



HACCP (Hazard Analysis and Critical Control Point)

Regulatory Compliance USDA

RTE-Ready to Eat Chili Con Carne –Fully Cooked; Not Shelf Stable

	SECTION:	Regulatory Compliance (USDA)		Document: Fully Cooked Chili Con Carne
	SUBJECT:	HACCP (Hazard Analysis and Critical Control Point)		HACCP Category: RTE-P
	Prepared By:	Diana Rivera	Date: 3/28/2024	REVISION: 9
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I. PURPOSE / FACILITY OVERVIEW

The purpose of this program is to comply with USDA regulations regarding HACCP. The program details rules, responsibilities and procedures to comply with USDA HACCP.

II. HACCP TEAM

The HACCP team is integrated by a group of R.C. Provision Inc. employees which have knowledge and experience in the process and as well as capital spending decision authority for any changes that may be required to improve process and food safety.

HACCP TEAM MEMBERS

_____ Date _____
(Haccp Coordinator)

III. HACCP TEAM RESPONSABILITIES

HACCP Team Members are responsible for the effective use of this program, the daily implementation of the procedures stated within the HACCP program and the necessary corrective actions required to prevent direct product contamination. Team meetings are held annually or whenever processes or products require it. HACCP Team Members and their responsibilities:

- A. General/Plant Manager, Sales Manager or designees:
 - 1. Responsible for implementing changes resulting from the HACCP Team’s recommendations to improve food safety procedures.
 - 2. Implement, coordinate and maintain HACCP plan
 - 3. Validate and verify HACCP plan.
- B. QC Department or designee:
 - 1. Responsible for carrying out the activities noted in the HACCP program (records, monitoring, verification, etc.).

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FREQUENCY OF MEETINGS OF TEAM HACCP

Team will meet annually for review and re-assessment, or as needed when new product/process is introduced.

PRODUCT CATEGORIES:

1. USDA Plan
 - A. RTE-U Ready To Eat-Chili Con Carne)—Fully cooked; not shelf stable [CFR 417.2 (b) (vii)]. Repackaged, stored and distributed chilled in containers. Fully Cooked Beef with any of the following:
 - a. Fully Cooked Chili Con Carne- CFR 430.4 Alternative 3
 - b. Meat (USDA Only)
 - i. Packaging used: Approved FDA packaging material for meat/poultry products.
 - ii. Intended use: The consumer is the general public. Product should be kept chilled (storage and distribution) and reheated before consumption.

DEFINITIONS:

1. **HACCP SYSTEM:** The Hazard Analysis and Critical Control Points System is a logical scientific approach to controlling safety in food productions.
2. **HACCP Plan:** The written document which is based upon the principles of HACCP and which delineates the procedure to be followed to assure the control of specific process or procedure to be followed to assure the control of specific process or procedure.
3. **HAZZARD:** A biological, chemical or physical property that may cause a food to be unsafe for consumption.
4. **CRITICAL CONTROL POINT (CCP):** A point, step, or procedure at which control can be applied and food safety hazard can be prevented, eliminated, or reduced to acceptable levels.
5. **CONTROL POINT (CP):** A point, step, or procedure at which biological, chemical or physical factors can be controlled.

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6. **CRITICAL LIMIT:** A criterion that must be met for each preventative measure associated with a critical control point.
7. **MONITORING:** To conduct a planned sequence of observations or measurements to assess whether a CCP is under control.
8. **DEVIATION:** Failure to meet a critical limit.
9. **CORRECTIVE ACTION:** Procedure to be followed when a deviation occurs.
10. **PREVENTATIVE MEASURE:** Physical, chemical or other factors that can be used to control an identified hazard.
11. **RISK:** An estimate of the likely occurrence of a hazard.
12. **SEVERITY:** The seriousness of a hazard.
13. **VEFIFICATION:** The use of methods, procedures, or tests in addition to those used in monitoring to determine if the HACCP system is in compliance with the HACCP plan.

14. **UNCONTROLLED/UNFORSEEN HAZARD.**
Hazards such as power failure, Earthquake etc. Emergency preparedness program will be followed after an unforeseen and/or uncontrollable hazard to ensure the food safety

15. **Test Product-** will be produced following the HACCP plan, CCP's and proper documentation.

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FACILITY ADDRESS:

1016 Victory Place Burbank, CA 91502

PHONE NUMBER:

S.F (818) 781-6333 - (818) 848-0577(fax)

PLANT NUMBER:

USDA only - EST 1244 / P-8142

EMPLOYS

This facility employs approximately 30+ employees

SHELF LIFE

60 days after processing.

METHOD OF PRESERVATION:

Cooler

PACKAGING USED:

Clipped Casings.

STORAGE REQUIREMENTS:

40°F or below

CODE DATING:

1. TYPE OF CODE DATE: MM DD YY
2. HOW APPLIED: Printed on individual product labels and outer case.

LABEL INSTRUCTIONS:

"KEEP REFRIGERATED"

DISTRIBUTION:

Temperature controlled trucks to storage.

HOW IS IT TO BE USED:

Reheated before consumption.

IS SPECIAL DISTRIBUTION CONTROL NEEDED?

Lot code control needed for traceability

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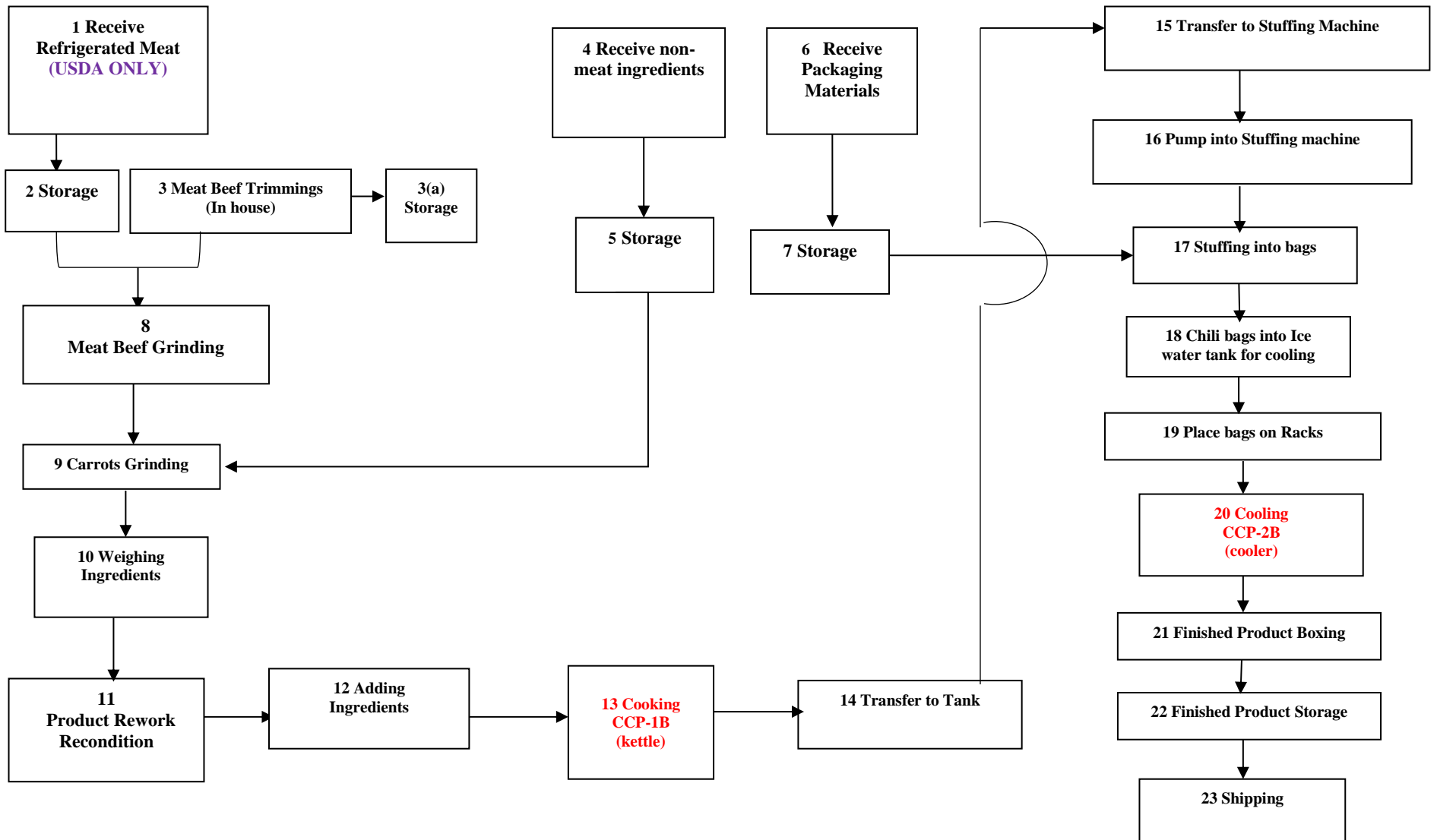
All ingredients are purchased from approved suppliers based on written product specifications.

3: List of Ingredients.

Non Meat/Poultry Ingredients	Meat Ingredients	Other
Salt Carrots Ground Spices Barley (manufactured in a facility that process wheat)	Beef	Approved FDA packaging materials City Water

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FLOW CHART FOR: Fully Cooked Not Shelf Stable Chili Con Carne



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HAZARD ANALYSIS FOR: Fully Cooked Not Shelf Stable Chili Con Carne

Process Step	Food Safety Hazards	Reasonably Likely to Occur?	Justification for decision	What control measures can be applied to prevent the significant hazards?	Is this a critical control point (CCP)?
1 Receive refrigerated meat	<p>B: Potential Survival of Food borned Pathogens Salmonella (outgrowth) SRM E-coli 0157:H7 BSE STEC'S</p> <p>P: Presence of foreign materials. Metal, wood, plastic</p> <p>C: None identified.</p>	<p>B: No</p> <p>P: No</p>	<p>B: Meat products are purchased from USDA inspected plants with HACCP plan. Product is maintained refrigerated ($\leq 40^{\circ}\text{F}$)⁽¹⁾ till use. Letter of Guarantee.</p> <p>P: Low risk. Trained employees to visually inspect product during receiving and processing.</p>	<p>B: Check incoming product temperature at receiving. In House Monitoring Program as part of receiving program (2). Subsequent cooking step is effective control. Purchase Specification.</p>	No
2 Storage of refrigerated meat	<p>B: Potential Survival of Food borned Pathogens Salmonella (outgrowth) SRM E-coli 0157:H7 BSE STEC'S</p> <p>P: None identified.</p> <p>C: None identified.</p>	<p>B: No</p>	<p>B: Product received and stored in refrigerator ($\leq 40^{\circ}\text{F}$)⁽¹⁾ till ready to use for assembly. Freezers and coolers are monitored on a daily basis.</p>	<p>B: Monitored by Q.C. Cooler Temperature Log.</p>	No
3 Meat Beef Trimmings (from process RTE (u) (z).	<p>B: Salmonella (outgrowth) E-coli 0157:H7 STEC'S</p> <p>P: None Identified</p> <p>C: None identified</p>	<p>B: No</p>	<p>B: All beef trimmings are collected and go directly into the grinding and cooking process for Chili con Carne.</p>	<p>B: Subsequent cooking is an effective step.</p>	No
3(a) Storing of left over trimmings			<p>3(a) B: Any leftover trimmings not used for that day go directly into cold storage ($\leq 40^{\circ}\text{F}$)⁽¹⁾ (2) for next day cooking.</p>	<p>(a)B: Cooler Temp. Log</p>	No

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Process Step	Food Safety Hazards	Reasonably Likely to Occur?	Justification for decision	What control measures can be applied to prevent the significant hazards?	Is this a critical control point (CCP)?
4,Receive non-meat ingredients	<p>B: Salmonella (outgrowth) E-coli 0157:H7 STEC's</p> <p>P: None Identified</p> <p>C: Allergic reaction due to unidentified ingredients/cross contamination. Cautionary labeling on product bag label with statement for Barley Flour (manufactured in a facility that process wheat).</p>	<p>B: No</p> <p>C: No</p>	<p>B: Pathogens may be present in carrots. Carrots are pre-washed and shipped to us in sealed plastic bags from supplier. All carrots undergo lethality during cooking. Low Risk. Ingredients are purchased from approved suppliers based on written specification. Good compliance history. A continuing letter of Guarantee from the supplier on file. COA's.</p> <p>C: Allergen Program in place. Cautionary labeling from supplier no allergen present in finished product.</p>	<p>B: In House Monitoring Program as part of receiving program. Letters of Guarantee. Subsequent cooking is an effective step.</p> <p>C: Supplier Statement labeling is cautionary no allergen in product. FSIS Directive 7230.1</p>	<p>No</p> <p>No</p>
5 Storage of non-meat ingredients	<p>B: Salmonella (outgrowth) E-coli 0157:H7</p> <p>P: Introduction of foreign objects</p> <p>C: Allergic reaction due to unidentified ingredients/cross contamination. Cautionary labeling on product bag label with statement for Barley Flour (manufactured in a facility that process wheat).</p>	<p>B: No</p> <p>P: No</p> <p>C: No</p>	<p>B: Incoming packaged carrots are stored in cooler ($\leq 40^{\circ}\text{F}$)⁽¹⁾. Covered product during storage. Stored at appropriate conditions.</p> <p>P: Covered products</p> <p>C: Allergen Program in place. Cautionary labeling from supplier no allergen present in finished product.</p>	<p>B: Monitored by the Q.C. Cooler temperature log. Subsequent cooking is an effective step.</p> <p>C: Supplier Statement labeling is cautionary no allergen in product. FSIS Directive 7230.1</p>	<p>No</p>
6 Receiving Packaging Materials	<p>B: None Identified</p> <p>P: Foreign Materials</p> <p>C: None identified</p>	<p>P: No</p>	<p>P: Covered products</p>	<p>B: Letters of Guarantee for food contact packaging material</p>	<p>No</p>

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7 Storage Packaging Materials	B: None Identified P: None Identified C: None identified	B: No		B: Stored covered in warehouse or dry storage areas until ready to use.	No
8 Meat Beef Grinding	B: Salmonella (outgrowth) E-coli 0157:H7/Stec's P: None identified. C: None identified.	B: No	B: Collection of beef trimmings occurs during a short process time, and goes directly to grinding which then goes directly into the cooking kettles for a full lethality of cooking (2).	B: Short term temperature abuse of raw products (1). Proper control of temperature and exposure time during assembly to prevent growth of microorganisms. Subsequent cooking is an effective step.	No
9 Carrots Grinding	B: Salmonella (outgrowth) E-coli 0157:H7 P: None identified C: None identified.	B: No	B: All carrots in (cold storage) have been guaranteed to be washed by our supplier. Carrots are grinded as part of further processing.	B: Subsequent cooking is an effective step. Letter of Guarantee.	No
10 Weighing Ingredients	B: None Identified P: None Identified C: Allergic reaction due to unidentified ingredients/cross contamination. Cautionary labeling on product bag label with statement for Barley Flour (manufactured in a facility that process wheat).	B: No C: No	C: Allergen Program in place. Cautionary labeling from supplier no allergen present in finished product.	C: Supplier Statement labeling is cautionary no allergen in product. FSIS Directive 7230.1	No

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Process Step	Food Safety Hazards	Reasonably Likely to Occur?	Justification for decision	What control measures can be applied to prevent the significant hazards?	Is this a critical control point (CCP)?
11 Product Rework Recondition	B: Listeria Mono (outgrowth) P: None Identified C: None identified	B: No	B: Potential survival of pathogens with the failure of cooking.	B: Subsequent cooking step is an effective control. Short-temp. abuse (1).	No
12 Adding Ingredients	B: Salmonella (outgrowth) E-Coli 0157:H7 P: None Identified C: None Identified	B: No	B: Grinded carrots are mixed in with grinded beef for cooking.	B: Subsequent cooking is an effective step.	No
13 Cooking	B: Salmonella (outgrowth) E-Coli 0157:H7 (survival) Listeria Monocytogenes (outgrowth) P: None Identified C: None identified	B: Yes	B: Food borne Pathogens may be present in raw beef. Potential survival of Pathogens with the failure of cooking. Chili is cook. Appendix A. FSIS New Meat Cooking Table 2 Cook to internal temp. of 160°F or higher no dwell time. Cooked Meat Products are processed to lethality to achieve a 6.5-log reduction of Salmonella per 381.17.	B: Proper finished internal temperature based on time, temperature schedules to eliminate risk of forborne pathogen survival. Cook to 180°F or higher as measured with a calibrated food thermometer. Appendix A	YES (CCP-1B)

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Process Step	Food Safety Hazards	Reasonably Likely to Occur?	Justification for decision	What control measures can be applied to prevent the significant hazards?	Is this a critical control point (CCP)?
14 Transferring F/C chili from kettle to tank	<p>B: Listeria Monocytogenes (outgrowth) Clostridium Perfigens Clostridium Botulirum</p> <p>P: None Identified</p> <p>C: None identified</p>	B: No	<p>B: During transferring process from kettle into portable tank chili (>160°F) is immediately transferred into the tank this process step occurs within 10 minutes or less.</p> <p>Validation records show that at this process step of transferring product remained >160°F</p>	B: SSOP procedure for Listeria control in place. Prerequisite program in place to prevent contamination and outgrowth of Listeria Mono. Product cooling according to Appendix B.	No
15 Transferring F/C chili from cooking to stuffing machine room	<p>B: Listeria Monocytogenes (outgrowth) Clostridium Perfigens Clostridium Botulirum</p> <p>P: None Identified</p> <p>C: None identified</p>	B: No	<p>B: Covered tanks containing F/C chili are moved from the kettle/tank area and into the RTE chili stuffing room. This process occurs within 5 minutes immediately after cooking process. The CCP stabilization does not occur until product chills to 120°F. However, product does not chill sufficient to by our chilling CCP (from 120°F-55°F in no more than 6 hours).</p> <p>See Validation records.</p>	B: SSOP procedure for Listeria control in place. Prerequisite program in place to prevent contamination and outgrowth of Listeria Mono. Alternative 3. Initial validation records demonstrate that our product from cooking to this step and prior to the final CCP 2B stabilization does not chill below 120°F.	No

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Process Step	Food Safety Hazards	Reasonably Likely to Occur?	Justification for decision	What control measures can be applied to prevent the significant hazards?	Is this a critical control point (CCP)?
16 Pumping F/C Chili in to stuffing machine	<p>B: Listeria Monocytogenes (outgrowth) Clostridium Perfigens Clostridium Botulinum</p> <p>P: None Identified C: None identified</p>	B: No	B: SSOP procedure for Listeria control in place. Prerequisite program in place to prevent contamination and outgrowth of Listeria Mono. Alternative 3.	B: SSOP procedure for Listeria control in place. Prerequisite program in place to prevent contamination and outgrowth of Listeria Mono. Alternative 3. Initial validation records demonstrate that our product from cooking to this step and prior to the final CCP 2B stabilization does not chill below 120°F.	No
17 Stuffing F/C Chili from stuffing machine into bags	<p>B: Listeria Monocytogenes (outgrowth) Clostridium Perfigens Clostridium Botulinum</p> <p>P: None Identified</p> <p>C: Allergic reaction due to unidentified ingredients/cross contamination. Cautionary labeling on product bag label with statement for Barley Flour (manufactured in a facility that process wheat).</p>	B: No	<p>B: Stuffing process for F/C chili is under one hour, this may allow product to chill <160°F, however it does not chill sufficiently to pass our chilling CCP. Subsequent ice water bath and transferring to cooler for proper chilling.</p> <p>C: Allergen Program in place. Cautionary labeling on product bag label with statement for Barley Flour (manufactured in a facility that process wheat). Verify labels against final product formula.</p>	B: SSOP procedure for Listeria control in place. Prerequisite program in place to prevent contamination and outgrowth of Listeria Mono. Alternative 3. Initial validation records demonstrate that our product from cooking to this step and prior to the final CCP 2B stabilization does not chill below 120. C: FSIS Compliance Guidelines Allergen & Ing. Of Public Concern November 2015	No

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18 Placement of bags of F/C Chili into ice water tank for cooling	B: Listeria Monocytogenes (outgrowth) Clostridium Perfigens Clostridium Botulinum P: None Identified C: None identified	B: No	B: At this step our RTE F/C Chili is not at post lethality and is fully sealed and contained inside plastic casings chubs.	B: Product is not post lethality exposed during this step. Cooling product according to Appendix B.	No
19 Place ice chilled bags of f/c chili on racks	B: Listeria Monocytogenes (outgrowth) Clostridium Perfigens Clostridium Botulinum P: None Identified C: None identified	B: No	B: At this step our RTE F/C Chili is not at post lethality and is fully sealed and contained inside plastic casings chubs.	B: Product is not post lethality exposed during this step. Reference validation records. LM program in place.	No
20 Cooling (inside cooler)	B: Listeria Monocytogenes (outgrowth) Clostridium Perfigens Clostridium Botulinum P: None Identified C: None identified	B: Yes	B: Not properly cooled heat shock Clostridium spores will become vegetative cells that proliferate. Product is chilled following Appendix B Table 1 Option 1.5 130F-80F in ≤2 hours 80F-40F ≤5 hours total cooling time ≤7 hours. (see validation)	B: Recommended Proper Time, Temperature for chilling cooked product. Appendix B Table 1 Option 1.5 130F-80F in ≤2 hours 80F-40F ≤5 hours total cooling time ≤7 hours. (see validation).	Yes (CCP-2B)

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21 Finished Product Boxing	B: Listeria Monocytogenes (outgrowth) P: None identified C: None identified	B: No	B: All finished pre-chilled NRTE F/C Chili is not post lethality exposed product is contained inside fully sealed plastic chub casings. Upon boxing our product is immediately placed into cold finished product storage stored in cooler ($\leq 40^{\circ}\text{F}$) ⁽¹⁾ . Process occurs during short time frame	B: Cooler Temp. Log	No
22 Finished Product Cold Storage	B: Listeria monocytogenes (outgrowth) P: None Identified C: None identified	B: No	B: Finished Product is sealed packed. All cooked finished products go directly into a temperature controlled cooler set at 40°F <(2).	B: Cooler Temperature Log.	No
23 Shipping	B: Listeria monocytogenes (outgrowth) P: None Identified C: None identified	B: No	B: All fully cooked sealed RTE products go directly into a refrigerated truck for delivery (2).	B: Product is shipped in refrigerated trucks. Trucks Shipping Log.	B: No

- (1) Department of Food Science, University of Wisconsin Growth of Pathogens on Raw Meat Products. Short term temperature abuse.
(2) Bruce Tompkin Ph.D.. Minimum growth temperatures for selected foodborne pathogens.

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CCP DESCRIPTION

CCP # and Location	Hazard	Critical Limits	Monitoring	Corrective Action	HACCP Records	HACCP System Verification
CCP-1B COOKING	Control of Pathogens Cooking: E-Coli 0157:H7 Salmonella (outgrowth)	Follows USDA's guidelines for cooking Appendix A. FSIS New Meat Cooking Table 2 Cook to internal temp. of 160°F or higher no dwell time. Cooked Meat Products are processed to lethality to achieve a 6.5-log reduction of Salmonella per 381.17.	Verified time temp. parameter to reach desired internal temp. At the end of each cooking cycle temperature is checked by designated employee by scooping out enough product to cover the sensor of a hand held thermometer. The temperature will then be recorded on the "chili" cooking log. (Historical Data). SOP 10012.01 Thermometer Calibration.	Corrective Actions will be in accordance with 9-CFR 417.3 (a)(1) (2) (3) (4). Findings and actions taken will be documented on HACCP Corrective Action log. If a deviation occurs our Plant Manager or designated HACCP team leader is responsible for performing corrective actions.	Cooking Log-signed and dated by person maintaining log. With time of observation. Thermometer Verification and Calibration Log. Corrective Action Log.	Daily review of Records to assure completeness, accuracy, including corrective actions if any. Weekly Calibration of Thermometers- Thermometer Verification and Calibration Log. (Thermometer Calibration Procedure). Weekly Direct Observation of Monitoring.

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CCP # and Location	Hazard	Critical Limits	Monitoring	Corrective Action	HACCP Records	HACCP System Verification
CCP-2B COOLING	Control of Food Borne Pathogens Clostridium Botulinum Clostridium Perfringens	Appendix B Table 1 Option 1.5 130F-80F in ≤2 hours 80F-40F ≤5 hours total cooling time ≤7 hours. (see validation)	Manual Time/Temp. Log to be maintained for each lot by designated plant employee Insert calibrated hand held thermometer sufficient to cover the sensor. Checking temp. in one piece (hottest) in the middle of the rack. SOP 10012.01 Thermometer Calibration Appendix B Recorded in Cooling Log (Historical Data).	Corrective Actions will be in accordance with 9-CFR 417.3 (a)(1) (2) (3) (4). Findings and actions taken will be documented on HACCP Corrective Action log. If a deviation occurs our Plant Manager or designated HACCP team leader is responsible for performing corrective actions.	Cooling Log-signed and dated by person maintaining log. With time of observation. Thermometer Verification and Calibration Log. Corrective Action Log. Packing Temperature Log.	Daily review of records to assure completeness, accuracy, including corrective actions if any. Weekly Calibration of Thermometers- Thermometer Verification and Calibration Log. (Thermometer Calibration Procedure). Weekly Direct Observation of Monitoring.

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