

## Self-Inspection Program Sample (Rendering Plant)

Below is an example of what a self inspection program might look like for a rendering facility utilizing Processing Method 3.

Remember the following requirements for Processing Method 3:

Method	Particle size	Time	Temperature	Pressure/pH	Notes
3	< or = 30 mm	95 min	>100 C	Not required	Batch or continuous
		55 min	>110 C		
		13 min	>120 C		

- The program must include procedures to follow if a critical limit is not met. Specifically, if product produced without meeting a critical limit, the plan must state that the area office will be notified that the material is: a) destroyed, b) reprocessed, or c) sold domestically. [Note the section of the sample program which says: “If product is produced without meeting one of the critical limits, the Virginia Area Office will be notified within 24 hours after the failure is identified. No material will be shipped without first being reprocessed, and verification is provided that all critical limits are now met.”](#)
- The program must also specify how the size of a lot will be determined (e.g., 5000 pounds or product produced in a calendar day). [Note the section of the sample program which says: “Lot size – all product produced on one calendar day.”](#)
- The program must list all required specific critical control points (CCPs) and critical limits. The location of the CCPs must be included on the process flow diagram. Consider the specific required CCPs and CLs for a facility using Processing Method 3.
- The program must include a CCP and CL for particle size, consistent with the processing method the facility is utilizing. For processing method 3, the CL for particle size is less than or equal to 30 millimeters. The process flow diagram notes this as CCP 1 located at the screener, and the program goes on to verify that the CCP is a particle size of less than or equal to 20 millimeters, which is less than 30 millimeters, and is therefore acceptable.

- The program must include a CCP and CL for processing time as well as a CCP and CL for processing temperature, consistent with the processing method the facility is utilizing. For processing method 3, there are actually three critical limits each for processing times and temperatures. Material must be treated for at least 95 minutes at greater than 100 degrees Celsius, then for at least 55 minutes at greater than 110 degrees Celsius, and then for at least 13 minutes at greater than 120 degrees Celsius. However, a facility could meet all of these critical limits with one set of parameters. On our example, the process flow diagram defines CCP 2 as the minimum temperature the product will be maintained at for the minimum time and CCP3 as the minimum time at which the product will be maintained at the minimum temperature. Both CCP2 and CCP 3 are located in the cooker. The program goes on to specify that the critical limit for CCP 2 is 130 degrees Celsius and the critical limit for CCP3 is 165 minutes. By maintaining the material at 130 degrees Celsius for 165 minutes, the facility is maintaining the material at, greater than 100 degrees Celsius for 95 minutes, then greater than 110 degrees Celsius for 55 minutes, and then greater than 120 for 13 minutes, with an extra two minutes.
- The program must include, if appropriate, CCPs and CLs for processing pressure and or pH consistent with the processing method the facility is utilizing. The only method ALWAYS requiring pressure treatment is processing method one. The only method always requiring pH adjustment is processing method six.
- The program must include a CCP and CL for Salmonella: The plan must indicate a critical limit for each batch of product. The critical limit must be an absence of Salmonella in 25 g of product ( $n = 5, c = 0, m = 0, M = 0$ ).
- The program must include a CCP and CL for Enterobacteriaceae: The plan must indicate a critical limit for each batch of product. The critical limit should be a maximum of an “m” value of 10 for the number of bacteria in all samples ( $n= 5, c = 2, m = 10, M = 300$  in 1 g). The program must clearly define not only the value but the definition of these terms. For example, the value of n may be 5, but the program should also define n as the number of samples to be tested.

# Raunchy Rendering Self-Inspection Plan

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Process flow diagram:

Raw materials



Grinder



Screener

CCP 1 (particle size)



Cooker

CCP 2 (minimum temperature)

CCP 3 (minimum time)



Storage

CCP 4 (salmonella)

CCP 5 (enterobactereaceae)

CCPs	Critical Limits	Details
CCP 1- particle size	$\leq 20$ mm	After materials are ground, they will pass through a screen with a mesh size of 20 mm.
CCP 2- temperature	120°C	In the batch cooker, the material will be heated to 120 °C. Once the thermocouple indicates the temperature has reached 120°C, the temperature will be maintained for 165 minutes.
CCP 3- time	165 minutes (at 120°C)	Time will be monitored, and printed (with the temperature) on a time-temperature graph.
CCP 4- salmonella	n = 5 c = 0 m = 0 M = 0 in 25 g	A sample of each finished lot will be tested for salmonella.
CCP 3- enterobactereaceae	n = 5 c = 2 m = 10 M = 300 in 1 g	A sample of each finished lot will be tested for enterobactereaceae.

Lot size – all product produced on one calendar day.

If product is produced without meeting one of the critical limits, the Virginia Area Office will be notified within 24 hours after the failure is identified. No material will be shipped without first being reprocessed, and verification is provided that all critical limits are now met.