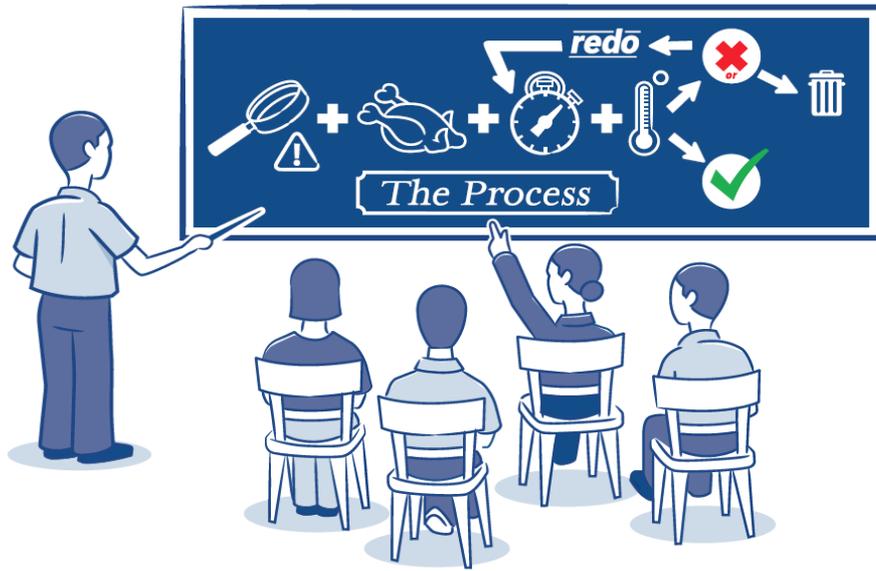


Sample Food Safety Plan MEETS BC REGULATORY REQUIREMENTS

TERIYAKI CHICKEN STIR-FRY GLUTEN FREE



Ministry of
Health

Product Description

| Product Description | |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1. What is your product name and weight/volume? | Teriyaki chicken stir-fry-gluten free (450 g) |
| 2. What type of product is it (e.g., raw, ready-to-eat, ready-to-cook, or ready for further processing, etc.)? | Cooked Ready to eat |
| 3. What are your product’s important food safety characteristics (e.g., acidity, A_w, salinity, etc.)? | None |
| 4. What allergens does your product contain? | Soya and sesame seeds |
| 5. What restricted ingredients (preservatives, additives, etc.) does your product contain, and in what amounts (e.g., grams)? | None |
| 6. What are your food processing steps (e.g., cooking, cooling, pasteurization, etc.)? | Receiving incoming materials, ambient storage, cool refrigerator storage, freezer storage, packaging material storage in a separate location, weighing, sauce cooking, rice cooking, sauce cooling, rice cooling, transfer to packaging tray, weighing, tray sealing, metal detecting, labeling, case packaging and labeling, palletizing, freezer storage, shipping. |
| 7. How do you package your product (e.g., vacuum, modified atmosphere, etc.) and what packaging materials do you use? | Chicken stir-fry is packaged in two-compartment plastic trays and sealed with polypropylene film. Packaged trays are packed in corrugated boxes. |
| 8. How do you store your product (e.g., keep refrigerated, keep frozen, keep dry) in your establishment and when you ship your product? | Keep frozen. Frozen chicken stir-fry packages are shipped in a clean, temperature-controlled truck (less than or equal to -18°C). |
| 9. What is the shelf-life of your product under proper storage conditions? | Frozen product shelf life is 3 months at freezer temperatures (less than or equal to -18°C). |
| 10. How is the best before date to be noted on your product? (When product shelf life is more than 3 month, lot code or manufacturing date is to be printed on product label.) | The best before date is printed on the cardboard sleeve as YY MM DD. Example: 15 JA 04 (January 04, 2015) |

| Product Description | |
|--------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <p>11. Who will consume your product (e.g., the general public, the elderly, the immunocompromised, infants)?</p> | <p>Ready to eat product for the general population.</p> <p>Note: Teriyaki chicken stir-fry is not suitable for people with soya and sesame seeds allergies.</p> <p>Frozen product must be thawed before eating.</p> <p>Preparation instructions, such as for thawing, are provided on the label.</p> |
| <p>12. How might the consumer mishandle your product, and what safety measures will prevent this?</p> | <ol style="list-style-type: none"> 1. Products not stored at correct temperatures can cause illness and can have quality defects – storage and handling instructions are on the label. 2. Products that have passed the best before date can cause illness and can have quality defects – the best before date is printed on the cardboard box. 3. Refreezing can cause quality defects – storage and handling instructions are on the label. |
| <p>13. Where will the product be sold?</p> | <p>Food service, retail, wholesale and distributor.</p> |
| <p>14. What information is on your product label?</p> | <p>Individual product label contains information such as product name, weight, ingredients listing including allergens, nutritional table, claim, storage and handling instructions, best before date, preparation instructions, manufacturing company name, address and contact information.</p> <p>Corrugated box label contains information such as product name, best before date, quantity, storage and handling instructions, preparation instructions, manufacturing company name, address and contact information.</p> |

Incoming Materials

| Ingredients | |
|-------------------------------------------------------------|-----------------------------|
| Diced raw chicken pieces | Soya sauce |
| Diced vegetables (carrots, broccoli, bok choy and shallots) | Hot pepper sauce |
| Green snow peas | Rice wine vinegar |
| Minced garlic and ginger | Chicken stock |
| Vegetable oil | Rice |
| Sesame seed oil | Water |
| Food contact processing aid materials | |
| None | |
| Food contact packaging materials | |
| Two-compartment plastic trays | Polypropylene plastic films |
| Non-food contact packaging materials | |
| Pre-printed cardboard boxes | Tape |
| Corrugated boxes | Shrink wrap |
| Plain labels | Wooden pallets |
| Ink | |
| Chemicals (hand washing, sanitation and maintenance) | |
| Hand soap | Sanitizer |
| Hand sanitizer | Lubricant |
| Degreaser | |

Food Safety Plan Table: Meets BC Regulatory Requirements

| 1. Identifying Hazards (Regulatory Requirement*) | 2. Identifying Critical Control Points (Regulatory Requirement*) | 3. Establishing Critical Limits (Regulatory Requirement*) | 4. Establishing Monitoring Procedures (Regulatory Requirement*) | 5. Establishing Corrective Actions (Regulatory Requirement*) | 6. Establishing Verification Procedures (Pending Regulatory Requirement) | 7. Keeping Records (Pending Regulatory Requirement) |
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| <p>Biological hazard: Pathogen survival due to improper agitation, improper temperature distribution, and/or improper application of time / temperature combinations (e.g., <i>Salmonella</i> spp., <i>Clostridium botulinum</i>, <i>Clostridium perfringens</i>, <i>Campylobacter jejuni</i>, <i>Escherichia coli</i> and <i>Escherichia coli</i> 0157:H7, <i>Yersinia</i> spp., <i>Listeria monocytogenes</i>, <i>Vibrio vulnificus</i>, <i>Staphylococcus aureus</i> and enterotoxin)</p> | <p>CCP # 1 Sauce cooking</p> | <p>The internal temperature of the product must be at least 74°C (165°F) for a minimum of 15 seconds.</p> <p><u>Definitions:</u> <i>Internal temperature:</i> The internal temperature is a temperature reading taken from the center of the product (in this case, chicken pieces in the sauce)</p> | <ol style="list-style-type: none"> 1. Measure the product’s internal temperature (i.e., of two samples collected from different areas of the kettle) once the operator believes the sauce is finished cooking. These temperature readings must be taken each time a batch of sauce is cooked. 2. Calibrate the thermometer to ensure it is working correctly before measuring the product’s internal temperature. 3. Insert the thermometer into the centre of the chicken pieces in the sauce and wait until the thermometer reading is steady. 4. Record the results on the “Daily Sauce Cooking Record,” including the date, the time, and initials. | <p>When critical limits are not being met for one or both samples</p> <ol style="list-style-type: none"> 1. The sauce will be cooked for a longer period of time until the product’s internal temperature reaches a temperature greater than or equal to 74°C (165°F) for a minimum of 15 seconds. If the limit cannot be met, the product must be destroyed. 2. Investigate the cause of the non-conformance and take necessary corrective actions to prevent reoccurrence. 3. Record all non-conformances and corrective actions taken on the “Daily Sauce Cooking Record,” including the date, the time, and initials. | <ol style="list-style-type: none"> 1. At the end of each production day, review the “Daily Sauce Cooking Record” to ensure that it has been properly completed. 2. Once per week, ensure that the monitoring of the temperature check follows the written monitoring procedure. 3. If non-conformance is found during the verification procedure, investigate the cause of the non-conformance and take necessary corrective actions to prevent reoccurrence. 4. Record all observations (e.g., temperature readings, non-conformances, and corrective actions) on the “Daily Sauce Cooking Record,” including the date, the time, and initials. | <p>Daily Sauce Cooking Record</p> |

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| <p>Biological hazard: Pathogen contamination due to inadequate cooling (e.g., <i>Clostridium perfringens</i>, <i>Listeria monocytogenes</i>)</p> | <p>CCP # 2 Sauce cooling</p> | <p>During cooling, the product’s internal temperature must not remain between 60°C (140°F) and 20°C (70°F) for more than 2 hours. The product’s internal temperature must not remain between 60°C (140°F) and 4°C (40°F) for more than 4 hours.</p> | <ol style="list-style-type: none"> 1. Measure the product’s internal temperature every hour during cooling. 2. Calibrate the thermometer to ensure it is working correctly before measuring the internal temperature of the product. 3. Measure the product’s internal temperature from different trays of the trolley (top, middle, and bottom) at each check. 4. Insert the thermometer into the centre of the product and wait until the thermometer reading is steady. 5. Record the results from the three readings from different trays on the “Daily Sauce Cooling Record,” including the date, the time, and initials. | <p>When critical limits are not being met for one or more samples</p> <ol style="list-style-type: none"> 1. Immediately place all products that do not meet the critical limit on hold. 2. Products put on hold must be re-cooked and re-cooled to meet the critical limit. If the critical limit is not being met, product must be destroyed. 3. Investigate the cause of the non-conformance and take necessary corrective actions to prevent reoccurrence. 4. Record all non-conformances and corrective actions taken on the “Daily Sauce Cooling Record,” including the date, the time, and initials. | <ol style="list-style-type: none"> 1. Review the “Daily Sauce Cooling Record” to ensure that it has been properly completed. 2. Once per week, ensure that the temperature check follows the written monitoring procedure. 3. If non-conformance is found during the verification procedure, investigate the cause of the non-conformance and take necessary corrective actions to prevent reoccurrence. 4. Record all observations (e.g., temperature readings, non-conformances, and corrective actions) on the “Daily Sauce Cooling Record,” including the date, the time, and initials. | <p>Daily Sauce Cooling Record</p> |

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| <p>Physical hazard: Presence of hazardous extraneous metallic material in the finished product due to the failure of the metal detector to detect metal and reject the product when metal is detected.</p> | <p>CCP # 3 Metal detecting</p> | <p>Metal detector must detect 2.5 mm ferrous, 2.5 mm non-ferrous, and 3.0 mm stainless steel test samples when the test samples are passed through the detector with the product. The metal detector must reject the product.</p> | <ol style="list-style-type: none"> 1. Test the metal detector at the start, every hour during packaging, and at the end of each packaging run. 2. Test the metal detector by passing a sample piece of metal through the detector to ensure that it is operating effectively and able to detect metal present in the product. 3. Check metal samples of 2.5 mm ferrous, 2.5 mm non-ferrous, and 3.0 mm stainless steel, one at a time. Each check must include all three sample tests. 4. Insert the metal sample into the middle of the product and then pass the product package through the metal detector. A properly operating metal detector must detect the metal sample in the product. 5. Each time a metal contaminant is detected, the metal detector belt must retract and the rejected product must | <p>A. When the metal detector fails to detect a metal test sample</p> <ol style="list-style-type: none"> 1. Immediately stop the line and place all products processed since the last successful check on hold. 2. All products processed while the metal detector was not functional must be held until they can be passed through a functional metal detector. <p>B. When a product is rejected by the metal detector</p> <ol style="list-style-type: none"> 1. Inspect the product for the metal piece. <p>For above listed non-conformances (A & B) investigate the cause of the non-conformance and take necessary corrective actions to prevent reoccurrence.</p> <p>Record all non-conformances and</p> | <ol style="list-style-type: none"> 1. At the end of each production day, review the “Daily Metal Detector Check Record” to ensure that it has been properly completed. 2. Once per week, ensure that the monitoring of the metal detector follows the written monitoring procedure. 3. If non-conformance is found during the verification procedure, investigate the cause of the non-conformance and take necessary corrective actions to prevent reoccurrence. 4. Record all observations (e.g., whether or not the detector is operating effectively, non-conformances, and corrective actions taken) on the “Daily Metal Detector Check Record,” | <p>Daily Metal Detector Check Record</p> |

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|------------------------------------------------------------|-------------------------------------------------------------------------|---------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------|---------------------------------------------------------------|
| | | | drop into the rejection box. 6. Record the metal sample check as acceptable (“✓”) (i.e., the metal detector is operating correctly) or not acceptable (“X”) (i.e., the metal detector is not operating correctly) on the “Daily Metal Detector Check Record,” including the date, the time, and initials. | corrective actions taken on the “Daily Metal Detector Check Record,” including the date, the time, and initials. | including the date, the time, and initials. | |

Daily Sauce Cooking Record
Critical Control Point # 1 (Biological)

Critical Limits: The internal temperature of the product must be at least 74°C (165°F) for a minimum of 15 seconds.

| Date | Time | Batch Number | Sample # 1 Temperature | Sample # 2 Temperature | Initials |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------|--------------|------------------------|------------------------|----------|
| 2015/11/02 | 12:00 | 1 | 78°C | 76°C | CC |
| 2015/11/02 | 13:04 | 2 | 74°C | 71°C | CC |
| 2015/11/02 | 16:00 | 3 | 76°C | 75°C | CC |
| | | | | | |
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| | | | | | |
| | | | | | |
| <p><u>Record non-conformance and corrective actions here:</u></p> <p>2015/11/02: Batch 2: The internal temperature of the product (sample # 2) did not reach 74°C. The product was baked again until the internal temperature reached 74°C. CC</p> | | | | | |
| Daily verification: MN | | | | Date: 2015/11/02 | |
| Weekly verification: ML | | | | Date: 2015/11/09 | |

Daily Sauce Cooling Record
Critical Control Point # 2 (Biological)

Critical Limits: During cooling, the product’s internal temperature must not remain between 60°C (140°F) and 20°C (70°F) for more than 2 hours. The product’s internal temperature must not remain between 60°C (140°F) and 4°C (40°F) for more than 4 hours.

Production Date: 2015/11/02 **Batch Number** 1

| Time | Top Tray Temperature | Middle Tray Temperature | Bottom Tray Temperature | Initials |
|------------------------------------------------------------|----------------------|-------------------------|-------------------------|----------|
| 12:30 | 66°C | 66°C | 64°C | CC |
| 13:04 | 36°C | 38°C | 36°C | CC |
| 14:05 | 19°C | 18°C | 16°C | CC |
| 15:04 | 9°C | 8°C | 6°C | CC |
| 16:06 | 1°C | 2°C | 1°C | CC |
| | | | | |
| | | | | |
| | | | | |
| <u>Record non-conformance and corrective actions here:</u> | | | | |
| Daily verification: MN | | | Date: 2015/11/02 | |
| Weekly verification: ML | | | Date: 2015/11/09 | |

Daily Metal Detector Check Record
Critical Control Point # 3 (Physical)

Critical Limits: Metal detector must detect 2.5 mm ferrous, 2.5 mm non-ferrous, and 3.0 mm stainless steel test samples when the test samples are passed through the detector with the product. The metal detector must reject the product.

Record the metal sample check as acceptable (“✓”) (i.e., the metal detector is operating correctly) or not acceptable (“X”) (i.e., the metal detector is not operating correctly)

| Date | Time | Batch Number | Product Name | 2.5 mm Ferrous | 2.5 mm Non-ferrous | 3.0 mm Stainless Steel | Initials |
|------------|----------------|--------------|---------------------------|----------------|--------------------|------------------------|----------|
| 2015/11/02 | 12:00 (start) | 1 | Teriyaki chicken stir-fry | ✓ | ✓ | ✓ | SM |
| | 13:05 | 1 | Teriyaki chicken stir-fry | ✓ | ✓ | ✓ | SM |
| | 14:07 | 1 | Teriyaki chicken stir-fry | ✓ | ✓ | ✓ | SM |
| | 15:37 | 1 | Teriyaki chicken stir-fry | ✓ | ✓ | ✓ | SM |
| | 16:04 | 1 | Teriyaki chicken stir-fry | ✓ | ✓ | ✓ | SM |
| | 17:05 | 1 | Teriyaki chicken stir-fry | ✓ | ✓ | ✓ | SM |
| | 17:44 (finish) | 1 | Teriyaki chicken stir-fry | ✓ | ✓ | ✓ | SM |

Record non-conformance and corrective actions here:

At 16:20, one package was rejected. The product was screened for a metal piece. A small piece (5 mm in size) of metal was found. Upon investigation, it appears that it came from one of the damaged belts. The belt was immediately removed and replaced with a new belt. SM

| | | |
|----------------------|----|------------------|
| Daily verification: | MN | Date: 2015/11/02 |
| Weekly verification: | ML | Date: 2015/11/09 |

