



HACCP Australia

Food Safety Bulletin

ISSUE 1 2004

SOMETHING FOR EVERYONE

This is the first HACCP Australia Food Safety Bulletin and is designed to offer information, news, tips and updates to the Food and Beverage Industry. Whether you are managing a processing plant, opening a restaurant or merely looking for a suitable and food safe product, we do trust this periodic journal has something of interest for everyone. Many of the articles herein have been written in response to the information most commonly sort by our customers and the industry in general.

HACCP Australia has no interests outside the food, beverage and water industries and, as such, is Australia's leading specialist 'food safety' organisation. HACCP Australia undertakes a variety of food safety projects for companies throughout Australia and the region including:

- ▶ **Composition and accreditation of Food Safety Programmes,**
- ▶ **Food Safety Training**
- ▶ **Verification and Endorsements of products supplied to the food industry**
- ▶ **Food label compliance**
- ▶ **VQA Programme Management**
- ▶ **Research and Specialist Projects**

FOOD SAFETY LEGISLATION UPDATE

The last meeting of the Australia and New Zealand Food Regulation Ministerial Council in 2003 was held in Auckland at the very end of 2003. The Ministerial Council of ANZFRMC, which comprises Health and Agriculture

Ministers, from Australia and New Zealand, agreed to policy guidelines for four important areas of food management. These policy guidelines have now been referred to Food Standards Australia New Zealand (FSANZ) to commence the food standards development process.

Ministers agreed that food safety programs, in highest risk sectors, be made mandatory in Australia and adopted policy guidelines developed by the Ministerial Council to improve food safety management in Australia. These principles include overarching recommendations on which food business sectors should develop and implement mandatory food safety programs.

Those food business sectors included in mandatory food safety programs will be:

- ▶ **food service in which potentially hazardous food is served to vulnerable populations (eg. hospitals, nursing homes);**
- ▶ **producing, harvesting, processing and distributing raw oysters and other bivalves;**
- ▶ **catering operations serving food to the general public, and**
- ▶ **producing manufactured and fermented meat**

Implementation of mandatory food safety programs for these sectors will be required within two years after the amendments to the Food Standards Code are gazetted. This allows for a flexible approach to implementation.

New Zealand is currently reviewing both mandatory and voluntary risk-based management plans in the context of a broad ranging Domestic Food Review.

FACT

"This product is food safe"

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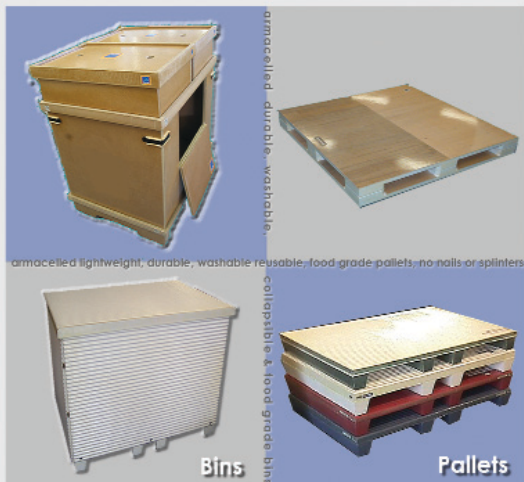
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Only products that carry HACCP Australia endorsement are advertised in this bulletin. They have been thoroughly examined by food technologists to assess their suitability in terms of food safety for use in food operations employing a HACCP based safety programme. Please see p12 for further details of endorsed products.

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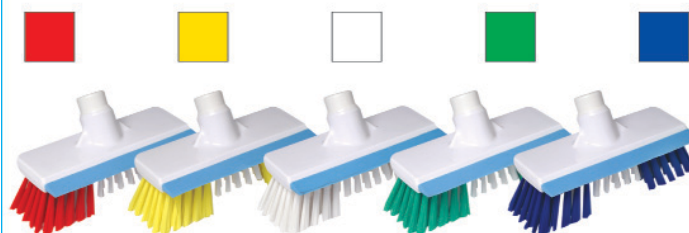
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CLEANING AND SANITATION UNDER THE AUDITOR'S MICROSCOPE

When auditing a food facility, HACCP Australia's Food Safety Auditors look for a number of key elements regarding cleaning and sanitation. These key elements include:

- ▶ What chemicals are being used and how? Appropriate and food-safe chemicals and methods should be employed by those carrying out the cleaning. MSDSs should be held on site for each chemical being used.
- ▶ Cleaning instructions should detail chemical dilutions, frequency and equipment to be used.
- ▶ The equipment being used should not pose a risk to the process. Items, such as steel wool for example, can introduce dangerous metal fibres into the operation through the cleaning process and this danger can be eliminated by using an alternative 'food-safe' material.
- ▶ Chemicals must be stored safely in an area where spills will be contained and not effect either the food product or its packaging.
- ▶ The cleaning regime must be appropriate for the process. In areas where microbial contamination is an issue, surfaces must be both cleaned (removal of soils) and sanitised (destruction of micro-organisms).
- ▶ A 'cleaning sign-off document' should be employed to ensure that routine tasks are, in fact, carried out in accordance with the schedule in the HACCP programme.
- ▶ Cleaning should be verified in a proper manner. Such verification might include surface analysis for microorganisms, internal audit-based visual inspections and routine pre-start-up checks. ▶



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For further information,
please contact 3M on 136 136



CLEANING & SANITATION

Continued from previous page

- Colour-coded materials and equipment should be employed to identify the correct product and area of usage thereby minimising the chances of cross-contamination.



Ensure your cleaning products are food safe and don't compromise your HACCP programme

Be aware that when auditing a facility during operating hours, evidence of normal operating daily soil build-up is usually not considered as a non-conformance. Most cleaning non-conformances come from yesterday's, or last week's, dirt.

Check your own routine against these points and you will be well on your way to an auditor tick for 'Cleaning and Sanitation'.

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INDUSTRY SERVICES & RESOURCES

FOOD LABEL FOCUS TO INTENSIFY

(ADVERTORIAL)

The restructuring of the various State Food Authorities over the last 12 months has allowed additional resources to be allocated to the enforcement of the labelling standards for packaged food products.

Most businesses have progressed to full compliance with section 1.2 of the Food Standards Code, although a number of operations are still manufacturing and packaging food that is in breach of the standards. Our research has shown that the common failures occur in the following areas:

- Absence of a correct nutritional panel
- Failure to have an appropriate date code
- Incorrect or missing statement of ingredients
- Lack of identification of the manufacturer
- Failure to correctly identify characterising ingredients in the ingredient statement
- Failure to comply with the requirements of mandatory warnings
- Failure to describe storage and usage conditions

Although there are a number of exemptions under the code, most packaged food is covered under the legislation. Failure to comply with the code can result in withdrawal, confiscation of stock and potentially, prosecution under the State Food Acts.

If you are not sure about the compliance of your labels, research the Food Standards Code yourself and/or talk to some experts in the field. Direct enquiries to FSANZ can save you time and provide interpretations on specific issues. It can be very worthwhile engaging specialist consultants such as Food Labels Australia when addressing issues that are less defined.

Food Labels Australia



Food Labels Australia specialises in the interpretation and requirements of Food Labelling legislation, both in Australia and Overseas. We can offer expert assistance in

- Compliance Determination
- Design of label content
- Analysis and data formatting

Please contact Food Labels Australia, at HACCP Australia on 02 9956 6911 or www.foodlabels.com.au



FACTORY EQUIPMENT & MACHINERY

FOOD SAFETY STARTS AT THE FACILITY DESIGN STAGE

Processing and packaging of food takes place in diverse locations and physical structures and on many different scales. The overall design of a facility, from receiving area to shipping dock, is an important consideration in eliminating opportunities for chemical, physical, and microbial contamination. Both direct contamination and cross-contamination of product can be minimized with proper attention to physical design, construction material selection, and facility traffic flow.

The building should be designed so that incoming products never cross paths or mix with finished products. This is a recommended practice for all processed food operations. Occasionally, the available space is limited, but physical separation of zones using walls or other barriers can achieve adequate separation. In addition, separate or segregated zones for chemical storage and mixing, and maintenance and fabrication shops are needed. Metal detectors at the end of the product line and in-line magnetic

separation offer a very effective method of capturing metallic foreign objects.

A properly designed facility is important because the additional mixing, processing, and packaging steps that may be part of food processing increase the opportunity for cross-contamination. Pallets and bins coming directly from a supplier may also be a source of contamination. Proper facility design can significantly reduce this potential hazard. Finally, processed, but unprotected, product should not be stored in the same location as raw materials, dirty containers and pallets. Additionally the facility should have sufficient storage room space to keep processed product, which is being held for later mixing and packaging, separate from incoming and stored materials.

Like the overall facility design, the movement of processing water, waste streams, airflow, and employees should be planned with food safety in mind. To conserve water and minimize wastewater discharge, many facilities recirculate water.

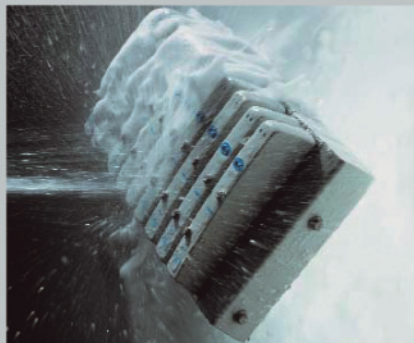
In a similar manner, some facilities have air-filtration systems installed for central distribution and airflow counter to product flow. In these systems clean filtered air moves with a positive pressure from the cleanest areas—packaging and packing—back toward the receiving area. Positive pressure flow (backward airflow) helps reduce the entry of dirt and debris. Expert advice should be sought to select materials ►

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FACTORY EQUIPMENT & MACHINERY

Continued from previous page

that facilitate cleaning and sanitation, and to design adequate floor slope for drainage. Flooring materials should be suitable for your facility and selected to be resistant to chemical damage and cracking from equipment movement and constant use and washing. Cracks in flooring are difficult to clean and may easily become a site for residue accumulation and subsequent microbial growth.

Walls should be constructed of materials that are readily cleaned and will not serve as a home for pests. Sealing and screening must be used to exclude pest entry through windows and vents.

Any access doors leading directly from outside the facility to the processing and packaging area should be designed with food safety in mind. An effective design utilizes a double entry barrier, sometimes in combination with a "forced-air curtain" to help exclude insects. In this design,



Note the location of handwash facilities and dials immediately outside process room entry

each person must enter self-closing doors, which open in opposing orientation, left to right then right to left. The doors leading directly to the outside must first close to allow the second door to open. The use of such doors during operating hours should be strictly controlled. Cautionary signs and boot dips alert the worker or maintenance person that they are entering a clean area. The areas outside the facility should be designed and maintained to minimize the potential for attracting or harbouring rodents and other potential sources of human pathogens. Landscape design and weed control programs should be part of the overall food safety plan.

The location and design of drains, floor flumes, and pipelines can be made to greatly improve the ease of maintenance and effectiveness of clean-up procedures. Expert advice should be sought to design placement or protective aides to prevent pipe and wall condensation from becoming a source of contamination. Drains should be fitted with seals and grates capable of preventing rodent entry. The use of floor flumes should receive careful consideration because of the potential for contamination of the room air or nearby equipment surfaces. This is especially true for floor flumes that carry water waste from one segregated area across another.

The design of the collection area for wastewater should incorporate systems to prevent product or equipment contamination that might serve as an attractant for pests.

If you are thinking of new plant or moving premises – get some expert food safety advice early in the process.

ENDORSEMENT FOR 'HARD' EQUIPMENT

When evaluating equipment for HACCP food-safety endorsement, a number of key issues are taken into consideration regarding food safety impact. Essentially, these are:

- ▶ Food contact surfaces must be constructed of an appropriate 'food grade' material.
- ▶ The design of the item must minimise the risk of pieces of the machinery itself contaminating the food. Fixtures, nuts, bolts etc should be designed to minimise any risk of coming loose and entering the product stream.
- ▶ 'Unseen' components such as lubricants, seals and others must be of an appropriate food safe grade.
- ▶ The equipment must be easily cleaned and be free of 'hang-up' points or areas which may collect food particles. For example, threaded surfaces should not be exposed, corners must be coved and open, small grooves or gaps should not exist.
- ▶ The equipment must be resistant to the chemical or temperature sanitation techniques that it will encounter as a component in food processing plant or equipment. Surfaces and fittings should not suffer damaged as a consequence of prolonged or frequent exposure to chemical cleaning agents.
- ▶ Failure of a component should not, in itself, present a contamination risk nor should it present a risk of such elsewhere in the process. It needs to be able to demonstrate 'failsafe' characteristics. The 'consequence of error' in the use of the equipment should be low or negligible either with or without control systems integrated into the equipment design.

Only the very best equipment will meet the strict standards based on real-life and applied food safety experience. Examples of outstanding design in terms of 'food safety impact' include the **Frilich** range of beverage dispensers, **Frostline's** icemakers, **Reedy's** water coolers, **Reefer** refrigerators, and **Testo's** thermometers. In terms of components, the **Festo** sanitary design terminals and cylinders are some of the most impressive equipment we have reviewed and are perfectly designed for use in the modern food industry.

Engineers, designers and those purchasing equipment really should pay very careful attention to the food safety impact of the equipment and components used in their process as the smallest detail can make a very significant difference to the safety of the finished product.



HAND HELD THERMOMETERS - A VITAL TOOL

Digital thermometers, from a reputable manufacturer, with verified accuracy performance, are an essential monitoring tool in most food facilities. Many CCPs are monitored by temperature checks and this is because temperature (or the lack of it) is used to control the growth of, or kill, microorganisms. A digital thermometer with an easy to read display, shock proof, water resistant, a stainless steel probe and accuracy to within 1 deg C are the recommended minimum requirements.



A good quality thermometer is essential - do not compromise your programme with one of inferior quality

Never use mercury or alcohol in glass anywhere near food. Breakages can cause toxic chemicals and glass to enter food.

And don't forget to calibrate your thermometers on a routine basis.

COLOUR CODING

Colour coding is one of the very best food safety disciplines and commonly used for items such as chopping boards. But knives, cleaning equipment and other utensils will just as easily cross contaminate foods particularly in raw/cooked situations. Consideration should be given to colour coding





Many items are colour coded nowadays

all equipment between key areas. Knives, utensils, wiping cloths, scrubbing brushes, tongs and containers are all available in colour-coded systems.

Consideration should be given to colour coding all equipment between key areas. Knives, utensils, wiping cloths, scrubbing brushes, tongs and containers are all available in colour-coded systems.

The catering and food service industry often use:

	White for	Dairy,
	Brown for	Cooked meat,
	Red for	Raw meat,
	Blue for	Seafood,
	Green for	Vegetables

However, there are many different food-handling processes and no colour scheme could accommodate every application. Any colour combinations are fine as long as they are easily recognisable and all staff follow the rules.

Make and hang posters in a conspicuous place to remind the food handlers of the code system. And check that all staff recognise the colours – remember one in ten males suffers from some form of colour blindness!

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ORIGINS OF THE HACCP AUSTRALIA FOOD SAFETY ACCREDITATION LOGO

Sometimes, people who are not directly employed in the manufacturing sector of the food industry ask about the origins of the accreditation logo...

"What do the shapes mean?"

When writing a HACCP programme, one of the early steps is to document the process steps involved. Typically, this is done using a flow chart and a set of internationally recognised symbols. The symbols used are those represented in the accreditation logo and have the following interpretations;

- SQUARE – An inspection step (such as weighing)
- CIRCLE – An operational step (such as mixing)
- ▲ TRIANGLE – A storage step (such as cool storage)
- ➡ ARROW – A transport step (such as distribution)
- D – A delay step in the process

HACCP Australian has incorporated all these symbols into its highly recognised food safety accreditation logo - now you know !

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HOLDING & COLD STORAGE

COLD STORAGE - WHAT CAN GO WRONG?

Failures in cold storage are a causal factor for some 25% of all food borne illness events. Regulatory authorities see this as a key area for control and recently a restaurant owner was fined over \$100,000 for an event that occurred due solely to poor control of his cool rooms.

If you store food under cool room conditions, you must ensure that:

- ▶ **Your controller is accurate and capable of keeping the cool room at the correct temperature. (Between 0-5 deg C) is good for most products.**
- ▶ **Your refrigeration equipment is capable of holding temperature even on hot days and through high use periods where doors are often opened. If door opening and temperature gain is a problem, strip curtains can assist greatly in reducing the rate of heat gain.**
- ▶ **Ensure that door seals are in good condition and doing the right job as per their design (they need to be kept clean too!)**
- ▶ **If you are using your coolroom to cool food down from high temperatures, you will need a bigger system than one simply designed to hold food at the right temperature.**
- ▶ **Get a good thermometer and check the temperatures often (see article).**
- ▶ **Keep it clean and dry inside. Listeria is a dangerous food pathogen and can survive and multiply at low temperatures... your cool room is not a guarantee of food safety.**

Through auditing many thousands of facilities, we have found that about 50% of all cool rooms and refrigerated display cabinets are running at temperatures failing the critical limit. Keep a close eye on your cool room; its management is a CCP in your HACCP programme for a very good reason.

COOLROOM MONITORING MADE EASY

Coolroom temperature monitoring is an easy task but is often done incorrectly....It is also a very important task. Some FAQs are;

▶ How often should I monitor?

Most coolrooms are monitored several times a day. A good rule of thumb is this...ask yourself "In the worst case scenario, perhaps a total failure of refrigeration, how long will it take the food in my coolroom to exceed the critical limit?" Once you know this.....monitor your coolroom at least as frequently as this period. Half this period is appropriate in a coolroom which is being used frequently.

▶ What should I monitor?

Monitoring the air temperature in your coolroom is an indicator only....what is really important is the product temperature. Air temperature will go up and down depending on door openings, where the temperature is measured and the defrost cycle. Product temperature will be more stable and is the key issue. Rather than probing actual food with the associated problems of damage to packaging, the food itself and the introduction of bacteria to food products, we recommend a simple alternative. Keep a PET bottle of water in the coolroom where it can be easily accessed and measure the temperature of the water each time. We call this a stored product substitute and it is a quick, sanitary and accurate method to determine product temperature in the coolroom. For a freezer, try a bag of frozen peas, identified as a test item, for the stored product substitute.

▶ What about data loggers?

Unless they have an alarm facility that triggers an alert that will be noticed in the facility at the time the failure occurs, these are not recommended. This is because it is easy to become complacent with this equipment and many times we have found a perfect data logger record of temperature failures which occurred in previous weeks – with no corrective action being taken at the time because there was no alarm and the system was only downloaded once per month.

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HACCP AUSTRALIA - HEAD OFFICE FACES

Many people involved with food safety find themselves talking on the telephone to staff in the HACCP Australia office in Sydney. We thought it might be useful to put a few faces to the more familiar voices!! In the next issue we will bring you six more (less attractive!!) regional office and specialist staff.



KELLIE CAMPBELL
HACCP Administration



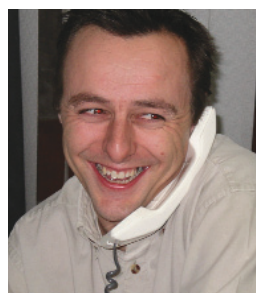
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- Food Safety Training • Food Label Compliance
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Temperature Monitoring

Danfoss

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The Danfoss Micromon can offer..

- ▶ Temperature monitoring and logging on board (no PC required)
- ▶ Door open or refrigeration system fault monitoring (can save on costly stock losses)
- ▶ Output contacts for high temperature or other alarms (for red light or security alert)
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- ▶ Easy installation by your local refrigeration technician.

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Accreditaion

The hygienic presentation of food and drinks is now under the spotlight more than ever before. Foodservice Equipment International and its German partner, FRILICH Zapfsysteme GmbH are proud to announce FRILICH juice and milk dispensers have been endorsed by HACCPAustralia.

Mr Martin Stone, Director of HACCP Australia says "We are very happy to provide endorsement for such a high quality range of products."

To celebrate this endorsement, FRILICH and FEI are offering special prices on the most popular juice and milk dispensers until the end of September.

FRILICH... your guarantee of quality and food safety – HACCPAccredited!



FRILICH

For more information
please contact:

FEI Pty Ltd
on Freecall
1800 673 153

Food Safety
Programme
Accreditation Australia
HACCP
Approved

Pascoe's

"always working for you"



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For further information: Pascoe's Pty Ltd
www.pascoes.com.au (08) 9353 3900

HACCP AUSTRALIA ENDORSED PRODUCTS SERVING THE FOOD INDUSTRY

The companies listed below carry a range of products or services that are endorsed by HACCP Australia as particularly appropriate, from a food safety perspective, for use in food businesses employing a HACCP-based food-safety programme. Their products or services have been rigorously reviewed by HACCP Australia's food technologists and, in their expert estimation, are manufactured or designed to meet all the appropriate food safety standards demanded by industry or regulation in Australia and internationally. In performing the assessment, our technologists look for 'world's best' in terms of food safety features and characteristics. Only such products or services carry the HACCP accreditation mark. Some organisations who have completed the process are included below. Many others are currently undergoing the process. If you are looking for particular food-safe products or services for use in a facility operating a HACCP programme, please call us for advice and recommendation at any time on (02) 9956 6911.

COMPANY	PRODUCTS	CONTACT
3M	Scotchbrite™ Cleaning Chemicals, Scourers	136 136
ADELAIDE OFFICE PROPERTY MGMT	Contract Cleaning Services for Food Premises	08 8284 4679
AEROBEAM PROFESSIONAL PEST MGMT	Specialist Food Premises Pest Management	02 9636 5840
ALCAB CABINETMAKERS PTY LTD	Chilled & Hot Food Display Cabinets	07 3245 6789
ARMACEL TECHNOLOGY GROUP	Plastic Pallets, Food Storage Containers, Food Grade Shelving	02 9450 0900
ASSURED PEST CONTROL	Specialist Pest Control Services for Food Premises	02 9896 0395
AUSSIE RED EQUIPMENT	Aquafortis Hot Water High Pressure Clean & Capture Equip.	1800 804 878
AVANTI CHEMICALS	Cleaning Chemicals for Food and Agri Businesses	07 55493666
BRITETTE AUSTRALIAPTY LTD	Scourers, Sponges and Cleaning Aids	02 9642 6411
CARTS AUSTRALIA	Coffee and Food Carts for Mobile Food Sales	02 9888 5200
CLOROX AUSTRALIA	Glad™ and Chux™ range of Cleaning and Wrapping Materials	02 9794 9500
COLDSHIELD FLEXIBLE DOORS	PVC Flexible Doors for Food Premises	1800 462 233
COPEST PEST CONTROL	Specialist Pest Control Services for the Food Industry	1800 131 315
CORPORATE PEST MANAGEMENT	Specialist Pest Control Services for the Food Industry	02 9311 1234
CROWLE INDUSTRIES	Utensil and Food Packaging Services	02 9568 4599
DANFOSS	M2 Alarm & Monitoring System	02 9648 4982
E D OATES PTY LTD	Full range of Food Grade Cleaning Equipment	03 9469 6900
FESTO PTY LTD	Pneumatics and valves for food manufacturing equipment	1300 889 696
FOOD SERVICE EQUIPMENT	Frilich juice dispensers and other buffet equipment	02 9938 5000
FROSTLINE REFRIGERATION SERVICES	Hozshizaki Ice making equipment & cold room services	03 9796 5933
HACCP PEST MANAGEMENT	Specialist Food Premises Pest Management Services	02 9922 3743
HEATCRAFT AUSTRALIA PTY LTD	HACCP specification cool room thermostats and alarms	03 9561 0199
IMPACT PEOPLE	Provider of HACCP trained staff to the food industry	07 3229 6399
KENCAN LTD	Kee-seal disposable piping bags	07 3272 9688
MAGICTANK SYSTEMS	SS deep cleaning tanks & systems for pans and trays	02 4959 3235
MATRIX HR INTERNATIONAL	Provider of HACCP aware staff to the food industry	02 9360 9111
MERINO PTY LTD	Swipes™ disposable and anti-bacterial paper cloths	1800 622 018
MITCHAM TRADING PTY LTD	PVC and Polyester Trolley covers for food protection	03 98737277
LANOTEC AUSTRALIA PTY LTD	Suppliers of Food Grade Lubricants	07 3373 3700
PASCOES	Cleaning Chemicals for the food industry	08 9353 3900
OZ TANK PTY LTD	SS deep cleaning tanks & systems for pans and trays	1300 66 88 66
POWERTANK PTY LTD	SS deep cleaning tanks & systems for pans and trays	0411 441 441
REFRIGERATION RESEARCH	Versatile, mobile refrigerators for travelling & remote use	08 8398 3224
REJUVENATORS (THE)	Specialist Cool room cleaning and rejuvenation services	0407 292 826
RELIABLE PEOPLE WORLD WIDE	Provider of HACCP trained staff to the food industry	02 9360 9111
STEAM AUSTRALIA	High temperature steam cleaning equipment	1300 795 050
STOP CREEP PEST CONTROL	Specialist Pest Control Services for the Food Industry	02 9315 7745
STRIPTANK	SS deep cleaning tanks & systems for pans and trays	03 9597 9726
TOMKIN AUSTRALIA PTY LTD	Providers of colour coded catering utensils	02 9319 2993
TESTO PTY LTD	Specialist thermometers for use in the food industry	03 9800 4677
WJB ENGINEERING	Magnetic Separation Technology and Services	02 4285 5577

The HACCP Australia endorsement and accreditation programme supports organisations achieving Food Safety excellence in their products. The HACCP endorsement is geared to those organisations that are required to supply compliant or 'HACCP Approved' products and services to their safety conscious customers. This independent assessment and verification of fitness for purpose is a valuable tool when a product or service is targeted at a food safety and HACCP conscious market. Such products will be:

1. Well designed with 'food safe' characteristics
2. Non-Toxic
3. Easy to clean
4. Likely to reduce the risk of any form of contamination
5. Designed for a low consequence of error in use