



Pikalo Empanadas
272 Riverdale Ave
Yonkers, NY 10705

HACCP PLAN #1
HEAT TREATED NOT FULLY COOKED, NOT SHELF STABLE

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Author: Dov Braun	Supersedes: 11/06/2023
Approved By: Jean Luis Valdez	Revision #: 3

**HACCP PLAN
FOR
HEAT TREATED NOT FULLY COOKED,
NOT SHELF STABLE
MEAT & POULTRY PRODUCTS**

**Prepared For:
Pikalo Empanadas
272 Riverdale Ave
Yonkers, NY 10705**

Signature Title: _____ **Title:** _____ **Date:** _____

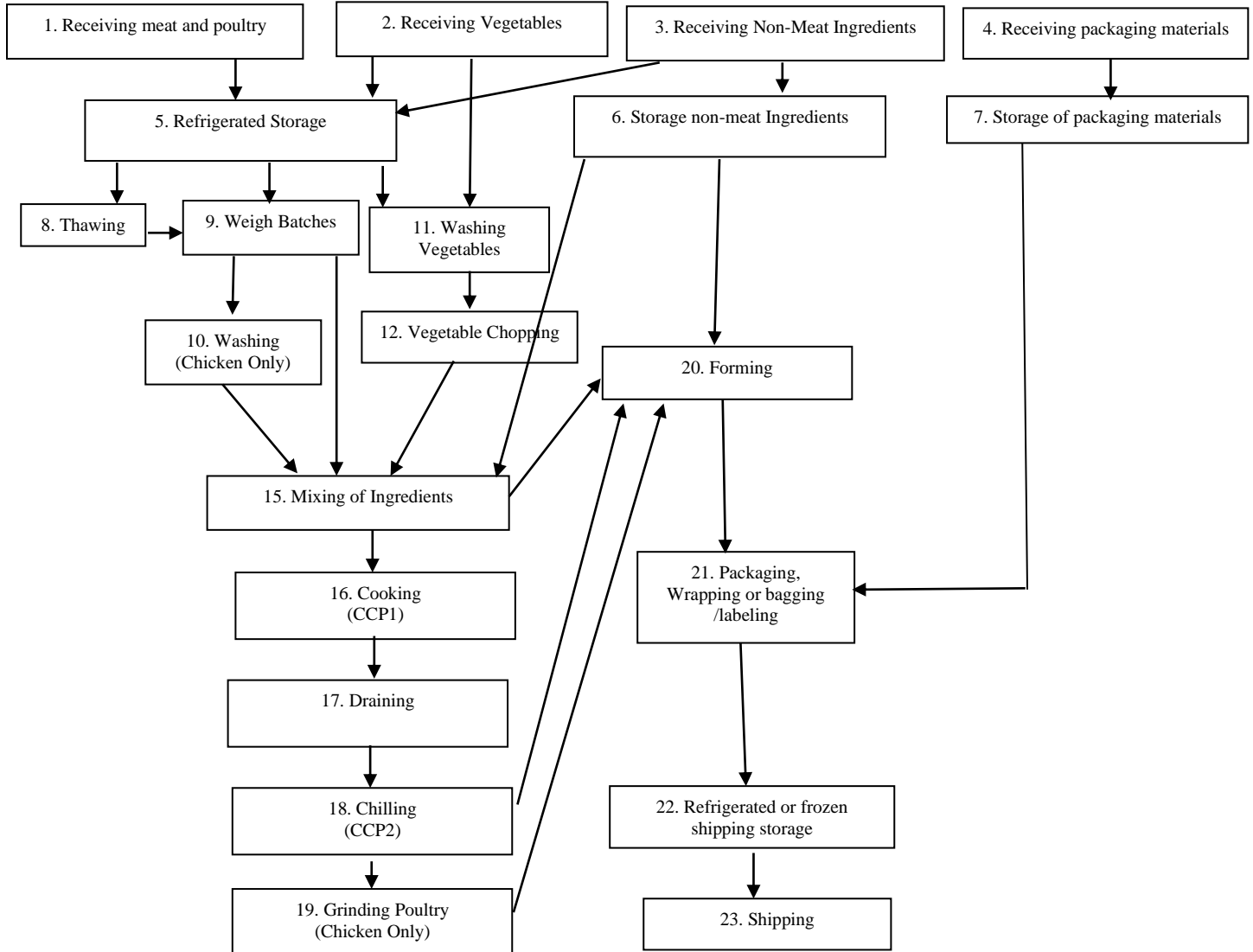
PRODUCT DESCRIPTION SHEET

THE HACCP TEAM:	The HACCP Team consists of Jean Luis Valdez (Owner/Manager) Dov Braun (QC Consultant)
Product Description:	Beef Empanadas, Chicken Empanadas, Beef and Cheese Empanadas, Chicken and Cheese Empanadas, Kipes
How Is It To Be Used?	Consumed after cooking.
Type of Package?	Over Wrap, Bagged; or Vacuum Packed
Where Will It Be Sold?	Retail, Food Service, wholesale to distributors
Labeling Instructions:	Keep refrigerated or keep frozen
Is Special Distribution Control Needed:	Keep refrigerated or keep frozen

Re-Assessment Sheet

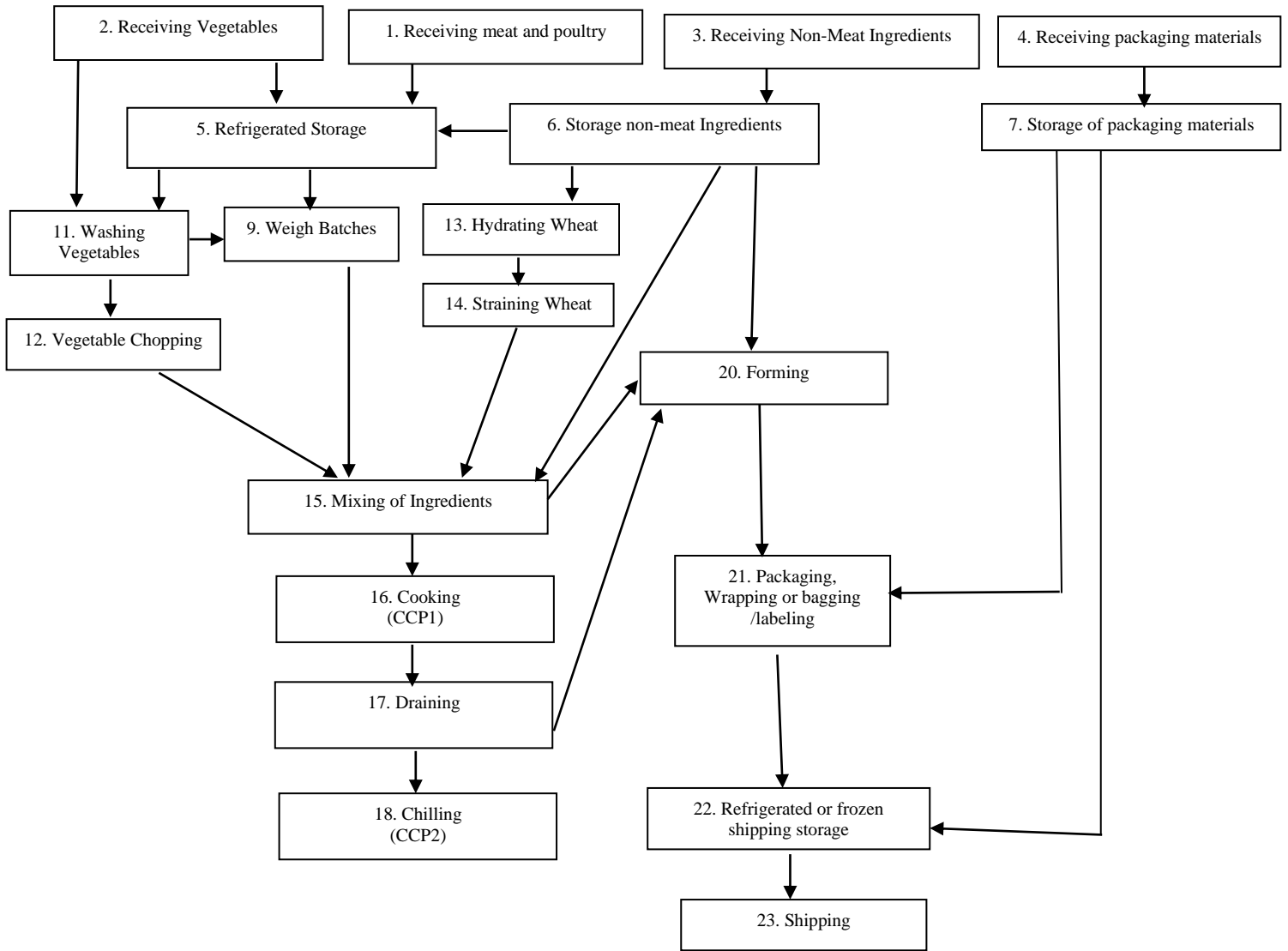
Description	Signed by	Position	Date
Creation	Dov Braun	QC Consultant	08/03/2022
Re-Assessed, Updated Grinding Step (#16) Added	Dov Braun	QC Consultant	08/25/2022
Annual Assessment, Updated Revised Appendix A and B	Dov Braun	QC Consultant	12/13/2022
Re-Assessed, Updated, Floor Plan, Operational Forms	Dov Braun	QC Consultant	02/20/2023
Updated, Product Kipes Added and Processing Steps	Dov Braun	QC Consultant	07/24/2023
Annual Assessment, Updated; Flow Chart, Hazard Analysis	Dov Braun	QC Consultant	10/31/2023
Updated; Draining Step	Dov Braun	QC Consultant	11/06/2023
Re-Assessed, Updated Revised; Pork and Ham Products Removed	Dov Braun	QC Consultant	02/27/2024

FLOW DIAGRAM-(Empanadas)



No Returns

FLOW DIAGRAM(Kipes)



No Returns

Supporting evidence for decision making on CCPs

9CFR417Sec. 417.5 Records. (a) The establishment shall maintain the following records documenting the establishment's HACCP plan: (1) The written hazard analysis prescribed in Sec. 417.2(a) of this part, including all supporting documentation;(2) The written HACCP plan, including decision making documents associated with the selection and development of CCP's and critical limits, and documents supporting both the monitoring and verification procedures selected and the frequency of those procedures.

Decision making documents associated with the selection and development of CCP's and critical limits

	Decision making documents associated with the selection and development of the CCP	Decision making documents associated with the selection and development of the CCP limit
CCP #1 Product internal temp upon cooking	The reason why we selected cooking temperatures as a CCP is because naturally occurring pathogens in meat (such as <i>Salmonella</i> , <i>Listeria monocytogens</i> , and <i>E coli</i> O157:H7) must be eliminated and destroyed to make the fully cooked products safe.	The supporting document for the CCP limit of CCP#1 (product internal temp upon cooking) is based on the FSIS Cooking Guideline for Meat and Poultry (Revised Appendix A) December, 2021
CCP#2 Chilling rate of product	The reason why we selected chilling rate as a CCP is because that the outgrowth of the heat shocked spore-former pathogen <i>Clostridium perfringenes</i> must be eliminated to ensure food safety, since the spore-former can produce toxin if its vegetative cells outgrow upon heat shock.	The supporting document for the CCP limit of CCP#2 product chilling rate is based on the FSIS Stabilization Guideline for Meat ad Poultry Products (Revised Appendix B) December, 2021

Documents supporting both the monitoring and verification procedures selected and the frequency of those procedures

	Documents supporting monitoring procedures	Documents supporting verification procedures	Documents supporting monitoring frequency	Documents supporting verification frequency
CCP #1 Product internal temp upon cooking	Based on FSIS Appendix A Revised 2021, all CCP records during validation will be kept on file.	Based on FSIS Appendix A Revised 2021, all CCP records during validation will be kept on file.	Based on FSIS Appendix A Revised 2021, all CCP records during validation will be kept on file.	Based on FSIS Appendix A Revised 2021, all CCP records during validation will be kept on file.
CCP#2 Chilling rate of product upon cooking	Based on FSIS Appendix B Revised 2021, all CCP records during validation will be kept on file.	Based on FSIS Appendix B Revised 2021, all CCP records during validation will be kept on file.	Based on FSIS Appendix B Revised 2021, all CCP records during validation will be kept on file.	Based on FSIS Appendix B Revised 2021, all CCP records during validation will be kept on file.

PROCESS CATEGORIES AND INGREDIENTS

PROCESS CATEGORY: Heat Treated Not Fully Cooked Not Shelf Stable
Meat & Poultry Products

PLANT NAME AND LOCATION: Pikalo Empanadas
272 Riverdale Ave
Yonkers, NY 10705

MEAT AND POULTRY BY PRODUCTS	NONMEAT INGREDIENTS	BINDERS/ EXTENDERS
Beef Chicken	See Label For Specifics	None
SPICES/ FLAVORINGS	RESTRICTED INGREDIENTS	PRESERVATIVES/ ACIDIFIERS
See Label For Specifics	None	None
Allergens	WATER	PACKAGING
Wheat, Milk, Soy	Must be Potable	Approved packaging materials

HAZARD ANALYSIS WORKSHEET					
(1)	(2)	(3)	(4)	(5)	(6)
Ingredient/ processing step	Food Hazard	Reasonably likely to occur?	Basis	If yes to column 3, what measures could be applied to prevent, eliminate or reduce the hazard to an acceptable level?	Critical control point
1. Receiving meat and poultry	BIOLOGICAL- Naturally occurring pathogens such as <i>E coli</i> <i>O157:H7</i> ; <i>Salmonella</i> , <i>Campylobacter</i>	No	Incoming product is checked upon receipt on the dock and any product that does not meet temperature guidelines is immediately rejected or corrective actions are taken. Accepted raw meat and poultry is moved into processing, cooler or freezer upon receipt, where temperatures are controlled in compliance with Bruce Tompkins Study. Product is to be fully cooked before consumption.	Pre-Requisite Program. Letters of guarantee Receiving Log	No
	BIOLOGICAL- BSE in beef	No	All SRMs are removed before the beef is received at our plant. Letter of guarantees are in place.	Letters of Guarantee	No
	CHEMICAL- None				
	PHYSICAL- Foreign material	No	Product may have been contaminated by supplier during manufacture or during transportation. Outer product package could be torn or compromised.	Pre-Requisite Program Visual Inspection	No
2. Receiving Vegetables	BIOLOGICAL- Naturally occurring pathogens such as <i>E coli</i> <i>O157:H7</i> ; <i>Salmonella</i> , <i>Campylobacter</i>	No	Incoming product is checked upon receipt on the dock and any product that does not meet temperature guidelines is immediately rejected or corrective actions are taken.	Pre-Requisite Program. Letters of guarantee	No
	CHEMICAL- Allergens	No	Incoming product is examined for package integrity and proper labeling upon receipt. Proper storage will prevent cross contamination.	Allergen Control Visual Inspection	No
	PHYSICAL- Foreign material	No	Product may have been contaminated by supplier during manufacture or during transportation. Outer product package could be torn or compromised.	Pre-Requisite Program Visual Inspection	No
3. Receiving Non-Meat Ingredients	BIOLOGICAL- Naturally occurring pathogens such as <i>E coli Strains</i> ; <i>Salmonella</i> , <i>Listeria</i> , <i>Staphylococcus aureus</i>	No	Only for refrigerated non-meat ingredients: Incoming product is checked upon receipt on the dock and any product that does not meet temperature guidelines ($\leq 41^{\circ}$ F) is immediately rejected or corrective actions are taken.	Visual Inspection Receiving Log	No
	CHEMICAL- Allergens, Chemical Residue	No	Incoming product is examined for package integrity and proper labeling upon receipt. Proper storage will prevent cross contamination.	Allergen Control Visual Inspection	No

HAZARD ANALYSIS WORKSHEET					
(1)	(2)	(3)	(4)	(5)	(6)
Ingredient/ processing step	Food Hazard	Reasonably likely to occur?	Basis	If yes to column 3, what measures could be applied to prevent, eliminate or reduce the hazard to an acceptable level?	Critical control point
	PHYSICAL- Foreign Material	No	Product may have been contaminated by supplier during manufacture or during transportation. Outer product package could be torn or compromised.	Pre-Requisite Program Visual Inspection	No
4. Receiving packaging materials	BIOLOGICAL- None				
	CHEMICAL- Chemical residue	No	Letters of guarantee are updated annually.		No
	PHYSICAL- Foreign Material	No	Integrity of packaging is ensured upon receiving.	Visual Inspection	No
5. Refrigerated Storage	BIOLOGICAL- Pathogen outgrowth such as <i>E coli</i> O157:H7, <i>Salmonella</i> , <i>Campylobacter</i>	No	Cooler, Holding Area and freezer temperatures are monitored and controlled to $\leq 45^{\circ}$ F for coolers and $\leq 20^{\circ}$ F for freezers Bruce Tompkins, 2000. Vegetables not maintained at proper temperature are at risk of supporting pathogen growth.	Pre-requisite program Cooler / Freezer Pre- operational/Midday operations	No
	CHEMICAL- None				
	PHYSICAL- None				
6. Storage of Non-Meat Ingredients	BIOLOGICAL- Naturally occurring pathogens such as <i>E coli</i> Strains; <i>Salmonella</i> , <i>Listeria</i> , <i>Staphylococcus aureus</i>	No	Non-meat ingredients that require refrigeration will be stored in a segregated area in Refrigerated Storage where temperatures are monitored and controlled.	Pre-requisite program Cooler / Freezer Pre- operational/Midday operations	No
	CHEMICAL- Allergens	No	Ingredients containing allergens are stored according to establishments allergen control procedures. Proper storage will prevent cross contamination.	Allergen Control	No
	PHYSICAL- Foreign Material	No	Storage area is maintained in sanitary condition and monitored daily.	Pre-Operational / Midday Operational	No
7. Storage of packaging materials	BIOLOGICAL- None				
	CHEMICAL- None				
	PHYSICAL- Foreign Material	No	Storage area is maintained in sanitary condition and monitored daily.	Pre-Operational / Midday Operational	No
8. Thawing	BIOLOGICAL- Pathogen outgrowth such as <i>E coli</i> O157:H7, <i>Salmonella</i> , <i>Campylobacter</i>	No	Thawing / defrosting is conducted either in a cooler, where temperature is monitored and controlled as per written pre-requisite program, or in running water at $\leq 70^{\circ}$ F, as per FDA code 2022, while monitored and controlled as per written pre-requisite program.	Pre-requisite program Thawing Procedures	No

HAZARD ANALYSIS WORKSHEET

(1)	(2)	(3)	(4)	(5)	(6)
Ingredient/ processing step	Food Hazard	Reasonably likely to occur?	Basis	If yes to column 3, what measures could be applied to prevent, eliminate or reduce the hazard to an acceptable level?	Critical control point
	CHEMICAL- None				
	PHYSICAL- None				
9. Weigh Batches	BIOLOGICAL- Pathogen outgrowth such as <i>E coli</i> O157:H7, <i>Salmonella</i> , <i>Campylobacter</i>	No	This is a transit step. Product temperature is monitored at a later step as a CCP.		No
	CHEMICAL- None				
	PHYSICAL- Bone fragments and foreign object contamination	No	Meat is carefully examined to make sure no bone fragments remain and no tools or foreign objects are left behind.	Pre- Operational/Mid- day Operational Visual Inspection	No
10. Washing (Chicken Only)	BIOLOGICAL- Pathogen outgrowth	No	Processing takes minimal time and occurs in a control environment.	Pre-requisite program	No
	CHEMICAL- Allergens	No	Hazard controlled through proper sanitation and correct utilization of SSOPs, allergen scheduling. Ensure recipes are followed closely to avoid ingredient mistakes.	Allergen Control SSOP	No
	PHYSICAL- Foreign object contamination	No	All equipment contact surfaces are inspected as part of the pre-operational inspection by both QC personnel, as per pre-requisite program, as well as by employees operating in that area.	Pre- Operational/Mid- day Operational	No
11. Washing Vegetable	BIOLOGICAL- None	No	Process is a transit step which takes minimal time.		No
	CHEMICAL- None				
	PHYSICAL- Foreign object contamination	No	Vegetables are carefully examined to make sure no tools or foreign objects are left behind or mixed in.	Pre-Requisite Program/SSOP Pre-Operational Mid-day operational	No
12. Chopping / Grinding Vegetables	BIOLOGICAL- None				
	CHEMICAL- Allergens	No	Hazard controlled through proper sanitation and correct utilization of SSOPs, allergen scheduling. Ensure recipes are followed closely to avoid ingredient mistakes.	Allergen Control SSOP	No

HAZARD ANALYSIS WORKSHEET

(1)	(2)	(3)	(4)	(5)	(6)
Ingredient/ processing step	Food Hazard	Reasonably likely to occur?	Basis	If yes to column 3, what measures could be applied to prevent, eliminate or reduce the hazard to an acceptable level?	Critical control point
	PHYSICAL- Foreign object contamination	No	All equipment contact surfaces are inspected as part of the pre-operational inspection by both QC personnel, as per pre-requisite program, as well as by employees operating in that area.	Pre- Operational/Mid- day Operational	No
13. Hydrating Wheat	BIOLOGICAL- None				
	CHEMICAL- Allergens	No	Hazard controlled through proper sanitation and correct utilization of SSOPs, allergen scheduling. Ensure recipes are followed closely to avoid ingredient mistakes.	Allergen Control SSOP	No
	PHYSICAL- Foreign object contamination	No	Product is carefully examined to make sure no foreign objects are present or left behind.	Pre- Operational/Mid- day Operational Visual Inspection	No
14. Straining Wheat	BIOLOGICAL- None				
	CHEMICAL- Allergens	No	Hazard controlled through proper sanitation and correct utilization of SSOPs, allergen scheduling. Ensure recipes are followed closely to avoid ingredient mistakes.	Allergen Control SSOP	No
	PHYSICAL- Foreign object contamination	No	Product is carefully examined to make sure no foreign objects are present or left behind.	Pre- Operational/Mid- day Operational Visual Inspection	No
15. Mixing of Ingredients / Forming	BIOLOGICAL- None	No	Process is a transit step which takes minimal time.		No
	CHEMICAL- Allergens	No	Hazard controlled through proper sanitation and correct utilization of SSOPs, allergen scheduling. Ensure recipes are followed closely to avoid ingredient mistakes.	Allergen Control SSOP	No
	PHYSICAL- None				
16. Cooking CCP 1	BIOLOGICAL- Pathogen outgrowth such as <i>Salmonella</i> , <i>Listeria</i>	Yes	Pathogen surviving is likely to occur if the cooking temperature is not sufficient. Total come up time where product is between 50 and 130°F is 6 hours or less. The establishment uses conduction or radiant heating (direct heat), where relative humidity does not need to be addressed.	Cook product using validated time/temp controls. Per FSIS Cooking Guideline for Meat and Poultry (Revised Appendix A) December, 2021	CCPI

HAZARD ANALYSIS WORKSHEET

(1)	(2)	(3)	(4)	(5)	(6)
Ingredient/ processing step	Food Hazard	Reasonably likely to occur?	Basis	If yes to column 3, what measures could be applied to prevent, eliminate or reduce the hazard to an acceptable level?	Critical control point
	CHEMICAL- None				
	PHYSICAL- None				
17. Draining	BIOLOGICAL- None	No	This is a transit step which takes minimal time (under 45 minutes), the product is still in the pre-cooling condition.	Validated chilling procedures. CCP Monitoring	No
	CHEMICAL- Allergens	No	Hazard controlled through proper sanitation and correct utilization of SSOPs, allergen scheduling. Ensure recipes are followed closely to avoid ingredient mistakes.	Allergen Control SSOP	No
	PHYSICAL- Foreign object contamination	No	All equipment contact surfaces are inspected as part of the pre-operational inspection by both QC personnel, as per pre-requisite program, as well as by employees operating in that area.	Pre- Operational/Mid- day Operational	No
18. Cooling CCP 2	BIOLOGICAL- Spore Formation such as <i>C. botulinum</i> and <i>C. perfringens</i>	Yes	Heat shocked <i>Clostridium</i> spores become vegetative cells that proliferate. Subsequent toxigenesis in the intestine (<i>Clostridium perfringens</i>) or in the food (<i>clostridium botulinum</i>) is possible.	Validated chilling procedures are used. As per FSIS Stabilization Guideline for Meat and Poultry Products (Revised Appendix B) December, 2021	CCP2
	CHEMICAL- None				
	PHYSICAL- None				
19. Grinding (Chicken Only)	BIOLOGICAL- Pathogen outgrowth	No	Product is taken from the cooler. Processing takes minimal time.	Pre-requisite program	No
	CHEMICAL- Allergens	No	Hazard controlled through proper sanitation and correct utilization of SSOPs, allergen scheduling. Ensure recipes are followed closely to avoid ingredient mistakes.	Allergen Control SSOP	No
	PHYSICAL- Foreign object contamination	No	All equipment contact surfaces are inspected as part of the pre-operational inspection by both QC personnel, as per pre-requisite program, as well as by employees operating in that area.	Pre- Operational/Mid- day Operational	No
20. Forming	BIOLOGICAL- None		This is a transit step where processing takes minimal time.		

HAZARD ANALYSIS WORKSHEET

(1)	(2)	(3)	(4)	(5)	(6)
Ingredient/ processing step	Food Hazard	Reasonably likely to occur?	Basis	If yes to column 3, what measures could be applied to prevent, eliminate or reduce the hazard to an acceptable level?	Critical control point
	CHEMICAL- Allergens	No	Hazard controlled through proper sanitation and correct utilization of SSOPs, allergen scheduling. Ensure recipes are followed closely to avoid ingredient mistakes.	Allergen Control SSOP	No
	PHYSICAL- None				
21. Packaging, Boxing, Labeling	BIOLOGICAL- Pathogen outgrowth such as <i>E coli</i> O157:H7, <i>Salmonella</i> , <i>Campylobacter</i>	No	This is a transit step where processing takes minimal time. Product is brought to the freezer following boxing and labeling where the product will be completely frozen.		No
	CHEMICAL- Allergens	No	Hazard controlled through proper sanitation and correct utilization of SSOPs, allergen scheduling. Ensure recipes are followed closely to avoid ingredient mistakes.	Allergen Control SSOP	No
	PHYSICAL- None				
22.Refrigerate d / frozen shipping storage	BIOLOGICAL- Pathogen outgrowth such as <i>E coli</i> <i>O157:H7</i> ; <i>Salmonella</i> , <i>Campylobacter</i>	No	Cooler and freezer temperatures are monitored and controlled in compliance with the Bruce Tompkins, 2000.	Pre-requisite program Cooler / Freezer Pre- operational/Midday operations	No
	CHEMICAL- None				
	PHYSICAL- None				
23.Shipping	BIOLOGICAL- <i>E coli</i> O157:H7; <i>Salmonella</i> , <i>Campylobacter</i>	No	Product is either picked up by customer where product is staged in cooler area or is delivered is refrigerated vehicles where temperature is controlled		No
	CHEMICAL- None				
	PHYSICAL- Foreign objects	No	Product is protected by packaging and boxing		No

HACCP PLAN FORM

(1) Critical Control Point (CCP)	(2) Significant Hazards	(3) Critical Limits for each Preventive Measure	Monitoring Procedures				(8) Corrective Action(s)	(9) Records	(10) Verification
			(4)	(5)	(6)	(7)			
			What	How	Frequency	Who			
Cooking CCP 1	Pathogen survival	Cook meat products to internal temp. of 160°F minimum; Cook poultry product to minimum of 165°F or cook using time/temp. tables in Appendix A. (Reference: Appendix A; Time/Temp Tables for Cooking Ready-to-eat Meat and Poultry Products)	Internal temperature of the product	Calibrated hand-held thermometer	At least one random product per batch.	QC personnel	Corrective actions will be followed by plant management as per 9CFR 417.3: Place product on hold and notify manager or designee. Reassess the HACCP plan. Disposition of retained product will be based on scientific data and / or scientific research results. No adulterated product to enter commerce. Evaluate and eliminate the root cause of deviation and take action to prevent reoccurrence.	Cooking and chilling log Thermo calibration form Corrective Actions	Plant management will follow 9CFR 417.4. Review of records before shipping product by a responsible establishment official will be conducted for each lot. HACCP pre-shipment review will be documented on the CCP log. QC will observe trained employees perform monitoring activities. Review of records and direct observation will be done by a HACCP team member on a weekly basis. QC will check all handheld thermometers used for monitoring and verification for accuracy weekly and calibrate weekly.

Signature: _____

Date: _____

HACCP PLAN FORM

(1) Critical Control Point (CCP)	(2) Significant Hazards	(3) Critical Limits for each Preventive Measure	Monitoring Procedures				(8) Corrective Action(s)	(9) Records	(10) Verification
			(4)	(5)	(6)	(7)			
			What	How	Frequency	Who			
Chilling CCP2	Spore formation	Chilling begins within 90 minutes, 120°F to 80°F in ≤ 1 hour 80°F to 55°F in ≤ 5 hours Continuous chilling until 40°F Total Cooling Time: ≤ 6 hours Plus time to reach 40°F (Reference: USDA Revised Appendix B 2021 Option 1.2) *If initial validation support available, it is not required for each batch.	Internal temperature of product	Calibrated handheld thermometer	At least one random product chilling rate per cook batch. Record review and direct observation will be done weekly.	QC Personnel	Corrective actions will be followed by plant management as per 9CFR 417.3: Place product on hold. Reassess the HACCP plan. Disposition of retained product will be based on scientific data and / or scientific research results. No adulterated product to enter commerce. Evaluate and eliminate the root cause of deviation and take action to prevent8 reoccurrence.	Cooking and chilling log Thermometer calibration form Corrective Actions	Plant management will follow 9CFR 417.4. Review of records before shipping product by a responsible establishment official will be conducted for each lot. HACCP pre-shipment review will be documented on the CCP log. QC will observe trained employees perform monitoring activities. Review of records and direct observation will be done by a HACCP team member on a weekly basis. QC will check all handheld thermometers used for monitoring and verification for accuracy weekly and calibrate weekly.

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