



REVISED SEPTEMBER 2017

Commercial Processing Example: *Wild Salmon Sushi Rolls*

Example: This is a Special Training Model for illustrative purposes only. The SHA models are based on guidance contained in FDA’s *Fish and Fishery Products Hazards and Controls Guidance* (4th Edition, 2011) and additional information available since the 2011 edition. It was produced by the National Seafood HACCP Alliance (SHA) strictly as an example for training. This Model does not represent a specific requirement or recommendation from FDA. Keep in mind that this model may not apply to all situations.

Narrative

| | |
|--|--|
| Company | ABC Sushi Rolls Company, Anywhere, USA |
| Market Name | Salmon (<i>Oncorhynchus kisutch</i>) |
| Source of Fishery Product | Wild caught salmon (frozen); purchased from another processor. |
| Describe the Food | Salmon sushi rolls (salmon, rice mixture and seaweed), chilled, packaged in oxygen permeable packaging, |
| Method of Receiving, Storage and Distribution | Salmon fillets are received frozen, thawed, stored under refrigeration and subsequently distributed under refrigeration. |
| Finished Packaging Type | Salmon sushi rolls are placed into plastic trays and covered by an oxygen permeable film. |
| Intended Use and Consumer | Salmon sushi rolls are an uncooked prepared product (ready-to-eat), to be consumed by the general public. |

Description of Process

Receive frozen salmon - Frozen wild salmon (ocean-caught) fillets are received from primary processor. The primary processor freezes the salmon to a temperature of -4°F/-20°C or lower for more than 7 days to kill parasites as required by the company’s product specifications. A statement is on file from the supplier verifying that all salmon shipped is provided to ABC Seafood Company indicating the fish have been processed according to the supplier’s HACCP plan to eliminate parasites.

Frozen salmon storage - After receipt, the salmon is held in frozen storage (0°F or below) until it removed for tempering prior to making sushi rolls. Product can remain in frozen storage for up to two weeks.

Preparing salmon- Frozen salmon fillets are brought to the preparation room, tempered for about 20 minutes prior to manually cutting into 1” strips. The preparation room temperature is 45°F/7.2°C.

Receive dry materials – Dry seaweed without added ingredients, and 40lb-bags of rice are received from approved vendors. Vinegar received with confirmation for sulfite-free.

Dry Storage – Seaweed and rice are stored in original containers in the dry storage area.

Cooking rice - Rice is removed from the dry storage area and taken to the rice cooking room where it is batch cooked in boiling water until done.

Rice acidification – Acidification is used to prepare rice with proper texture and to prevent growth of potential pathogenic bacteria, *Bacillus cereus*. The hot rice is immediately mixed in the cooker with vinegar (sulfite-free) to acidify to a pH of 4.3 or less. Mixing is done manually. Acidified rice is put into 5-gallon insulated containers to keep it warm (80-105°F/~27-41°C) so it will roll better. The insulated containers are taken to the sushi prep room which is maintained at 45°F/7.2°C. The finished rice is allowed to equilibrate for at least 30 minutes before pH is tested.

Assemble nori, rice and salmon into rolls – The acidified rice, seaweed (nori) and salmon portions are assembled into sushi rolls in a process that takes less than two hours. The rice is formed into a sheet, the seaweed and salmon

are placed on the rice and it is rolled together. Each roll takes about two minutes to assemble.

Cut rolls - The finished roll is manually sliced into approximately 1" round pieces, using a handheld unbreakable knife.

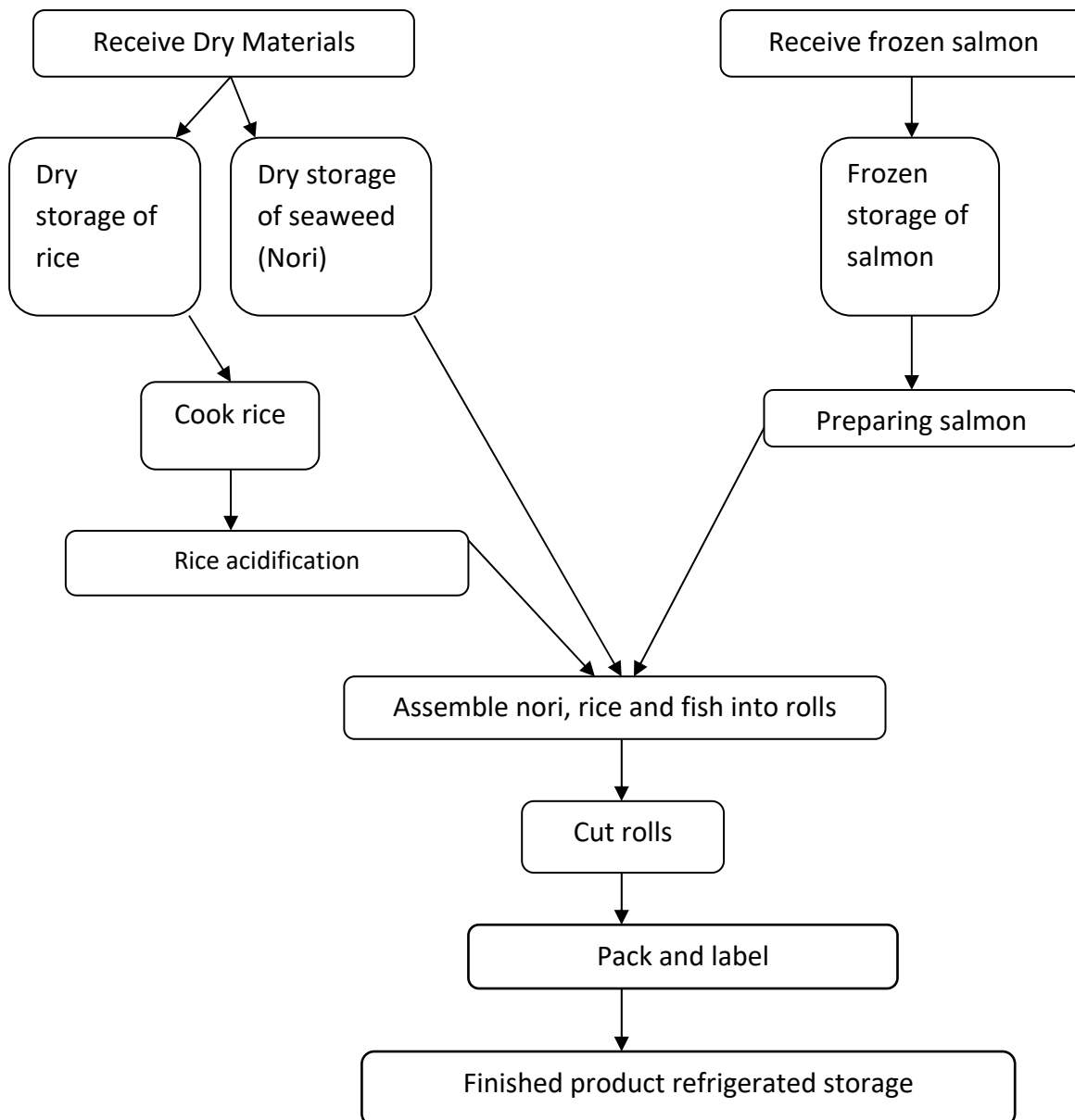
Pack and label - All pieces are placed into plastic trays with oxygen permeable film and labeled.

The total process time after rice is cooked through the Pack and Label step is no more than 2 hours.

Finished product refrigerated storage - The finished packaged sushi product is either placed directly on a refrigerated truck and shipped to the customer the same day or stored in a refrigerated cooler overnight at 40°F/4.4°C or less for shipment the next day.

SPECIAL NOTE: No glassware or glass containers are used in processing the salmon, rice or sushi rolls.

Wild Salmon Sushi Rolls Process Flow Chart



Commercial Processing Example: *Wild Salmon Sushi Rolls*

Example: For Illustrative Purposes Only. Models are based in current guidance contained in FDA’s *Fish and Fishery Products Hazards and Control Guidance*. Keep in mind that this model does not apply to all situations.

| Description | Company: ABC Sushi Rolls Company | | | | | | | | | | | | | | | | | | | | | | |
|---|----------------------------------|----------------|----------------|-------------------------|------|--------|--------------|-----------------------|------|--------|--------------|------------------------|------|--------|--------------|-------------------------|------|------------------------------|----------|-------------|-------------------|--------------------|--|
| | Where Product Is Purchased | | | How Product Is Received | | | | How Product Is Stored | | | | How Product Is Shipped | | | | How Product is Packaged | | How Product Will Be Consumed | | | Intended Consumer | | |
| | From Fisherman | From Fish Farm | From Processor | Refrigerated | Iced | Frozen | Shelf-Stable | Refrigerated | Iced | Frozen | Shelf-Stable | Refrigerated | Iced | Frozen | Shelf-Stable | Air Packed | ROP* | Raw to be cooked | Raw RTE* | Cooked RTE* | General Public | At Risk Population | |
| Common Name: Salmon (wild) Market Name: Salmon Scientific Name: <i>Oncorhynchus kisutch</i> | | | √ | | | √ | | | | √ | | | | | √ | | | | √ | | | √ | |

*ROP = Reduced Oxygen Packaging; *RTE = Ready-to Eat

Potential Food Safety Hazards: All potential food safety hazards based on the product description and processing flow diagram associated with this product and process are identified using Tables 3-2 (species-related hazards) and 3-4 (process-related hazards) in the FDA *Hazards and Controls Guidance* (2011 edition). Processors should be aware that additional guidance may be periodically posted on FDA Seafood HACCP Websites, and additional hazards not covered by this guidance may be relevant to certain products under certain circumstances.

The FDA recommendations indicate 5 potential hazards that that are species or process related. Each potential hazard must be addressed in the Hazard Analysis. Glass Inclusion as listed in the FDA Guidance Table 3-4 Process-related hazards was not included because no glassware or glass containers are used in processing the salmon, rice or sushi rolls.

1. Parasites (species-related, chapter 5)
2. Pathogenic bacteria growth (thermal abuse during processing) – (process-related, chapter 12) **[NOTE:** Although not specifically listed in the FDA Tables for potential hazards, pathogen growth in cooked rice should be included as a potential hazard for this particular product (mentioned on FDA Guidance page 217)]
3. Food Allergens (natural) – (process-related, chapter 19)
4. Food Additives (use of sulfites to control melanosis) – (process-related, chapter 19)
5. Metal Inclusion (if used in packaging step) – (process-related, chapter 20)

SANITATION CONTROL PROCEDURES (SCP) are monitored throughout all processing steps and the daily SCP records accompany the HACCP records.

Hazard Analysis Worksheet

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|--|---|
| Firm Name: <i>ABC Sushi Rolls Company</i> | Product Description: <i>Salmon sushi rolls in oxygen permeable packages</i> |
| Firm Location: <i>Anywhere, USA</i> | Method of Storage & Distribution: <i>Refrigerated at ≤ 40° F</i> |
| | Intended Use & Consumer: <i>Ready-to-eat uncooked prepared product, to be consumed by general public without further cooking</i> |

| (1) Processing Step | (2) List all potential food safety hazards that could be associated with this product and process. | (3) Is the potential food safety hazard significant (introduced, enhanced or eliminated) at this step? (Yes or No) | (4) Justify the decision that you made in column 3 | (5) What control measure(s) can be applied to prevent this significant hazard? | (6) Is this step a Critical Control Point? (Yes or No) |
|--|---|---|--|--|---|
| Receive dry ingredients and packaging materials | Parasites | No | Not reasonably likely to occur in ingredients or packaging | | |
| | Pathogenic bacteria growth – temperature abuse | No | Not reasonably likely to occur in ingredients or packaging | | |
| | Food Allergens | No | Not reasonably likely to occur in ingredients or packaging | | |
| | Food Additives | No | No additives used | | |
| | Metal Inclusion | No | Not reasonably likely to occur at this step | | |
| Dry Storage | Parasites | No | Not reasonably likely to occur in dry storage | | |
| | Pathogenic bacteria growth – temperature abuse | No | Not reasonably likely to occur in dry storage | | |
| | Food Allergens | No | Not reasonably likely to occur in dry storage | | |
| | Food Additives | No | No additives used | | |
| | Metal Inclusion | No | Not reasonably likely to occur at this step | | |
| Receive frozen salmon | Parasites | No | Controlled by supplier with freezing | | |
| | Pathogenic bacteria growth- temperature abuse | No | Not reasonably likely in frozen salmon | | |
| | Food Allergens | Yes | Salmon is a food allergen | Finished product label applied at pack and label step will identify fish market name (salmon). | No |
| | Food Additives | No | No additives used | | |
| | Metal Inclusion | No | Metal inclusion is not likely to occur at this step | | |

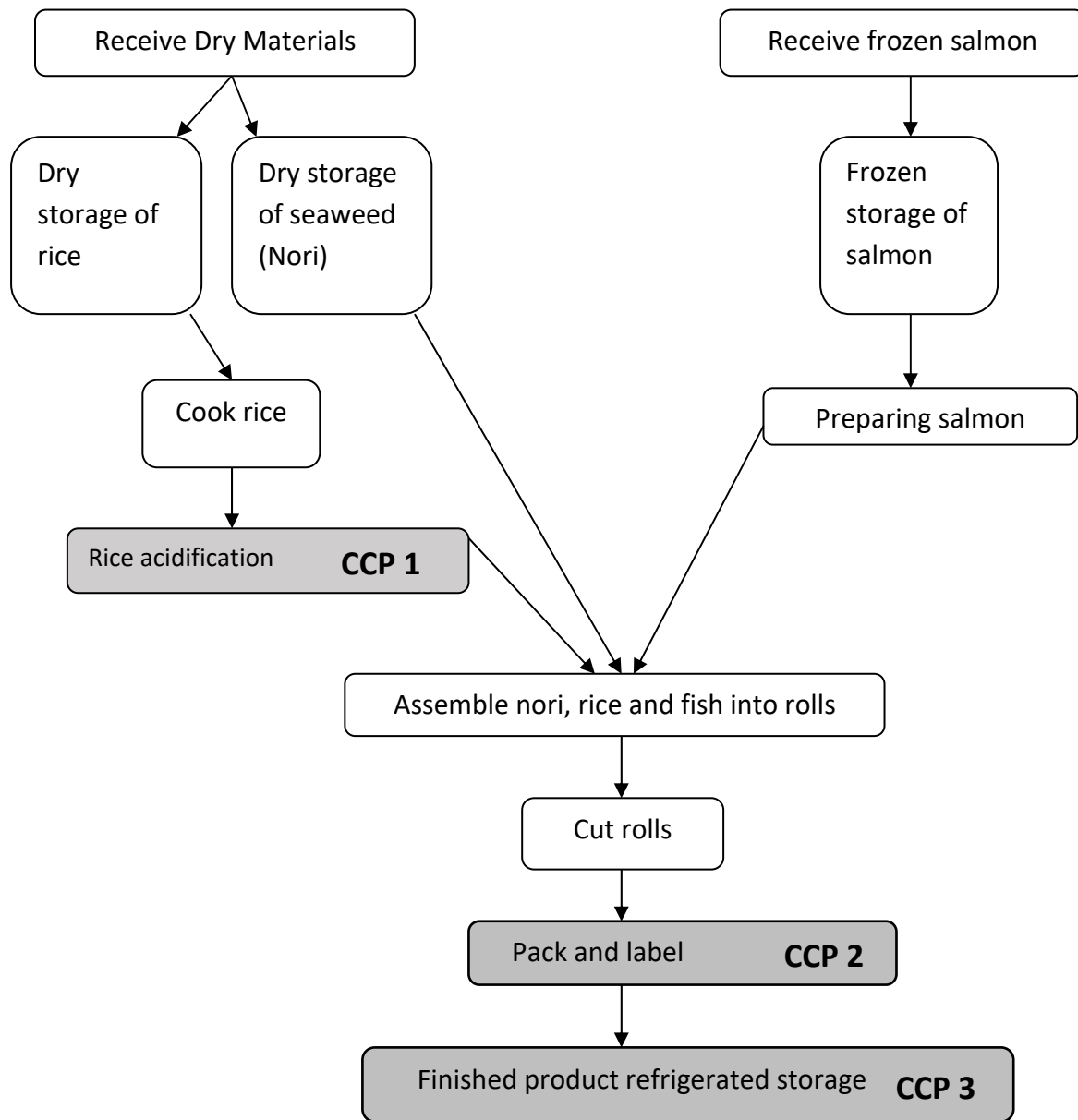
| (1) Processing Step | (2) List all potential food safety hazards that could be associated with this product and process. | (3) Is the potential food safety hazard significant (introduced, enhanced or eliminated) at this step? (Yes or No) | (4) Justify the decision that you made in column 3 | (5) What control measure(s) can be applied to prevent this significant hazard? | (6) Is this step a Critical Control Point? (Yes or No) |
|------------------------|---|---|---|--|---|
| Frozen Storage | Parasites | No | Controlled by supplier with freezing | | |
| | Pathogenic bacteria growth–temperature abuse | No | Not likely to occur in frozen salmon | | |
| | Food Allergens | Yes | Salmon is a food allergen | Finished product label applied at pack and label step will identify fish market name (salmon). | No |
| | Food Additives | No | No additives used | | |
| | Metal Inclusion | No | Not reasonably likely to occur at this step | | |
| Cook rice | Parasites | No | Not reasonably likely to occur in cooked rice | | |
| | Pathogenic bacteria growth – temperature abuse | No | Not reasonably likely to occur during cooking | | |
| | Food Allergens | No | Rice is not a major food allergen | | |
| | Food Additives | No | No additives used | | |
| | Metal Inclusion | No | Not reasonably likely to occur at this step | | |
| Rice acidification | Parasites | No | Not reasonably likely to occur in rice or acidified rice | | |
| | Pathogenic bacteria growth – temperature abuse | Yes | <i>Bacillus cereus</i> could grow and form toxins if cooked rice is time-temperature abused | Rice acidification | Yes |
| | Food Allergens | No | Rice is not a major food allergen | | |
| | Food Additives | No | No additives used ; vinegar (sulfite-free) is not a food additive | | |
| | Metal Inclusion | No | Not reasonably likely to occur at this step | | |

| (1) Processing Step | (2) List all potential food safety hazards that could be associated with this product and process. | (3) Is the potential food safety hazard significant (introduced, enhanced or eliminated) at this step? (Yes or No) | (4) Justify the decision that you made in column 3 | (5) What control measure(s) can be applied to prevent this significant hazard? | (6) Is this step a Critical Control Point? (Yes or No) |
|--|---|---|---|--|---|
| Preparing salmon | Parasites | No | Controlled by supplier with freezing | | |
| | Pathogenic bacteria growth – temperature abuse | No | Not reasonably likely to occur because of short time at this step in separate, chilled room | | |
| | Food Allergens | Yes | Salmon is a food allergen | Finished product label applied at pack and label step will identify fish market name (salmon). | No |
| | Food Additives | No | No additives are used | | |
| | Metal Inclusion | No | Not reasonably likely to occur at this step | | |
| Assemble nori, rice and fish into rolls | Parasites | No | Controlled by supplier with freezing | | |
| | Pathogenic bacteria growth – temperature abuse | No | Not reasonably likely to occur due to short time at this step in separate, chilled room | | |
| | Food Allergens | Yes | Salmon is a food allergen | Finished product label applied at pack and label step will identify fish market name (salmon). | No |
| | Food Additives | No | No additives are used | | |
| | Metal Inclusion | No | Not reasonably likely to occur at this step | | |
| Cut Rolls | Parasites | No | Controlled by supplier with freezing | | |
| | Pathogenic bacteria growth – temperature abuse | No | Not reasonably likely to occur due to short time at this step in separate, chilled room | | |
| | Food Allergens | Yes | Salmon is a food allergen | Finished product label applied at pack and label step will identify fish market name (salmon). | No |
| | Food Additives | No | No additives are used | | |
| | Metal Inclusion | No | Not reasonably likely to occur at this step (using special cutting blades) | | |

| (1) Processing Step | (2) List all potential food safety hazards that could be associated with this product and process. | (3) Is the potential food safety hazard significant (introduced, enhanced or eliminated) at this step? (Yes or No) | (4) Justify the decision that you made in column 3 | (5) What control measure(s) can be applied to prevent this significant hazard? | (6) Is this step a Critical Control Point? (Yes or No) |
|--|---|---|---|--|---|
| Pack and Label | Parasites | No | Controlled by supplier with freezing | | |
| | Pathogenic bacteria growth – temperature abuse | No | Not reasonably likely to occur due to short time at this step in separate, chilled room | | |
| | Food Allergens | Yes | Salmon is a food allergen | Finished product label applied at pack and label step will identify fish market name (salmon). | Yes |
| | Food Additives | No | No additives are used | | |
| | Metal Inclusion | No | Not reasonably likely to occur at this step | | |
| Finished product refrigerated storage | Parasites | No | Controlled by supplier with freezing | | |
| | Pathogenic bacteria growth – temperature abuse | Yes | Pathogens can grow in storage if rolls exposed to temperature abuse conditions | Time and temperature controls | Yes |
| | Food Allergens | No | Undeclared allergens not reasonably likely to occur; already controlled at the pack and label step. | | |
| | Food Additives | No | No additives are used | | |
| | Metal Inclusion | No | Not reasonably likely to occur at this step | | |

Wild Salmon Sushi Rolls Process Flow Chart

Shaded steps are critical control points



HACCP Plan Form

| | |
|--|---|
| Firm Name <i>ABC Sushi Rolls Company</i> | Product Description <i>Salmon sushi rolls in oxygen permeable packaging</i> |
| Firm Location <i>Anywhere USA</i> | Method of Storage & Distribution <i>Refrigerated below 40°F/4.4°C</i> |
| | Intended Use & Consumer <i>Ready-to-eat product, to be consumed by the general public without further cooking</i> |

| | |
|---|--|
| Critical Control Point (CCP) | CCP 1: RICE ACIDIFICATION |
| Significant Hazard(s) | Pathogenic bacteria growth – temperature abuse. (<i>Bacillus cereus</i>) |
| Critical Limits for each Control Measure | Equilibration time of acidification is 30 minutes or more. pH of rice is 4.3 or less |
| Monitoring | What Time of acidification and pH of rice |
| | How Clock and pH meter |
| | When Each batch |
| | Who Quality Control person |
| Corrective Action | <p>If the equilibration time is not met, then the rice will be on hold until it reaches the 30 minute timeframe. Evaluate production procedures to prevent future recurrences. Retrain staff.</p> <p>If the pH is not 4.3 or less; then add more vinegar and re-check the pH; allow full equilibration time.</p> <p>Evaluate rice acidification formula to prevent future recurrences. Retrain involved staff.</p> |
| Verification | <p>Daily review of monitoring and corrective action records; Prior accuracy check for pH meter standardized per batch, and pH meter calibration as required by manufacturer.</p> <p>Study on file that validates the equilibration time to yield a stable pH of less than or equal to 4.3</p> |
| Records | Acidification record; Corrective Actions and pH meter calibration and accuracy log; training record. |

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| Signature: | Date: |
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HACCP Plan Form

| | |
|--|--|
| Firm Name <i>ABC Sushi Rolls Company</i> | Product Description <i>Salmon sushi rolls in oxygen permeable packaging</i> |
| Firm Location <i>Anywhere USA</i> | Method of Storage & Distribution <i>Refrigerated below 40°F/4.4°C</i> |
| | Intended Use & Consumer <i>Ready-to-eat product, to be consumed by the general public without further cooking</i> |

| | |
|---|--|
| Critical Control Point (CCP) | CCP 2: PACK AND LABEL |
| Significant Hazard(s) | Food Allergens |
| Critical Limits for each Control Measure | Labels on finished product packages include the market name “salmon” in the ingredient list. |
| Monitoring | What Finished product labels |
| | How Visual checks of ingredient list on finished product label |
| | When Representative sample of finished product containers from each lot. |
| | Who Packing Supervisor |
| Corrective Action | If the label does not have salmon in the ingredient list Then segregate and re-label incorrectly labeled product Review and modify label procedures as necessary. Retrain involved staff. |
| Verification | Daily review of monitoring and corrective action records for time sensitive product |
| Records | Pack room report; Corrective Actions; training records. |

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|-------------------|--------------|
| Signature: | Date: |
|-------------------|--------------|

HACCP Plan Form

| | |
|--|--|
| Firm Name <i>ABC Sushi Rolls Company</i> | Product Description <i>Salmon sushi rolls in oxygen permeable packaging</i> |
| Firm Location <i>Anywhere USA</i> | Method of Storage & Distribution <i>Refrigerated below 40°F/4.4°C</i> |
| | Intended Use & Consumer <i>Ready-to-eat product, to be consumed by the general public without further cooking</i> |

| | |
|---|---|
| Critical Control Point (CCP) | CCP 3: FINISHED PRODUCT REFRIGERATED STORAGE |
| Significant Hazard(s) | Pathogenic bacteria growth – temperature abuse |
| Critical Limits for each Control Measure | Cooler at 40°F/4.4°C or below |
| Monitoring | What Cooler temperature |
| | How Continuous time and temperature recorder |
| | When Continuous with visual checks at least once per day |
| | Who Shift Supervisor |
| Corrective Action | <p>If cooler temperature is above 40°F/4.4°C, then move product to another cooler or ice and hold for evaluation for exposure. Adjust or repair cooler as necessary. Evaluate product safety by determining cumulative exposure temperature and time above 40°F/4.4°C.</p> <p>Destroy if necessary. Retrain involved staff.</p> |
| Verification | <p>Weekly review of monitoring and corrective action records.</p> <p>Calibrate temperature recorder once per year</p> <p>Check accuracy of time temperature recorder daily.</p> |
| Records | Cooler temperature log and time temperature recording chart; Corrective Actions; training records |

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|-------------------|--------------|
| Signature: | Date: |
|-------------------|--------------|

HACCP Plan Form (*landscape format*)

| | |
|--|---|
| Firm Name <i>ABC Sushi Rolls Company</i> | Product Description <i>Salmon sushi rolls in oxygen permeable packaging</i> |
| Firm Location <i>Anywhere USA</i> | Method of Storage & Distribution <i>Refrigerated below 40°F/4.4°C</i> |
| | Intended Use & Consumer <i>Ready-to-eat product, to be consumed by the general public without further cooking</i> |

| Critical Control Point (CCP) | Significant Hazard(s) | Critical Limits for each Control Measure | Monitoring | | | | Corrective Action | Verification | Records |
|------------------------------|---|--|--------------------------------------|--|---|------------------------|--|---|--|
| | | | What | How | When | Who | | | |
| Rice Acidification | Pathogenic bacteria growth – temperature abuse. (Bacillus cereus) | Equilibration time of acidification is 30 minutes or more. pH of rice is 4.3 or less | Time of acidification and pH of rice | Clock and pH meter | Each batch | Quality Control person | <p>If the equilibration time is not met, then the rice will be on hold until it reaches the 30 minute timeframe. Evaluate production procedures to prevent future recurrences. Retrain staff.</p> <p>If the pH is not 4.3 or less; then add more vinegar and re-check the pH; allow full equilibration time.</p> <p>Evaluate rice acidification formula to prevent future recurrences. Retrain involved staff.</p> | <p>Daily review of monitoring and corrective action records; Prior accuracy check for pH meter standardized per batch, and pH meter calibration as required by manufacturer.</p> <p>Study on file that validates the equilibration time to yield a stable pH of less than or equal to 4.3</p> | Acidification record; Corrective Actions and pH meter calibration and accuracy log; training record. |
| Pack and Label | Food Allergens | Labels on finished product packages include the market name “salmon” in the ingredient list. | Finished product labels | Visual checks of ingredient list on finished product label | Representative sample of finished product containers from each lot. | Packing supervisor | <p>If the label does not have salmon in the ingredient list Then segregate and re-label incorrectly labeled product</p> <p>Review and modify label procedures as necessary. Retrain involved staff.</p> | Daily review of monitoring and corrective action records. | Pack room report; Corrective Actions; training records. |

| Critical Control Point (CCP) | Significant Hazard(s) | Critical Limits for each Control Measure | Monitoring | | | | Corrective Action | Verification | Records |
|---------------------------------------|--|--|--------------------|--|---|------------------|--|---|---|
| | | | What | How | When | Who | | | |
| Finished Product Refrigerated Storage | Pathogenic bacteria growth – temperature abuse | Cooler at 40°F/4.4°C or below | Cooler temperature | Continuous time and temperature recorder | Continuous with visual checks at least once per day | Shift Supervisor | <p>If cooler temperature is above 40°F/4.4°C, then move product to another cooler or ice and hold for evaluation for exposure. Adjust or repair cooler as necessary. Evaluate product safety by determining cumulative exposure temperature and time above 40°F/4.4°C.</p> <p>Destroy if necessary. Retrain involved staff.</p> | <p>Weekly review of monitoring and corrective action records.</p> <p>Calibrate temperature recorder once per year</p> <p>Check accuracy of time temperature recorder daily.</p> | Cooler temperature log and time temperature recording chart; Corrective Actions; training records |

| | |
|-------------------|--------------|
| Signature: | Date: |
|-------------------|--------------|