



**Summary of Substantive Changes  
between the 2009 and the 2014 editions, including the November 2011 addenda, of  
NSF/ANSI 4 “Commercial Cooking, Rethermalization, and Powered Hot Food  
Holding and Transport Equipment”**

**Presented to the IAPMO Standards Review Committee on January 12, 2015**

**General:** The changes to this standard should not have an impact on currently listed products. The substantive changes are:

- Moved the unit extraction testing of beverage equipment in former normative Annex B to NSF 51 to avoid duplication of requirements (see Section 4.6 and Annex B).
- Changed the requirement for covers from *readily removable* to *readily accessible* (see Section 5.13.5).
- Changed the requirement for glass materials from compliance with the impact test of ANSI Z97.1, UL 197 or BS857:1967, to compliance with the applicable requirements in NSF 51 (see Section 5.29).
- Added marking requirements for non-hazardous food warming equipment (see Section 5.48).
- Added an exception for the compliance of non-hazardous food warming equipment with the internal temperature performance requirements (see Section 6.1.1).

Section 4.6, Beverage equipment: Moved the unit extraction testing of beverage equipment in former normative Annex B to NSF 51 and changed the reference as follows:

*Beverage equipment having brass or bronze components in contact with tea, coffee, or water (as permitted under NSF/ANSI 51) shall not impart a lead (Pb) concentration greater than 15 µg/L when tested in accordance with ~~annex-B~~ [NSF/ANSI 51](#).*

Section 5.13, Covers: Changed the requirement for covers from readily removable to readily accessible as follows:

5.13.5

*All surfaces on the underside and beneath covers shall be readily ~~removable~~ accessible and easily cleanable.*

Section 5.29, Breakable glass components: Changed the requirement for glass materials from compliance with the impact test of ANSI Z97.1, UL 197 or BS857:1967, to compliance with the applicable requirements in NSF 51 as follows:

*5.29.3 ~~Glass, other than light fixtures, that may be subject to contact during use and routine maintenance and cleaning shall conform to the impact test in ANSI Z97.1, or to the impact test within ANSI/UL 197, or to the impact test within BS857:1967~~ Glass shall conform to the requirements in NSF/ANSI 51 applicable to the zone in which the glass is used.*



Section [5.48 Food warming equipment](#): Added marking requirements for non-hazardous food warming equipment as follows:

[Food warming equipment intended solely for the display of foods that are not potentially hazardous shall have a permanently attached label that states: "Not for the storage or display of potentially hazardous foods." The label shall be clearly visible to the user after installation of the equipment.](#)

Section 6.1, Enclosed hot food holding equipment and hot food transport cabinets: Added an exception for the compliance of non-hazardous food warming equipment with the internal temperature performance requirements as follows:

*6.1.1 Performance requirement*

*Enclosed hot food holding equipment and hot food transport cabinets shall be capable of maintaining an internal air temperature of 150 °F (65 °C) or greater when tested in accordance with 6.1.2. There shall be no stratification in cabinet air temperature greater than 25 °F (14 °C).*

*NOTE 1 – Hot food holding wells in display cases shall conform to 6.2.1 of this Standard. If the case is also designed for holding hot food in the enclosed air space above the wells, 6.1.1 shall also apply.*

*NOTE 2 – These requirements shall also apply to ovens designed to hold hot food after cooking is complete.*

*NOTE 3 – These requirements shall not apply to proofing boxes and proofing cabinets.*

[NOTE 4 - These requirements shall not apply to heated food holding equipment marked "Not for the storage or display of potentially hazardous foods." The marking shall be permanent and clearly visible to the user upon installation of the equipment.](#)

Removed normative Annex B as follows:

~~[Annex B, Method for conducting in-unit extraction testing of beverage equipment](#)~~