**ABC Restaurant**

**123 Main Street**

**King County, WA**

**Hazard Analysis Critical Control Point (HACCP) Plan**

**Shelf Stable, Not-Heat Treated Cured Meat Product**

**Smoked/Cured Meat Products:** (provide full list of products)

**Processing:** A shelf-stable dry fermented product must achieve, pH ≤ 5.3; Aw 0.85 -0.93; salt 4.0-4.5%

Dried to remove 25 – 50% of the moisture

Additional, if used, Sodium Nitrite at 6.25% = .25 lbs. cure per 100 pounds of meat to achieve <156 ppm nitrite in product (9 CFR 318.7).

Ingredients used: (provide list of ingredients)

Complete recipes will be kept on file at establishment for review by Public Health.

**Provide supporting documentation which validates the process by an accredited authority and/or finished product has confirmed laboratory testing with results showing critical limits were achieved through out the processing steps.**

**Resource:**

Ready-to-Eat Fermented, Salt Cured, and Dried Products Guideline:

<https://www.fsis.usda.gov/sites/default/files/media_file/documents/FSIS-GD-2023-0002.pdf>

**FLOW DIAGRAM: Shelf Stable, Not-Heat Treated Cured Meat Product**

Dry Storage

**Weigh Cure**

**CCP # 1**

Receiving Meat

Cold storage

Prepare ingredients – Cut and weigh meat and weigh spices.

Receiving Dry Goods

Mix - meats, spices, cure, acidification, and water

*(list products*

*being produced)*

**Fermenting CCP # 2**

Achieve pH of 5.3 or less within time/temperature established parameters for proper acidification.

**Drying CCP # 3**

Moisture/protein limitation with established drying time and temperature for pathogen control

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**Procedures: Shelf Stable, Not-Heat Treated cured meat products**

1. **Receiving Meat:** Verify meat products are at or below 41˚F and do not show signs of distress. Reject meat products with temperatures higher than 41˚F or those that have signs of damage.
2. **Cold Storage:** Store meat under refrigeration in cooler at 41˚F or less or in freezer set to maintain products frozen.
3. **Dry Storage:** Store dry goods in clean location that is separated from any potential sources of contamination.
4. **Prepare Ingredients:** Review the recipe to confirm that all required ingredients are on hand. Assemble spices, binders/extenders, cure agents, casing, containers, meat, etc. in the work area.
5. **Weigh out curing agent (CCP #1):** Weigh out specific cure identified in recipe using digital scale with verified accuracy.
   * **Critical Limit:** Cure Mixture with Sodium Nitrite at 6.25% = .25 lbs. cure per 100 pounds of meat to achieve <156 ppm nitrite in product (9 CFR 318.7).
   * **Monitoring:** Use digital scale to weigh amount of cure added to each batch.
   * **Corrective Action:** Add or remove cure to scale to get correct weight.
   * **Records:**  Document on Batch Record Log Sheet.
   * **Verification:** Manager on Duty will verify that designated employees have taken the required temperatures by visually monitoring employees during their shift and sign off on Batch Records weekly.
6. **Mix:** Addmeat and cure/seasoning/water and mix thoroughly.
7. **Prepare Casings and Stuff:** Rinse casings until salt taste is minimal. Find ends of casing and put over container edges. Put casing on sausage horns of stuffer. Put meat in stuffer. Turn on and appropriate speed and stuff casings.
8. **Fermenting CCP # 2:** Achieve pH of 5.3 or less within time/temperature established parameters for proper acidification. (identify each of these processing procedures to complete your HACCP plan)
   * **Critical Limit:** type/brand/mix of acidification
   * **Monitoring:**
   * **Corrective Action:**
   * **Records:**
   * **Verification:**
9. **Drying CCP # 3**: Moisture/protein limitation with established time and temperature for pathogen control. (identify each of these processing procedures to complete your HACCP plan)
   * **Critical Limit:**
   * **Monitoring:**
   * **Corrective Action:**
   * **Records:**
   * **Verification:**

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| **(1)**  **Critical Control Points** | **(2) Significant Hazards** | **(3) Critical Limits** | **Monitoring** | | | | **(8) Corrective Actions** | **(9) Verification** | **(10) Records** |
| **(4) What** | **(5) How** | **(6) Frequency** | **(7) Who** |
| **CCP #1**  Weigh out cure and meat products | Chemical: Nitrites | Cure with Sodium Nitrite at 6.25% = .25 lbs. cure per 100 pounds of meat to achieve <156 ppm nitrite in product. | Weight of cure added to mixture | Weigh cure out using digital scale | Each batch | Trained Staff | Adjust cure weight until at  .25 lbs. cure per 100 pounds of meat. | Batch record log will be reviewed for meeting CL, signed, and dated by manager prior to product being offered for sale. | Record Log: Sodium Nitrite added meat products. |
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| **CCP # 2**  **Fermenting** | pH  Temperature  Time  for  *Staphylococcus*  *aureus* control | Achieve pH of 5.3  or less within  time/  temperature  established  parameters for  *Staphylococcus* control.  Follow validated  pH, time/  temperature  protocols for E. coli  control. | Responsible plant employee should monitor established temperature and time parameters. (For, example, monitor product temperature twice daily.) | pH meter | Each batch | Trained Staff | Place product on  hold, evaluate.  significance of  deviation, and utilize plant established  procedures for  product disposition.  Evaluate cause of deviation and take action to prevent reoccurrence. | Periodic pH meter  Calibration  (i.e., weekly)  Periodic observation  and/or weight  measurement  checks (i.e., daily) | Fermentation log  pH meter  calibration log  Hold summary  log  Verification log  Deviation/  corrective action log |
| **CCP # 3**  **Drying** | Drying | Established time  and temperature to achieve Aw 0.85-0.93  Control as  specified  in the  regulations  for trichinae  and/or  studies  which  validate *E.*  *coli*  O157:H7  control. | Designated plant  employee should  monitor product  weight loss (shrink)  (i.e., 5 randomly  selected products per  batch)  Designated plant  employee should  monitor drying  time/ temperature per batch. | Scale for monitoring weight reduction  Verify working thermometer for holding temperature | Each batch | Trained Staff | Place product on  hold, evaluate  significance of  deviation, and utilize plant established  procedures for  product disposition  (i.e., release, rework, condemn, etc.)  Evaluate cause of deviation and take action to prevent reoccurrence. | Periodic MPR testing (i.e., per lot).  Periodic observation  and/or weight measurement checks (i.e., daily) | Time/temp log  and/or Drying room recorder chart  Thermometer  calibration log  Scale calibration log  Hold summary  log  Verification log  Deviation/  corrective action log |

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**HACCP Plan Record Log is required for each separate production lot: Meat curing of not-heat treated and/or meat curing of heat-treated ready to eat products.**

Product production name:

Batch record log identification: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Date of production: Batch size total weight:

Units of weight used:

type of meat: \_\_\_\_\_\_\_\_\_\_\_\_\_ pounds of meat:

type of meat: \_\_\_\_\_\_\_\_\_\_\_\_\_ pounds of meat:

type of meat: \_\_\_\_\_\_\_\_\_\_\_\_\_ pounds of meat:

**Critical Control Point:** Nitrate Formulation

Critical Limit: Sodium Nitrite at 6.25% = .25 lbs. cure per 100 pounds of meat to achieve <156 ppm nitrite in product.

Type/Brand of curing product or agent:

Amount of cure by weight used: \_\_\_\_\_\_\_

**Critical Control Point:** Fermentation

Critical Limit: Achieve pH of ≤ 5.3; salt 4.0-4.5%

Type/brand/mix of acidification or starter culture:

Fermentation temperature:

Target pH:

Time to reach target pH:

pH batch tested: yes\_\_\_\_ no\_\_\_\_

pH results from standard recipe with initial product lab tested: yes\_\_\_\_ no\_\_\_\_

**Critical Control Point:** Drying

Critical Limit: Moisture/protein limitation with established drying time and temperature for pathogen control to remove 25 – 50% of the moisture with Aw 0.85-0.93 in finished product.

Initial wet weight:

Target dried weight:

Drying time:

Final Aw achieved:

Aw batch tested: yes\_\_\_\_ no\_\_\_\_

Aw results from standard recipe with initial product lab tested: yes\_\_\_\_ no\_\_\_\_

Was the product heat treated: yes\_\_\_\_ no\_\_\_\_ If heat treated, final cook temperature achieved:

Product production completion date – ready for use:

Additional Batch Control Comments:

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**Thermometer Calibration Procedure**

\*You need a tip sensitive food probe thermometer to measure the temperature of a product. How to calibrate a thermometer.

To use ice-point method:

* Insert the thermometer probe into a cup of crushed ice.
* Add enough cold water to remove any air pockets that might remain.
* Allow the temperature reading to stabilize before reading temperature.
* Temperature measurement should be 32ºF (+ 2ºF). If not, adjust according to manufacturer’s instructions.

Employees will check the accuracy of the food thermometers:

* At regular intervals (at least weekly) and record finding on this Thermometer Calibration Log

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| **Thermometer Calibration Log**  **Instructions**: Foodservice employees will record the calibration temperature and corrective action taken, if applicable, on the Thermometer Calibration Log each a time thermometer is calibrated. The foodservice manager will review and initial the log. Record log sheets to be kept on file at least 6 months and available for review upon request by Public Health. | | | | | |
| Date | Thermometer  Being Calibrated | Temperature Reading | Corrective Action\* | Initials | Manager Initials/Date |
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**\*Corrective Action:** Follow manufacture instructions on how calibrate thermometer and/or discard and obtain a new thermometer if thermometer cannot be calibrated

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**Standard Sanitation Operating Procedure, (SSOP)**

**Cleaning and Sanitizing Food Contact Surfaces and Equipment**

Properly cleaned and sanitized food contact surfaces are critical to ensuring a safe, sanitary operation. Use of approved cleaners and sanitizers will reduce levels of pathogenic organisms to prevent cross contamination of the product.

This procedure applies to foodservice employees involved in cleaning and sanitizing food contact surfaces.

Wash, rinse, and sanitize food contact surfaces of sinks, tables, equipment, utensils, thermometers, carts, and equipment using the following procedure:

* Wash surface with detergent solution.
* Rinse surface with clean water.
* Sanitize surface using a sanitizing solution mixed at a concentration specified on the manufacturer’s label. Test the sanitizer concentration by using the appropriate test kit for the chemical.
* Place wet items in a manner to allow air drying.

Food contact surfaces of sinks, tables, equipment, utensils, thermometers, carts, and equipment shall be: washed, rinsed, and sanitized:

* Before each use.
* Between uses when preparing different types of raw animal foods, such as eggs, fish, meat, and poultry.
* Between uses when preparing ready-to-eat foods and raw animal foods, such as eggs, fish, meat, and poultry.
* Any time contamination occurs or is suspected.
* Food contact surfaces and utensils must be cleaned at least every four hours if used with potentially hazardous foods prepared in an ambient room temperature above 55°F.

**List of equipment and materials used in the process.** Equipment must meet ANSI standards, described in sections 4-1 and 4-2 of the FDA Model Food Code. Attached Specs from Manufacture

1. \_\_\_\_\_\_\_\_\_\_\_\_\_smoker
2. \_\_\_\_\_\_\_\_\_\_\_\_\_oven
3. \_\_\_\_\_\_\_\_\_\_\_\_\_stuffer
4. \_\_\_\_\_\_\_\_\_\_\_\_\_scale

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**Standard Operating Procedure, (SOP) - Personal Hygiene for Foodservice Workers**

To prevent contamination of food by foodservice employees.

* Report to work in good health, clean, and dressed in clean attire.
* Change apron when it becomes soiled.
* Wash hands properly, frequently, and at the appropriate times.
* Keep fingernails trimmed, filed, and maintained so that the edges are cleanable and not rough.
* Treat and bandage wounds and sores immediately. When hands are bandaged, single-use gloves must be worn.
* Eat, drink, use tobacco, or chew gum only in designated break areas where food or food contact surfaces may not become contaminated.

**Washing Hands** - To prevent foodborne illness by contaminated hands.

Use designated handwashing sinks for handwashing only. Provide warm running water, soap, and a means to dry hands.

Keep handwashing sinks accessible anytime employees are present. Do not use food preparation, utility, and dishwashing sinks for handwashing.

Wash hands:

* + Before starting work.
  + During food preparation.
  + When moving from one food preparation area to another.
  + Before putting on or changing gloves.
  + After using the toilet.
  + After sneezing, coughing, or using a handkerchief or tissue.
  + After touching hair, face, or body.
  + After smoking, eating, drinking, or chewing gum or tobacco.
  + After handling raw meats, poultry, or fish.
  + After any clean up activity such as sweeping, mopping, or wiping counters.
  + After touching dirty dishes, equipment, or utensils.
  + After handling trash.
  + After handling money.
  + After any time, the hands may become contaminated.

**Restrictions/Exclusion and Notification of Sick Food Workers**

Healthy food workers are important factors in foodborne illness prevention.

Food workers must inform the Person in Charge (PIC) if they have:

* Symptoms including diarrhea, vomiting or jaundice.
* A diagnosed illness from Salmonella Typhi, Shigella, Shiga toxin-producing E. coli, or hepatitis A
* Infected, uncovered wounds.
* Sore throat with fever.

The PIC must restrict or exclude food workers with these conditions.

**Notification:**

The PIC must notify the Health Department if a food worker has jaundice or a diagnosed illness that can be transmitted through food. Also notify the Health Department if a customer calls to report they got sick.

Call: 206-296-4774

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**Standard Operating Procedure, (SOP) - Training Program for HACCP Plan**

The employer is providing training to ensure the food stays safe for the customers.

Standard Operating Procedures, commonly called SOPs, are a detailed set of instructions, steps or procedures that control the operational conditions within a food establishment, which allow for environmental conditions favorable to the production of safe food. These written procedures are often equivalent to prerequisite programs of HACCP.

The employee is receiving the training needed to work the HACCP Plan, is taking responsibility for doing the work correctly and understands what the critical limits are to reduce hazards in the food and takes corrective actions in case the critical limits have not been achieved.

The employee will stop all production activity if a situation arises where SOP’s and or the HACCP Plan cannot be maintained and will consult with a Manager, Person in Charge, (PIC) as to what corrective action steps to take.

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| **Employee Food Safety Training Record**  **Directions:** Use this form to record food safety training provided to employees. Maintain this record on file for review upon request by Public Health. | | |
| Employee Name / Date | Training Provided By | Training and Materials Reviewed |
| *Joe Smith 1-10-2018* | *John, owner* | *HACCP plan and use of log sheets* |
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Employee acknowledges this training was provided by being listed on a company record training log with the names of individuals who have been approved to prepare foods under this HACCP Plan.