

Directions for Using the HACCP Plan Form

1. Examine your Hazard Analysis form to determine which steps are CCP's and what type of hazard (Biological, Chemical, or Physical) each CCP controls.
2. Check to see whether each CCP is already listed on the HACCP Plan Form. If a CCP is not already listed, enter the CCP number and step in the column labeled "CCP # and Location".
3. For CCP's already listed on the model form, examine the Critical Limits listed. In the HACCP Plan Form for some HACCP categories there will be several options for Critical Limits. If this is the case, choose the Critical Limits that will work best in your plant and cross out, white out, or delete the other Critical Limits and the Monitoring Procedures that go with them. It may be helpful to check the "Monitoring Procedures and Frequency" column during your decision-making. For CCP's already on the model form, supporting scientific documentation is already included in your manual.
4. If you are adding a new CCP, you will need to determine the scientifically valid Critical Limits to be used with the CCP. You must also obtain scientific information supporting your choice of Critical Limits. Consult your inspector or university extension specialists for help.
5. Examine the "Monitoring Procedures and Frequency" column for each CCP. If you wish to change the procedure and/or the frequency, check with your inspector or a university extension specialist for help. If a change is OK, you will need to write down your reasoning for making the change and include this reasoning in your HACCP manual.
6. Examine the "HACCP Records" column. If you are using different forms for record-keeping in this HACCP Plan, please put the correct form title(s) in the "HACCP Records" column.
7. The verification activities listed in the "Verification Procedures and Frequency" column are required by the regulation. However, you may choose to do additional activities; for example, for verification, beef jerky samples may be sent to the lab each quarter for water activity and Moisture : Protein Ratio testing. If you do any additional verification activities, enter them in the "Verification Procedures and Frequency" column. If you choose to use a frequency for the required verification activities that is different than the frequency shown, you must provide written justification for the different frequency. Consult your inspector or university extension specialists for help.
8. We suggest that you make no changes in the "Corrective Actions" column. Be sure to have a form for documenting corrective actions that you take. A corrective action form is included in this model.

Raw, Ground Model

HACCP PLAN					
PROCESS CATEGORY: Raw, ground					
Product example: Ground Beef, Pork Sausage, Fresh Bratwurst, Italian Sausage					
CCP# and Location	Critical Limits	Monitoring Procedures and Frequency	HACCP Records	Verification Procedures and Frequency	Corrective Actions
1B - Cooler Storage OR 2B - Packaging and Labeling - with no Cooler Storage immediately before it	1. Meat internal temperature is between 41°F - and a designated maximum temperature for no more than the time designated in the table shown below. This means that product internal temperature must return to 41°F or lower within the designated time. Note that if product internal temperature does not exceed 41°F, then the Critical Limit has been met. OR	1. The meat temperature will be measured by the establishment owner or designee at the start of each lot (earliest of steps 5, 6, 8, 9, or 10) using a calibrated thermometer. Monitoring starts at the time product temperature first exceeds 41°F, but for simplicity you can note the time when product is removed from the cooler and assume the product temperature exceeded 41°F at this time. Meat internal temperature will be taken again after the last of the product is packaged and placed in the cooler and a final meat internal temperature will be measured when product is refrigerated to show that the temperature was 41°F	Product Temperature Log Corrective Action Log Thermometer Calibration Log	Establishment owner or designee will review the Product Temperature Log, Corrective Action Log, and Thermometer Calibration Log once per week. Establishment owner or designee will calibrate all thermometers to a known standard monthly. Thermometers will be calibrated to ± 2° F or taken out of operation as stated in the SOP. Calibration actions are recorded in the Thermometer Calibration Log. Establishment owner or designee will observe monitoring of temperature at least once per month.	If a deviation from a critical limit occurs, the establishment owner or designee is responsible for corrective action protocol as stated in 9 CFR 417.3 1. The cause of the deviation will be identified and eliminated. 2. The CCP will be under control after the corrective action is taken. 3. Measures to prevent recurrence are established. 4. No product that is injurious to health or otherwise adulterated as a result of the deviation will be permitted to enter commerce.

Raw, Ground Model

		<p>or lower within the Critical Limit time. Note that if meat temperature is 41°F or lower when the meat is returned to the cooler, no additional temperature measurement is necessary. All temperature measurements will be made by the establishment owner or designee using a calibrated thermometer.</p> <p>Temperature monitoring will be done at least once for each product grouping done in each production day.</p> <p>All products within a "product grouping" have a similar diameter and volume. For example, pork sausage mix and ground beef in the same volume could constitute a product grouping. Fresh bratwurst and Polish sausage might constitute another product grouping.</p>			
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	<p>2. Product exposed to a designated maximum room temperature and returned to refrigeration (meat internal temperature of 41°F or lower) within a time designated in the table shown below.</p>	<p>2. The room temperature will be measured at the start of each lot (earliest of steps 5, 6, 8, 9, or 10) and at the end of each lot (last of the packaged product enters cooler) by the establishment owner or designee using a calibrated thermometer. Note the warmer of the two room temperature measurements. Within the Critical Limit time for this temperature (time elapsed since start of the lot) the product temperature will be measured using a calibrated thermometer by the establishment owner or designee.</p> <p>Temperature monitoring will be done at least once for each product grouping in each production day.</p> <p>All products within a "product grouping" have a</p>			
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Raw, Ground Model

		similar diameter and volume. For example, pork sausage mix and ground beef in the same volume could constitute a product grouping. Fresh bratwurst and Polish sausage might constitute another product grouping.			
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Raw, Ground Model

			<p>Product Temperature Log</p> <p>Corrective Action Log</p> <p>Thermometer Calibration Log</p>	<p>Establishment owner or designee will review the Product Temperature Log, Corrective Action Log, Thermometer Calibration Log once per week.</p> <p>Establishment owner or designee will calibrate all thermometers to a known standard monthly. Thermometers will be calibrated to $\pm 2^\circ$ F or taken out of operation as stated in the SOP. Calibration actions are recorded in the Thermometer Calibration Log.</p> <p>Establishment owner or designee will observe monitoring of temperature at least once per month.</p>	<p>If a deviation from a critical limit occurs, the establishment owner or designee is responsible for corrective action protocol as stated in CFR 9, 417.3</p> <ol style="list-style-type: none"> 1. The cause of the deviation will be identified and eliminated. 2. The CCP will be under control after the corrective action is taken. 3. Measures to prevent recurrence are established. 4. No product that is injurious to health or otherwise adulterated as a result of the deviation will be permitted to enter commerce.
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Raw, Ground Model

<p>2B - Packaging and Labeling - WITH Cooler Storage immediately before it</p>	<p>1. Meat internal temperature is between 41°F - and a designated upper temperature for no more than the time designated in the following table. This means that product internal temperature must return to 41°F or lower within the designated time. Note that if product internal temperature does not exceed 41°F, then the Critical Limit has been met.</p> <p><u>PORK</u></p> <p>Max. Temp. - Hrs:Min</p> <p>50°F - 54:45</p> <p>55°F - 17:30</p> <p>60°F - 8:30</p> <p>65°F - 8:15</p> <p>70°F - 5:45</p> <p>75°F - 4:15</p> <p>80°F - 4:15</p> <p>85°F - 1:30</p>	<p>1. The meat temperature will be measured by the establishment owner or designee at the start of each lot (earliest of steps 5, 6, 8, 9, or 10) using a calibrated thermometer. Monitoring starts at the time product temperature first exceeds 41°F, but for simplicity you can note the time when product is removed from the cooler and assume the product temperature exceeded 41°F at this time.</p> <p>Meat internal temperature will be taken again after the last of the product is packaged and placed in the cooler and a final meat internal temperature will be measured when product is refrigerated to show that the temperature was 41°F or lower within the Critical Limit time. Note that if meat temperature is 41°F or lower when the meat is</p>	<p>Product Temperature Log</p> <p>Corrective Action Log</p> <p>Thermometer Calibration Log</p>	<p>Establishment owner or designee will review the Product Temperature Log, Corrective Action Log, and Thermometer Calibration Log once per week.</p> <p>Establishment owner or designee will calibrate all thermometers to a known standard monthly. Thermometers will be calibrated to $\pm 2^\circ$ F or taken out of operation as stated in the SOP. Calibration actions are recorded in the Thermometer Calibration Log.</p> <p>Establishment owner or designee will observe monitoring of temperature at least once per month.</p>	<p>If a deviation from a critical limit occurs, the establishment owner or designee is responsible for corrective action protocol as stated in CFR 9, 417.3</p> <ol style="list-style-type: none"> 1. The cause of the deviation will be identified and eliminated. 2. The CCP will be under control after the corrective action is taken. 3. Measures to prevent recurrence are established. 4. No product that is injurious to health or otherwise adulterated as a result of the deviation will be permitted to enter commerce.
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	<p>90°F - 1:30 95°F - 1:30 100°F - 1:30 105°F - 1:00 110°F - 1:00</p> <p><u>BEEF</u> Max. Temp. - Hrs:Min 50°F - 27:00 55°F - 9:00 60°F - 6:00 65°F - 3:45 70°F - 3:30 75°F - 2:30 80°F - 2:00 85°F - 1:30 90°F - 1:30 95°F - 1:15 100°F - 1:15 105°F - 1:00 110°F - 1:00</p> <p><u>POULTRY</u> Max. Temp. - Hrs:Min 50°F - 22:30 55°F - 14:45 60°F - 13:45 65°F - 8:15 70°F - 4:45 75°F - 3:00</p>	<p>returned to the cooler, no additional temperature measurement is necessary. All temperature measurements will be made by the establishment owner or designee using a calibrated thermometer.</p> <p>Temperature monitoring will be done at least once for each product grouping in each production day.</p> <p>All products within a "product grouping" have a similar diameter and volume. For example, pork sausage mix and ground beef in the same volume could constitute a product grouping. Fresh bratwurst and Polish sausage might constitute another product grouping.</p>			
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<p>80°F - 3:00 85°F - 2:00 90°F - 2:00 95°F - 2:00 100°F - 1:30 105°F - 0:45 110°F - 0:45</p> <p><u>SAUSAGE (with salt but no sodium nitrite)</u> Max. Temp. - Hrs:Min</p> <p>50°F - 8:30 55°F - 8 :30 60°F - 8 :30 65°F - 8 :30 70°F - 6 :00 75°F - 5 :15 80°F - 3 :15 85°F - 2 :30 90°F - 2 :30 95°F - 1 :45 100°F - 1 :45 105°F - 1:45 110°F - 2:15</p> <p>Sources: Ingham et al., 2007. Predicting Pathogen Growth during Short-Term</p>				
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Raw, Ground Model

	<p>Temperature Abuse of Raw Pork, Beef and Poultry Products: Use of an Isothermal Based Predictive Tool. Journal of Food Protection: Vol. 70, pp. 1445-1456. AND Ingham et al., 2009. Predicting pathogen growth during short-term temperature abuse of raw sausage. Journal of Food Protection: Vol. 72, pp. 75-84.</p> <p>OR</p> <p>2. Product exposed to a designated maximum room temperature and returned to refrigeration (meat internal temperature of 41°F or lower) within a time designated in the</p>	<p>2. The room temperature will be measured at the start of each lot (earliest of steps 5, 6, 8, 9, or 10) and at the end of each lot (last of the packaged product enters cooler) by the establishment owner or designee using a calibrated</p>			
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Raw, Ground Model

	<p>table shown above.</p>	<p>thermometer. Note the warmer of the two room temperature measurements. Within the Critical Limit time for this temperature (time elapsed since start of the lot) the product temperature will be measured using a calibrated thermometer by the establishment owner or designee.</p> <p>Temperature monitoring will be done at least once for each product grouping in each production day.</p> <p>All products within a "product grouping" have a similar diameter and volume. For example, pork sausage mix and ground beef in the same volume could constitute a product grouping. Fresh bratwurst and Polish sausage might constitute another product grouping.</p>			
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Raw, Ground Model

Sign and date at initial acceptance, modification, or annual reassessment.

Signed _____

Date _____

Signed _____

Date _____

Signed _____

Date _____

Signed _____

Date _____

Raw, Ground Model