



HACCP PROGRAM

Version 20.0

PRODUCT NAME: Hickory Smoked Pork Sausage

HACCP CATEGORY: Heat Treated but Not Fully Cooked-Not Shelf Stable

PRODUCT DESCRIPTION

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: _____



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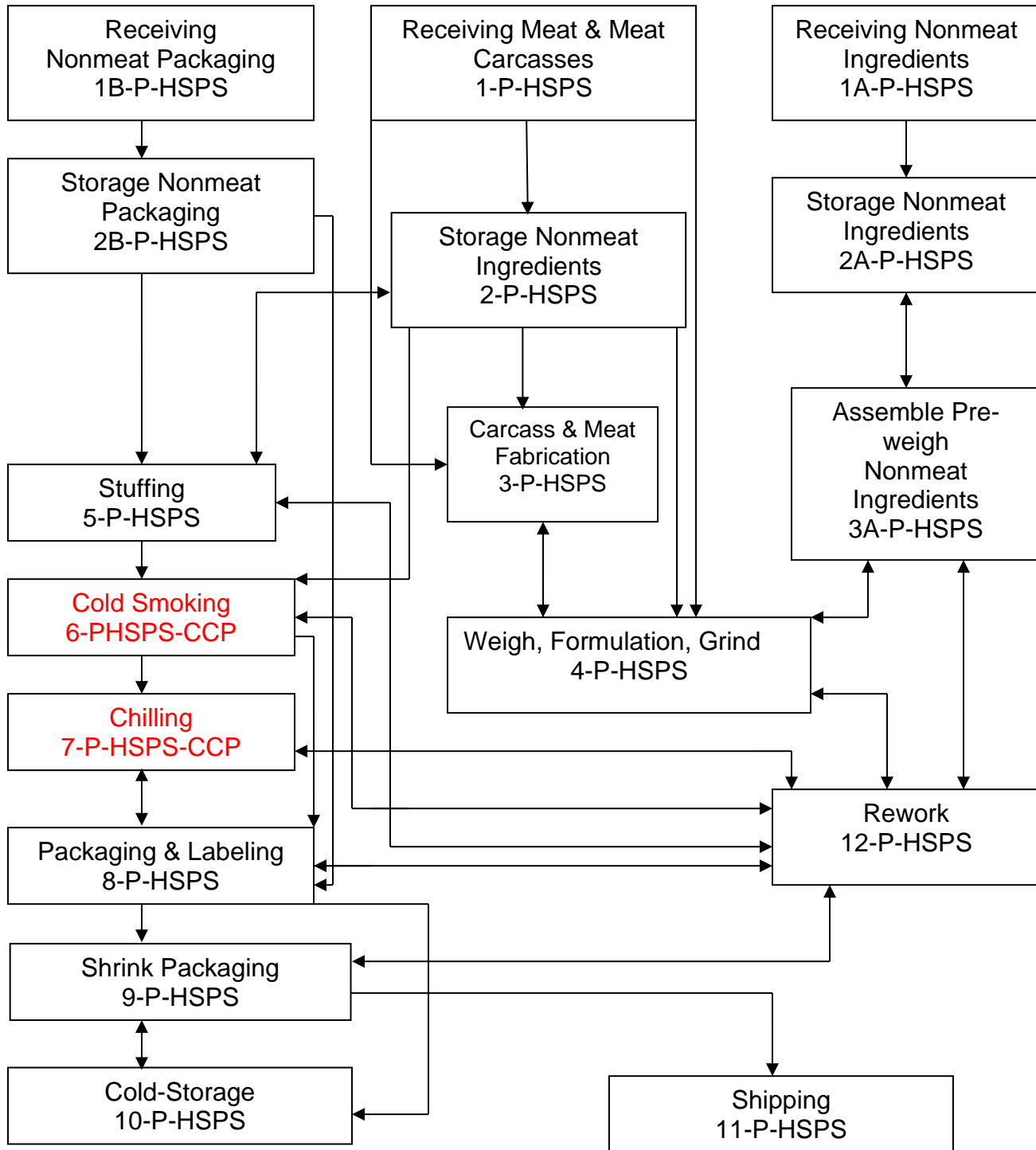
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LIST OF PRODUCT INGREDIENTS

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 (B ₁), Pyridoxine hydrochloride (B ₆), Riboflavin (B ₂), Cyanocobalamine (B ₁₂)), Red, Black, & White Pepper, Chili Pepper, Sugar, Paprika, Spices, Spice Extractives, Garlic Powder, Onion Powder, Dextrose, Corn	Sodium Nitrite, Celery Powder	Sodium Nitrite, Celery Powder
OTHER		
Approved Packaging Materials	Cheeses-Dairy	NO

FLOW CHART





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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

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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



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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



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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

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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	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

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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

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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.	

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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

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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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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. <i>Ref. Appendix A (Version 2017)</i>	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 (<i>Pre-shipment, Direct Observation, Record Review and Pre-shipment</i>)	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 (<i>Pre-shipment, Direct Observation, Record Review and Pre-shipment</i>)	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. <i>Ref. Appendix A (Version 2017)</i>				
		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).				
		Time/Temperature Records					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 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