

INDUSTRY GUIDANCE DOCUMENT

SEPTEMBER 2025

Guide to Implementing RABC in Industrial Laundries to Enable EN14065 Auditing and Certification

This document has been prepared by the Technical Committee Working Group CEN/TC 248 WG17, responsible for EN14065 “Hygienic quality of textiles processed in industrial laundries and used in sectors in which it is necessary to control biocontamination”, the secretariat of which is held by Centexbel and ETSA.

WG17 is tasked with reviewing at recognised intervals or by exception, the standard EN14065 and it was decided by the WG that this review should include the construction of a guide on how to implement EN14065 within an Industrial Laundry.

Whilst certain countries and companies have previously generated their own guidance documents and auditing companies have similarly constructed their own audit checklists, this guidance is current and makes reference to the latest version of EN14065: 2025. It provides a common set of procedures which may be adopted across Europe and may be adopted by all sectors (laundries, their customers and auditors), thus creating a ‘level playing field’.

WG17 fully debated that EN14065 is a standard for Risk Assessment and by very definition of the term ‘validation’, should not include specific, quantitative values to be achieved. However, it is considered by Experts within the industry that the inclusion of quantitative values in the Guide to Implementing is essential to assist with implementation, customer acceptance and third-party auditing.

Introduction

The Healthcare and Food industry sectors across Europe have long demanded hygienic laundering of linen and garments to the point where barrier-washing and clean room technology **may** be dictated, along with suitable test methodologies for proof of delivery of assured hygienic quality.

Similar laundering conditions have also been dictated by the pharma and electronics sectors.

The SARS COV-2, Covid 19 pandemic suddenly raised the bar and the proof of hygienic quality was demanded by other sectors, namely hospitality, leisure, washrooms and general industry which were massively disrupted by the new procedures mandated to prohibit cross contamination and eliminate the potential vectors for transmission.

This generated the requirement for the CEN TC248 WG17 (responsible for the reviewing of EN14065) to generate a new work item for the standard to be reviewed in order to ensure that compliance with the standard by an industrial laundry did indeed ensure the elimination of the SARS COV-2 virus on linen.

The WG addressed available technical evidence which specified the required processing parameters and it is now stated in the body of the standard that for textiles laundered in compliance with the standard, elimination of the SARS COV-2 virus is achieved.

The WG17 members then proposed that the implementation of the RABC procedures, in order to achieve auditable compliance with the standard, required further explanation and advice in the form of technical guidance.

Exact processing parameters and procedures to achieve the validation of hygienic laundering are now firmly in place in many countries and this would never have been achieved without having the EN14065 standard as the benchmark for implementation and compliance auditing.

Some countries have also developed their own implementation advice documents, however many have not and as a result, the benefits of the standard and the assurance of hygienic quality, are not necessarily being realised.

Customers must be able to demand and be assured that the laundry service operates to a bio-contamination control system (RABC), which consistently controls microbiological contamination and realises the hygienic supply of laundered articles.

The standard highlights certain sectors where the RABC approach is most necessary, e.g., Medical Devices, various Healthcare and Food sectors, as well as Pharmaceuticals. RABC can be used elsewhere, as deemed appropriate by laundry management and their customers/markets, e.g., food processing/manufacture, preparation and supply, electronics and lesser critical healthcare (residential and domiciliary care).

Laundry management intending to implement RABC should purchase a copy of the latest EN 14065 standard and in particular, study this Guide to Implementation, which is referenced in the Annex G of this standard. The key elements of the Guide are the two Checklists which have been constructed to aid implementation and also to define the specific requirements for auditing.

Scope

This Guide will assist laundry management to successfully implement a RABC plan in accordance with the standard EN14065.

Risk Analysis & Bio-contamination Control (RABC) is the widely recognised system or plan to assure the consistent microbial quality of processed textiles throughout all the stages of laundering and their delivery to the customer. Operating a RABC plan enables laundries to produce safe-for-use textiles and demonstrate validated proof of delivery consistently to their customers.

The RABC approach can be applied in any market sector, but it is most widely used in technical and regulated markets, e.g., Healthcare linen and garments, Food Processing garments and Medical Devices (with Medical Device standards and regulations).

Laundries and other contexts vary, but all RABC plans set out to ensure good general practices, in an appropriate work environment, with capable, consistent equipment, processing and handling systems. The results should always include effective washing, disinfection and drying through the laundry process, followed by protective packaging incorporating identification and delivery to customers.

The language of Bio-Contamination Control varies across countries and market sectors.

Different market sectors in all countries use specific labels for their approach to assuring product safety. Laundry management can introduce the idea of RABC by demonstrating its equivalence to these approaches; in the UK for example:

- HACCP - Hazard Analysis, Critical Control Points, used in the Food industry.
- GMP – Good Manufacturing Practice, used in Pharmaceutical and Medical Device manufacturing sectors

-
- Infection Prevention – used across the Healthcare Services.

Some familiarity with the above approaches is useful to ensure that the final results are appropriate to a laundry's unique situation and for communicating the principles to the customers and sectors involved.

Terms and definitions

The terms and their definitions are listed in the main body of the EN14065 standard, but are also listed here for ease of reference, along with additional terms and definitions which are specific to guiding implementation.

3.1

acceptance criteria

required output from a process, specified quantitatively where possible, for a particular product or its process characteristics

Note 1 to entry: Meeting acceptance criteria is the minimum requirement for product release.

3.2

action level

established level of a CCP parameter set by the RABC team at which remedial procedures are activated to bring the laundry process back into control.

3.3

alert level

established level of a CCP parameter set by the RABC team giving early warning of a change from normal conditions

3.4

biocontamination

contamination with viable microorganisms, where contamination is the presence of an unwanted constituent, foreign to the textile

3.5

control measure

action or activity used to prevent, contain, reduce or eliminate a biocontamination risk.

3.6

control point (CP)

point or process step at which a control measure is applied.

Note 1 to entry: Loss of control does not necessarily result in failure to meet acceptance criteria. Some control measures may not be applied at control points (e.g. cleaning, maintenance).

3.7

corrective action

action to be taken, when the results of monitoring indicate that alert or action levels are exceeded, in order to restore control of the process

3.8

critical control point (CCP)

any process step at which all of the following apply; control is essential to eliminate or reduce biocontamination risk, effective control is possible and is sufficient to achieve the acceptance criteria, no subsequent step can achieve the acceptance criteria.

3.9

cross-contamination

introduction of biocontamination to decontaminated textiles, directly or indirectly from contaminated textiles.

3.10

decontamination

process combining cleaning and sufficient microbial reduction for the intended purpose, e.g., disinfection.

3.11

flow diagram

graphical representation of the sequence and interaction of steps in a process

3.12

hazard

in the context of this standard, any element or factor that may adversely affect the achievement of the agreed microbiological quality of textiles

3.13

laundry

plant/factory where soiled/used textiles undergo a laundering cycle (see 3.14) such that processed textiles are fit for purpose.

3.14

laundering cycle

those process steps that textiles undergo in a laundry, between receipt from and hand over to the customer, including all or a combination of the following; sorting, classifying, washing, extraction, drying, finishing,

folding, packing.

3.15

microbiological quality (of textiles)

number and if required types of microorganisms present on textiles.

Note 1 to entry: The intended end-use will inform decisions on the agreed level of microbiological quality.

3.16

monitoring programme

planned observations or measurements of control measures.

3.17

parameter

process or product characteristic which can be monitored and compared to an agreed range of values to indicate the current degree of control.

3.18

prerequisites

those facilities and practices relating to processing and hygiene that contribute significantly to effective implementation of a RABC system, including both enabling and control measures.

3.19

processed textiles

textiles which have undergone a specified laundering cycle.

3.20

process validation

providing objective evidence that a process operating within established parameters consistently produces a result or product that meets its pre-determined specifications.

3.21

re-contamination

introduction of biocontamination to decontaminated textiles from sources other than contaminated textiles.

3.22

risk

probability of a hazard occurring combined with the severity of the consequences. For this standard, consequences relate to the potential for adverse effects from processed textiles' end use arising from biocontamination of the textile product.

3.23

risk analysis

investigation of available information to identify hazards and to estimate the consequential risks

3.24

Risk Analysis and Biocontamination Control System (RABC system)

management system for assuring processed textiles of appropriate microbiological quality in accordance with their intended use.

3.25

target level

defined level for the parameters which are monitored at the critical control points (CCPs), generally established with action and alert levels.

3.26

verification

provision of objective evidence from operation of the monitoring programme to confirm that specified requirements have been fulfilled.

3.27

viable microorganisms

microorganisms capable of multiplying to produce demonstrable growth

3.28

washing

operations taking place in a machine, in an aqueous medium, with the purpose of cleaning, decontaminating and conditioning the textile for further processing, e.g. wetting out, preliminary washing, washing, bleaching, decontaminating, neutralising, rinsing

3.29

washing supplies

materials used in the wash process, e.g., for one or more of the following functions; textile decontamination, suspension of soiling and staining from textiles, providing residual benefit to textile after washing.

The following additional terms and definitions which guide implementation

TERM

COMMENT

Bio-contamination

Contamination from sources such as bacteria, fungi, protozoa and viruses

Control Measure	Action or activity used to prevent, contain, reduce or eliminate a biocontamination risk
Control Point (CP)	Point or process step at which a control measure is applied
Critical Control Point (CCP)	Any process where control is essential to eliminate or reduce biocontamination risk, effective control is possible and is sufficient to achieve the acceptance criteria, no subsequent step can achieve the acceptance criteria.
Decontamination	Achieving sufficient reduction in bio-contamination for set purposes, such as disinfection.
Disinfection	Not defined in BS EN 14065, but is defined in many certification schemes, e.g., HTM 01-04 (the UK healthcare memorandum defining laundering procedures in the healthcare sector).
Microbiological (or microbial) quality of textiles	The amount and types of bio-contamination allowed on processed textiles is determined by the end use and by agreement with the end user or local authority.
Validation	In simple terms, validation is the accumulated efforts and evidence you need to put in place a capable disinfection process and to prove to independent parties that it consistently performs as it should.

Key elements of implementation

Key elements which are outside of scope

EN 14065 is now the recognised basis for assuring microbiological quality of laundered textiles in many countries throughout Europe. It is however important to understand that this standard does not address certain key elements of laundered quality and fitness for purpose, e.g., presentation, handle, odour and other product characteristics that require effective Quality Assurance measures. It is also advised that EN 14065 is not a health and safety standard and therefore does not specify a safe system of work, nor does it address the requirement for risk assessment or method statement for measures of implementation. Equally it does not address procedures for ensuring that there is no physical contamination from the likes of lint, dust, glass fragments, elements of packaging, or even allergens.

Such necessary controls as may be applied to a clean room specification should be referenced and are described in **Annex A** of this guidance document.

Prerequisites and Principles

These are the essence of what procedures/controls are **key** and how the RABC procedures should be implemented to realise conformance with the standard.

The key elements to be achieved are concisely and simply defined in this Guide and focus on:

- The reason for and the requirements of the standard
- The theoretical and practical implementation of procedures to achieve conformance
- The checklist for internal management and external audit

See the implementation checklist in **Annex B** of this guidance document.

Certification

Certification is the procedure by which laundries secure and maintain objective, independent verification that an effective RABC plan is in place and is managed and operated effectively. EN 14065 was written specifically to enable certification for a laundry for this purpose and it may be difficult to apply its logic or terminology to any other procedure or process.

For example, in the UK, UKAS (the United Kingdom Accreditation Service) accredits qualifying organisations to certify other organisations' capability and performance against a range of standards. At the time of writing, the following UKAS accredited organisations offer certification to BS EN 14065: NSAI, SGS, Intertek, CFA, QMS. Others may yet become qualified and available to do so. This certification can be used in healthcare or food industry laundering and potentially in other market sectors requiring laundry provision.

For Healthcare, certification to BS EN 14065 secures presumption of conformance to the Essential Quality Requirements of HTM 01-04 (applied by NHS in the UK and may be expanded upon for reference).

Similar procedures apply and are complemented by Guidance documents in other countries, e.g., Austria, Germany, Netherlands and USA.

Audit

In reverse order, the audit checklist should be addressed by the laundry management (RABC Team) before then engaging an external auditor to ensure ultimate conformance and certification.

See the Certification and Audit Checklist in **Annex C** of this guidance document.

Annex A

Examples of Key Elements Outside of Scope

A.1 Avoiding allergen cross-contamination

It is important for food businesses to take steps to avoid cross-contamination in food preparation to protect customers with a food allergy.

There are a number of actions you can take to prevent cross-contamination with allergens. These include:

- cleaning utensils before each usage, especially if they were used to prepare meals containing allergens
- washing hands thoroughly between preparing dishes with and without certain allergens
- storing ingredients and prepared foods separately in closed and labelled containers
- keeping ingredients that contain allergens separate from other ingredients
- Allergen cross-contamination can also happen through using the same cooking oil. To cook gluten-free chips, you cannot use the same oil which has been previously used for cooking battered fish.

If you cannot avoid cross-contamination in food preparation, you should inform customers that you cannot provide an allergen-free dish.

A.2 Clean Room Specification – Example of Glass Policy (typical QMS)

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Approved by:

Issue date:

Approval date:

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SCOPE: This procedure applies to all glass and hard plastic used on site, including lights and windows. **PURPOSE:** To remove or ameliorate the hazard of broken glass and ensure the risk to consumer health as a result of glass breakage is as low as is practicably possible given the nature of the structure.

RESPONSIBILITY: It is the responsibility of the management to ensure that the following procedures are adhered to and understood by all relevant personnel and the personnel follow State or local health department requirements. All members of staff must appreciate the potential risks associated with breakages and must follow the instructions outlined in this procedure. The Quality Manager is responsible for ensuring Glass Log is completed on a weekly basis. Glass Breakage Record acts as an expression of due diligence in the event of an investigation due to contamination / customer complaints etc.

INSTRUCTIONS: 1. The designated employee completes Glass Log weekly. 2. Each piece of glass and clear Perspex is checked and confirmed is intact. 3. The team leaders complete the Daily Machine Glass Log. In the event of any glass breakage within the production, storage, or other areas, the following must be adhered to in order to ensure product safety. This includes the breakage or loss of Glasses and Contact lenses: 1. Production in the area must be stopped immediately. 2. All products in the immediate vicinity must be quarantined. 3. The area at risk will be isolated using coloured tape. 4. The Manager must be informed immediately of any breakage in any area. 5. No

food items, equipment or glass to be removed until the site has been examined by manager. 6. All staff is to leave the area until all broken glass has been removed.

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On leaving the area, staff shoes will be inspected to ensure they are not contaminated with glass. 8. On leaving the area, affected staff protective clothing will be changed to ensure there will be not any further cross contamination. Affected protective clothing will be discarded. 9. A nominated staff member on instruction will pick / sweep up all glass fragments. Ensure all staff involved is wearing appropriate protective clothing and gloves. 10. Broken glass will be placed in a marked polythene bag within a plastic refuse container. 11. All food contact surfaces, food machinery, and floor areas will be wiped down using a damp cloth. 12. Brushes, shovels, and cloths used to collect broken glass must be disposed of, together with the polythene bag and plastic refuse container, immediately in the external refuse area. If hoses or vacuum cleaners have been used, they must be thoroughly cleaned and signed off on Glass Breakage Record. 13. The coloured tape is only to be removed once the Manager agrees that all broken glass has been removed from the affected area. 14. The affected area to be left in a safe condition and arrange repair of the broken item using approved personnel. The manager must ensure it can cause no further damage before resuming production in this area and place a warning sign for staff advising that care needs to be taken when working in the area where broken glass was found. 15. The manager must ensure that all action is recorded on Glass Breakage Record.

MONITORING: 1. Each area to be audited accordingly to glass audit schedule by designated employee.
CORRECTIVE ACTION: 1. Any foodservice employee found not following the procedures to be retrained.
VERIFICATION AND RECORD KEEPING: 1. The manager will verify that employees are following this procedure by visually observing the employees during all hours of operation. 2. The manager will complete the Food Safety Checklist daily.

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RECORDS APPLIED TO THIS PROCEDURE:

- Food Safety Checklist
- Glass Log
- Glass Breakage Record

DOCUMENTATION RETENTION: Records applied to this procedure are to be kept on file for a minimum of 3 years.

Annex B

B.1 Example of an Implementation Checklist

EN 14065 IMPLEMENTATION CHECKLIST

Key Stages	What to Do	Task Owner	Done (Yes/No)	Audit Comment
Collect the garments from the customer	Risk assessment (onsite or shared by the customer)			
	Instruct the customer on exact requirements			
	Contract - detailed understanding and agreement			
	Risk assessment - vehicle			
	Prepare the vehicle (with measures to manage the risks identified)			
	Driver training (including covid-19 risks and measures)			
	Provide PPE against risks that may not be managed any other way			

	Use the TSA relevant National Guide, Safe Delivery of Goods to Customer premises			
	Special reference to handling infective work			
	Develop a policy on handling infective work			
	Training on handling infective work (enabling effective decision making)			
Deliver to the laundry	Carefully plan and prepare route			
	Develop policy and procedures for segregation of clean/soiled work			
	Effective training on agreed procedures			
	Prepare the laundry to receive work			
	Define soiled storage area			
Design and construct the necessary soiled work reception, storage, signage and connection/route to wash area	Provide segregation of classifications, soiled, infective, etc			
	Specify and select laundry skips/roll pallets, liners, covers, etc			
	Implement cleaning regime for floor, racking, skips, etc			
Modify washer extractors to comply with HTM01-04 requirements (minimum)	Select and allocate machines for infective work processing			
	Implement modifications:			

<p>programme controls along with the detergent supplier</p> <p>Process monitoring (data logging), may be available in the machine functionality</p>	Drain and vent modification			
	Cleaning regime			
	Wash process programmes defined, implemented and written			
	Liaise closely with detergent supplier for service support and training of staff			
	Consider the use of data logger or alternative process validation methods			
	Implement machine logs to specify, record and comment on each load processed			
	General comment on data logging, reference HTM01-04; 6.1 - 6.22			
	Temperature recording reference HTM01-04; 6.23 - 6.36			
	Pressure and water flow measurement are not so critical (6.37 - 6.44)			
	The perpetual monitoring and testing of the m/c performance			
	Proof of its functionality should be undertaken within a written procedure agreed between the laundry and the detergent supplier. See HTM01-04; 6.45 - 6.83			
	Apply the check list logic of HTM01-04; 6.82			
	Apply the General Test Method logic in HTM01-04; 6.84 - 6.132			

Modify CTWs to comply with HTM01-04 requirements (minimum)	Implement modifications:			
	Drain and vent modification			
Study the machine operation and programme controls along with the detergent supplier (from tunnel input to dryer)	Cleaning regime			
	Wash process programmes defined, implemented and written			
Process monitoring(data logging) may be available in the machine functionality	Liaise closely with detergent supplier for service support and training of staff			
	Consider the use of data logger or alternative process validation methods			
	Implement machine logs to specify, record and comment on each load processed			
	Include press/extractor and dryers in the logs and record comments			
	General comment on data logging, reference HTM01-04; 6.1 - 6.22			
	Temperature recording reference HTM01-04; 6.23 - 6.36			
	Pressure and water flow measurement are not so critical (6.37 - 6.44)			

Design and implement quality control procedures	Ideally this should include data for the work from receipt at laundry, to despatch			
	Liaise closely with detergent supplier			
	Inspect the work at point of unloading washing m/c			
	Re-wash as required			
	Load barrow/container and cover with plastic film			
	Transfer work to finishing/drying area			
Design and implement route for work to be transferred to drying/finishing area.	Mark out and sign the route			
	Implement skip/rollpallet/ wash barrow cleaning, management for next use			
Design and implement modifications required for dryers, tunnel finishers, ironers, etc	Design and specify finishing programme for all classifications			
Design and implement quality control procedures	Reference HTM01-04 Appendix F; Risk Assessment			
	Undertake risk assessment and implement requirements			
	The QA procedure			

Design and implement packaging equipment and procedures	Liaise with customer to specify packaging requirements and implement procedure			
	Ensure the full packaging solution (primary layers, outer bags, boxes, transport containers etc.)			
	protect the linen from contamination until the point of handover to the end user and is capable of preserving the linen until the point of use.			
	Be clear and consistent; assign in advance responsibilities and authority to take effective corrective actions, consistently.			
	Provide evidence that corrective actions as described are in use			
	Provide evidence that these systems work as intended.			
	Records of decisions and tracking of linen are each useful contributors to this capability			
Design and implement clean work storage in despatch area	Mark out and sign the area and storage/ racking facilities			
Prepare vehicles for clean work delivery to customer	Follow the required segregation, cleaning and route load order procedures			

Deliver work to customer	Risk assess the on-site procedure for delivery/off-loading at site			
	Design and implement delivery/receipt of goods confirmation and record			
	Risk assess the procedures for delivery of goods to customer premises			
Collect soiled goods from the customer	Return to top of this column			

Annex C

c.1. Example of a Certification and Audit Checklist

N.B. This is a **worked example** for information only and includes certain observations and advised corrections which are retained to assist implementation.

This Audit checklist requirement has been reviewed in order to define those actions or key stages which are in progress, 80% completed or 100% completed and are defined by colour highlighting. The Implementation and Audit checklists should be referenced together by all parties involved in implementation, training, operation of the laundry service as well as the auditor.

The following defines the colour coding:

Green – evidence that the stage/what to do is being implemented and is almost complete (installed/operating)

Yellow – the stage is at least 80% completed with evidence to satisfy such proof at audit

Red – the stage must be completed and will pass the strictest audit

N.B. This checklist makes reference to HTM01-04 which is the UK National Health Service healthcare technical memorandum (HTM) specifying the criteria for achieving hygienic quality in laundering.

Prerequisites & Preliminary Actions		Done Yes/No/NA	Evidence available	Auditor Comment	Compliant Y/N
Management commitment	Is there management commitment from a Director or equivalent?				
	Is responsibility for the RABC plan documented?				
RABC Team	Is there an RABC team in place?				
	Is the team made up of: snr management, production, engineering, distribution, hygiene/cleaning staff, representative from each area of the laundry, quality				

	team and microbiologist expertise?				
	Have two members of the RABC team been trained on HACCP, RABC or Infection prevention?				
	Are RABC trained staff on site during core operating hours?				
	Is there a biocontamination risk analysis showing CCPs and CPs? If so, does it detail the wash cycle and linen type?				
	Is there a RABC plan?				
	<p>Does the plan include:</p> <ul style="list-style-type: none"> • Functional separation of soiled and clean work areas? • Consistent application of infectious linen practices • Wash process validation and frequencies to include bio process indicators as capability verification • Wash load size, accuracy of weighing avoiding overloading • Ensuring wash and dry programmes designed to achieve disinfection • Ensure wash process is fail safe • Validate each CCP and revalidate annually?? (when any change dictates) 				

	Is the RABC plan reviewed and revised during implementation e.g. every 3 months, before and after control regimes are in place and when several months of monitoring data is available?				
Laundry diagram/map/plan	Is there a laundry diagram/map/plan showing the process?				
	Does the laundry diagram/map/plan show product category/market sector i.e. healthcare linen/gowns?				
	Is the flow of rinse, wash and re-use water mapped through the plant?				
	How do they ensure no re-use of water from infectious or other high-risk classifications?				
	Is the flow of air through the plant mapped?				
	Is adequate ventilation provided and does this avoid air flow from soiled to clean areas?				
	Is there functional separation of soiled and clean processing areas e.g. barrier washing, sealed zones air pressure gradients?	??			
	Does the laundry manage donning, doffing, washing/sanitizing facilities at every entrance and exit adequately stocked with PPE?				
Specification	Is an appropriate washing and drying process in place and used for healthcare				

	linen and gowns (including infectious)?				
	Has a full assessment been carried out on the laundry facility and equipment for state of maintenance, integrity and capability to maintain required controls?				
	Is there a preventative maintenance plan in place and evidence of this being implemented?				
	Is all measuring equipment calibrated? View records				
Training	What hygiene training has been given to: Laundry staff? Distribution staff? Have they been deemed competent?				
	What good manufacturing practice training has been given to: Laundry staff? Distribution staff? Have they been deemed competent?				
	Is the level of training given reflective of the type of work undertaken and goods handled?				
Purchasing	Is the purchase of materials controlled and documented, particularly those on contact with textiles during of after laundering?				
	Is there an agreed specification for Textiles?				
	Are textiles purchased to the agreed specification from approved suppliers?				

	Is there an agreed documented specification for detergents especially concentration of active agents?				
	How is it ensured that disinfectants comply with Biocide Regulations?				
	Are detergents purchased to the agreed specification from approved suppliers?				
	Is there an agreed specification for packaging e.g. food grade?				
	Are packaging materials purchased to the agreed specification from approved suppliers?				
	If not to specified food grade are packaging materials disinfected?				
	Are packaging materials stored to prevent contamination before use with processed textiles?				
	Is there good control of stocks to ensure washing materials are used before degradation affects ability to disinfect or clean textiles (use by dates)? Hypochlorite bleach.				
Staff focussed measures	Are there separate access points to soiled and clean work zones for people?				
	Does the laundry ensure staff wash their hands: On leaving soiled work areas? On entering clean work areas?				
	Does the laundry ensure staff use dedicated outer wear when in the soiled				

	area and remove it on leaving the area?				
	Is there a facility to store this workwear when leaving the soiled work zone?				
	Does the laundry ensure staff wear hygienically clean outerwear when in the clean area?				
	Is there a facility to store this workwear when leaving the clean zone?				
	Are toilet facilities located outside work areas beyond hand wash and clothing stations?				
	Other than risk assessed water stations, are food and drinks kept out of work zones?				
Cleaning	<p>Is there a documented cleaning plan for the laundry detailing:</p> <ul style="list-style-type: none"> • Priority? • Frequency? • Methods? • Materials? • Equipment? • Cleanliness standards? • How to measure effectiveness? 				
	Are cleaning staff trained in hygienic principles and cleaning techniques?				
	Is cleaning carried out by critical areas (surfaces in contact with textiles and immediate environments) first, back to front of surface?				
	Is the cleaning plan followed using specified methods, materials and				

	equipment to required standards at the relevant frequency?				
	Is separate equipment and materials used for soiled work areas?				
	Are surfaces coming in to contact with disinfected textiles regularly sanitized?				
Other Prerequisites	<p>Focussing mainly in finishing zones and on water, is there a schedule (and followed) or active sampling for sampling and testing for biocontamination using swabs of:</p> <p>Key surfaces/materials?</p> <p>Raw water?</p> <p>Stored water?</p> <p>Water at the point of rinsing?</p>				
	Does the laundry implement pest control measures through an independent provider at food or healthcare specific levels to address crawling and flying risks?				
	Are pest control assessment reports provided at least 8 per year?				
	<p>Are all inappropriate materials removed or disqualified?</p> <p>All work surfaces to be washable.</p> <p>Wood is not acceptable in finishing areas. Glass needs to be shatterproof encapsulated (fluorescent light coverings)</p>				

Operational Pre-requisites	<p>Are all sources of biocontamination in the clean processing area minimised and controlled for:</p> <ul style="list-style-type: none"> • Airborne? • People? • Liquids? • Materials? • Equipment? • Textiles? 				
	<p>Are control points identified in the process where additional measures are required e.g. hand hygiene at finishing workstations, cleaning of work surfaces coming in to contact with disinfected textiles?</p>				
	<p>Are laundered textiles protected from recontamination until packaged?</p>				
	<p>Are all walls, floors, equipment and work surfaces in clean work areas washable or at least moist wipeable?</p>				
	<p>Are surfaces coming in to contact with disinfected textiles regularly sanitized?</p>				
	<p>Is the laundering process completed without delay once started?</p>				
	<p>Are there clear specifications and limits for laundry process steps for:</p> <ul style="list-style-type: none"> • accurate weighing? • Washing? • Drying? 				
	<p>Has a qualified Microbiologist or laboratory been engaged?</p>				
	<p>Are recognised testing techniques used, with reports from the qualified</p>				

	Microbiologist addressing identification/classification, enumeration of species, total bioburden and interpretation of results.				
	Is a set schedule of testing with frequency, targeted and random sampling in place and adhered to? See example tables on page 13 of the interim standard.				
	Does the schedule include focus on CP's surfaces that come in to contact with disinfected textiles: <ul style="list-style-type: none"> • Water? • Hands? • Equipment? • Tables? • Conveyors? • Primary packaging? • Shelving? • Transport containers? • Truck holds? • Random Surfaces? • Wash process bio indicators? • Moist clean linen? • Dry clean linen? 				
	Are targets set (possibly by the customer) for maximum colony forming units (CFU/dm ²)?				
	Is microbiological data used to track performance, learn, respond to variations and trends?				
Monitoring and measuring	Is mains sourced water tested at least quarterly to ensure it is potable?				
	If well or surface water, is this tested at least monthly, filtered or treated until consistent compliance with				

	potable water standards is met? Then quarterly				
	Are samples taken from raw untreated and process (at the wash equipment) waters?				
	Is steam used in linen contact processing clean and free from pyrogens?	?			
	Is air used in linen contact processing and in the clean linen areas filtered and not contaminated from soiled areas?				

Isolation & Surgical Gowns Processing	Do all gowns have labels for: Washing instructions? Dated usage Grid? Reusable Isolation Gown?			
Washing recommendations to be used in conjunction with manufacturer instructions.	Are laundry staff aware of manufacturer's instructions for washing and drying?			
	Are strict washing machine load limits in place in compliance with manufacturer and detergent supplier recommendations? Typical load for polyester is 65-70% of normal limit.			
	Is pH below 10 in wash stages?			
	Is non-ionic detergent used?			
	Where oxidizing bleaching agents (hypochlorite, hydrogen peroxide, per(oxy)acetic acid (PAA) are used, is it in consultation with competent detergent suppliers?			
	Are wash temperatures in line with manufacturers guidance			

	and adequate to meet disinfection requirements?			
	Is there a gradual cooling process to 40°C to avoid creasing?			
	Is fabric neutralised to achieve pH of 6?			
	Is fabric rinsed thoroughly to remove all traces of surfactant?			
	Are fabric conditioners avoided?			
	Is low speed spinning used to minimise creasing?			
Tumble Drying	Are garments dried at a controlled temperature to ensure the textile is not exposed to a temperature exceeding 75°C?			
	Is there a controlled cool down period to minimise creasing?			
	Are garments inspected and folded immediately after tumbling?			
	Are tumblers positioned for clean air intake?			
Tunnel Finish Dryer	Are garments dried at a controlled temperature to ensure the textile is not exposed to a temperature exceeding 75°C?			
	Is entry steam turned off at the first drying stage to protect the fluorocarbon finish?			
	Have trials been carried out on tunnel finisher processing as recommended by the garment/fabric manufacturer?			
	Are gowns secured to avoid falling off hangers?			
	Is the dryer exit in a clean segregated inspection area?			

Inspecting	Has the laundry confirmed lighting levels in the inspection area are greater than 500 lux level?			
	Are 100% of gowns visually inspected for damage (no holes), integrity, dryness (bone dry on cuffs)?			
	Are there back-lit inspection tables or alternative providing back lighting (from below/behind the garment)?			
	Are damaged garments removed for repair/disposal?			
	Are damp garments returned for reprocessing?			
	Are garments checked for the correct labelling and marked with an impermeable pen as washed on the grid? Is this something laundry staff should be doing?			
Folding/Hanging	Are garments folded neatly? e.g. 2 lateral 2 cross			
	Where machine folding, are static checks made?			
Packaging	Is there a customer specification?			
	Are garments packed to customer requirements?			
	Does the laundry have the ability to pack to single or multi pack using food grade LDPE or equivalent?			
Tracking	Is performance monitoring and age of product in place, removing any garments at the end of intended life?			
	Are gowns tracked through every laundry process?			

	Are the number of washes tracked using RFID chip, barcode or grid on garment?			
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Collect the garments from the customer				
	Is there a risk assessment (onsite or shared by the customer)?			
	Has the customer been instructed on the exact requirements for collection?			
	Is there a contract with detailed understanding and agreement?			
	Is there a risk assessment relating to the vehicle?			
	Is the vehicle prepared appropriately (with measures to manage the risks identified) including regular sanitization of cargo areas, particular attention to doors (inside and out) and inner walls?			
	Have drivers been effectively trained including Covid-19 risks and measures?			
	Is appropriate PPE issued to drivers based on risk assessments?			
	Is the National guide used/referred to?			
	Do procedures make special reference to handling infective work?			
	Is there a policy on handling infective work?			

	Are drivers/handlers trained on handling infective work (enabling effective decision making)			
	Are drivers trained effectively on hygiene practices including hand sanitization?			
	Do drivers ensure soiled and clean textiles are segregated at all times by using sealed containers, cages, cage hoods or barriers?			
	Do procedures limit contact between staff, vehicles and soiled goods?			
Deliver to the laundry				
	Is there good planning and preparation of the route?			
	Are there policies and procedures for segregation of clean/soiled work?			
	Is there effective training on agreed delivery procedures?			
Prepare the laundry to receive work				
	Is there a defined dry soiled storage area? Is this used?			
	Does the laundry ensure soiled textiles cannot enter the clean work area (without washing)?			

Design and construct the necessary soiled work reception, storage, signage and connection/route to wash area				
	Does the laundry classify and segregate soiled and infective linen?			

	Does the laundry segregate healthcare from non healthcare textile items?			
	Are clean and soiled textiles segregated at all times?			
	Does the laundry avoid storing soiled textiles overnight?			
	Are there specified and selected laundry skips/roll pallets, liners, covers, etc			
	Is a cleaning regime for floor, racking, skips implemented?			

Modify washer extractors to comply with for example, the UK NHS HTM01-04 technical guidance	Have machines for infective work processing been selected and allocated?			
Study the machine operation and programme controls along with the detergent supplier	Have any modifications been identified and implemented?			
Process monitoring (data logging) may be available in the machine functionality	Is air routed to safe discharge outside the building away from windows and ventilation inlets? Annex B & HTM01-04			
	Are effluent drains from laundry machines sealed to the manhole outside the laundry or if a sump, is this covered to prevent bacteria spreading by aerosol?			
	Is a cleaning regime in place with a 24h protection disinfection?			
	Are wash process programmes defined, implemented and written?			
	Does the laundry liaise closely with detergent supplier for			

	service support and training of staff?			
	Has consideration been given to the use of data logger or alternative process validation methods?			
	What logging is in place to specify, record and comment on each load processed by each machine?			
General comment on data logging, reference for example the UK NHS technical guidance HTM0104; 6.1 - 6.22	Are measuring instruments subject to planned preventative maintenance and annual calibration to manufacturers recommendations? Auditor to view records and plans			
	Are instruments labelled with calibrations dates?			
	Was a reference instrument with a valid calibration certificate traceable to national standards?			
	Are electronic monitoring/test instruments located away from draughts and rapid temperature variations and manufacturer's instructions followed?			
	If analogue recorders are used, do they comply with BS3693 for displays and potentiometric sensor systems with BS5164?			
	Where digital recorders are used, are they validated in accordance with ISO 9001?			
Temperature recording HTM01-04; 6.23 - 6.36	Are temperature sensors platinum resistance compliant with IEC 751 class A or thermocouples compliant with IEC 584 tolerance class 1?			
	Are temperature recording systems consistently within +/- 1° C in a known source and =/- 0.5°C after calibration?			

	Are thermometric recorders used, recording from a minimum of three sensors?			
	Does the scale range include expected maximum and minimum values of the operating cycle (normally 10°C to 110°C)?			
	If analogue instrument is the minor mark interval lower than 1K with a chart speed of not less than 10mm per minute?			
	If digital, does the instrument register and record increments of no more than 0.1K?			
Pressure and water meters	Does the pressure measurement recorder have an error of no more than 1% of maximum specified operating pressure?			
Transducers	Do transducers conform to BS 6447 or equivalent standard?			
	Is the natural frequency of the sensor and connected tubing 10Hz or greater with a time constant for rising pressure no greater than 0.04s?			
Gauges	If a pressure gauge is needed, do they conform to BS 837-1, size 150mm and accuracy class 0.25?			
	Are gauges laboratory tested annually, as per BS 837-1?			
Water Flow	Is a water meter conforming to ISO 4064-1 Class A used?			
	Does the meter operate up to 90°C and supply water up to 16 Bar with a minimum scale of 0.1L or less and designed flow at 1025L/min? Alternatively, is the system compliant with ISO 4064 -1 class B or C or BS EN 15154?			

	Is the meter calibrated at least annually using volumetric or gravimetric measurement?			
	Is there perpetual monitoring and testing of the m/c performance?			
Liquid Chemical Additives Proof of its functionality should be undertaken within a written procedure agreed between the laundry and the detergent supplier. See HTM01-04; 6.45 - 6.83	Are flow sensors designed to monitor flows of 0-2 L/min linked to data loggers?			
	Is the sensor suitable for viscosity 0.8-20 centistokes and designed to operate at up to 70°C with a supply pressure up to 10 bar?			
	Is the sensor suitably calibrated for the fluid to be measured?			
	Does the meter have a scale of 10mL or less and is designed to measure flow rates ranging from 50 to 1500mL/min?			
	Does the liquid chemical system have an accuracy of +/- 2.5% deflection?			
	Is the calibration of the meter verified by flowing to a collecting vessel comparing by gravimetric or volumetric measurement?			
Other Instruments - chemical disinfection	Is volumetric measurement used using a graduated vessel complying with BS 5898 or ISO384?			
	Alternatively, is density measured and converted to volume (where liquid density is known)?			

	In either of the above two points is measurement accurate to +/- 2%			
Testing of Washers used in the laundry	Are disinfection processes validated before use?			
	Is performance of the process monitored during routine use?			
	Is there a suitable maintenance program in place?			
	Is the calibration of all controls and instruments verified?			
	Are tests carried out after repairs or modifications to one or more components that influence the attainment of critical disinfection?			
Installation Qualification	Does the laundry have records of installation checks?			
Checks on ancillary equipment	Was ancillary equipment installed before validation began?			
	<p>Are checks made to ensure equipment:</p> <ul style="list-style-type: none"> • Is installed correctly? • Is adequate to meet demand? • Has no leaks? • Drains remove effluent effectively when operating? • Water treatment plant operates correctly and supplies correct quality of water for disinfection stage. • To ensure the ventilation discharge system duct is not blocked and exhaust air is discharged safely? 			
Additional checks for washers using chemical disinfections	Is there a risk assessment relating to use of chemicals, e.g., to ensure COSHH compliance?			

Additional checks for washers using chemical disinfections	Was the installation to manufacturer's specification?			
	Is airflow in the direction away from the operator and towards equipment?			
	Has it been confirmed airflow is not from the plant room or chemical storage area to the loading/unloading area?			
	Is airflow non recirculating and confirmed as conforming to relevant safety standards?			
	For chemical discharge to drains, is the drainage system trapped, sealed and vented to a safe place?			
	Has the drainage system been checked to ensure it is not possible for toxic materials to be vented into other parts of the laundry?			
	If a change in chemical, is there a documented process and records that repeat performance qualification tests have been carried out to validate the new process?			
Schedule of periodic tests	Are quarterly performance tests carried out after planned maintenance tasks?			
	Is there annual revalidation testing?			
	Is there a schedule of tests to include: Monthly <ul style="list-style-type: none"> • Automatic control • Bacillus cereus Quarterly <ul style="list-style-type: none"> • Safety checks • Automatic control 			

	<ul style="list-style-type: none"> • Verification or calibration of washer instruments • Chemical vapour emission (where chemical disinfection) • Chemical dosing (where chemical disinfection) • Bacillus cereus <p>Yearly</p> <ul style="list-style-type: none"> • Safety checks • Automatic control • Verification or calibration of washer instruments • Chemical vapour emission (where chemical disinfection) • Chemical dosing (where chemical disinfection) • Thermometric test for disinfection stage • Microbiological test for disinfection stage • Bacillus cereus 			
General Test Method	Were automatic control tests carried out?			
	Were results positive or action needed?			

Modify CTWs to comply with HTM01-04 requirements -do we need listed seperately	This section may require input from the manufacturer and the chemical supplier			
	Have any machine modifications been carried out?			

	Have drains and vents been modified to provide safe discharge?			
	Do vents discharge/terminate to a safe point outside the building?			
	Are effluent drains shielded/covered in and sealed?			
	Is a cleaning regime in place?			
	Are wash process programmes defined, implemented and written?			
Process monitoring (data logging) may be available in the machine functionality	Were detergent suppliers liaised with for service support and training of staff?			
	Are data loggers used or an alternative for process validation? Note alternatives			
	Is machine specific logging implemented, recording and commenting on each load processed?			
	Are press, extractor and dryers included in the logs and record comments?			
	General comment on data logging, reference HTM0104; 6.1 - 6.22			
	Temperature recording reference HTM01-04; 6.23 - 6.36			
	Pressure and water flow measurement are not so critical (6.37 - 6.44)			

Design and implement quality control procedures				
	Do procedures cover work from receipt at laundry, to despatch?			
	Does the laundry team liaise closely with detergent supplier for development of procedures and continue to do so where needed in relation to and amendments?			
	Is there visual inspection of the work at point of unloading washing m/c?			
	Are items re-washed as required?			
	Are loaded barrows/containers covered with protective sheet?			
	Where the same container is used for transferring soiled and then clean textiles, is this disinfected after every use?			
	Are machines drained of any used water at the end of the day to avoid overnight holding?			

Design and implement route for work to be transferred to drying/finishing area.				
	Is the route marked out and with appropriate signage?			
	Are containers/wash barrows cleaned using a standard process at all necessary stages, ensuring they are ready for next use?			

Design and implement modifications required for dryers, tunnel finishers, callenders, etc	Design and specify finishing programme for all classifications of textiles			
	Were manufacturers consulted?			
	Give details of any modifications made?			

Design and implement packaging equipment and procedures				
	Was the customer consulted on packaging requirements?			
	Does the laundry ensure there is a full packaging solution (primary layers, outer bags, boxes, transport containers etc.) ?			
	Is the linen protected from contamination until the point of handover to the end user and is capable of preserving the linen until the point of use?			
	Is there clear and consistent accountability, responsibility and authority to take effective corrective actions, consistently with records of			

	decisions and tracking of linen?			
	Provide evidence that corrective actions as described are in use?			
	Is there an audit report to prove that these systems work as intended?			

Design and implement clean work storage in despatch area				
	Is the storage area clearly marked out, signed and with signed storage/ racking facilities?			

Prepare vehicles for clean work delivery to customer	Are delivery staff trained, competent and certified on segregation, hygiene, vehicle cleaning and load order procedures?			
	Do delivery staff follow all the correct procedures?			

Deliver work to customer				
	Has the procedure for delivery/offloading at the customers site been risk assessed?			
	Has a delivery/receipt of goods confirmation document been designed and implemented?			