADDED: <ul style="list-style-type: none"> <li>• as it relates to food safety</li> </ul>

Section	Changes
F-2.3 (formerly F-3.3)	ADDED: <ul style="list-style-type: none"> <li>• Septic tanks and sewage conveyance locations are identified by the operation in relation to water systems.</li> </ul>
F-4.4 (formerly F-5.4)	ADDED: <ul style="list-style-type: none"> <li>• indicated by current industry standard or prevailing regulation</li> <li>• sufficient to meet treatment objectives</li> </ul> REMOVED: <ul style="list-style-type: none"> <li>• “relevant”</li> <li>• “Adequate to ensure that the treated water is consistently safe and of adequate sanitary quality for its intended use and/or consistently meets the relevant microbial quality criteria”</li> </ul>
F-4.5 (formerly F-5.5)	ADDED: <ul style="list-style-type: none"> <li>• microbial die-off</li> <li>• the operation’s</li> </ul>
F-4.6 (formerly F-5.6)	ADDED: <ul style="list-style-type: none"> <li>• compared to current industry standards or regulations</li> <li>• as providing the same level of public health protection.</li> <li>• To support</li> </ul>
F-5.1 (formerly F-6.1)	ADDED: <ul style="list-style-type: none"> <li>• (e.g., does crop grow on ground vs. tree), type, concentration and occurrences.</li> </ul> REMOVED: <ul style="list-style-type: none"> <li>• “and approximate”</li> </ul>
F-5.3 (formerly F-6.3)	ADDED: <ul style="list-style-type: none"> <li>• (e.g., installation of buffer zones, fences, ditches, berms, etc.)</li> </ul>
F-6.1 (formerly F-7.1)	ADDED: <ul style="list-style-type: none"> <li>• storage of animal-based soil amendments or biosolids.</li> <li>• (if produced by your operation), application methods.</li> </ul> REMOVED: <ul style="list-style-type: none"> <li>• “soil amendment”</li> <li>• “Utilized”</li> </ul>
F-6.2 (formerly F-7.2)	ADDED: <ul style="list-style-type: none"> <li>• as required by current industry standard or prevailing regulation.</li> </ul>
F-6.3 (NEW)	ADDED: <ul style="list-style-type: none"> <li>• If an alternative growing media, soil-less media, or substrate not of animal-origin is used (e.g., perlite, peat, coconut fiber, rock wool,</li> </ul>

Section	Changes
F-6.3 (NEW)	<p>clay pebbles), it is appropriate for its intended use and stored and handled in a manner to minimize the risk of contamination.</p> <ul style="list-style-type: none"> <li>• WP, R</li> <li>• The operation shall have a procedure for storing and handling alternative growing media, soil-less media, and substrate so that it does not pose a food safety risk to produce. Operation maintains a record of type, supplier, and use (e.g., clay pebbles used for growing hydroponic herbs).</li> <li>• Auditor reviews procedure and records to determine the media or substrate is appropriate for its intended use and being stored and handled in a manner that does not introduce contamination.</li> <li>• Operation develops a procedure for storing and handling growing media or substrate being used and develops the records needed for verification.</li> </ul>
F-7.2 (formerly F-8.2)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Fit for purpose</li> <li>• And foot</li> <li>• Managed to</li> <li>• And traffic</li> <li>• Workers</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “flow”</li> <li>• “from traveling through an untreated manure area into the harvesting field”</li> </ul>

Section	Changes
<p>F-7.2.c (formerly F-8.2.c) P-5.5.a (formerly P-6.5.a)</p>	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Cleaning and sanitation</li> <li>• Demonstrate</li> <li>• Are appropriate and effective</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• A cleaning and sanitation program for food contact surfaces shall be established, implemented and maintained.</li> <li>• An implemented cleaning and sanitation program shall be established, including SOPs.</li> <li>• The SOP must justify the frequency of cleaning, demonstrate that the cleaning and sanitizing methods are effective on the surfaces that they are used on, are being used at appropriate concentrations as required by the label. Operation shall demonstrate effectiveness in minimizing the potential for cross contamination from cleaning and sanitizing. Records of sanitizer chemical concentrations shall be maintained.</li> </ul>
<p>F-7.4 (formerly F-8.4)</p>	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• on production and harvesting vehicles</li> <li>• tools and utensils</li> </ul>
<p>F-7.5 (formerly F-8.5)</p>	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• in a manner that minimizes the risk of becoming a source of contamination in growing and/or product storage areas</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “away from the growing area, product handling/storage areas, and other equipment to reduce the potential for contamination.”</li> </ul>
<p>F-7.6 (formerly F-8.6)</p>	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• water tanks and other water holding containers (e.g., cisterns, water totes, agricultural chemical tanks, dust control tanks),</li> <li>• water</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “such as those used for dust control, the water”</li> </ul>
<p>F-8.1 (formerly F-9.1)</p>	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• risk</li> </ul>
<p>F-9.3 (formerly F-10.3)</p>	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• If an antimicrobial process or chemical treatment is used for harvest or post-harvest water, it shall be used in accordance with manufacturer instructions and the operation’s written SOP.</li> <li>• antimicrobial pesticide (e.g., sanitizer or disinfectant)</li> </ul>

Section	Changes
F-9.3 (formerly F-10.3)	<ul style="list-style-type: none"> <li>• Treatment is delivered in a manner to ensure that the treated water is consistently safe and of adequate sanitary quality for its intended use and/or consistently meets the relevant microbial quality criteria indicated by current industry standard or prevailing regulation. Treatment is monitored at a frequency to meet treatment objectives. Records shall be kept.</li> <li>• Operation develops, documents, and implements procedures for use of the antimicrobial system in compliance with manufacturer’s label and instructions including monitoring for meeting the established acceptance criteria.</li> </ul> <p>REPLACED: “recirculated” with “re-used”</p> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “if water is re used SOPs address antimicrobial treatment”</li> <li>• “Approved antimicrobial”</li> </ul>
F-9.4 (NEW)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• If water contacting product or food contact surfaces is re-used, it shall be treated using a registered or approved antimicrobial process or chemical treatment.</li> <li>• Mandatory requirement “•”</li> <li>• Re-used water shall be managed using an antimicrobial treatment sufficient to prevent cross-contamination, unless current industry standard or prevailing regulation provide an alternative.</li> <li>• Auditor reviews water treatment process and evidence of compliance with regulation and the operation’s established procedure.</li> <li>• Operation suspends operation until water treatment functions to prevent risk of product contamination. Affected product and product handling areas are evaluated for potential contamination and disposition.</li> </ul>
F-9.6 and P-6.7 (formerly F-10.5 and P-7.9)	<p>REPLACED:</p> <ul style="list-style-type: none"> <li>• “prevailing regulation or industry guidelines” with “with current industry standards or prevailing regulations”</li> </ul>
F-10.2 (formerly F-11.2)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• And packaging</li> </ul>
F-10.4 (formerly F-11.4)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Packing and packaging materials</li> </ul> <p>REMOVED:</p>

Section	Changes
F-10.4	<ul style="list-style-type: none"> <li>• “other”</li> </ul>
F-11.6 (formerly F-12.6)	REPLACED: <ul style="list-style-type: none"> <li>• “Prevents” with “minimizes”</li> <li>• “be designed to maintain” with “keep”</li> <li>• “particular” with “Care”</li> </ul>
F-11.7 (formerly F-12.7)	ADDED: <ul style="list-style-type: none"> <li>• Current</li> <li>• Or prevailing regulation</li> </ul>
F-11.8.a (formerly F-12.8.a)	ADDED: <ul style="list-style-type: none"> <li>• inspect harvested and/or staged product for visible contamination prior to leaving the field.</li> </ul> REMOVED: <ul style="list-style-type: none"> <li>• ensure that all potential hazards have been addressed prior to transport.</li> </ul>
P-1.1	ADDED: <ul style="list-style-type: none"> <li>• Good Agricultural Practices (GAP)</li> </ul>
P-2.1 (formerly P-3.1)	REPLACED: <ul style="list-style-type: none"> <li>• “hazard analysis” with “risk assessment”</li> </ul>
P-2.1.a (formerly P-3.1.a)	ADDED <ul style="list-style-type: none"> <li>• Risk assessment</li> <li>• Packinghouse risk assessment</li> </ul>
P-4.1 (formerly P-5.1)	ADDED: <ul style="list-style-type: none"> <li>• And well maintained to prevent bacterial harborage</li> </ul>
P-4.4 (formerly P-5.4)	ADDED: <ul style="list-style-type: none"> <li>• or tools (e.g., test strips, titration kits)</li> <li>• electronic devices</li> <li>• (within valid expiration date)</li> <li>• parameters</li> <li>• Calibration of measuring and monitoring equipment (thermometers, pH meters, scales, chemical application equipment, or other monitoring devices) is performed using an established method or according to manufacturer’s instructions. Records shall be kept.</li> <li>• to verify that an established method or manufacturer’s instructions are followed</li> <li>• Reviews</li> </ul>

Section	Changes
P-4.4 (formerly P-5.4)	REPLACED: <ul style="list-style-type: none"> <li>• “ORP” with “in-line”</li> <li>• “requirements” with “parameters”</li> </ul>
P-4.5 (formerly P-5.5)	ADDED: <ul style="list-style-type: none"> <li>• and conform to current industry standard or prevailing regulation.</li> </ul>
P-5.1 (formerly P-6.1)	ADDED: <ul style="list-style-type: none"> <li>• A preventive maintenance schedule with related SOPs shall be established.</li> <li>• written preventative maintenance</li> <li>• equipment,</li> <li>• maintenance</li> <li>• Floors are maintained to minimize and/or facilitate the removal of standing water.</li> <li>• maintenance schedule</li> </ul> REMOVED: <ul style="list-style-type: none"> <li>• cleaning and sanitation</li> <li>• preventive maintenance and/or master cleaning schedule</li> <li>• cleaned and</li> </ul>
P-6.1.b	REMOVED
P-5.2 (NEW)	ADDED: <ul style="list-style-type: none"> <li>• A master cleaning schedule with related SOPs shall be established.</li> <li>• WP, R</li> <li>• Mandatory requirement “•”</li> <li>• There is a written cleaning schedule for all food and non-food contact surfaces including equipment, floors, drains, walls, ceilings, and other surfaces which may pose a source of product contamination. Established SOPs shall include instructions, person(s) responsible, specific frequency, and cleaning products and concentration. Sanitation tools must be appropriate for their designated purpose.</li> <li>• Auditor reviews cleaning records and associated SOPs and observes that food and non-food contact surfaces are cleaned in a manner and frequency sufficient to preventing product contamination.</li> <li>• Operation develops a master cleaning schedule with related SOPs. Cleaning deficiencies are corrected. Retraining is performed and documented. Affected product is evaluated for potential contamination and disposition.</li> </ul>
P-5.3	ADDED:



Section	Changes
P-5.3 (formerly P-6.2)	<ul style="list-style-type: none"> <li>• Cleaning and sanitation protocols are reviewed and updated respective to temporary repairs. Equipment is cleaned and sanitized after repair prior to being used.</li> <li>• of permanent repairs and cleaning and sanitation protocols.</li> </ul>
P-5.7 (formerly P-6.7)	<p>REMOVED:</p> <ul style="list-style-type: none"> <li>• Written</li> </ul>
P-6.1 (formerly P-7.1)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• Postharvest</li> </ul>
P-6.4 (formerly P-7.4)	<p>REPLACED:</p> <ul style="list-style-type: none"> <li>• “Shall be performed that takes into consideration” with “includes”</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• An initial</li> </ul>
P-6.5 (formerly P-7.6)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• a registered or</li> <li>• according to current industry standard or prevailing regulation</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “or commodity specific standards provide an alternative.</li> <li>• Treatments shall comply with prevailing regulation or the country in which the product is intended to be traded, whichever is more stringent”</li> </ul>
P-6.6 (formerly P-7.8)	<p>ADDED:</p> <ul style="list-style-type: none"> <li>• postharvest</li> <li>• treatment</li> <li>• Treatment is delivered in a manner to ensure that the treated water is consistently safe and of adequate sanitary quality for its intended use and/or consistently meets the relevant microbial quality criteria indicated by current industry standard or prevailing regulation. Treatment is monitored at a frequency to meet treatment objectives. Records shall be kept.</li> <li>• Auditor reviews water use SOP for completeness and observes water treatment records for adequacy and consistency of treatment. Water treatment outcomes align with current industry standard or prevailing regulation.</li> <li>• label and instructions including monitoring for meeting the established acceptance criteria established by current industry standard or prevailing regulation.</li> <li>• Retraining is performed and documented</li> </ul> <p>REMOVED:</p> <ul style="list-style-type: none"> <li>• “wash”</li> </ul>

Section	Changes
P-6.6 (formerly P-7.8)	<ul style="list-style-type: none"> <li>• Operation shall have a procedure that includes minimum limits concentration for antimicrobial in postharvest wash water for food safety (e.g., washing, cooling, commodity movement). Procedure shall include how to control, monitor and record use of wash water antimicrobial as needed to assure compliance with minimum concentration and labeled use limits. Operation shall have a procedure as to what corrective actions are taken if criteria are not met. Monitoring shall be performed, as appropriate to specific operation, to demonstrate that acceptance criteria have been met. Records shall be kept.”</li> <li>• Auditor reviews operational procedures, and antimicrobial use, monitoring records, product label, and corrective actions records for compliance.</li> </ul>
P-7.1 (formerly P-8.1)	ADDED: <ul style="list-style-type: none"> <li>• And labels</li> </ul> REMOVED: <ul style="list-style-type: none"> <li>• “on”</li> </ul>
P-7.5 (formerly P-8.5)	REMOVED: <ul style="list-style-type: none"> <li>• “If produce does not normally contact the ground during production”</li> </ul>
P-8.1 (formerly P-9.1)	ADDED: <ul style="list-style-type: none"> <li>• Current</li> </ul> REPLACED: <ul style="list-style-type: none"> <li>• “not pose a” with “minimize”</li> </ul>
P-8.3 (formerly P-9.3)	ADDED: <ul style="list-style-type: none"> <li>• And equipment</li> </ul>
P-8.4 (formerly P-9.4)	ADDED: <ul style="list-style-type: none"> <li>• Food packaging and packing materials shall be stored in a manner that minimizes contamination.</li> <li>• Food packaging and packing materials</li> </ul> REMOVED: <ul style="list-style-type: none"> <li>• “Materials and”</li> <li>• “Protected from contaminants”</li> </ul>

**Table 2. Requirement Numbers across Harmonized Standard Versions**

2024 Harmonized Standard	Previous 2020 Harmonized Standard	International Fresh Harmonized Standard
G-1.1	G-1.1	1.1.1.

<b>2024 Harmonized Standard</b>	<b>Previous 2020 Harmonized Standard</b>	<b>International Fresh Harmonized Standard</b>
G-1.2	G-1.2	1.1.2.
G-1.3	G-1.3	1.1.3.
G-2.1	G-2.1	1.2.1.
G-2.2	G-2.2	1.2.2.
G-2.3	G-2.3	1.14.1.
G-2.4 (NEW)		1.14.2.
G-3.1	G-3.1	1.4.1.
G-3.2	G-3.2	1.4.2.
G-3.3	G-3.3	1.4.3.
G-4.1	G-4.1	1.5.1.
G-4.2	G-4.2	1.5.2.
G-4.3	G-4.3	1.5.3.
G-5.1	G-5.1	1.6.1.
G-5.2	G-5.2	1.6.2.
	G-5.3	
G-5.3	G-5.4	1.6.3.
G-6.1	G-6.1	1.7.1.
G-6.2	G-6.2	1.7.2.
G-7.1	G-7.1	1.8.1.
G-7.2 (NEW)		1.8.2.
G-7.3 (NEW)		1.8.3.
G-8.1	G-8.1	1.9.1.
G-8.2	G-8.2	5.16.1
G-9.1	G-9.1	1.10.1.
G-10.1	G-10.1	1.11.1.
G-10.2	G-10.2	1.11.2.
G-10.3	G-10.3	1.11.3.
G-10.4	G-10.4	1.11.4.
G-10.5	G-10.5	1.11.5.
G-10.6	G-10.6	1.11.6.
G-10.7	G-10.7	1.11.7.
G-10.8	G-10.8	1.11.8.
G-10.9	G-10.9	1.11.9.
G-10.10	G-10.10	1.11.10.

<b>2024 Harmonized Standard</b>	<b>Previous 2020 Harmonized Standard</b>	<b>International Fresh Harmonized Standard</b>
G-10.11	G-10.11	1.11.11.
G-10.12	G-10.12	1.11.12.
G-10.13	G-10.13	1.11.13.
G-10.14	G-10.14	1.11.14.
G-10.15	G-10.15	1.11.15.
G-10.16	G-10.16	1.11.16.
G-10.17	G-10.17	1.11.17.
G-10.18	G-10.18	1.11.18.
G-10.19	G-10.19	1.11.19.
G-10.20	G-10.20	1.11.20.
G-10.21	G-10.21	1.11.21.
G-10.22	G-10.22	1.11.22.
G-11.1	F-2.1, P-2.1	1.12.2.
G-11.2	F-2.2, P-2.2	1.12.4.
G-11.3	F-2.3, P-2.3	1.12.5.
G-11.4	F-2.4	1.12.6.
G-11.5 (NEW)		1.12.3.
G-11.6	F-2.5	1.12.7.
G-11.7	F-8.7, P-6.3	1.12.1.
G-11.8 (NEW)		1.12.8.
G-12.1	G-11.1	1.13.1.
G-12.2	G-11.2	1.13.2.
G-13.1	G-12.1	1.3.1.
G-13.2	G-12.2	1.3.2.
F-1.1	F-1.1	2.1.1.
F-1.2	F-1.2	2.1.2.
F-1.3	F-1.3	2.1.3.
F-2.1	F-3.1	2.2.1.1.
F-2.2	F-3.2	2.2.1.2.
F-2.3	F-3.3	2.2.1.3.
F-3.1	F-4.1	2.2.2.1.
F-4.1	F-5.1	2.2.3.1.
F-4.2	F-5.2	2.2.3.2.
F-4.3	F-5.3	2.2.3.3.

<b>2024 Harmonized Standard</b>	<b>Previous 2020 Harmonized Standard</b>	<b>International Fresh Harmonized Standard</b>
F-4.4	F-5.4	2.2.3.4.
F-4.5	F-5.5	2.2.3.5.
F-4.6	F-5.6	2.2.3.6.
F-5.1	F-6.1	2.3.1.
F-5.2	F-6.2	2.3.3.
F-5.3	F-6.3	2.3.2.
F-6.1	F-7.1	2.4.1.
F-6.2	F-7.2	2.4.2.
F-6.3 (NEW)		2.4.3.
F-7.1	F-8.1	2.5.1.
F-7.2	F-8.2	2.5.2.
F-7.3	F-8.3	2.5.3.
F-7.4	F-8.4	2.5.4.
F-7.5	F-8.5	2.5.5.
F-7.6	F-8.6	2.5.6.
F-8.1	F-9.1	3.1.1.
F-9.1	F-10.1	3.2.1.
F-9.2	F-10.2	3.2.2.
F-9.3	F-10.3	3.2.3.
F-9.4 (NEW)		3.2.4.
F-9.5	F-10.4	3.2.5.
F-9.6	F-10.5	3.2.6.
F-10.1	F-11.1	3.3.1.
F-10.2	F-11.2	3.3.2.
F-10.3	F-11.3	3.3.3.
F-10.4	F-11.4	3.3.4.
F-11.1	F-12.1	3.4.1.
F-11.2	F-12.2	3.4.2.
F-11.3	F-12.3	3.4.3.
F-11.4	F-12.4	3.4.4.
F-11.5	F-12.5	3.4.5.
F-11.6	F-12.6	3.4.6.
F-11.7	F-12.7	3.4.7.
F-12.1	F-13.1	5.3.1.

<b>2024 Harmonized Standard</b>	<b>Previous 2020 Harmonized Standard</b>	<b>International Fresh Harmonized Standard</b>
F-12.2	F-13.2	5.5.4.
F-13.1	F-14.1	4.1.1.
F-13.2	F-14.2	4.1.2.
P-1.1	P-1.1	5.2.1.
P-2.1	P-3.1	5.1.1.
P-2.2	P-3.2	5.6.1.
P-2.3	P-3.3	5.6.8.
P-2.4	P-3.4	5.10.1.
P-2.5	P-3.5	5.12.3.
P-2.6	P-3.6	5.7.1.
P-3.1	P-4.1	5.15.2.
P-3.2	P-4.2	5.15.1.
P-3.3	P-4.3	5.15.3.
P-4.1	P-5.1	5.12.1.
P-4.2	P-5.2	5.12.2.
P-4.3	P-5.3	5.11.1.
P-4.4	P-5.4	5.6.10.
P-4.5	P-5.5	5.6.11.
P-5.1	P-6.1	5.6.3.
P-5.2 (NEW)		5.6.4
P-5.3	P-6.2	5.6.7.
P-5.4	P-6.4	5.6.5.
P-5.5	P-6.5	5.6.6.
P-5.6	P-6.6	5.6.13.
P-5.7	P-6.7	5.9.1.
P-5.8	P-6.8	5.6.14.
P-5.9	P-6.9	5.6.15.
P-5.10	P-6.10	5.6.16.
P-5.11	P-6.11	5.6.2.
P-6.1	P-7.1	5.4.1.
P-6.2	P-7.2	5.4.2.
P-6.3	P-7.3	3.2.2.
P-6.4	P-7.4	5.4.3.
P-6.5	P-7.6	5.4.5.

<b>2024 Harmonized Standard</b>	<b>Previous 2020 Harmonized Standard</b>	<b>International Fresh Harmonized Standard</b>
P-6.6	P-7.8	5.4.6.
P-6.7	P-7.9	3.2.6.
P-6.8	P-7.10	5.4.4.
P-6.9	P-7.11	5.4.8.
P-7.1	P-8.1	5.5.1.
P-7.2	P-8.2	5.5.2.
P-7.3	P-8.3	5.5.3.
P-7.4	P-8.4	5.5.4.
P-7.5	P-8.5	5.5.5.
P-7.6	P-8.6	5.5.6.
P-7.7	P-8.7	5.5.7.
P-7.8	P-8.8	5.5.8.
P-7.9	P-8.9	5.5.9.
P-8.1	P-9.1	5.8.1.
P-8.2	P-9.2	5.8.2.
P-8.3	P-9.3	5.8.3.
P-8.4	P-9.4	5.8.4.
P-8.5	P-9.5	5.8.5.
P-8.6	P-9.6	5.8.6.
P-8.7	P-9.7	5.14.1.
P-8.8	P-9.8	5.6.9.
P-8.9	P-9.9	5.6.12.
P-9.1	P-10.1	6.1.1.
P-9.2	P-10.2	6.1.2.
P-9.3	P-10.3	6.1.3.
P-9.4	P-10.4	6.1.4.
P-9.5	P-10.5	6.2.1.
P-9.6	P-10.6	6.2.2.

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