



**Chester County Health Department
Bureau of Environmental Health Protection**
Government Services Center
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HACCP Plan Review Guidelines for Reduced Oxygen Packaging

In order to ensure your Hazard Analysis Critical Control Point (HACCP) Plan meets the requirements outlined in §8-201.14 of the 2017 Food and Drug Administration (FDA) Food Code, please complete all applicable sections of this packet and include any necessary attachments. Please contact our office with questions regarding this form at the phone number above or by emailing CCHD@chesco.org

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|-----------------------|-------------------------|----------|--------------|
| Name of Facility | Facility Street Address | | |
| Tax Parcel Number | City | Zip Code | Municipality |
| Business Phone | Business Fax | | |
| Owner's Name | Mailing Address | | |
| Owner's Contact Phone | Contact Email Address | | |
| Contact Person | Contact Person's Phone | | |

Section 1: Overview

a) Indicate which method the facility will be using to package foods using reduced oxygen packaging (ROP):

- Cook/Chill** Cooked food is hot filled into impermeable bags which have the air expelled and are then sealed or crimped closed. The bagged food is rapidly chilled and refrigerated at temperatures that inhibit the growth of psychrotrophic pathogens.
- Sous Vide** Raw or partially cooked food is vacuum packaged in an impermeable bag, cooked in the bag, rapidly chilled, and refrigerated at temperatures that inhibit the growth of psychrotrophic pathogens.
- Vacuum Packaging Cold Foods** At 41°F or below or frozen foods (Section 1b below must be completed as well)

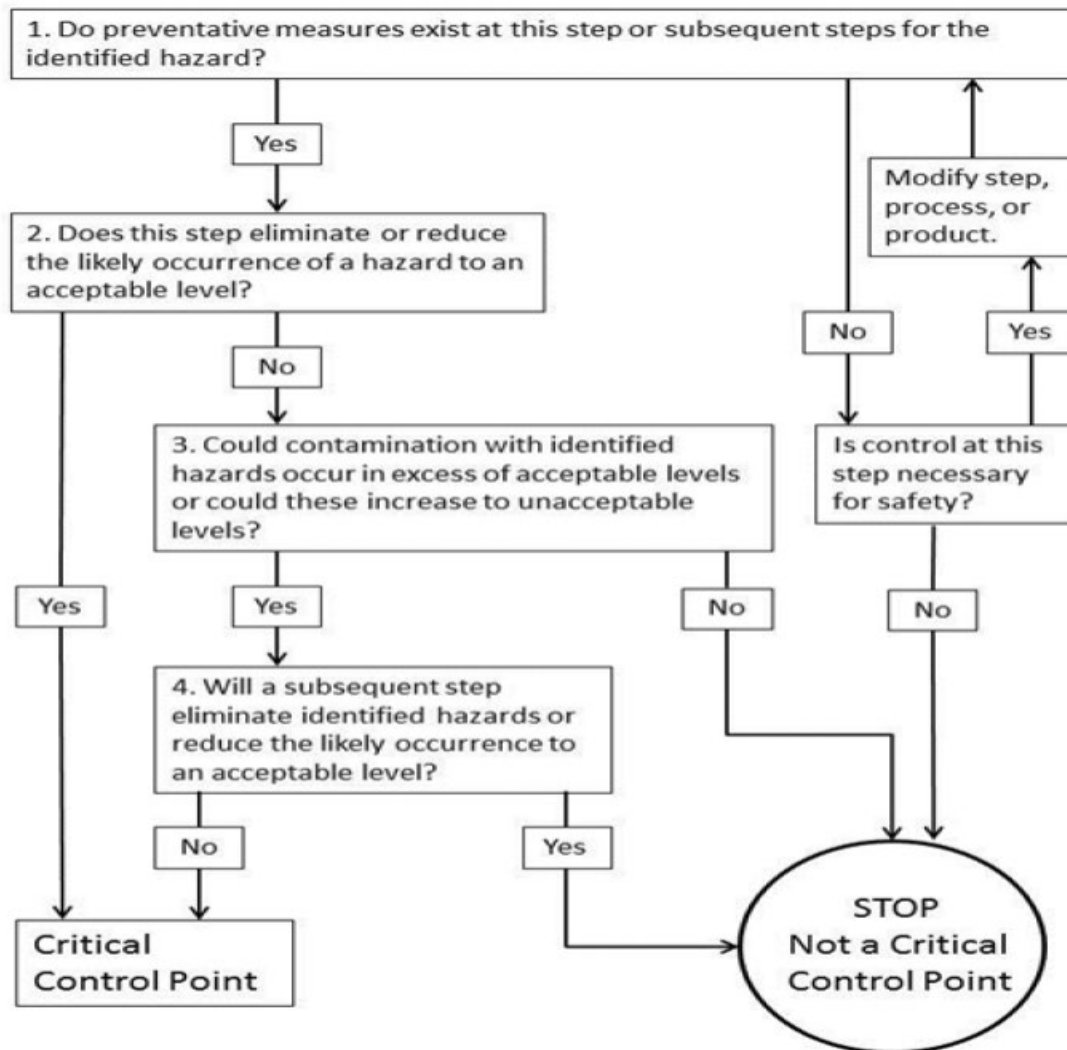
b) Per §3-501.12 of the 2017 Food Code, foods placed in reduced oxygen packaging must meet one of the standards below: (Select any that apply)

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|--------------------------|---|
| <input type="checkbox"/> | The food item has a water activity (a _w) of 0.91 or less. |
| <input type="checkbox"/> | The food item has a pH of 4.6 or below. |
| <input type="checkbox"/> | The food item is a meat or poultry product cured at a food processing plant regulated by the USDA using substances specified in 9 CFR 424.21, use of food ingredients and sources of radiation, and is received in an intact package (e.g., luncheon meats). |
| <input type="checkbox"/> | The food item is a food with a high level of competing organisms such as raw meat, raw poultry, or raw vegetables. |
| <input type="checkbox"/> | If the food is fish , then it <i>must</i> be frozen before, during, and after packaging. |
| <input type="checkbox"/> | If the food is cheese, then it must be limited to products that are commercially manufactured in a food processing plant with no ingredients added in the food establishment and that meet the Standards of Identity as specified in 21 CFR 133.150 Hard cheeses, 21 CFR 133.169 Pasteurized process cheese or 21 CFR 133.187 Semisoft cheeses. |
| <input type="checkbox"/> | Other: If the food item does not meet one of the conditions above, then it may be unsafe to vacuum package. Please contact our office for further guidance. |

Section 2: Identification of Critical Control Points (CCPs)

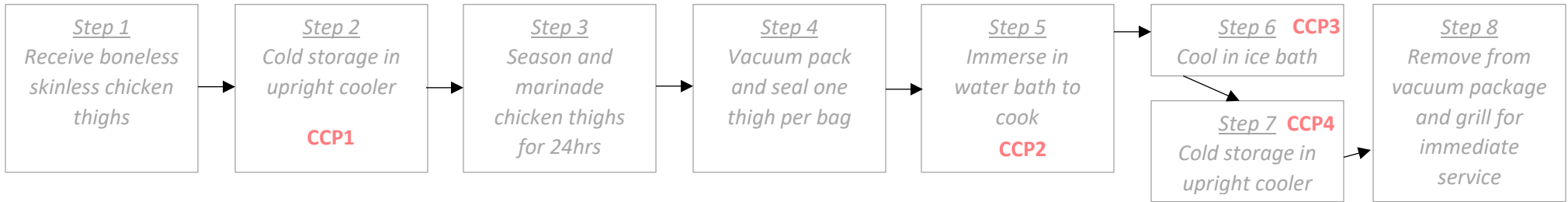
Potential hazards in the special process must be identified and mitigated. A CCP is defined by the FDA Food Code as a point or procedure in a specific food system where loss of control may result in an unacceptable health risk.

Use the decision tree below from the 2017 Food Code Annexes to identify process steps as CCPs.



Flow of Food

a) In the space provided draw or insert a flow chart for each menu item produced using the special process and clearly identify the CCPs. The chart must start with the food or ingredient's arrival at the facility and end with service to consumer. *An example is provided for sous vide cooking of chicken thighs.*



Draw or paste CCP Flow Charts

Draw or paste CCP Flow Charts

Draw or paste CCP Flow Charts

Section 3: Create a Hazard Plan Summary and Hazard Analysis

Complete the charts provided on the next page and list the CCPs for each food item covered under the special process. The chart(s) must include the hazards addressed, critical limits, monitoring procedures, corrective actions, record keeping, and verification procedures. You may use as many charts as necessary to list all CCPs. *Example provided*

Key Terms

Hazard: A biological, chemical, or physical property that may cause an unacceptable consumer health risk.

Critical Limit: The maximum or minimum value to which a physical, biological, or chemical parameter must be controlled at a CCP to minimize the risk that the identified food safety hazard may occur.

Monitoring Procedure: Method and frequency for monitoring and controlling each CCP by the person completing the CCP step.

Corrective Action: Action to be taken by the person completing the CCP step if the critical limit is not met.

Records: Logs or other documents completed by the person completing the step and maintained by the person in charge for at least six months. Records must be available for review during inspection.

Verification: Method and frequency for the person in charge to ensure food employees are following procedures and adequately monitoring CCPs to mitigate identified hazards.

EXAMPLE

| Facility Name <i>Big Bob's Grilled Chicken</i> | | | | Process: Food <i>Sous Vide: Chicken Thigh for use in salads, tacos, and sandwiches</i> | | | | | |
|---|---|--|-------------------------------|---|--|--------------------------|--|--|---|
| 1 Critical Control Point (CCP) | 2 Significant Hazards | 3 Critical Limit (CL) | 4 Monitoring | | | | 5 Corrective Action | 6 Verification | 7 Record |
| | | | What | How | When | Who | | | |
| Cold Storage | Harmful bacterial growth | Store raw chicken at ≤41°F | Temperature of upright cooler | Metal-stemmed thermometer | Twice daily | Manager or Designee | Discard foods if greater than 41°F | ▶ Daily calibration of thermometer ▶ Review of logs | ▶ Cold holding log ▶ Calibration log |
| Cooking | Survival of harmful organisms | Cook chicken to ≥165°F | Internal product temperature | Metal-stemmed thermometer | Last package added to circulator of each batch | Employee cooking chicken | Continue cooking until next package removed is at CL | ▶ Daily calibration of thermometer ▶ Review of logs | ▶ Cooking log ▶ Calibration log |
| Cooling | Growth of spore forming bacteria | Cool from 135°F to 70°F in ≤2hrs and from 70°F to ≤41°F in ≤4hrs | Cooling time and temperature | Metal-stemmed thermometer | Last package added to ice bath | Employee cooking chicken | If product does not hit CL it will be destroyed | ▶ Daily calibration of thermometer ▶ Review of logs | ▶ Cooling log ▶ Calibration log ▶ Product destruction log |
| Cold Storage of Cooked Food | Growth of <i>L. Monocytogenes</i> & <i>C. Botulinum</i> | Hold at ≤41°F for ≤7 Days | ▶ Temperature ▶ Time | ▶ Metal probe thermometer ▶ Date marking | Dates checked at daily temp audit | Manager or Designee | Discard if ≥41°F or held for ≥7 days | ▶ Daily calibration of thermometer ▶ Review of logs ▶ Daily check of dates | ▶ Cold holding log ▶ Product discard log |
| Signature (Person in Charge) <i>Big Bob McGrellin</i> | | | | | | | | Date: 12/30/2021 | |

| Facility Name | | | | Process: Food | | | | | |
|-----------------------------------|--------------------------|---------------------|-----------------|---------------|------|-----|------------------------|-------------------|-------------|
| 1 Critical Control Point (CCP) | 2 Significant Hazards | 3 Critical Limit | 4 Monitoring | | | | 5 Corrective Action | 6 Verification | 7 Record |
| | | | What | How | When | Who | | | |
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| Signature (Person in Charge) | | | | | | | | | Date |

| Facility Name | | | | | Process: Food | | | | |
|-----------------------------------|--------------------------|---------------------|-----------------|-----|---------------|-----|------------------------|-------------------|-------------|
| 1 Critical Control Point (CCP) | 2 Significant Hazards | 3 Critical Limit | 4 Monitoring | | | | 5 Corrective Action | 6 Verification | 7 Record |
| | | | What | How | When | Who | | | |
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| Signature (Person in Charge) | | | | | | | | | Date |

Section 4: Cooking and Cooling information

This section is for Sous Vide or Cook/Chill only. Please proceed to Section 5 if not performing Cook/Chill or Sous Vide.

- a) Describe how all foods will be cooked including specific temperatures and for how long.
- **All foods must be sealed in the reduced oxygen or vacuum package prior to cooking or immediately after cooking while still at greater than 135°F.**
 - **All parts of the food item must reach the minimum temperatures specified in §3-401.11 or other scientifically supported cooking charts such as these provided [here](#). Foods may not be cooked to a temperature under 135°F in Sous Vide or Cook/Chill.**

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- b) After the food is cooked then rapidly cooled in the reduced oxygen packaging following §3-501.14(A), how will it be further cooled and/or stored?
- Cooled to 34°F within 48 hours of reaching 41°F and held at that temperature until served or discarded at a time not to exceed 30 days from the date of cooking and packaging.
 - Held at 41°F or less for no more than 7 days, at which point the food must be served or discarded.
 - Held solidly frozen with no shelf-life restriction while it remains frozen.

- c) Describe how the facility will comply with §3-502.12(D)(2)(f) which states, “Ensure the food is held in a refrigeration unit that is equipped with an electronic system that continuously monitors time and temperature and is visually examined for proper operation twice daily”.

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Section 5: Labeling

Food must be prominently labeled as specified below for the specific process or food item packaged using reduced oxygen packaging.

Cook/Chill or Sous Vide: The package must be labeled with the product name, date packaged, and date it must be discarded if not served. **It may not be sold to consumers in this package for off-site consumption.**

Vacuum Packaging (Under Section 1b): The package must be labeled on the principal display panel in bold type on a contrasting background with instructions to maintain the food at 41°F or below, discard the food if not consumed within 30 days of its packaging or the manufacturers use-by or sell-by date, whichever is soonest, if not consumed. **The food may be sold to consumers in this package for off-site consumption if the label is compliant with §3-602.11.**

Pre-printed food labels must be submitted for each food item listed in this HACCP plan for review. Improperly labeled foods may be subject to destruction.

Section 6: Standard Operating Procedures (SOPs)

A HACCP plan must include SOPs that cover the following topics pursuant to §3-502.12(B)(5).

Describe how the following will be achieved:

- a) Prohibit staff from contacting ready-to-eat foods with bare hands.

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- b) Identify a designated work area and the method by which physical barriers or separation will minimize cross contamination between raw and ready-to-eat foods. In addition, identify how access to processing equipment is limited to trained and responsible staff who are familiar with the potential hazards of the operation.

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c) Describe in detail the cleaning and sanitization procedures for food-contact surfaces.

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Section 7: Training

Describe the training program that ensures that the person responsible for the reduced oxygen packaging operation understands the

- Concepts required for a safe operation,
- Equipment and facilities, and
- Procedures and concepts specified in Sections 2, 3, & 6 of this guide.

This description must also include how the person in charge will verify that the employees are following the SOPs listed and that they are adequately monitoring CCPs.

Yes No

Use the space below or attach your training plan that satisfies the requirements above. **Training plan attached?**

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