1. **SCOPE**
2. From exhausting to packing of basket
3. **PURPOSE**
4. To ensure hazards that can be a source of biological contamination from organisms of public health significance which may enter through poorly-formed seams.
5. **DEFINITIONS**
   1. **Hypoglycin:** is a naturally occurring toxic organic compound found in ackee

* 1. **Contaminant:** any substance that causes water air or food to no longer be suitable for use
  2. **HACCP:** Hazard Analysis Critical Control Points
  3. **Corrective Action:** Procedures to be followed when a deviation occurs.
  4. **Critical Control Point (CCP):** A step at which control can be applied and is essential to prevent or eliminate a food safety hazard or reduce it to an acceptable level.
  5. **Critical Limit:** A criterion that must be met for each preventative measure associated with a critical control point.
  6. **Deviation:** Failure to meet a critical limit.
  7. **Hazard:** A biological, chemical, or physical property that may cause a food to be unsafe for consumption
  8. **Monitor:** To conduct a planned sequence of observations or measurements to assess whether a CCP is under control and to produce an accurate record for future use
  9. **Verification:** The use of methods, procedures, or tests in addition to those used in monitoring to determine if the HACCP procedure results are in compliance.
  10. **Validation:** The use of methods, procedures, or tests other than those used in monitoring and verifying to ensure the HACCP procedures results are correct.

1. **PROCEDURE**
2. **Responsibility**

**QC Assistant/Food Safety Team Leader/Functional Responsibility**

1. **Critical Limits and Monitoring**
2. The Quality Control Officer shall check the seam at the canners end (CE) (ie. the seam of the end attached in the plant) prior to the start of each batch.
3. The can seams are inspected visually, with the aid of a micrometer and by calculation for:
4. The seam length (should be 0.115 - 0.125 inch)
5. The seam thickness (should be 0.040 - 0 .044")
6. The body hook (should be 0.075 - 0 .085")
7. The end plate thickness (should be 0.008")
8. The body plate thickness (should be 0.007")
9. The cover hook (should be 0.075 - 0 .085")
10. The tightness rating (should be > or = 70%)
11. The actual overlap (should be > or = 40%)
12. Pleats and puckers (should be free from these)
13. Other visual defects (should be free from these)
14. If there are any deviations from the specifications, the Maintenance Manager is notified and the seamer is adjusted. If adjustment is necessary after production has started, the affected cans (i.e. those sealed since the last check) are isolated and additional cans examined for can seams both internally and by an external lab. Should these be found to be still out of specification, the cans produced during the affected period are disposed of.
15. **Verification**
16. **Quality Manager/ Functional Responsibility**

Review the monitoring forms weekly

1. **RECORDS**

The log of CCP3 Monitoring Form

[..\..\..\..\FORMS\CCP Forms\Ackee\CCP 3 - CAN SEAMING - CAN CONDITION (Ackee, CCP3) (Callaloo, CCP 1)\CCP 3 - CAN SEAMING - CAN CONDITION (Ackee, CCP3) (Callaloo, CCP 1).docx](file:///\\Dc2\j\FoodSafety\FSSC%2022000%20Management%20System\FORMS\CCP%20Forms\Ackee\CCP%203%20-%20CAN%20SEAMING%20-%20CAN%20CONDITION%20(Ackee,%20CCP3)%20(Callaloo,%20CCP%201)\CCP%203%20-%20CAN%20SEAMING%20-%20CAN%20CONDITION%20(Ackee,%20CCP3)%20(Callaloo,%20CCP%201).docx)

Record of Visual Seam Examination

[..\..\..\..\FORMS\CCP Forms\Ackee\RECORD OF VISUAL SEAM EXAMINATION\RECORD OF VISUAL SEAM EXAMINATION.docx](file:///\\Dc2\j\FoodSafety\FSSC%2022000%20Management%20System\FORMS\CCP%20Forms\Ackee\RECORD%20OF%20VISUAL%20SEAM%20%20EXAMINATION\RECORD%20OF%20VISUAL%20SEAM%20%20EXAMINATION.docx)

CCP Review Form

[..\..\..\..\FORMS\CCP Forms\Ackee\Review Form Ackee\CCP Review Form - Ackee.docx](file:///T:\FSSC%2022000%20Management%20System\FORMS\CCP%20Forms\Ackee\Review%20Form%20Ackee\CCP%20Review%20Form%20-%20Ackee.docx)

1. **REFERENCES**

Corrections and Corrective Actions

[..\..\..\ManagementSystemProcedures\CorrectionsAndCorrectiveActions\CorrectionsandCorrectiveActions.docx](file:///\\Dc2\j\FoodSafety\FSSC%2022000%20Management%20System\PROCEDURES\ManagementSystemProcedures\CorrectionsAndCorrectiveActions\CorrectionsandCorrectiveActions.docx)

1. **DOCUMENT CONTROL INFORMATION**

7.1 **APPROVAL AUTHORITY**

|  |  |  |  |
| --- | --- | --- | --- |
| Authored by; | REVISED BY | APPROVAL BY | DATE |
| Monacia Williams | Food Safety Team | Food Safety Team | September 25, 2018 |