

Page G. Inspection of Dry Products Blending and Packaging Operations. (Form DA - 151 - 6)

Product Dumping

Item G1—Room Construction (58.126, 58.211, 58.212).

See the guidelines for Item D34—Room Construction.

There shall be a separate room or area for product dumping operations and it shall meet all the construction and facilities requirements of Item D-34.

A layout where the dumping operation is done from a mezzanine or solid deck level is acceptable provided that the following parameters are followed:

1. The mezzanine level or solid deck is sturdy and large enough to accommodate the entire dumping operation, to avoid product spillage, and prevent empty containers from dropping into the blender level below.
2. Blenders do not protrude through the mezzanine or solid deck into the dumping area.
3. Dump hoppers are firmly attached (with a flanged junction or flexible connector) to the blender covers below the mezzanine or solid deck level.
4. Provisions have been made to direct air flow from the dumping area away from the blending area.
5. Housekeeping practices and disposal of empty containers are properly observed.

Properly trapped floor drains shall be provided and the floors shall be pitched to the drain points. While the dry products' dumping room or area may not require regular or frequent wet cleaning, floor drains are required for times when wet cleaning will be necessary. Because of their infrequent use, floor drains should be equipped with a removable cap or seal or filled with a nonevaporating liquid. Open drains shall not be in the vicinity of air intakes for processing or conveying air.

The room should not have unnecessary equipment, fixtures, or unsealed false areas that may harbor insects or that may collect dust and debris. Give special attention to cracks, crevices or holes in the ceilings, walls, and floor to assure adequate insect control, following the

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guidelines for Item A37—Pest Control. If insect infestation is observed, record it under Item G50—Pest Control.

See the guidelines for Item G12—Feeding Equipment - Vitamins, etc. for guidance in handling small volume, special ingredients.

Item G2—Lighting & Ventilation (58.126d, e).

See the guidelines for Item A2—Lighting & Ventilation.

Item G3—Dump Hopper & Screen (58.228).

Dump hoppers and product contact surfaces of screens and hoods shall be made of stainless steel. Interior surfaces of the dump hoppers and hoods shall be accessible for cleaning and inspection. Design and construction shall comply with the *USDA Equipment Guidelines*. If the equipment is not in the *Accepted Equipment List* see the guidelines for Item A3—Pumps, Pipelines, & Valves. Check for defects such as open seams, exposed threads, improperly gasketed junctures, and inappropriate radii. Dump screens shall be removable and have openings not smaller than ½ by ½ inch. Exhaust ducts from hoods shall be made of stainless steel and be accessible for cleaning at least to the point where they are pitched away from the product contact surfaces.

Dump hoppers shall be positioned at a height above the floor that will prevent foreign materials or spilled products from entering the hopper. A hopper that passes through the floor or decking and has the blending, packaging, or conveying system underneath shall have a minimum of four-inch curbs to prevent foreign materials or spilled product from falling through the opening around the hopper. Raised decking shall be cleanable and should not have cracks and crevices that would contribute to poor housekeeping or pest control.

Platforms or tables shall be provided so that the outer plies of bagged ingredients can be easily removed or vacuumed before the bags are placed over the dump hopper. Encourage plant management to have this stripping or cleaning procedure performed in an area or room separate from the dump room. Wherever possible, outer plies are to be removed. However, the bags shall retain proper identification throughout the dumping procedures. Laminated bags that cannot be stripped of their outer plies shall be thoroughly vacuumed. Check that there are sanitary procedures for the handling and disposal of the empty containers.

The dump hopper shall be covered or sealed when not in use. Covers shall be of sanitary design and shall be properly stored when not in use. Inspect gaskets, level controls, and other parts for design and condition.

Item G4—Bulk Dumping Equipment (58.128a).

See the guidelines for Item D45—Tote to Bag Packaging.

Item G5—Conveyor(s) to Blender (58.128a, 58.221, 58.228, 58.246).

See the guidelines for Item D24—Product Removal & Conveying Equip.

Item G6—Dust Control (58.211, 58.230).

See the guidelines for Item D36—Dust Control.

Galvanized metal or plastic pipes, not in the product zone, are acceptable for vacuum conveying lines to dust collectors. Stainless steel lines are required in the product zone, which extends up to the point where the line first slopes downward, away from the dump hopper. Check that the fines collected from the dump hoppers are directed to an animal feed collector. Dump hopper fines are not acceptable as human food because of the introduction of unfiltered air.

The plant shall have a heavy duty vacuum system (see the guidelines for Item D30—Vacuum Cleaner) and shall use it regularly for dust control and housekeeping at the end of each production day. Check the floor, walls, ceiling, and ledges for accumulations of dust. Make recommendations as appropriate for the conditions observed.

Any false ceiling areas shall be accessible for cleaning and inspection. False ceiling areas should be discouraged in dry products processing areas.

Item G7—Housekeeping (58.126e, 58.127f, 58.146d).

See the guidelines for Item A7—Housekeeping.

When it is necessary that ingredients be stored in the dump room or area, recommend that the supply of ingredients to be stored be limited to only a day's requirements. Ingredients should be stored on racks or tables that have approximately a six-inch clearance from the floor or on movable pallets.

All empty containers shall be handled in a manner that shall not adversely affect the cleanliness and housekeeping of the dumping room, general plant areas, or the plant environment. Check that the empty containers are disposed of in a suitable container or are neatly stacked on a pallet and routinely removed from the dumping area. Empty bags shall not be piled on the floor.

Keeping cardboard or paper products for recycling purposes is acceptable provided that these materials are maintained in a sanitary fashion and do not invite the harborage of pests. Waste collection containers shall be free of mold, insects, or excessive accumulations of product residue. The collected materials should be shipped from the plant regularly. Compactor equipment for reclaimed paper products shall be located outside the processing area.

Check exterior dumpsters or trash compactors. The areas surrounding such equipment shall be kept clean. Waste containers shall be provided with covers.

Dry Blending Operation

Item G9—Room Construction (58.126, 58.211, 58.212).

See the guidelines for Item D34—Room Construction.

Dry blending shall be done in a separate room or an area within the packaging room where there is sufficient distance between the operations to facilitate proper housekeeping and dust control. The room or designated area shall meet all the construction and facility requirements for a bulk packaging room.

Properly trapped floor drains shall be provided and the floors pitched to the drain points. Although the dry products blending room or area may not require regular or frequent wet cleaning, floor drains are required for times when wet cleaning will be necessary. Because of their infrequent use, floor drains should be equipped with a removable cap or seal or nonevaporating liquid. Open drains shall not be in the vicinity of air intakes for processing or conveying air.

Item G10—Lighting & Ventilation (58.126d, e).

See the guidelines for Item A2—Lighting & Ventilation.

The room may be air conditioned to regulate temperature and humidity. Air systems drawing air from outside sources shall be filtered. Air ducts shall not blow directly on exposed product or product contact surfaces of vessels. Check air filters for proper placement and cleanliness. The room should be maintained at a slight negative pressure to minimize dust drift throughout the plant.

Item G11—Blender Loading Equipment (58.128a, 58.223, 58.228, 58.246).

Blenders may be loaded by a variety of methods. They may receive ingredients from mechanical conveyors (either belt or auger type), pneumatic conveyors, vacuum conveyors, or gravity chutes directly from dump hoppers.

If a conveyor is used list the deficiencies under Item G5—Conveyor(s) to Blender.

Inspect product contact surfaces for proper construction and sanitation. Pay particular attention to open seams, exposed threads, cracks, crevices, and other design or fabrication defects that would create hard to clean areas when the equipment would need to be wet cleaned. Product contact areas shall be free of product accumulations, moisture contamination, or discolored product.

Conveyors or chutes are to be properly positioned or suitably shielded to prevent the entry of contaminants from the exterior of the equipment. Inspect the exterior of all blender loading

equipment, and note exterior cracks and crevices that may collect dust or harbor insects and adversely affect the housekeeping, dust control, or pest control of the blending operation.

Very often blended products contain small-volume, high-cost, special ingredients such as vitamins, flavorings, or colorants. These special ingredients are not easily added to the product through the same system as the bulk ingredients. These ingredients may be added directly into the blender provided that the procedure is done in a sanitary manner.

Item G3 requires a separate room or area for the dumping operation. A dust collector attached to a blender does not satisfy this requirement. A separate dump hopper and blender are required. If direct dumping of bulk ingredients into the blender is observed, assign the deficiency to category C and record it under Item G3.

Item G12—Feeding Equipment – Vitamins, etc. (58.128a, 58.223).

Dry blending operations may have provisions to add a variety of small volume, nondairy ingredients to mixers or flowing product streams. These ingredients may be vitamins, flow promoting ingredients, flavorings, colorants, etc. The equipment used for adding these food chemical ingredients do not have to meet dairy construction criteria, except for the piece (nozzle, chute, auger, etc.) which comes in contact with the dry blended product or from which liquids may drip, drain or be drawn into the dry blended product. This piece shall comply with product contact surface construction criteria.

The same policy as above applies to feeding equipment for liquid nondairy ingredients. In addition, they shall be constructed in a way that would not adversely affect product sanitation or wholesomeness.

The equipment used for the addition of dairy ingredients shall comply with either the *3-A Sanitary Standards for Belt-Type Feeders, Number 75-* or with the *USDA Equipment Guidelines*. Check the sanitary condition of the unit. Regular dry brushing or vacuuming is a satisfactory cleaning practice for dry products feeding equipment. Feeders shall be equipped with tightly fitting covers to protect the products from contamination with extraneous materials.

Feeders that utilize air to convey the ingredients to the main body of the product shall use air that is supplied following the criteria in the *3-A Accepted Practices for Supplying Air Under Pressure in Contact With Milk, Milk Products and Product Contact Surfaces, Number 604-* .

Item G13—Blending Equipment (58.128a, 58.228).

The most common style of blending equipment used for dry blending operations is the ribbon blender. Other styles of batch and continuous blenders, however, may be employed. Refer to the *Accepted Equipment List*, if the equipment is not listed there, follow the guidelines for Item A3—Pumps, Pipelines, & Valves.

Ribbon blenders consist of a horizontal, cylindrical or half moon shaped body with a horizontal shaft running through it. Welded to the shaft are a series of support arms connected by one or

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more metal ribbons. The rotation of the shaft and the spiral configuration of the ribbons results in a vigorous mixing action of the various dry ingredients. Some models may incorporate secondary, high speed agitator or cutting blades mounted on the side wall of the body. Ribbon blenders shall be equipped with dust tight covers and sanitary discharge valve assemblies. Discharge valves may be located on either the bottom or end plates of the blenders.

Inspect the blender carefully for sanitation deficiencies. Product contact surfaces shall be free of product encrustation or wet product. Dry surfaces covered with a light film of product dust should not be criticized. Disassemble and inspect the discharge valves and shaft seals for evidence of improper or infrequent cleaning. While wet cleaning is not recommended for routine, daily cleanup, all dry blending equipment will be periodically wet cleaned. When a wet cleaning is conducted, carefully inspect that the cleaning has been thorough and that no wet product residue remains. Particular attention should be placed on the discharge valve and shaft seal assemblies.

Inspect the blender carefully for maintenance and design deficiencies. Support arms and ribbons shall be free of cracks and pits, be fully welded, ground, polished and have the proper radii. End plates may be either welded or bolted to allow for the removal of the ribbon shaft. Bolted end plates shall be fully gasketed. The gasket juncture shall provide a tight, pinch seal with the gasket material. Bent flanges that do not have sharp 90 degree sealing edges are unacceptable.

Shaft bearings are to be mounted outboard (a minimum of 1 inch between the bearing and the outer surface of the seal assembly is required) with sufficient space to allow cleaning and servicing of the sanitary shaft seal. Shaft seals shall be of a sanitary design and be easy to disassemble without the use of special tools. Dry products blenders may use solid plastic "V" or square shaped packing rings or air purge seals. Braided style packing may be used for dry products blenders provided they are discarded whenever the blenders are wet cleaned. The air supply for air purge seals must comply with the requirements of the *3-A Accepted Practice for Supplying Air Under Pressure in Contact with Milk, Milk Products and Product Contact Surfaces, Number 604-* except that a sanitary check valve is not required and plastic air hoses and fittings can be used.

Inspect the cover to assure that it is tight fitting. There shall be no damaged or cracked areas on the cover. Cover gaskets may be removable or bonded. If bonded, there shall be no voids or crevices at the glue joints. Gasket material shall be of solid or closed cell rubber or rubber-like material.

When products are conveyed to the blender by pneumatic means, inspect the air exhaust filters or dust collectors for proper cleaning and maintenance. Product dust collected from ingredient dump hoppers shall not be discharged into the blender. These dust collectors draw substantial quantities of unfiltered air.

Tumbler type blenders mix ingredients by revolving the entire vessel. This style of blender may be cylindrical with internal baffles or "V" shaped. These are usually batch blenders, with the

ingredients and finished product entering and exiting through the same valve assembly. Inspect the product contact surfaces as any other style blender.

For very large blenders it may be necessary to enter the blender to properly inspect the surfaces. Extreme caution is to be exercised whenever entering equipment. Follow the safety guidelines in Section I. P (which requires lockout/tagout, etc.). Also, do not enter without a plant representative present. If these requirements are not met, do not enter the equipment and recommend the plant initiate a confined space safety program. If the blender is only dry cleaned special boots or shoe covers, and protective clothing shall be used when entering. The plant shall provide sanitized rubber, plastic or disposable boots or shoe coverings and protective clothing. In addition, the plant shall provide a sanitized step, platform or mat to facilitate putting on the boots or shoe covering prior to entering the blender. Check that these sanitary items are kept clean and stored in a special cabinet. If these items are dirty, make the appropriate recommendations. A satisfactory alternative is to wet wash the blender after entering it.

Inspect exterior surfaces and support structures also for excessive product residue and exterior cracks and crevices.

Item G14—Fluidizers or Other Conveyors (58.128a,o, 58.221, 58.223, 58.246).

See the guidelines for Item D24—Product Removal & Conveying Equip.

Products may be conveyed from the blending equipment by air, vacuum, augers or belt type conveyors.

Item G15—Stationary Bulk Bins (58.226, 58.246).

See the guidelines for Item D28—Storage Bins & Conveyors.

If the bulk bin is equipped with automatic level control sensors, check that these are of sanitary design and construction. Mounting connections or flanges shall comply with sanitary fitting criteria. Paddle-style level sensors, such as "bindicators" shall not have twisted cable flexible shafts or threaded connectors. All paddles shall be fully welded with the proper radii. When unsatisfactory conditions are observed, recommend repair or replacement.

Item G16—Portable Bulk Bins (58.226, 58.246).

See the guidelines for Items D39—Portable Bin Filling Equipment, D40—Portable Bulk Bins, and D45—Tote to Bag Packaging.

Describe any deficiencies in container identification, condition or sanitation and make the appropriate recommendations.

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Item G17—Dust Control (58.211, 58.230).

See the guidelines for Item G6—Dust Control.

Item G18—Housekeeping (58.126e, 58.127f, 58.146d).

See the guidelines for Item A7—Housekeeping.

Packaging

Item G20—Room Construction (58.126, 58.212, 58.213).

See the guidelines for Item D34—Room Construction.

There shall be a separate room for packaging operations and it shall meet all the requirements for construction and facilities for a bulk packaging room.

The location of doors or adjacent operations shall not cause excessive or unnecessary personnel traffic through the packaging area.

There shall be properly trapped floor drains provided and the floors shall be pitched to the drain points. While the dry products packaging areas may not require regular or frequent wet cleaning, floor drains are required for times when wet cleaning will be necessary. Because of their infrequent use, floor drains may be equipped with a removable cap or seal or nonevaporating liquid. Open drains shall not be in the vicinity of air intakes for processing or conveying air.

Item G21—Lighting & Ventilation (58.126d, e).

See the guidelines for Item A2—Lighting & Ventilation.

The room may be air conditioned to regulate temperature and humidity. Air systems drawing air from outside sources shall be filtered. Air ducts shall not blow directly on exposed product or contact surfaces of product vessels. Check air filters for proper placement and cleanliness. The room should be maintained at a slight negative pressure to limit dust drift throughout the plant.

Item G22—Product Conveyors (58.128a, 58.228, 58.246).

See the guidelines for Item D24—Product Removal & Conveying Equip.

Item G23—Sifter (58.224, 58.246).

See the guidelines for Item D37—Sifter.

It is a USDA requirement that dry blending and packaging operations be equipped with a sifter at some suitable location following the dumping and blending operations and before the final packaging. A sifter is required to ensure all plastic and paper that may enter the product from the dumping operation are removed prior to packaging. The sifter shall comply with the *3-A Sanitary Standards for Sifters for Dry Milk and Dry Milk Products, Number 26-* . A sifter is not required when the plant is dumping powder from super saks, tote bins, or other bulk bins.

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If the ingredients are mechanically or pneumatically conveyed from the dump hopper to the blender, the sifter may be placed just before entrance to the blender.

The size of sifter screen openings may be dictated by the type of product being processed. However, they shall be sufficiently small to cull out oversized particles and extraneous materials from the dumping operations such as pieces of paper bag, plastic liners, string, etc. See the appendix of the 3-A Sanitary Standards for general guidance on screen openings.

Item G24—Packaging Machine (58.229).

Check that the filling equipment is of sanitary design and construction. New or replacement equipment shall comply with the *3-A Sanitary Standards for Equipment for Packaging Dry Milk and Dry Milk Products, Number 27-* .

Filling equipment may vary depending on the size and style of package for the finished product. Finished products may be packaged in bulk bags (50lb. or 25Kg.), consumer size bags or pouches, consumer size boxes, single serving pouches or packets, cans, jars, envelopes, etc. Filling equipment configurations may therefore vary considerably.

Generally the filling equipment for small packages has been manufactured for the general food industry and not the dairy industry. Carefully check the machines for cleanability and ease of disassembly. While frequent wet washing of dry product packaging equipment is not recommended, wet washing will occasionally be needed, therefore ease of disassembly is important. Product contact areas shall be free of cracks, crevices, and exposed thread. The equipment shall protect the product from contamination.

Item G25—Conveyors, Scales, Vibrators (58.128a, m, 58.241).

Equipment used for handling packaged product such as conveyors, scales and vibrators are not considered product contact surfaces. They should be checked, however, for general cleanliness. The equipment shall be free of accumulations of spilled product that provide breeding places for insects or contribute to the growth of mold.

Item G26—Sealing Equipment (58.128).

Sealing equipment for dry blending operations may vary according to the size, type, and style of the finished product container (bags, pouches, packets, cans, or over wrapped fiberboard boxes).

Regardless of the size or style or package used, the sealing equipment must be constructed so that the products are protected at all times from the entrance of extraneous materials from the environment or from the sealing equipment itself. Recommend protective shields and guards as appropriate.

Check the equipment for cleanliness. The equipment shall be free of accumulations of old or encrusted product residues. If the equipment utilizes heated surfaces for sealing purposes, the surfaces shall be in good repair and free of accumulations of charred product, glue, or wax.

Whenever possible, observe the equipment in operation to check that the containers are being properly sealed. Closures shall be tight, and free of wrinkles or voids to prevent the product from leaking out. Any over wrap shall completely envelope the interior box, be tightly sealed to the box and be free of wrinkles that would allow insects to enter the container.

Check the interior drive and control areas of the equipment for excessive product accumulation or evidence of insects.

Item G27—Packaging Workmanship (58.241 a, b, c).

Observe actual packaging operations when assessing packaging technique. If packaging is not in process during the survey, arrange to have two or three boxes of packaged product opened so that the packaging can be evaluated.

Workmanship items to be checked include the neatness and readability of markings and coding, absence of product residues on the exterior of the packages, no product spillage during packaging, proper sealing of the containers, protection of empty containers before they are filled, and handling of filled containers.

When package weights are adjusted manually, check that the "makeup" product is stored in a clean, covered container and that a clean, sanitary, plastic or metal utensil is used for this operation. Also, the product in the "makeup" container shall be the same as that being packaged.

When unsatisfactory workmanship factors are observed, make appropriate recommendations for improvement.

Item G28—Facilities to Clean Equipment (58.128a, 58.146a, 58.246).

Dry blending and packaging equipment is normally cleaned by dry methods. Wet cleaning should be reserved for changeovers to different products or special cleaning activities (e.g., after Salmonella or Listeria contamination had been detected). Check that adequate brushes made with molded plastic heads and with plastic or metal handles are used for cleaning purposes. Separate brushes shall be used to clean product contact surfaces and nonproduct contact surfaces. Brushes used for the product contact surfaces shall be identified and stored in a sanitary storage cabinet. If air is used for cleaning, make sure dust control is maintained during the cleaning procedures so that other plant operations are not adversely affected by dust drift.

Although wet cleaning is reserved for special cleaning activities, adequate facilities for wet cleaning shall be present. Hot and cold water shall be readily available. Floors shall be equipped with adequate floor drains and be constructed with a proper slope so that the entire

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room environment can be effectively cleaned. When wet cleaning is conducted at the time of the survey, carefully check that all product residues have been removed. Check for pockets of wet or caked powder in the equipment or in hard to reach areas of the rooms. All areas or pieces of equipment that have been wet cleaned should be allowed to dry completely before reassembly.

Item G29—Vacuum Cleaner (58.230).

See the guidelines for item D30—Vacuum Cleaner.

Item G30—Other Products Processed (58.151, 58.152, 58.241, 58.242).

Check that all other products processed or packaged are fit for human consumption. If animal feed or nonfood products are packaged, except as noted below and allowed by Item D43—Waste Products Handling, recommend the assignment of the INELIGIBLE status.

If the plant blends and packages other dairy products for which it has not requested approval, the plant shall have operating procedures that will prevent the intermixing of these unapproved products and products subject to inspection and approval. Check that there are efficient dry cleaning procedures for all equipment. The approved products should be run first. Alternately, the unapproved products shall be taken out of the system prior to processing approved products. Unapproved products shall not be "flushed out" with approved product.

A plant that blends and packages human food products that have an offensive odor or that are incompatible with dairy operations, such as meat or poultry broths, gravies, etc., shall provide totally separate blending and packaging equipment. There shall be no cross utilization of any equipment between the two operations. If shared equipment is observed, the INELIGIBLE status shall be assigned (category A deficiency).

A plant that blends and packages nondairy human food products that are incompatible with dairy operations because of color or odor shall provide a comprehensive quality manual detailing the steps that will be taken to prevent cross contamination between dairy products and other products. A copy of the quality manual shall be sent to the Washington Office. If you encounter this situation during a survey, contact the National Field Office or the Washington Office to determine if this requirement has been met. If this requirement has not been met assign the deficiency to category C.

Item G31—Waste Products Handling (58.127f, 58.241c).

See the guidelines for item D43—Waste Products Handling.

Item G32—Dust Control (58.212, 58.230).

See the guidelines for Item G6—Dust Control.

Item G33—Housekeeping (58.126e, 58.127f, 58.146d).

See the guidelines for Item A7—Housekeeping.

Product Storage

Item G35—Tanker Unloading & Equipment (58.126, 58.128a, o, 58.221, 58.246).

If the plant receives bulk dairy ingredients, try to inspect at least one transport truck trailer or railroad car during the survey.

A. Room Construction.

See the guidelines for Item A2—Lighting & Ventilation and A10—Room Construction.

Check if the location of doors or adjacent operations is causing excessive or unnecessary personnel traffic through the unloading area. If excessive personnel traffic is observed, recommend that management take steps to reduce or limit access to this area.

Truck drivers should not be allowed inside the processing area.

Hot and cold water and hand washing facilities shall be available in the unloading area.

B. Unloading Equipment, Lines and Valves.

Bulk tankers or railroad cars are routinely unloaded pneumatically. These unloading systems shall comply with criteria in the *3-A Sanitary Standards for Pneumatic Conveyors for Dry Milk and Dry Milk Products, Number 39-*.

Rotary airlocks, whether supplied by the plant or which are integral parts of the bulk tankers/trailer, shall be reviewed and accepted by the Dairy Grading Branch.

Check that filters for conveying air are the correct types and are installed properly to prevent the entrance of unfiltered air during unloading. All pipelines, flexible hoses, valves and fitting shall be of sanitary design. Unloading hoses shall be tightly capped when not in use.

Equipment that is not routinely wet washed must be adequately protected from moisture during cleanups of the unloading facilities or when high humidity conditions exist. Check that unloading hoses are properly stored in clean cabinets or racks. If the unloading hose is transported with the truck, it should be protected inside a sealed tube.

Inspect product contact surfaces of the unloading equipment for evidence of encrusted product or moisture.

C. Unloading Procedure.

Whenever possible, observe tanker or railroad car unloading procedures. Check that all connections are adequately cleaned and sanitized or are capped prior to unloading. If the tankers or railroad cars have vents, check that vents are properly covered by filters.

D. Inspection procedure.

Inspect (with a flashlight if necessary) the interior of the truck trailers or railroad cars to determine if the trailer is of sound construction, has no protruding nails or broken internal walls, is free of debris or spilled product from damaged containers and is free of mold, insect, or rodent infestation. Describe any deficiencies in truck or trailer condition, sanitation, or housekeeping practices and make the appropriate recommendations. Record on the report the truck's identification number or name so that the plant can follow-up on deficiencies.

If dry products are received in bulk tanker trailers, check if the tanker design and fabrication have been reviewed and accepted by the Dairy Grading Branch. Refer to the *Accepted Equipment List*. If it is not listed there, see the guidelines for Item A3—Pumps, Pipelines, & Valves.

If the bulk tanker trailers are routinely wet cleaned after unloading, inspect one trailer following the inspection guidelines for a liquid tanker in the Bulk Receiving Section (Item A13—Truck Tanks, Pumps, & Fittings). When a tanker is entered for inspection purposes, instruct plant management to have the tanker rewashed after the inspection.

If the bulk tanker trailers are not wet cleaned and are left in a dry condition instead, follow the inspection guidelines for a box type spray dryer as outlined in Item D22—Drying Chamber and Item D29—Dryer Dry Cleaning Methods. These require special boots or shoe covers, a sanitized step, platform, or mat to ease putting on the boots or shoe coverings and entering the tanker, a special cabinet for storage of these sanitary items, etc.

The interior surfaces of the tanker may be dusty but are unacceptable if they show areas of heavy or encrusted product buildup, discolored product, or dampness. Door openings, inlets and outlet valves and hoses shall be of sanitary design and maintained in a clean condition. If the trailer is equipped with an onboard rotary airlock valve, it shall comply with the *USDA Equipment Guidelines*. Describe any deficiencies in tanker condition, sanitation or housekeeping practices and make the appropriate recommendations. Record on the report the truck identification number or name so the plant can follow-up on the deficiencies.

Item G36—Room Construction - Raw Ingredients (58.126).

See the guidelines for Item D46—Room Construction - Warehouse.

Products should be stored in an orderly fashion to simplify inventory control and proper identification. Bulk ingredients may be received in a variety of packaging styles such as bulk bags (50 lb. or 25Kg.), portable bulk bins (metal, cardboard, or woven fabric), or over-the-road tankers. In all cases the condition and identification of the containers shall be checked.

Carefully check that the ingredients are stored in an orderly way for easy identification. Ingredients shall not be stored in close proximity with nonfood materials such as cleaners, pesticides, etc.

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Carefully check for damaged or torn containers, sifting or exposed product, and insect, rodent, or other infestation. If rodent or insect infestation is observed, follow the guidelines for Item A37—Pest Control and record the deficiency under item G50—Pest Control with the appropriate recommendations. Also, recommend that infested or contaminated products be removed immediately from the plant.

Item G37—Lighting & Ventilation (58.126d, e).

See the guidelines for Item B54—Lighting & Ventilation.

Item G38—Housekeeping (58.126e, 58.127f, 58.146d).

See the guidelines for Item D48—Housekeeping.

Item G39—Room Construction - Finished Products (58.126).

See the guidelines for item D46—Room Construction - Warehouse.

Item G40—Lighting & Ventilation (58.126d, e).

See the guidelines for Item B54—Lighting & Ventilation.

Item G41—Housekeeping (58.126e, 58.127f, 58.146d).

See the guidelines for Item D48—Housekeeping.

General Items

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