

# Contents

<b>Preface</b> .....	<b>xi</b>
<b>The Author</b> .....	<b>xiii</b>
<b>1 Sanitation Regulatory Requirements</b> .....	<b>1</b>
FDA.....	2
Food Safety Modernization Act of 2011 .....	16
USDA.....	17
Sanitation Standard Operating Procedures (SSOPs) .....	17
Sanitation Performance Standards (SPSs) .....	24
European Food Safety Authority .....	34
References.....	35
<b>2 Regulatory Inspection and Control Action</b> .....	<b>37</b>
Inspection.....	37
Regulatory Control Action .....	46
Recall.....	48
Recall Policy .....	49
Recall Procedure.....	50
Practice Recovery.....	57
References.....	60
<b>3 Microorganisms of Food Manufacturing Concern</b> .....	<b>61</b>
Microorganisms.....	61
Bacterial Requirements .....	62
Moisture .....	63
Temperature .....	63
Oxygen .....	64
Differentiation .....	64
Bacteria Shapes.....	65
Gram Staining.....	65
Spore Formation.....	65
Nutrient Metabolism .....	65

Nonpathogenic Microorganisms.....	65
Spoilage Organisms.....	66
Pathogens.....	67
<i>Listeria monocytogenes</i> .....	67
<i>Salmonella</i> .....	68
<i>Escherichia coli</i> O157:H7.....	68
<i>Staphylococcus aureus</i> .....	69
<i>Campylobacter</i> .....	69
<i>Bacillus cereus</i> .....	69
<i>Yersinia enterocolitica</i> .....	69
<i>Clostridium</i> .....	70
Viruses.....	70
Parasites.....	71
Foodborne Illness.....	71
Microbiological Control Methods.....	71
Incoming Ingredients.....	73
Sanitary Design and Materials.....	77
Sanitation.....	78
Microbiological Testing and Validation.....	78
Good Manufacturing Practices.....	78
Pest Control.....	78
Employee Education.....	79
References.....	79
<b>4 Control of <i>Listeria</i> in Food Manufacturing.....</b>	<b>81</b>
<i>Listeria</i> .....	81
Requirements.....	82
<i>Listeriosis</i> .....	83
<i>Listeria</i> Harborage and Contamination.....	84
<i>Listeria</i> Management and Control Methods.....	84
Ingredients.....	89
Sanitary Design and Materials.....	91
Sanitation.....	93
Product.....	94
Microbiological Testing and Validation.....	94
Personnel.....	95
Pest Control.....	95
Construction.....	95
Employee Education.....	99
References.....	99
<b>5 Biofilms.....</b>	<b>101</b>
Formation.....	101

Evidence of Biofilm.....103  
 Biofilm Removal.....105  
 Current Research.....106  
 References.....107

**6 Sanitary Facility Design.....109**

The AMI 11 Principles of Sanitary Facility Design [10,12]..... 111  
     Principle 1: Distinct Hygienic Zones Established in the Facility..... 111  
     Principle 2: Personnel and Material Flows Controlled to Reduce Hazards..... 112  
     Principle 3: Water Accumulation Controlled in the Facility ..... 113  
     Principle 4: Room Temperature and Humidity Controlled ..... 113  
     Principle 5: Room Airflow and Room Air Quality Controlled ..... 115  
     Principle 6: Site Elements Facilitate Sanitary Conditions..... 116  
     Principle 7: Building Envelope Facilitates Sanitary Conditions..... 116  
     Principle 8: Interior Spatial Design Promotes Sanitation ..... 118  
     Principle 9: Building Components and Construction Facilitate Sanitary Conditions..... 118  
     Principle 10: Utility Systems Designed to Prevent Contamination ..... 121  
     Principle 11: Sanitation Integrated into Facility Design ..... 122  
 Other Considerations for Facility Sanitary Design ..... 122  
 Equipment..... 124  
 The 10 Principles of Sanitary Design ..... 124  
     Principle 1: Cleanable to a Microbiological Level (Contact and Noncontact Surfaces)..... 124  
     Principle 2: Made of Compatible Materials..... 125  
     Principle 3: Accessible for Inspection, Maintenance, Cleaning, and Sanitation ..... 126  
     Principle 4: Self-Draining—No Product or Liquid Collection..... 126  
     Principle 5: Hollow Areas Hermetically Sealed (No Penetration of Hollow Areas)..... 126  
     Principle 6: No Niches (Pits, Cracks, Recesses, Poor Welds, Corrosion) ..... 127  
     Principle 7: Sanitary Operational Performance (No Contribution to Insanitary Conditions During Operations)..... 128  
     Principle 8: Hygienic Design of Maintenance Enclosures (Junction Boxes, etc.)..... 129  
     Principle 9: Hygienic Compatibility with Other Plant Systems (Electric, Air, Water)..... 129  
     Principle 10: Validate Cleaning and Sanitary Protocols (Encourage Equipment Designers to Demonstrate Effective Cleaning of the Equipment) ..... 129

Other Considerations for Sanitary Equipment Design.....	130
Repairs.....	131
References.....	132
<b>7 Sanitation Best Practices.....</b>	<b>135</b>
Who Is Responsible for Sanitation?.....	136
Sanitarians.....	137
Written Cleaning Procedures.....	142
Considerations for Effective Cleaning.....	143
Soils.....	144
Chemical Functions.....	144
Water.....	145
Cleaning Chemicals.....	146
Cleaning Systems and Equipment.....	147
The Cleaning Process.....	148
Specialized Cleaning Procedures and Equipment.....	153
Equipment Baking.....	154
Deep Cleaning.....	155
Floors and Floor Drain Cleaning.....	155
Sanitizing.....	157
Ozone.....	161
Operational Sanitation.....	162
Mid-Shift Cleanup.....	163
Inspections.....	164
References.....	165
<b>8 Verification of Sanitation.....</b>	<b>167</b>
Verification.....	167
Organoleptic.....	168
ATP Bioluminescence.....	170
Microbiological.....	173
Validation.....	178
Environmental <i>Listeria</i> Monitoring.....	178
Alternatives.....	181
Prerequisite Monitoring Program.....	183
Identification of Swab Sites.....	184
Commando Swabs.....	184
Swab Frequency and Selection of Sites.....	186
Collection of Swabs.....	186
Analysis.....	191
Data Tracking.....	192
Positive Swab Investigation.....	193
Corrective Actions.....	195

	Test and Hold.....	197
	Special Event Sampling .....	198
	FSIS Testing .....	198
	Intensified Verification Testing and Routine <i>L. monocytogenes</i> Monitoring .....	199
	Product Testing for <i>L. monocytogenes</i> .....	200
	References.....	201
<b>9</b>	<b>Employee Good Manufacturing Practices.....</b>	<b>205</b>
	Rationale for Good Manufacturing Practices (GMPs) .....	205
	Basic Good Manufacturing Practices.....	206
	Hands and Hand Washing .....	206
	Employee Welfare Rooms.....	213
	Locker Storage and Sanitation .....	215
	Gloves.....	216
	Hair and Beard Covers .....	217
	Clothing and Footwear.....	218
	Jewelry.....	221
	Disease Control .....	222
	Food and Tobacco .....	222
	Raw and Cooked Separation.....	223
	Visitors and Contractors .....	223
	Maintenance GMPs.....	224
	Training and Implementation.....	227
	Monitoring and Enforcement .....	228
	Operational Sanitation .....	228
	References.....	232
<b>10</b>	<b>Pest Control and Sanitation .....</b>	<b>233</b>
	Pests of Food Plant Concern .....	234
	Insects.....	234
	Rodents .....	237
	Birds .....	238
	Pest Control Measures .....	238
	Pest Control Program .....	238
	Habitat Elimination.....	242
	Exclusion .....	245
	Sanitation .....	247
	Externally.....	247
	Internally.....	248
	Warehousing.....	248
	Extermination.....	248
	Bird Control .....	252

Chemical Interventions.....	253
Insecticides and Alternatives.....	253
Residuals and Nonresidual Insecticides .....	253
Insecticide Application .....	254
Alternatives to Chemical Insecticides.....	255
Rodenticides .....	255
Avicides.....	256
What Do You Do if a Bird Gets in the Plant?.....	256
References.....	256
<b>11 Chemical and Physical Hazard Control.....</b>	<b>259</b>
Chemical Hazards .....	259
True Food Allergy.....	260
Food Intolerance.....	260
Regulatory Requirements.....	262
Allergen Management.....	265
Ingredients.....	268
Production .....	271
Packaging and Labeling.....	273
Sanitation and Allergen Control .....	274
Consumer Feedback .....	275
Disposition/Liability.....	275
Physical Hazards.....	277
Sanitation Role in Physical Hazard Prevention .....	279
References.....	280
<b>Index .....</b>	<b>281</b>