Answers

Receiving Area

1. An operator is responsible for unloading pallets of bagged flour from a semi-trailer and inspecting the semi-trailer and shipment received. What questions would you ask to evaluate the employee's knowledge of trailer inspections?
   - Can you explain what you are looking for during your inspection of the trailer?
   - What type of food safety issues have you noticed during other trailer inspections?
   - Have you had any reasons to reject trailers or products in the past? If so, what were the reasons?

2. Receiving operators are responsible for inspecting seals on bulk trailers of dry ingredients before unloading. What questions would you ask to evaluate the employee's knowledge of seal inspections?
   - Can you take me through the process of inspecting seals on trailers?
   - What do you do if a seal is broken or missing?
   - How do you know how many seals should be present and what the seal numbers are supposed to be?

Raw Material Warehouse and Cooler

1. Warehouse personnel are responsible for following first-in, first-out rotation practices for raw materials in the warehouse. What questions would you ask to evaluate the employee's knowledge of stock rotations practices?
   - Can you explain how you select which items to pull when requested by production?
   - What information on the pallets is used to follow the FIFO program?
   - What do you do if a newer material was accidentally used before an older item?

2. Wheat flour, dry milk powder, and soy flour are located in the warehouse and your company has an allergen segregation policy that includes like-over-like storage practices. What questions would you ask to evaluate the employee's knowledge of allergens in the warehouse?
   - What are the allergens in our warehouse?
   - Where are the allergens stored and what are the storage policies for allergens?
   - How do you know which allergens are in each of the pallets?

3. The cooler is to be maintained at 40°F or less. Employees are responsible for monitoring and documenting the temperature of the cooler at least once per shift. What questions would you ask to evaluate the employee's knowledge of temperature monitoring?
   - What is the temperature requirement for the cooler?
   - How often do you check the cooler temperature? Do you need to document these checks? If so, how is this done?
   - If the temperature is above 40°F, what do you do?

Production Area

1. Operators in production areas are responsible for general housekeeping during their shifts and during downtime. What questions would you ask to evaluate the employee's understanding of this requirement?
   - What are your housekeeping responsibilities?
   - What do you do during downtime?

2. Employees working in a mixing area are responsible for scooping ingredients from containers, dumping them into the mixer, and recording lot numbers. What questions would you ask to evaluate the employee's knowledge of lot traceability?
   - How are lot numbers of various ingredients recorded?
   - What do you do when an ingredient runs out and you transfer to a new one with a different lot number?
   - Why do you need to record ingredient lot numbers?

3. The process has a small rack style oven for baking products in a batch process. The temperature of at least one product on the bottom rack and one on the top rack must be checked for each batch that is baked. The internal temperature of the product must be 165°F. This is a critical control point in the HACCP program. What questions would you ask to evaluate the employee's knowledge of temperature checks?
   - Can you show me how temperatures are checked?
   - How do you document the temperatures?
   - What is the critical limit of the temperature check? If a product does not meet the critical limit, what do you do?

Packaging Area

1. Your facility produces and packages various types of snack bars. Some of the bars contain peanuts and others do not. The bars are packed in a clear plastic film and labels are then applied. Packaging operators are responsible for verifying that the correct label is present on the labeling machine and for recording the packaging lot numbers. What questions would you ask to evaluate the employee's knowledge of package procedures?
   - Can you explain how your duties in this area relate to food safety?
   - Why is it important to verify that the correct label is on the product?
   - How do identify the lot number of the plastic film being used and where is this documented?

2. The snack bars being produced pass through a metal detector once they are packaged and labeled. Employees are responsible for checking the metal detector on an hourly basis with three different test wands, 1.0 mm ferrous, 1.5 mm non-ferrous, and 2.0 mm stainless steel. This is a critical control point in your HACCP program. What questions would you ask to evaluate the employee's knowledge of metal detectors?
   - Can you show me how you check the metal detector?
   - What do you do if one of the test wands is not detected and/or rejected?
   - Can you show me how you record and document metal detector checks?
   - What do you do if you miss one of the hourly checks?

Answers

Cooling Unit on a Water Fountain

Observation: The interior of the floor-mounted water cooler located in the production area near line 4 was noted to have a significant accumulation of wet, rotted product debris. Numerous small flies were noted in the residue. Additionally, the base was badly rusted. Powdered residue was noted to have warehouse beetle cast skins and a few live adult beetles.

Significance of the observation:
This water fountain base has not been opened or cleaned for an extended period of time and has become a source of infestation and product contamination in the production area.

Immediate corrective action:
Since this water fountain appears to be beyond recovery, immediately remove the unit and clean all remaining debris and sanitize the floor area. Inspect all remaining units in the facility to ensure no issues exist with them.

Long-term corrective action:
Determine if a water fountain is needed in this location. If needed, select a unit that can be installed up off the floor and is easily accessible for maintenance and cleaning. Place the unit on the preventive maintenance and master cleaning schedules to ensure the unit is routinely inspected and cleaned to avoid cleaning or pest issues. Area inspections must include routine inspection of the units to make sure all are being properly maintained.

Answers

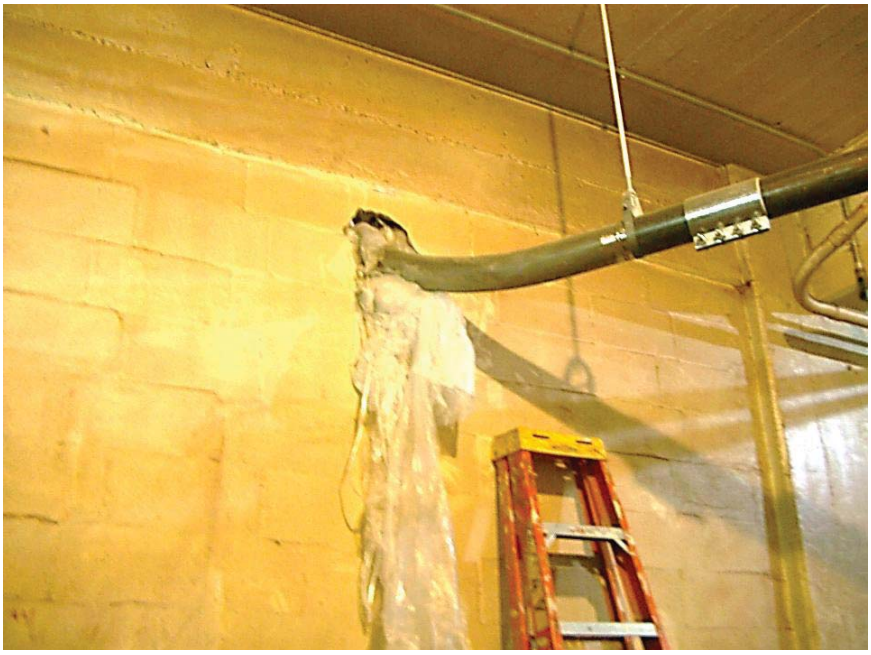
Oven Conveyors

Observation: A 2x4 piece of wood was noted between the transition between conveyors feeding the oven. Personnel indicated that maintenance was working on a piece of equipment next to this conveyor that morning and must have forgotten it there.

Significance of the observation:
If the system is turned on, there will likely be severe damage to the conveyors and a long delay for startup.

Immediate corrective action:
Remove the wood and discard. Attempt to identify who was working in this area and may have left the wood on the conveyer to inform them about the potential risks or initiate disciplinary action if needed.

Long-term corrective action:
Initiate post-maintenance inspection procedures. Review current work procedures and update to make sure issues are covered. Determine if there is a viable replacement for the wood as part of the materials used for repair.



Answers

Observation: Plastic sheeting is stuffed in the wall opening for the new ingredient line contractors recently installed. Discussions with personnel indicated that this work was done about nine weeks prior to the inspection.

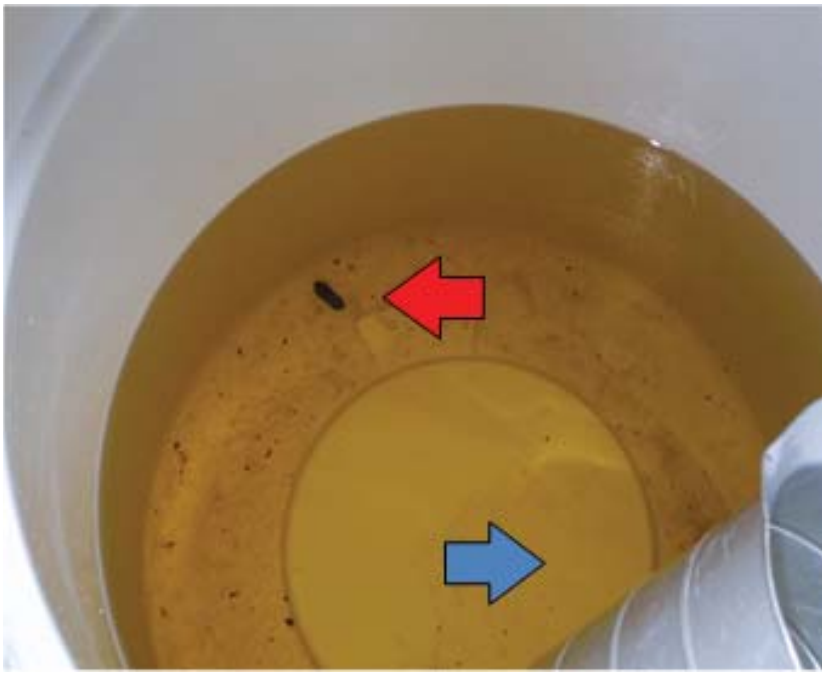
Significance of the observation:
This poorly thought out temporary repair appears to have become permanent. The method of this repair has created a collection point for product and insect activity. The self-inspection program for this area has been severely lacking and it reflects on the education and training of personnel who tolerated this for 9 weeks.

Immediate corrective action:
Remove all existing materials. Inspect for insect activity and address the activity if noted. Initiate a work order to have the opening properly sealed as soon as possible. Inspect other projects done by this contractor for job completion.

Long-term corrective action:
Review the contractor release criteria for job completion. If none exists, develop rigid post-work inspection criteria that must be conducted prior to the release of any contractor working in the facility. Designate key personnel who are authorized to release the contractor upon satisfactory completion of work. Develop a procedure that a contractor must provide complete specification for all work they will be conducting and review these before work begins and check work against specification once completed. Any changes to the agreed work must be approved prior to making the change. Provide refresher training to area personnel and assess the performance of the self-inspection team to improve their recognition of these significant items.

Answers

Product Debris



Observation: Product debris (cinnamon) was noted in the bottom of the vegetable oil barrel in the cake department. The material was determined to be cinnamon topping from the Danish department that shares the ingredient barrel. The Danish department personnel removed and transferred the oil with their own utensil rather than the utensil provided. The barrel is routinely filled from an oil line located in the cake department.

Significance of the observation:
An adulterated ingredient is being used.

Immediate corrective action:
Disposition this oil to be used in the Danish department in formulas with cinnamon until it is gone. Provide a temporary container for the cake department or have them draw oil directly from the line in their department. Once empty, clean and sanitize the barrel.

Long-term corrective action:
Plumb a line from the line in the cake department into the Danish area so that each department has their own independent line and the oil remains in a closed system until it is actually being used.

Answers

Dry Storage

Observation: A slight dust accumulation was noted under the pallets in the dry storage section in aisle "D" of the dry goods warehouse beneath the bagged flour storage area. Cleaning schedules indicated that the area was cleaned 12 days ago as part of a two week cleaning cycle. No evidence of insect activity was noted in this area at the time of the inspection.

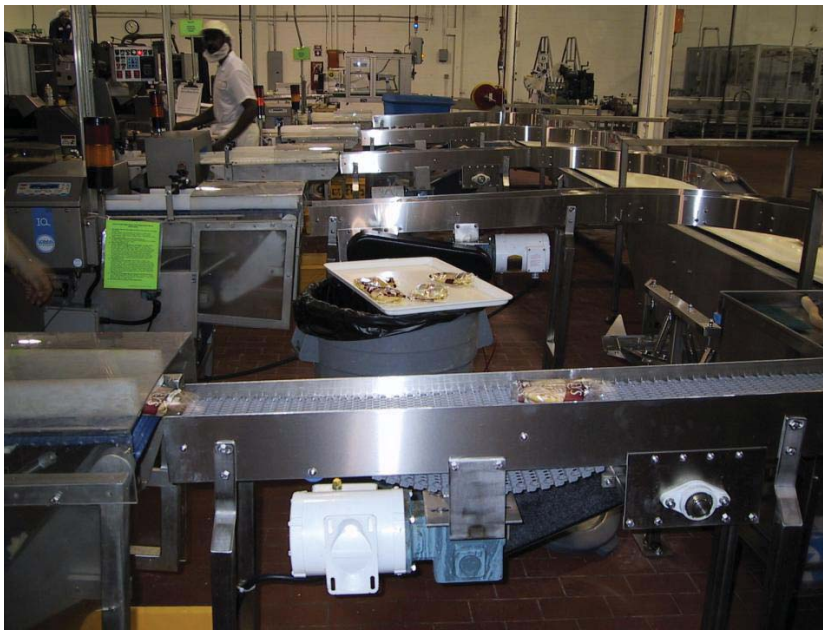
Significance of the observation:
With the slight dust accumulation and no evidence of insect activity, they are cleaning too often.

Immediate corrective action:
Adjust the cleaning schedule to every three weeks and use the time gained to work on other items that may not be getting done.

Long-term corrective action:
Monitor the area with the self-inspection and also have cleaning personnel report any negative issues with the schedule change. If none are reported you may consider going to a four week cleaning cycle to gain more efficiency in your program.

Answers

Packaging



Observation: A gray barrel on a dolly with a white plastic tray on top was noted being used to collect the miswrapped product at the discharge of the packaging machine. Periodically throughout the shift, the machine operator moves the barrel to the in-feed section, unwraps the product, placing it on the in-feed to be rewrapped. The wrapper is discarded into the gray barrel. Once all the miswrapped product has been fed into the machine, the barrel is returned to the discharge end to place any additional miswrapped product.

Significance of the observation:
Though not a significant product safety risk, the use of a barrel whose color code signifies a general trash container is a poor choice that could lead to issues in other areas of the plant. Personnel appear to be telling supervision that they have a need and since that need is not being met, they have developed their own solution.

Immediate corrective action:
Modify this in a recognizable way either through labeling or by changing the color of the barrel and plastic bag to eliminate the association with general trash.

Long-term corrective action:
Design a rewrap station that meets the needs of this work station and is clearly distinguishable as for this purpose only.

Answers

Bird Droppings

Observation: Bird droppings were noted on a pallet of finished product in the finished goods warehouse along the north wall. Overhead piping in this area also had several bird droppings on them. An opening was noted at the roof line and nesting materials were observed in the opening.

Significance of the observation:
Birds have gained access into the facility and contaminated packaging material.

Immediate corrective action:
Remove all affected materials for disposal. Conduct a detailed inspection of the area and remaining materials for other evidence of contamination. If bird droppings are located, clean and sanitize the surfaces. All identified openings where a bird could enter should be sealed or a barrier put in place.

Long-term corrective action:
A thorough inspection of the facility needs to be conducted to identify potential openings birds could use to enter. Conduct the inspection at night as well as the daytime so more areas can be identified. Examine the exterior for possible attractants based on the species of bird identified and work toward eliminating them. Evaluate door control procedures to ensure doors remain closed unless a truck is in the bay or people are actually entering or exiting the building. Meet with employees to explain the situation and the corrective actions. Encourage immediate notification if birds enter the facility.