##### PRODUCT DESCRIPTION

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| **WORKSHOP LOCATION** |
| Paris, TN |
| **COMMON NAME** |
| Hickory Smoked Pork Sausage, Uncured Smoked Pork Sausage, The Species (Beef, Pork or Lamb) and the product form or spice reference’s, such as (Links, Bulk, Chub, Patties, 1 or 2 pound, Mild, Medium, Hot) may or may not be included in the listed names. |
| **HACCP CATEGORY** |
| Heat Treated but Not Fully Cooked—Not Shelf Stable |
| **HOW IS IT TO BE USED** |
| Fully Cooked and Consumed |
| **LENGTH OF SHELF LIFE AT WHAT TEMPERATURE?** |
| 1 Year if Frozen, 2 Months Refrigerated |
| **IS SPECIAL DISTIBUTION CONTROL NEEDED?** |
| Keep Frozen or Refrigerated |

Sign:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ Date:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

##### LIST OF PRODUCT INGREDIENTS

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| MEAT & MEAT BYPRODUCTS | NON-MEAT INGREDIENTS | BINDERS/EXTENDERS |
| Pork Meat | Water, Swiss Cheese, American Cheese, Cheddar Cheese, Pepperjack Cheese | NO |
| SPICES/FLAVORINGS | RESTRICTED INGREDIENTS | PRESERVATIVES/ACIDIFIERS |
| Salt, Turbinado Sugar, Black Pepper, Red Pepper, Sage, and Spice Extractives, Salt, Textured Vegetable Protein (Soy Flour, Zinc Oxide, Niacinamide, Ferrous Sulfate, Copper gluconate, Vitamin A palmitate, Calcium pantothenate, Thiamine mononitrate (B1), Pyridoxine hydrochloride (B6), Riboflavin (B2), Cyanocobalamine (B12)), Red, Black, & White Pepper, Chili Pepper, Sugar, Paprika, Spices, Spice Extractives, Garlic Powder, Onion Powder, Dextrose, Corn Syrup Solids | Sodium Nitrite, Celery Powder | Sodium Nitrite, Celery Powder |
| OTHER |  |  |
| Approved Packaging Materials | Cheeses-Dairy | NO |

FLOW CHART

Cold-Storage

10-P-HSPS

Shrink Packaging

9-P-HSPS

Shipping

11-P-HSPS

Receiving Nonmeat

Ingredients

1A-P-HSPS

Storage Nonmeat

Packaging

2B-P-HSPS

Assemble Pre-weigh

Nonmeat Ingredients

3A-P-HSPS

Weigh, Formulation, Grind

4-P-HSPS

Stuffing

5-P-HSPS

Packaging & Labeling

8-P-HSPS

Chilling

7-P-HSPS-CCP

Cold Smoking

6-PHSPS-CCP

Rework

12-P-HSPS

Carcass & Meat

Fabrication

3-P-HSPS

Storage Nonmeat

Ingredients

2A-P-HSPS

Receiving Meat & Meat

Carcasses

1-P-HSPS

Receiving

Nonmeat Packaging

1B-P-HSPS

Storage Nonmeat

Ingredients

2-P-HSPS

| **Hickory Smoked Pork Sausage** | | | | | |
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| **HAZARD ANALYSIS** | | | | | |
| **Process Step** | **Potential Hazard** | **The Significance of Hazard** | **Justification For Decision** | **What Control Measures Can Be Applied to Prevent The Hazard** | **Is This Step A Critical Control Point** |
| Step1-P-HSPS  Receiving Meat & Meat Carcasses | **B:** Microbiological  **C:** Physical  **C:** None Identified | **B:** NO  **P:** NO | **B:** Biological contamination is unlikely to occur due to plant’s SSOP and GMPs.  **P:** Physical hazards are reasonably unlikely to occur due to the observance of product. | **P:** Upon observing the presence of physical contaminants, measures shall be taken to remove contaminants by washing and/or trimming. | NO |
| Step 2-P-HSPS  Storage Meat | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO | **B:** Biological contamination is unlikely to occur due to plant’s SSOP and GMPs.  **P:** Physical hazards are reasonably unlikely to occur due to the observance of product. | **P:** Upon observing the presence of physical contamination, measures shall be taken to remove contaminants by washing and/or trimming. | NO |

| **Hickory Smoked Pork Sausage** | | | | | |
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| **HAZARD ANALYSIS** | | | | | |
| **Process Step** | **Potential Hazard** | **The Significance of Hazard** | **Justification For Decision** | **What Control Measures Can Be Applied to Prevent The Hazard** | **Is This Step A Critical Control Point** |
| **Step 1A-P-HSPS**  Receiving Non-Meat Ingredients | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO | **B:** Biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Unlikely to occur; letters of guarantee received. | **P:** Letters of guarantee on file. Any busted packaging of seasoning, etc. is completely discarded. | NO |
| **Step 2A-P-HSPS**  Storage of Non-Meat Ingredients | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO | **B:** Biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Physical hazards are reasonably unlikely to occur due to the observance of product. | **P:** Upon observing the presence of physical contaminants measures shall be taken to remove contaminants. | NO |

| **Hickory Smoked Pork Sausage** | | | | | |
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| **HAZARD ANALYSIS** | | | | | |
| **Process Step** | **Potential Hazard** | **The Significance of Hazard** | **Justification For Decision** | **What Control Measures Can Be Applied to Prevent The Hazard** | **Is This Step A Critical Control Point** |
| **Step 3A-P-HSPS**  Assemble, Pre-weigh, Non-Meat Ingredients | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO  **C:** NO | **C:** Low risk. Unlikely to occur.  B: Biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Physical hazards are reasonably unlikely to occur due to the observance of product. | **P:** Upon observing the presence of physical contaminants, measures shall be taken to remove contaminants. | NO |
| **Step 1B-P-HSPS**  Receiving Non-Meat Packaging | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO | **B:** Biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Unlikely to occur; letters of guarantee received. | **P:** Upon observing the presence of physical contaminants, measures shall be taken to remove contaminants. | NO |

| **Hickory Smoked Pork Sausage** | | | | | |
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| **HAZARD ANALYSIS** | | | | | |
| **Process Step** | **Potential Hazard** | **The Significance of Hazard** | **Justification For Decision** | **What Control Measures Can Be Applied to Prevent The Hazard** | **Is This Step A Critical Control Point** |
| **Step 2B-P-HSPS**  Storage Non-Meat Packaging | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO | **B:** Biological contamination is unlikely to occur | **P:** Upon observing the presence of physical contaminants, measures shall be taken to remove contaminants. | NO |
| **Step 3-P-HSPS**  Carcass & Meat Fabrication | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO | **B:** Potential for pathogen growth is reasonably unlikely to occur due to the average processing time at this step.  Biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Physical hazards are reasonably unlikely to occur due to the observance of product. | **P:** Upon observing the presence of physical contaminants, measures shall be taken to remove contaminants by washing, and/or trimming. | NO |

| **Hickory Smoked Pork Sausage** | | | | | |
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| **HAZARD ANALYSIS** | | | | | |
| **Process Step** | **Potential Hazard** | **The Significance of Hazard** | **Justification For Decision** | **What Control Measures Can Be Applied to Prevent The Hazard** | **Is This Step A Critical Control Point** |
| **Step 4-P-HSPS**  Weigh, Formulation, Grind | **B:** Microbiological  **P:** Physical  **C:** Chemical- Addition of all allergenic ingredients; ingredients, such as (Sodium Nitrite) not being added or used as intended.  Cleaning/Sanitizing chemical residues. | **B:** NO  **P:** NO  **C:** NO | **B:** Biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Physical hazards are reasonably unlikely to occur due to the observance of product.  **C:** Approved formulation is followed to prevent improper level of use. Operational SSOP prevents cross contamination of allergenic agents. Application of correct label prevents inadvertent consumption of allergens by consumers. Pre-operational SSOP makes chemical residue hazard unlikely. | **P:** Upon observing the presence of Physical contaminants measures shall be taken to remove contaminants. | NO |
| **Step 5-P-HSPS**  Stuffing | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO | **B:** Potential for pathogen growth, due to temperature abuse, is reasonably unlikely to occur because of the average processing time. Biological contamination is unlikely to occur due to plants ssop plan.  **P:** Physical hazards are reasonably unlikely to occur, due to the observance of product. | **P:** Upon observing the presence of Physical contaminants, measures shall be taken to remove contaminants. | NO |
| **Hickory Smoked Pork Sausage** | | | | | |
| **HAZARD ANALYSIS** | | | | | |
| **Process Step** | **Potential Hazard** | **The Significance of Hazard** | **Justification For Decision** | **What Control Measures Can Be Applied to Prevent The Hazard** | **Is This Step A Critical Control Point** |
| **Step 6-P-HSPS**  Cold Smoking | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** YES  **P:** NO | **B:** Supporting Documentation is on file to verify that the incidence of Clostridium Perfringens is reasonably unlikely to occur. | **B:** The length of the process is monitored and recorded. Sodium nitrite and Smoke Powder or Liquid Smoke, ingredients in this product, are bacterial inhibitors. | **YES**  **CCP 12-P-HSPS** |
| **Step 7-P-HSPS**  Chilling | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** YES  **P:** NO  **C:** NO | **B:** If product temperature is not reduced soon enough it has the potential of growing microorganisms. Other biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Physical hazards are reasonably unlikely to occur due to the observance of product at this step. | **P:** Upon observing the presence of physical contaminants, measures shall be taken to remove contaminants by washing and or trimming.    **B:** Product will be chilled to the temperature parameters listed in the HACCP program. | **YES**  **CCP 13-P-HSPS** |
| **Hickory Smoked Pork Sausage** | | | | | |
| **HAZARD ANALYSIS** | | | | | |
| **Process Step** | **Potential Hazard** | **The Significance of Hazard** | **Justification For Decision** | **What Control Measures Can Be Applied to Prevent The Hazard** | **Is This Step A Critical Control Point** |
| **Step 8-P-HSPS**  Packaging & Labeling | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO  **C:** NO | **B:** Biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Physical hazards are reasonably unlikely to occur due to the observance of product during the process step.  **C:** Low risk. Use of approved packaging material. | **B:** Product is labeled as “Cook Before Eating”.  **P:** Upon observing the presence of physical contaminants, measures shall be taken to remove contaminants by washing and or trimming. | **NO** |
| **Step 9-P-HSPS**  Shrink Packaging | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO  **C:** NO | **B:** Biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Physical hazards are reasonably unlikely to occur due to the observance of product during the process step.  **C:** Low risk. Use of approved packaging material. | **P:** Upon observing the presence of physical contaminants, measures shall be taken to remove contaminants. |  |
| **Hickory Smoked Pork Sausage** | | | | | |
| **HAZARD ANAYLISIS** | | | | | |
| **Process Step** | **Potential Hazard** | **The Significance of Hazard** | **Justification For Decision** | **What Control Measures Can Be Applied to Prevent The Hazard** | **Is This Step A Critical Control Point** |
| **Step 10-P-HSPS**  Cold Storage | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO  **C:** NO | **B:** Continuous automatic monitoring of refrigerated storage temperatures will reduce the risk to reasonably unlikely to occur. Other biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Not likely to occur due to product being packaged or sealed. | **B:** Continuous automatic monitoring of refrigerated storage temperatures will reduce the risk to reasonably unlikely to occur. | **NO** |
| **Step 11-P-HSPS**  Shipping | **B:** Microbiological  **P:** Physical  **C:** None Identified | **B:** NO  **P:** NO  **C:** NO | **B:** Product maintained at proper temperature when shipped.  **P:** Not likely to occur. Product is sealed in packages or containers. | **B:** Continuous automatic monitoring of refrigerated storage temperatures will reduce the risk to reasonably unlikely to occur. | **NO** |
| **Hickory Smoked Pork Sausage** | | | | | |
| **HAZARD ANAYLISIS** | | | | | |
| **Process Step** | **Potential Hazard** | **The Significance of Hazard** | **Justification For Decision** | **What Control Measures Can Be Applied to Prevent The Hazard** | **Is This Step A Critical Control Point** |
| **Step 12-P-HSPS**  Rework | **B:** Microbiological  **P:** Physical  **C:** None identified | **B:** NO  **P:** NO | **B:** Biological contamination is unlikely to occur due to plant’s SSOP plan.  **P:** Physical hazards are reasonably unlikely to occur due to the observance of product. | **P:** Upon observing the presence of physical contaminants, measures shall be taken to remove contaminants by washing and or trimming. | NO |

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| **Hickory Smoked Pork Sausage** | | | | | | | |
| HACCP PLAN | | | | | | | |
| **Process Step** | **Biological**  **Chemical**  **Physical**  **Hazard**  **Description** | **CCP** | **Critical**  **Limits** | **Monitoring**  **Procedures/Frequency**  **Person Responsible** | **Corrective/**  **Preventive**  **Action/Person**  **Responsible** | **HACCP Records** | **Verification**  **Procedure**  **Person Responsible** |
| Step 6-PHSPS  Cold Smoking | **B:** Biological | 12-P-HSPS | Internal product temperature is not to dwell below 120F for more than 2 hours and between (50F-130F) for more than 6 hours. The internal product temperature is to reach 136 F. or more for 22 minutes or more.  *Ref. Appendix A (Version 2017)* | Internal temperature of product, the length of time in the step and the house temperature is monitored on every lot produced and recorded by plant designee.  Record all findings in HACCP, packaging and labeling Log, sign, and date records  Calibration is performed at a minimum of once per month with an ice and boiling water bath. | Plant designee will identify the cause of deviation, correct the cause and ensure that all of regulation 417.3 is met before resuming operation. | Plant designee will record all results and corrective action(s) in a plant specific log/record and/or corrective action, Log and Sign record.  Calibration log,  Deviation/Corrective Log,  Hold Summary Log.  Hickory Smoked Sausage Log *(Pre-shipment, Direct Observation, Record Review and Pre-shipment)* | Direct observation of monitoring activities will be performed at a minimum of once monthly or for every lot produced, whichever is the lessor.  Record Review is performed on each lot produced. |
| Step 7-PHSPS  Chilling | **B:** Biological | 12-P-HSPS | Product will be chilled according to Part 1 of Appendix B (Version 2017). | Internal temperature of product, the length of time in the step and the house temperature is monitored on every lot produced and recorded by plant designee.  Record all findings in HACCP, packaging and labeling Log, sign, and date records  Calibration is performed at a minimum of once per month with an ice and boiling water bath. | Plant designee will identify the cause of deviation, correct the cause and ensure that all of regulation 417.3 is met before resuming operation. | Plant designee will record all results and corrective action(s) in a plant specific log/record and/or corrective action, Log and Sign record.  Calibration log,  Deviation/Corrective Log,  Hold Summary Log.  Hickory Smoked Sausage Log *(Pre-shipment, Direct Observation, Record Review and Pre-shipment)* | Direct observation of monitoring activities will be performed at a minimum of once monthly or for every lot produced, whichever is the lessor.  Record Review is performed on each lot produced. |

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| 0 | **HICKORY SMOKED SAUSAGE HACCP LOG** | | | | | | | | | |
| Step 8-BPB-CCP-1 Smoking | | | | | | | Internal product temperature is not to dwell below 120F for more than 2 hours and between (50F-130F) for more than 6 hours. The internal product temperature is to reach 136 F. or more for 22 minutes or more.  *Ref. Appendix A (Version 2017)* | | | |
|  | | Smoke Treatment | | | | |  |  | **Monitor** | **Record Review** |
| **Date** | **Product Description ID Code** | **Time/Temperature Records** | | | | | **Accept/**  **Reject** | **Corrective Action if needed** | **Date, Time, Int.** | **Date, Time, Signature** |
|  |  | **Time In** |  | **Total Time at 50–130F** | |  |  |  |  |  |
| **Total Time 120F or less** |  | **Total Time at 136F>** | |  |  |  |
|  |  |
| Step 9-BPB Chilling Log | | | | | | | **CRITICAL LIMITS:** Product will be chilled according to Part 1 of Appendix B (Version 2017). During cooling, the product’s maximum internal temperature should not remain between 130°F to 80°F for more than 1.5 hours nor between 80°F and 40°F for more than 5 hours (6.5 hours total cooling time). | | | |
| **Date** | **Product Description ID Code** | **Time/Temperature Records** | | | | | **Accept/**  **Reject** | **Corrective Action if needed** | Monitor | Record Review |
| **Date, Time, Int.** | **Date, Time, Signature** |
|  |  | **Time In** | | |  | |  |  |  |  |
| **Total Time at 130F- 80F** | | |  | |  |  |
| **Total time at 80F – 40F** | | |  | |  |  |
| **In the Event of Monitoring With a Manual Thermometer a Direct Observation of Monitoring Will be Performed**  (at a minimum of once monthly or for every lot produced, whichever is the lessor.) | | | | | | | | Date | Time | Signature |
|  |  |  |
| **Pre-shipment Review** | | | | | | | | Date | Time | Signature |
|  |  |  |