

System :	ISO 22000 FOOD SAFETY MANAGEMENT SYSTEM		Date of Issue:	2017.01.01
Company:	<b>SSF (PVT) LTD</b>		Date of Revision:	N/A
Manual:	HACCP Manual		Issue no:	02
Doc No:	SSF/DOC -3		Revision No:	00

Step/Input	Hazard	Control Measures	SI	LI	Q1	Q2	Q3	Q4	PRINCIPLE 1		Reason for Decision
									SI * LI	CCP/OPRP	
2.Hatching (For Chips )	<b>Biological Hazard:</b> Cross Contamination of Bacteria/fungus/pathogenic Microorganism through workers & if use unhygienic utensils.	Medical Checkups Concerned the Personal Hygiene & good hygienic practices	L	L	Y	N	N	-	L	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP
	<b>Chemical Hazard:</b> Potential Cross Contamination of any Chemical Hazard through hatching Axe.	Proper Cleaning Programme	L	L	Y	N	N	-	L	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP
	<b>Physical Hazard:</b> Nails, Coconut shell Pieces like any harmful extraneous matter Cross Contamination through Workers.	Personal Hygiene Proper cleaning Programme	H	L	Y	N	N	-	L	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP
											Ref.: Cleaning record-[QA/FM/20]
											Ref.: Personal hygiene record-[QA/FM/14] Cleaning record-[QA/FM/20]

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Step/Input	PRINCIPLE 1				PRINCIPLE 2				Reason for Decision		
	Hazard	Control Measures	SI	LI	SI*LI	Q1	Q2	Q3		Q4	CCP/OPRP
3. Pairing & Cutting (For Chips )	<b>Biological Hazard:</b> Cross contamination with Bacteria/fungus/pathogenic Microorganism through workers & Pairing knives.	Personal Hygiene Medical check up Proper cleaning Programme	L	L	L	Y	N	N	-	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP  Ref.: Personal hygiene record-[QA/FM/14] Employee medical clearance record Cleaning record-[QA/FM/20]
	<b>Chemical Hazard:</b> Potential Cross contamination with any chemical hazards through Pairing knives.	Proper Cleaning Programme Food grade certificates for Cleaning Chemicals.	L	L	L	Y	N	N	-	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP  Ref.: Cleaning record-[QA/FM/20]
	<b>Physical Hazard:</b> Contamination with Non metallic foreign extraneous matter like coconut shell pieces & Pairings.	Proper Cleaning Programme Further step will eliminate these hazards.	H	L	H	Y	N	N	-	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP  Ref.: Cleaning record-[QA/FM/20]



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	Hazard	Control Measures	SI	LI	Q1	Q2	Q3	Q4		SI * LI	CCP/OP RP
4.washing (For Chips )	<b>Biological Hazard:</b> Cross contamination with Bacteria/fungus/pathogenic Microorganism through washing tank, workers & water.	Personal Hygiene Medical check up Testing of Water Use clean chlorinated water for nut washing. (1-3ppm of Chlorinated water)	H	H	Y	N	N	-	H	OPRP-1B	According to the Risk Assessment & decision tree the Severity & Likely occurrence are High. Therefore this is an OPRP.  Ref.: Personal hygiene record-[QA/FM/14] Employee medical clearance record Cleaning record-[QA/FM/20] Washing tank monitoring record-[QA/FM/23]
	<b>Chemical Hazard:</b> Potential Contamination Chemical hazards which are coming with water.	Water is tested for heavy metals & other chemicals.	L	L	Y	N	N	-	L	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP  Ref.: Washing tank monitoring record-[QA/FM/23] Water testing report
	<b>Physical Hazard:</b> Potential contamination Pairings & Coconut shell pieces which are coming from previous stages.	Visual Inspection	H	H	Y	N	N	-	H	OPRP-2P	According to the Risk Assessment & decision tree the Severity & Likely occurrence are High. Therefore this is an OPRP.  Ref.: Washing tank monitoring record-[QA/FM/23]



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PRINCIPLE 1							PRINCIPLE 2						
Step/Input	Hazard	Control Measures	SI	LI	Q1	Q2	Q3	Q4	SI * LI	CCP/OP RP	Reason for Decision		
5. Sterilization (For Chips)	<b>Biological Hazard:</b> Cross contamination with Bacteria/fungus/pathogenic Microorganism.	(The Entire area is Fully closed. Temperature Controlling methods also available.)	H	H	Y	N	Y	Y	H	CCP-1B	According to the Risk Assessment & decision tree the Severity & Likely occurrence are High. Therefore this is an CCP.		
	<b>Chemical Hazard:</b> Potential contamination with Sterilization tank Cleaning chemicals.	Proper cleaning Programme Food grade certificates for Cleaning Chemicals.	L	L	Y	N	N	-	L	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP		
	<b>Physical Hazard:</b> Potential Contamination with Metals like any harmful extraneous matter through the sterilization tank.	Proper cleaning Programme	L	L	Y	N	N	-	L	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP		
											Ref.: Cleaning record - [QA/FM/20]		
											Ref.: Cleaning record - [QA/FM/20]		



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PRINCIPLE 1							PRINCIPLE 2						
Step/Input	Hazard	Control Measures	S1	L1	Q1	Q2	Q3	Q4	S1 * L1	CCP/OPR	Reason for Decision		
6.Cutting FOR CHIPS	<b>Biological Hazard:</b> Potential Cross contamination with Bacterial/APC,TPC; Fecal coliform, Salmonella spp] / fungus[Yeast; Monascus bisporus, Aspergillus niger & Mould; Saccharomyces rouxii] / pathogenic Microorganism through workers.	Proper Personal Hygiene Practices & ensuring of workers health Proper cleaning Programme Further Drying step will eliminate this hazard.	L	L	Y	N	N	-	L	Not a CCP or OPR	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP Ref.: personal hygiene record-[QA/FM/14] Employee medical clearance record Cleaning record-[QA/FM/20]		
	<b>Chemical Hazard:</b> No Hazards.	No Hazards.	-	-	-	-	-	-	-	-	-		
	<b>Physical Hazard:</b> Potential Cross Contamination with Metal pieces like any harmful extraneous matter.	Proper cleaning Programme	L	L	Y	N	N	-	L	Not a CCP or OPR	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP Ref.: Cleaning record- [QA/FM/20]		



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Step/Inpu	Hazard	PRINCIPLE 1						PRINCIPLE 2			
		Control Measures	SI	LI	Q1	Q2	Q3	Q4	SI * LI	CCP/OPRP	Reason for Decision
7.Drying (For Chips)	<b>Biological Hazard:</b> Potential Cross contamination with Bacteria/APC,TPC; <i>Fecal coliform</i> , <i>Salmonella spp</i> / fungus Yeast; <i>Monascus bisporus</i> , <i>Aspergillus niger</i> & Mould; <i>Saccharomyces rouxii</i> /Bacterial APC,TPC; <i>Fecal coliform</i> , <i>Salmonella spp</i> / fungus Yeast; <i>Monascus bisporus</i> , <i>Aspergillus niger</i> & Mould; <i>Saccharomyces rouxii</i> /	Apply proper temperature & retain constant time at drying process Proper size of nut pieces according to CDA standard & check the moisture content of dried product.	H	H	Y 1	Y	-	-	H	CCP-2B	According to the Risk Assessment & CCP Decision tree, this is a CCP. Ref.: Temperature monitoring record(dryer)-[QA/FM/24]
	<b>Chemical Hazard:</b> Potential Cross contamination with Cleaning & maintenance chemicals like machine lubricants, Kerosine or residues from utensils	Proper cleaning Programme Food grade certificates for Cleaning Chemicals.	L	L	Y	N	N	-	L	Not a CCP or OPRP	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP Ref.: Maintenance record-[MNT/FM/01]
	<b>Physical Hazard:</b> Potential Cross Contamination with Metal, particles like any harmful extraneous matter through Dryer.	Proper cleaning & maintenance Programme Further Magnetic Separation step will eliminate these hazards.	L	L	Y	N	N	-	L	Not a CCP or OPRP	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP Ref.: Maintenance record-[MNT/FM/01]

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Step/Input	PRINCIPLE 1						PRINCIPLE 2					
	Hazard	Control Measures	S1	L1	Q1	Q2	Q3	Q4	S1 * L1	CCP/OPR	Reason for Decision	
8. Inspection (Moisture checking (for Chips)	<b>Biological Hazard:</b> Potential contamination with Bacterial/APC,TPC; <i>Faecal coliform, Salmonella spp/ / fungus</i> [Yeast; <i>Monascus bisporus, Aspergillus niger &amp; Mould; Saccharomyces rouxii / pathogenic Microorganism due to High Moisture content of product.</i> <b>Chemical Hazard:</b> No hazards <b>Physical Hazard:</b> Potential contamination of Workers Hair & foreign impurities.	Moisture Checking	H	H	Y	Y	-	-	H	CCP -3B	According to the Risk Assessment & CCP Decision tree, this is a CCP.	
			-	-	-	-	-	-	-	-	Ref.: Inspection Record -DC(QA/FM/05 )	
			-	-	-	-	-	-	-	-	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP Ref.: Personal Hygiene Record(QA/FM/14 ) Cleaning Record (QA/FM/20)	



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Step/Input	Hazard	Control Measures	PRINCIPLE 1				PRINCIPLE 2				Reason for Decision
			SI	LI	SI*LI	Q1	Q2	Q3	Q4	CCP/OP RP	
09.Packing & sealing (For Chips)	<b>Biological Hazard:</b> Potential Contamination of Microbiological Hazards through Workers & Potential contamination if the bag not seal properly	Personal Hygiene Medical check up Sealing Monitoring	M	H	H	Y	N	N	-	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP
	<b>Chemical:</b> No Hazards	-	-	-	-	-	-	-	-	-	-
	<b>Physical Hazard:</b> Potential Contamination Polythene particles.	Proper cleaning Programme Incoming Inspection of packing Material.	M	H	H	Y	N	N	-	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP
											Ref.: Cleaning record-[QA/FM/20] Packing material inspection record-[QA/FM/03]

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Step/Input	Hazard	Control Measures	PRINCIPLE 1				PRINCIPLE 2				Reason for Decision
			SI	LI	SI* LI	Q1	Q2	Q3	Q4	CCP/OPR <sup>p</sup>	
10. Dispatching (For CHIPS)	<b>Biological Hazard:</b> Potential contamination with Bacteria [ <i>APC, TPC, coliform, Salmonella spp</i> ] /Fungus [ <i>Yeast; Monascus bisporus, Aspergillus niger</i> & Mould; <i>Saccharomyces rouxii</i> ] /pathogens like spoilage Microorganism through Packing material. <b>Chemical Hazards:</b> No Hazards <b>Physical Hazard:</b> Cross Contamination with Wooden, Polythene like any harmful extraneous matter.	Inspection of the conditions of loading vehicles	L	L	L	Y	N	N	-	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP Ref.: Loading Vehicle Inspection Record- [QA/FM/02]
		Delivery Vehicle Inspection Proper cleaning Programme	L	L	L	Y	N	N	-	Not a CCP or OPRP.	According to the Risk Assessment & CCP Decision tree, this is not a CCP or OPRP Ref.: Loading Vehicle Inspection Record- [QA/FM/02]


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STEP 8. PRINCIPLE 3(P3) – DETERMINE CRITICAL LIMITS  
 STEP 9. PRINCIPLE 4(P4) – ESTABLISH A MONITORING SYSTEM FOR EACH CRITICAL LIMIT  
 STEP 10. PRINCIPLE 5(P5) – ESTABLISH CORRECTIVE ACTIONS FOR DEVIATIONS THAT MAY OCCUR  
 STEP 11. PRINCIPLE 6(P6) – ESTABLISH VERIFICATION PROCEDURES  
 STEP 12. PRINCIPLE 7(P7) – ESTABLISH DOCUMENTATION & RECORD KEEPING

**HACCP PLAN – COCONUT CHIPS (cpd)**

Step	Hazard	Control Measures(6)	P2 CCP - Type (7)	P3 Critical Limit (8)	P4 Monitoring (9)			P5 Corrective Action (10) What & Who	P6 Verification (11) What & Who	P7 Records (12)		
					What	Where	How				When	Who
05. Sterilization	Biological (Bacteria [APC,TPC; <i>Fecal coliform</i> , <i>Salmonella spp</i> ] / Fungus] Yeast; <i>Monascus bisporus</i> , <i>Aspergillus niger</i> & Mould; <i>Saccharomyces rouxii</i> ] Pathogens may remain in the final product & they grow on the product if not proceed this step.	Inspection of Temperature in sterilization tank	CCP - IB	203F or 95°C in 90 seconds (Releaser CDA Regulation)	Temperature	At the sterilization tank	Using Digital Thermometer	Once in Three Hour	QAA	Hold the Suspended Lot. Adjust the Temperature of sterilization tank. After that re sterilize the Product. QAA	External Laboratory Testing- CDA Thermometer calibration Reports	External Lab Reports- CDA Temperature Monitoring Record sterilization tank)-[QAV/M/33]


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HACCP PLAN – COCONUT CHIPS

Step	Hazard	Control Measures(6)	P2 CCP Type (7)	P3 Critical Limit(8)	P4 Monitoring (9)				P5 Corrective Action (10) What & Who	P6 Verification (11) What & Who	P7 Records (12)	
					What	Where	How	When				Who
07. Drying	Biological (Bacteria [APC,TPC; <i>fecal coliform</i> , <i>Salmonella spp</i> ] / Fungus/ Yeast; <i>Monascus bisporus</i> , <i>Aspergillus niger</i> & Mould; <i>Saccharomyces roxii</i> / Pathogens growth due to -High moisture content. -High Water Activity)	Monitoring Temperature in Dryer	CCP - 2B	(Above 72 °C Salmonella & E.coli Bacteria Killing Temperature).	Temperature	At the dryer	Using Digital Thermo meter	Once in Three hours	QAA	Hold the Suspended Lot. Adjust the Temperature of Dryer. After that Re dry the Product. QAA	External Laboratory Testing-CDA Thermometer calibration Reports	External Lab Reports-CDA Temperature Monitoring Record(dryer)- [QA/FM/24]
										Moisture check Records	Moisture Inspection record- [QA/FM/05]	

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HACCP PLAN – COCONUT CHIPS

Step	Hazard	Control Measures (6)	CCP Type (7)	Critical Limit (8)	Monitoring (9)				Corrective Action (10) What & Who	Verification (11) What & Who	Records (12)	
					What	Where	How	When				Who
08. Inspection	Biological  (Contamination through Workers & potential cross contamination if the bag not seal properly. In case of that, Bacteria [APC, TPC; <i>Fecal coliform</i> , <i>Salmonella spp</i> ] / Fungus [Yeast; <i>Monascus bisporus</i> , <i>Aspergillus niger</i> & Mould; <i>Saccharomyces rouxii</i> ] Pathogens may grow in the final product due to absorption of air moisture. It may cause to increase the moisture content & increase the Water Activity of final product)	Checking the Moisture content.	CCP -3B (CDA Specific on for Desiccated Coconut)	3%	Moisture content	After Drying	Using Digital Moisture meter	Three times per batch	QAA	If desiccated coconut contain moisture >3%  Redrying.  If: <3% it is acceptable	Recheck the moisture content  Calibration of Moisture meter  External Microbiology Reports.	Inspection Record DC [QA/FM/05]  Moisture meter calibration Reports  External Lab Reports-CDA

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**OPERATIONAL PRE-REQUISITE PROGRAMME – COCOMUT CHIPS**

Step	Hazard	Control Measures(6)	OPRP Type (7)	Monitoring (9)			Corrective Action (10) What & Who	Verification (11) What & Who	Records (12)	
				What	Where	How				When
4. washing	Biological hazard (if use untidy water for washing kernels contaminations may cause due to presence of contaminant Micro-organisms in water)	Use clean chlorinated water for kernels washing (1-3 ppm)	OPRP-1B	Chlorine concentration in water.	At the washing process.	Check the cleanliness of washing water & refill the Chlorinated water.	Once in three hours Period	QAA	1. Stop the washing of kernels & after change the water in tank, rewash the lot.  2. Replace the water use for kernels washing & add 1-3ppm of Chlorinated water	External Laboratory Report.  Washing tank monitoring Record-QA/FM/23

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**OPERATIONAL PRE-REQUISITE PROGRAMME – COCONUT CHIPS**

Step	Hazard	Control Measures (6)	OPRP Type (7)	Monitoring (9)			Corrective Action (10) What & Who	Verification (11) What & Who	Records (12)		
				What	Where	How				When	Who
4. washing (For DC)	Physical hazard (Pairings may consist with the kernel)	Inspection the kernel which are contaminated with pairings.	OPRP- 2P	Changing the water of the washing tank.	At H&P unit (Hachuri ng & Pairing Unit)	Manual Cleaning & Refill the Chlorinated water.	Once in three hours Period	QAA	Stop the conveyer belt. Temporary suspend the lot .Change the water of the washing tank. Then Resend the kernel through the washing tank.	100% Inspect the lot for any foreign impurities. (Pairings)	Washing tank Monitoring Record(QA/FM/23) External Lab Record

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