

901:3-1-09

**Manufacturing Operations.**

- (A) Equipment and utensils and finished food containers shall be maintained in an acceptable condition through appropriate cleaning and sanitizing. Equipment shall be disassembled as necessary to allow access for thorough cleaning.
- (B) All food manufacturing, including packaging and storage, shall be conducted under such conditions and controls as are necessary to minimize the potential for the growth of microorganisms, or for the contamination of food.
- (C) Food that can support the rapid growth of undesirable microorganisms, particularly those of public health significance, shall be held in a manner that prevents the food from becoming adulterated and as applicable:
- (1) Maintaining refrigerated foods at forty-five degrees Fahrenheit or below as appropriate for the particular food involved.
  - (2) Maintaining frozen foods in a frozen state.
  - (3) Maintaining hot foods at one hundred forty degrees Fahrenheit or above.
  - (4) Heat treating acid or acidified foods to destroy mesophilic microorganisms when those foods are to be held in hermetically sealed containers at ambient temperatures.
- (D) Measures such as sterilizing, irradiating, pasteurizing, freezing, refrigerating, controlling pH or controlling a<sub>w</sub> that are taken to destroy or prevent the growth of undesirable microorganisms, particularly those of public health significance, shall be effective under the conditions of manufacture, handling, and distribution to prevent food from being adulterated.
- (E) Work-in-process shall be handled in a manner that protects against contamination.
- (F) Effective measures shall be taken to protect finished food from contamination by raw materials, other ingredients, or refuse. When raw materials, other ingredients, or refuse are unprotected, they shall not be handled simultaneously in a receiving, loading, or shipping area if that handling could result in contaminated food. Food transported by conveyor shall be protected against contamination as necessary.
- (G) Equipment, containers, and utensils used to convey, hold, or store raw materials, work in-process, rework, or food shall be constructed, handled, and maintained during manufacturing or storage in a manner that protects against contamination.
- (H) Effective measures, such as using sieves, traps, magnets, electronic metal detectors, or other suitable effective means shall be taken to protect against the inclusion of metal or other extraneous material in food.
- (I) Food, raw materials, and other ingredients that are adulterated shall be disposed of in a

manner that protects against the contamination of other food. If the adulterated food is capable of being reconditioned, it shall be reconditioned using a method that has been proven to be effective or it shall be reexamined and found not to be adulterated before being incorporated into other food.

(J) Mechanical manufacturing steps such as washing, peeling, trimming, cutting, sorting and inspecting, mashing, dewatering, cooling, shredding, extruding, drying, whipping, defatting, and forming shall be performed so as to protect food against contamination.

(K) Heat blanching, when required in the preparation of food, shall be effected by heating the food to the required temperature, holding it at this temperature for the required time, and then either rapidly cooling the food or passing it to subsequent manufacturing without delay.

(L) Batters, breading, sauces, gravies, dressings, and other similar preparations shall be treated or maintained in such a manner that they are protected against contamination.

(M) Filling, assembling, packaging, and other operations shall be performed in such a way that the food is protected against contamination.

(N) Food including but not limited to, dry mixes, nuts, intermediate moisture food, and dehydrated food, that relies on the control of  $a_w$  for preventing the growth of undesirable microorganisms shall be processed to and maintained at a safe moisture level by any effective means including employment of one or more of the following practices: monitoring the  $a_w$  of the food, controlling the soluble solids-water ratio in finished food, and/or protecting finished food from moisture pickup by use of a moisture barrier or by other means so that the  $a_w$  of the food does not increase to an unsafe level.

(O) Food including but not limited to, acid and acidified food, that relies principally on the control of pH for preventing the growth of undesirable microorganisms shall be monitored and maintained at a pH of 4.6 or below by any effective means including employment of one or more of the following practices: monitoring the pH of raw materials, food in process, and finished food and/or controlling the amount of acid or acidified food added to low-acid food.

(P) When ice is used in contact with food, it shall be made from water that is safe and of adequate sanitary quality, and shall be used only if it has been manufactured in accordance with current good manufacturing practice as outlined in this Chapter.

(Q) Unless there is no reasonable possibility for the contamination of the food intended for human consumption, food manufacturing areas and equipment used for manufacturing food intended for human consumption shall not be used to manufacture food grade animal feed or inedible products.

(R) The mixing of a food containing defects above the current defect action level with another lot of food is not permitted and renders the final food adulterated, regardless of the defect level of the final food.

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