

CODE OF HYGIENIC PRACTICE FOR FRESH FRUITS AND VEGETABLES

Content

CODE OF HYGIENIC PRACTICE FOR FRESH FRUITS AND VEGETABLES	1
INTRODUCTION	2
1. OBJECTIVES OF THE CODE	2
2. SCOPE, USE AND DEFINITIONS	3
2.1 SCOPE	3
2.2 USE	3
2.3 DEFINITIONS	3
3. PRIMARY PRODUCTION.....	4
3.1 ENVIRONMENTAL HYGIENE	5
3.2 HYGIENIC PRIMARY PRODUCTION OF FRESH FRUITS AND VEGETABLES	5
3.2.1 <i>Agricultural input requirements</i>	5
3.2.2 <i>Indoor facilities associated with growing and harvesting</i>	8
3.2.3 <i>Personnel health, hygiene and sanitary facilities</i>	8
3.2.4 <i>Equipment associated with growing and harvesting</i>	9
3.3 HANDLING, STORAGE AND TRANSPORT.....	10
3.3.1 <i>Prevention of cross-contamination</i>	10
3.3.2 <i>Storage and transport from the field to the packing facility</i>	10
3.4 CLEANING, MAINTENANCE AND SANITATION	10
3.4.1 <i>Cleaning programs</i>	11
3.4.2 <i>Cleaning procedures and methods</i>	11
3.4.3 <i>Pest control systems</i>	11
3.4.4 <i>Waste management</i>	11
4. PACKING ESTABLISHMENT: DESIGN AND FACILITIES.....	11
5. CONTROL OF OPERATION	11
5.1 CONTROL OF FOOD HAZARDS.....	11
5.2 KEY ASPECTS OF HYGIENE CONTROL SYSTEMS	11
5.2.1 <i>Time and temperature control</i>	11
5.2.2 <i>Specific process steps</i>	11
5.2.3 <i>Microbiological and other specifications</i>	12
5.2.4 <i>Microbial cross-contamination</i>	12
5.2.5 <i>Physical and chemical contamination</i>	13
5.3 INCOMING MATERIAL REQUIREMENTS	13
5.4 PACKING.....	13
5.5 WATER USED IN THE PACKING ESTABLISHMENT	13
5.6 MANAGEMENT AND SUPERVISION.....	13
5.7 DOCUMENTATION AND RECORDS	13
5.8 RECALL PROCEDURES	13
6. PACKING ESTABLISHMENT: MAINTENANCE AND SANITATION	13
7. PACKING ESTABLISHMENT: PERSONAL HYGIENE	13
8. TRANSPORTATION	14
9. PRODUCT INFORMATION AND CONSUMER AWARENESS.....	14
10. TRAINING	14
10.1 AWARENESS AND RESPONSIBILITIES	14
10.2 TRAINING PROGRAMMES	14
ANNEX I	16
ANNEX FOR READY-TO-EAT FRESH PRE-CUT FRUITS AND VEGETABLES	16
INTRODUCTION	16
1. OBJECTIVE	16
2. SCOPE, USE AND DEFINITIONS	16
2.1 SCOPE	16
2.2 USE.....	17
2.3 DEFINITIONS	17
3. PRIMARY PRODUCTION.....	17
4. ESTABLISHMENT: DESIGN AND FACILITIES	17

4.4	FACILITIES	17
4.4.2	<i>Drainage and Waste Disposal</i>	17
5.	CONTROL OF OPERATIONS	17
5.1	CONTROL OF FOOD HAZARDS	17
5.2	KEY ASPECTS OF CONTROL SYSTEMS	17
5.2.2	<i>Specific Process Steps</i>	17
5.7	DOCUMENTATION AND RECORDS	18
5.8	RECALL PROCEDURES	19
6.	ESTABLISHMENT: MAINTENANCE AND SANITATION	19
7.	ESTABLISHMENT: PERSONAL HYGIENE	19
8.	TRANSPORTATION	19
9.	PRODUCT INFORMATION AND CONSUMER AWARENESS	19
10.	TRAINING	19
10.2	TRAINING PROGRAMS	19
	ANNEX II	20
	ANNEX FOR SPROUT PRODUCTION	20
	INTRODUCTION	20
1.	OBJECTIVES	20
2.	SCOPE, USE AND DEFINITION	20
2.1	SCOPE	20
2.2	USE	20
2.3	DEFINITIONS	20
3.	PRIMARY PRODUCTION OF SEEDS	21
3.2	HYGIENIC PRODUCTION OF SEEDS	21
3.2.4	<i>Equipment associated with growing and harvesting</i>	21
3.3	HANDLING, STORAGE AND TRANSPORT	21
3.4	ANALYSES	21
3.5	RECALL PROCEDURES	22
4.	ESTABLISHMENT FOR SPROUT PRODUCTION	22
4.2.1	<i>Design and layout</i>	22
5.	CONTROL OF OPERATION	22
5.2.2	<i>Specific process steps in sprout production</i>	22
5.2.3	<i>Microbiological and other specifications</i>	24
5.2.4	<i>Microbiological cross-contamination</i>	24
5.3	INCOMING MATERIAL REQUIREMENTS	25
5.3.1	<i>Specifications for incoming seeds</i>	25
5.3.2	<i>Control of incoming seeds</i>	25
5.3.3	<i>Seed storage</i>	25
5.7	DOCUMENTATION AND RECORDS	25
6.	ESTABLISHMENT: MAINTENANCE AND SANITATION	26
7.	ESTABLISHMENT: PERSONAL HYGIENE	26
8.	TRANSPORTATION	26
9.	PRODUCT INFORMATION AND CONSUMER AWARENESS	26
10.	TRAINING	26
10.1	AWARENESS AND RESPONSIBILITIES	26

INTRODUCTION

Scientific research over the last decades has shown that a diet rich in fruits and vegetables is protective against many cancers and lowers the occurrence of coronary heart disease. This recognition of the importance of routine consumption of fresh fruits and vegetables, together with a marked increase in the year-round availability of fresh fruits and vegetables from a global market, has contributed to the substantial increase in consumption of fresh fruits and vegetables over the past two decades. However, the recent increase in reports of food borne illness associated with fresh fruits and vegetables has raised concerns from public health agencies and consumers about the safety of these products.

1. OBJECTIVES OF THE CODE

This code addresses Good Agricultural Practices (GAPs) and Good Manufacturing Practices (GMPs) that will help control microbial, chemical and physical hazards associated with all stages of the

production of fresh fruits and vegetables from primary production to packing. Particular attention is given to minimizing microbial hazards. The code provides a general framework of recommendations to allow uniform adoption by this sector rather than providing detailed recommendations for specific agricultural practices, operations or commodities. The fresh fruit and vegetable industry is very complex. Fresh fruits and vegetables are produced and packed under diverse environmental conditions. It is recognized that some of the provisions in this code may be difficult to implement in areas where primary production is conducted in small holdings, in both developed and developing countries and also in areas where traditional farming is practised. Therefore, the code is, of necessity, a flexible one to allow for different systems of control and prevention of contamination for different groups of commodities.

2. SCOPE, USE AND DEFINITIONS

2.1 SCOPE

This code of practice covers general hygienic practices for the primary production and packing of fresh fruits and vegetables cultivated for human consumption in order to produce a safe and wholesome product: particularly for those intended to be consumed raw. Specifically, this code is applicable to fresh fruits and vegetables grown in the field (with or without cover) or in protected facilities (hydroponic systems, greenhouses). It concentrates on microbial hazards and addresses physical and chemical hazards only in so far as these relate to GAPs and GMPs.

The *Annex for Ready-to-eat Fresh Pre-cut Fruits and Vegetables* (Annex I) and the *Annex for Sprout Production* (Annex II) are supplements to this code and include additional recommendations to cover, respectively, the hygienic practices for the processing of ready-to-eat fresh pre-cut fruits and vegetables, and the hygienic practices that are specific for the primary production of seeds for sprouting and the production of sprouts for human consumption.

The code does not provide recommendations for handling practices to maintain the safety of fresh fruits and vegetables at wholesale, retail, food services or in the home. It excludes food products for which there is a specific Codex Alimentarius Code of Hygienic Practices.

2.2 USE

This code follows the format of the Codex *Recommended International Code of Practice - General Principles of Food Hygiene*- CAC/RCP 1-1969, Rev 3 (1997) and should be used in conjunction with it. This code focuses upon hygienic issues that are specific to the primary production and packing of fresh fruits and vegetables. The major issues are covered in Section 3. In other sections, the *General Principles of Food Hygiene* have been expanded where there are issues specific to primary production and packing. The *Annex for Ready-to-Eat Fresh Pre-Cut Fruits and Vegetables* provides additional recommendations specific for the processing of ready-to-eat fresh pre-cut fruits and vegetables and the *Annex for Sprout Production* provides additional recommendations specific for the primary production of seeds for sprouting and the production of sprouts for human consumption.

2.3 DEFINITIONS

Definitions of general expressions are included in the General Principles of Food Hygiene. For the purpose of this code, the following terms have the definition stated:

Agricultural inputs - any incoming material (e.g. seeds, fertilizers, water, agricultural chemicals, plant support, etc.) used for the primary production of fresh fruits and vegetables.

Agricultural worker - any person that undertakes one or more of the following: cultivation, harvesting and packing of fresh fruits and vegetables.

Antimicrobial agents - any substance of natural, synthetic or semi-synthetic origin which at low concentrations kills or inhibits the growth of microorganisms but causes little or no host damage.

Biological control - the use of competing biologicals (such as insects, microorganisms and/or microbial metabolites) for the control of mites, pests, plant pathogens and spoilage organisms.

Biosolids - Sludge and other residue deposits obtained from sewage treatment plants and from treatment applied to urban and industrial wastes (food industries or other types of industry).

Composting - a managed process in which organic materials are digested aerobically or anaerobically by microbial action.

Cultivation- any agricultural action or practise used by growers to allow and improve the growing conditions of fresh fruits or vegetables grown in the field (with or without cover) or in protected facilities (hydroponic systems, greenhouses).

Farm - any premise or establishment in which fresh fruits and/or vegetables are grown and harvested and the surroundings under the control of the same management.

Grower - the person responsible for the management of the primary production of fresh fruits and vegetables.

Harvester - the person responsible for the management of the harvesting of fresh fruits and vegetables.

Hazard – a biological, chemical or physical agent in, or condition of, food with the potential to cause an adverse health effect.

Hazardous material - any compound which, at specific levels, has the potential to cause adverse health effects. **Hydroponics** - a general term for the production of plants without soil in a water medium.

Manure - Animal excrement which may be mixed with litter or other material, and which may be fermented or otherwise treated.

Microorganisms -include yeasts, moulds, bacteria, viruses and parasites. When used as an adjective, the term "microbial" is used.

Packer - the person responsible for the management of post-harvest processing and packing of fresh fruits and vegetables.

Packing -the action of putting fresh fruits and vegetables in a package. This may take place in a field or in an establishment.

Packing establishment - any indoor establishment in which fresh fruits and vegetables receive post-harvest treatment and are packaged.

Primary production - those steps involved in the growing and harvesting of fresh fruits and vegetables such as planting, irrigation, application of fertilizers, application of agricultural chemicals, etc.

Types of Water:

Clean water - water that does not compromise food safety in the circumstances of its use.

Potable water - water which meets the quality standards of drinking water such as described in the WHO Guidelines for Drinking Water Quality.

3. PRIMARY PRODUCTION

Fresh fruits and vegetables are grown and harvested under a wide range of climatic and diverse geographical conditions, using various agricultural inputs and technologies, and on farms of varying sizes. Biological, chemical and physical hazards may therefore vary significantly from one type of production to another. In each primary production area, it is necessary to consider the particular agricultural practices that promote the production of safe fresh fruits and vegetables, taking into account the conditions specific to the primary production area, type of products, and methods used. Procedures associated with primary production should be conducted under good hygienic conditions and should minimize potential hazards to health due to the contamination of fresh fruits and vegetables.

3.1 ENVIRONMENTAL HYGIENE

Where possible, potential sources of contamination from the environment should be identified. In particular, primary production should not be carried out in areas where the presence of potentially harmful substances would lead to an unacceptable level of such substances in or on fresh fruits and vegetables after harvest.

Where possible, growers should evaluate the previous uses of the sites (indoor and outdoor) as well as adjoining sites in order to identify potential microbial, chemical and physical hazards. The potential for other types of contamination (e.g., from agricultural chemicals, hazardous wastes, etc.) should also be considered. The evaluation process should include the following:

- Previous and present usage of the primary production area and the adjoining sites (e.g. crop grown, feed lot, animal production, hazardous waste site, sewage treatment site, mining extraction site) to identify potential microbial hazards including faecal contamination and contamination by organic waste and potential environmental hazards that could be carried to the growing site.
- The access of farm and wild animals to the site and to water sources used in primary production to identify potential faecal contamination of the soils and water and the likelihood of contaminating crop. Existing practices should be reviewed to assess the prevalence and likelihood of uncontrolled deposits of animal faeces coming into contact with crops. Considering this potential source of contamination, efforts should be made to protect fresh produce growing areas from animals. As far as possible, domestic and wild animal should be excluded from the area.
- Potential for contaminating produce fields from leaking, leaching or overflowing manure storage sites and flooding from polluted surface waters.

If previous uses cannot be identified, or the examination of the growing or adjoining sites leads to the conclusion that potential hazards exist, the sites should be analysed for contaminants of concern. If the contaminants are at excessive levels and corrective or preventative actions have not been taken to minimize potential hazards, the sites should not be used until correction/control measures are applied.

3.2 HYGIENIC PRIMARY PRODUCTION OF FRESH FRUITS AND VEGETABLES

3.2.1 Agricultural input requirements

Agricultural inputs should not contain microbial or chemical contaminants (as defined under the Recommended International Code of Practice – General Principles of Food Hygiene (CAC/RCP 1-1969, Rev 3 (1997) at levels that may adversely affect the safety of fresh fruits and vegetables and taking into consideration the WHO guidelines on the safe use of wastewater and excreta in agriculture and aquaculture as appropriate.

3.2.1.1 *Water for primary production*

- Growers should identify the sources of water used on the farm (municipality, re-used irrigation water, well, open canal, reservoir, rivers, lakes, farm ponds etc.). They should assess its microbial and chemical quality, and its suitability for intended use, and identify corrective actions to prevent or minimize contamination (e.g. from livestock, sewage treatment, human habitation).
- Where necessary, growers should have the water they use tested for microbial and chemical contaminants. The frequency of testing will depend on the water source and the risks of environmental contamination including intermittent or temporary contamination (e.g. heavy rain, flooding, etc.). If the water source is found to be contaminated corrective actions should be taken to ensure that the water is suitable for its intended use.

3.2.1.1.1 Water for irrigation and harvesting

Water used for agricultural purposes should be of suitable quality for its intended use. Special attention to water quality should be considered for the following situations:

- Irrigation by water delivery techniques that expose the edible portion of fresh fruits and vegetables directly to water (e.g. sprayers) especially close to harvest time.
- Irrigation of fruits and vegetables that have physical characteristics such as leaves and rough surfaces which can trap water.
- Irrigation of fruits and vegetables that will receive little or no post-harvest wash treatments prior to packing, such as field-packed produce.

3.2.1.1.2 Water for fertilizers, pest control and other agricultural chemicals

Water used for the application of water-soluble fertilizers and agricultural chemicals in the field and indoors should not contain microbial contaminants at levels that may adversely affect the safety of fresh fruits and vegetables. Special attention to the water quality should be considered when using fertilizer and agricultural chemical delivery techniques (e.g. sprayers) that expose the edible portion of fresh fruits and vegetables directly to water especially close to harvest time.

3.2.1.1.3 Hydroponic water

Plants grown in hydroponic systems absorb nutrients and water at varying rates, constantly changing the composition of the re-circulated nutrient solution. Because of this:

- Water used in hydroponic culture should be changed frequently, or if recycled, should be treated to minimize microbial and chemical contamination.
- Water delivery systems should be maintained and cleaned, as appropriate, to prevent microbial contamination of water.

3.2.1.2 Manure, biosolids and other natural fertilizers

The use of manure, biosolids and other natural fertilizers in the production of fresh fruits and vegetables should be managed to limit the potential for microbial, chemical and physical contamination. Manure, biosolids and other natural fertilizers contaminated with heavy metals or other chemicals at levels that may affect the safety of fresh fruits and vegetables should not be used. Where necessary, in order to minimize microbial contamination the following practices should be considered:

- Adopt proper treatment procedures (e.g. composting, pasteurization, heat drying, UV irradiation, alkali digestion, sun drying or combinations of these) that are designed to reduce or eliminate pathogens in manure, biosolids and other natural fertilizers. The level of pathogen reduction achieved by different treatments should be taken into account when considering suitability for different applications.
- Manure, biosolids and other natural fertilizers which are untreated or partially treated may be used only if appropriate corrective actions are being adopted to reduce microbial contaminants such as maximizing the time between application and harvest of fresh fruits and vegetables.
- Growers who are purchasing manure, biosolids and other natural fertilizers that have been treated to reduce microbial or chemical contaminants, should, where possible, obtain documentation from the supplier that identifies the origin, treatment used, tests performed and the results thereof.
- Minimize direct or indirect contact between manure, biosolids and other natural fertilizers, and fresh fruits and vegetables, especially close to harvest.
- Minimize contamination by manure, biosolids and other natural fertilizers from adjoining fields. If the potential for contamination from the adjoining fields is identified, preventative

actions (e.g. care during application and run-off controls) should be implemented to minimize the risk.

- Avoid locating treatment or storage sites in proximity to fresh fruit and vegetable production areas. Prevent cross-contamination from runoff or leaching by securing areas where manure, biosolids and other natural fertilizers are treated and stored.

3.2.1.3 Soil

Soils should be evaluated for hazards. If the evaluation concludes that such hazards are at levels that may compromise the safety of crops, control measures should be implemented to reduce hazards to acceptable levels. If this cannot be achieved by available control measures, growers should not use these soils for primary production.

3.2.1.4 Agricultural chemicals

- Growers should use only agricultural chemicals which are authorized for the cultivation of the specific fruit or vegetable and should use them according to the manufacturer's instructions for the intended purpose. Residues should not exceed levels as established by the Codex Alimentarius Commission.
- In order to minimize and contain the emergence of microbial resistance:
- the use of antimicrobial agents significant to human and animal therapy should be avoided.
- Antimicrobial agents not significant to human and animal therapy should be used only when unavoidable and in accordance with good agricultural practices and in a manner that achieves this objective.
- Agricultural workers who apply agricultural chemicals should be trained in proper application procedures.
- Growers should keep records of agricultural chemical applications. Records should include information on the date of application, the chemical used, the crop sprayed, the pest or disease against which it was used, the concentration, method and frequency of application, and records on harvesting to verify that the time between application and harvesting is appropriate.
- Agricultural chemical sprayers should be calibrated, as necessary, to control the accuracy of the rate of application.
- The mixing of agricultural chemicals should be carried out in such a way as to avoid contamination of water and land in the surrounding areas and to protect employees involved in this activity from potential hazards.
- Sprayers and mixing containers should be thoroughly washed after use, especially when used with different agricultural chemicals on different crops, to avoid contaminating fruits and vegetables.
- Agricultural chemicals should be kept in their original containers, labelled with the name of the chemical and the instructions for application. Agricultural chemicals should be stored in a safe, well ventilated place, away from production areas, living areas and harvested fruits or vegetables, and disposed of in a manner that does not pose a risk of contaminating crops, the inhabitants of the area, or the environment of the primary production.
- Empty containers should be disposed of as indicated by the manufacturer. They should not be used for other food-related purposes.

3.2.1.5 Biological control

Environmental and consumer safety should be considered when using competing biological organisms and/or their metabolites applied for the control of pests, mites, plant pathogens and spoilage organisms in fresh fruits and vegetables.

Growers should use only biological controls which are authorized for the cultivation of the specific fruit or vegetable and should use them according to the manufacturer's instructions for the intended purpose.

3.2.2 Indoor facilities associated with growing and harvesting

For operations where fresh fruits and vegetables are grown indoors (greenhouses, hydroponic culture, etc.) suitable premises should be used.

3.2.2.1 Location, design and layout

- Premises and structures should be located, designed and constructed to avoid contaminating fresh fruits and vegetables and harboring pests such as insects, rodents and birds.
- Where appropriate, the internal design and layout should permit compliance with good hygienic practices for the primary production of fresh fruits and vegetables indoors, including protection against cross-contamination between and during operations. Each establishment should be evaluated individually in order to identify specific hygienic requirements for each product.

3.2.2.2 Water supply

Where appropriate an adequate supply of potable or clean water with appropriate facilities for its storage and distribution should be available in indoor primary production facilities. Non-potable water should have a separate system. Non-potable water systems should be identified and should not connect with, or allow reflux into, potable water systems.

- Avoid contaminating potable and clean water supplies by exposure to agricultural inputs used for growing fresh produce.
- Clean and disinfect potable and clean water storage facilities on a regular basis.
- Control the quality of the water supply.

3.2.2.3 Drainage and waste disposal

Adequate drainage and waste disposal systems and facilities should be provided. These systems should be designed and constructed so that the potential for contamination of fresh fruits and vegetables, agricultural inputs or the potable water supply is avoided.

3.2.3 Personnel health, hygiene and sanitary facilities

Hygiene and health requirements should be followed to ensure that personnel who come directly into contact with fresh fruits and vegetables during or after harvesting are not likely to contaminate them. Visitors should, where appropriate, wear protective clothing and adhere to the other personal hygiene provisions in this section.

3.2.3.1 Personnel hygiene and sanitary facilities

Hygienic and sanitary facilities should be available to ensure that an appropriate degree of personal hygiene can be maintained. As far as possible, such facilities should:

- Be located in close proximity to the fields and indoor premises, and in sufficient number to accommodate personnel.
- Be of appropriate design to ensure hygienic removal of wastes and avoid contamination of growing sites, fresh fruits and vegetables or agricultural inputs.

- Have adequate means of hygienically washing and drying hands.
- Be maintained under sanitary conditions and good repair.

3.2.3.2 Health status

People known, or suspected, to be suffering from, or to be a carrier of a disease or illness likely to be transmitted through fresh fruits and vegetables, should not be allowed to enter any food handling area if there is a likelihood of their contaminating fresh fruits and vegetables. Any person so affected should immediately report illness or symptoms of illness to the management.

3.2.3.3 Personal cleanliness

Agricultural workers who have direct contact with fresh fruits and vegetables should maintain a high degree of personal cleanliness and, where appropriate, wear suitable protective clothing and footwear. Cuts and wounds should be covered by suitable waterproof dressings when personnel are permitted to continue working.

Personnel should wash their hands when handling fresh fruits and vegetables or other material that comes in contact with them. Personnel should wash their hands before starting work involving the handling of fruits and vegetables, each time they return to handling areas after a break, immediately after using the toilet or after handling any contaminated material where this could result in contamination of fresh fruits and vegetables.

3.2.3.4 Personal behaviour

Agricultural workers should refrain from behaviour which could result in the contamination of food, for example: smoking, spitting, chewing gum or eating, or sneezing or coughing over unprotected fresh fruits and vegetables.

Personal effects such as jewellery, watches, or other items should not be worn or brought into fresh fruit and vegetable production areas if they pose a threat to the safety and suitability of the food.

3.2.4 Equipment associated with growing and harvesting

As required, growers and harvesters should follow the technical specifications recommended by the equipment manufacturers for their proper usage and maintenance. Growers and harvesters should adopt the following sanitary practices:

- Equipment and containers coming into contact with fresh fruits and vegetables should be made of materials that are non-toxic. They should be designed and constructed to ensure that, when necessary, they can be cleaned, disinfected and maintained to avoid the contamination of fresh fruit and vegetables. Specific hygienic and maintenance requirements should be identified for each piece of equipment that is used and the type of fruit or vegetable associated with it.
- Containers for waste, by-products and inedible or dangerous substances, should be specifically identifiable, suitably constructed and, where appropriate, made of impervious material. Where appropriate, such containers should be lockable to prevent malicious or accidental contamination of fresh fruits and vegetables or agricultural inputs. Such containers should be segregated or otherwise identified to prevent their use as harvesting containers.
- Containers that can no longer be kept in a hygienic condition should be discarded.
- Equipment and tools should function according to the use for which they are designed without damaging the produce. Such equipment should be maintained in good order.

3.3 HANDLING, STORAGE AND TRANSPORT

3.3.1 Prevention of cross-contamination

During the primary production and post-harvest activities, effective measures should be taken to prevent cross-contamination of fresh fruits and vegetables from agricultural inputs or personnel who come directly or indirectly into contact with fresh fruits and vegetables. To prevent the potential of cross-contaminating fresh fruits and vegetables, growers, harvesters and their employees should adhere to the recommendations presented elsewhere in section 3 of this code and the following:

- At the time of harvest, consideration should be given to the need for additional management action where any local factor, for example adverse weather conditions, may increase the opportunity for contamination of the crop.
- Fresh fruits and vegetables unfit for human consumption should be segregated during harvesting. Those which cannot be made safe by further processing should be disposed of properly to avoid contamination of fresh fruits and vegetables or agricultural inputs.
- Agricultural workers should not use harvesting containers for carrying materials (e.g. lunches, tools, fuel, etc.) other than harvested fruits and vegetables.
- Equipment and containers previously used for potentially hazardous materials (e.g. garbage, manure, etc.) should not be used for holding fresh fruits or vegetables or have contact with packaging material that is used for fresh fruits and vegetables without adequate cleaning and disinfecting.
- Care must be taken when packing fresh fruits and vegetables in the field to avoid contaminating containers or bins by exposure to , manure or animal/human faeces.

3.3.2 Storage and transport from the field to the packing facility

Fresh fruits and vegetables should be stored and transported under conditions which will minimize the potential for microbial, chemical or physical contamination. The following practices should be adopted:

- Storage facilities and vehicles for transporting the harvested crops should be built in a manner to minimize damage to fresh fruits and vegetables and to avoid access by pests. They should be made of non-toxic materials that permit easy and thorough cleaning. They should be constructed in a manner to reduce the opportunity for potential contamination from physical objects such as glass, wood, plastic, etc.
- Fresh fruits and vegetables unfit for human consumption should be segregated before storage or transport. Those which cannot be made safe by further processing should be disposed of properly to avoid contamination of fresh fruits and vegetables or agricultural inputs.
- Agricultural workers should remove as much soil as possible from fresh fruits and vegetables before they are stored or transported. Care should be taken to minimize physical damage to crop during this process.
- Transport vehicles should not be used for the transport of hazardous substances unless they are adequately cleaned, and where necessary disinfected, to avoid cross-contamination.

3.4 CLEANING, MAINTENANCE AND SANITATION

Premises and harvesting equipment should be kept in an appropriate state of repair and condition to facilitate cleaning and disinfection. Equipment should function as intended to prevent contamination of fresh fruits and vegetables. Cleaning materials and hazardous substances such as agricultural chemicals should be specifically identifiable and kept or stored separately in secure storage facilities. Cleaning materials and agricultural chemicals should be used according to manufacturer's instructions for their intended purpose.

3.4.1 Cleaning programs

Cleaning and disinfection programs should be in place to ensure that any necessary cleaning and maintenance is carried out effectively and appropriately. Cleaning and disinfection systems should be monitored for effectiveness and should be regularly reviewed and adapted to reflect changing circumstances. Specific recommendations are as follows:

- Harvesting equipment and re-usable containers that come in contact with fresh fruits and vegetables should be cleaned, and, where appropriate, disinfected on a regular basis.
- Harvesting equipment and re-usable containers used for fresh fruits and vegetables that are not washed prior to packing should be cleaned and disinfected as necessary.

3.4.2 Cleaning procedures and methods

The appropriate cleaning methods and materials will depend on the type of equipment and the nature of the fruit or vegetable. The following procedure should be adopted:

- Cleaning procedures should include the removal of debris from equipment surfaces, application of a detergent solution, rinsing with water, and, where appropriate, disinfection.

3.4.3 Pest control systems

When primary production is carried out in indoor establishments (e.g. greenhouses), the recommendations of the *General Principles of Food Hygiene*, section 6.3 should be followed with respect to pest control.

3.4.4 Waste management

Suitable provision must be made for the storage and removal of waste. Waste must not be allowed to accumulate in fresh fruit and vegetable handling and storage areas or the adjoining environment. Storage areas for waste should be kept clean.

4. PACKING ESTABLISHMENT: DESIGN AND FACILITIES

Refer to the General Principles of Food Hygiene.

5. CONTROL OF OPERATION

5.1 CONTROL OF FOOD HAZARDS

Refer to the General Principles of Food Hygiene.

5.2 KEY ASPECTS OF HYGIENE CONTROL SYSTEMS

5.2.1 Time and temperature control

Refer to the General Principles of Food Hygiene.

5.2.2 Specific process steps

5.2.2.1 Post-harvest water use

Water quality management will vary throughout all operations. Packers should follow GMPs to prevent or minimize the potential for the introduction or spread of pathogens in processing water. The quality of water used should be dependent on the stage of the operation. For example, clean water could be used for initial washing stages, whereas water used for final rinses should be of potable quality.

- Post-harvest systems that use water should be designed in a manner to minimize places where product lodges and dirt builds up.
- Antimicrobial agents should only be used where absolutely necessary to minimize cross-contamination during post-harvest and where their use is in line with good hygienic

practices. The antimicrobial agents levels should be monitored and controlled to ensure that they are maintained at effective concentrations. Application of antimicrobial agents , followed by a wash as necessary, should be done to ensure that chemical residues do not exceed levels as recommended by the Codex Alimentarius Commission.

- Where appropriate, the temperature of the post-harvest water should be controlled and monitored.
- Recycled water should be treated and maintained in conditions that do not constitute a risk to the safety of fresh fruits and vegetables. The treatment process should be effectively monitored and controlled.
- Recycled water may be used with no further treatment provided its use does not constitute a risk to the safety of fresh fruits and vegetables (e.g. use of water recovered from the final wash for the first wash).
- Ice should be made from potable water. Ice should be produced, handled and stored to protect it from contamination.

5.2.2.2 Chemical treatments

- Packers should only use chemicals for post-harvest treatments (e.g. waxes, fungicides) in accordance with the General Standards on Food Additives or with the Codex Pesticide Guidelines. These treatments should be carried out in accordance with the manufacturer's instructions for the intended purpose.
- Sprayers for post-harvest treatments should be calibrated regularly to control the accuracy of the rate of application. They should be thoroughly washed in safe areas when used with different chemicals and on different fruits or vegetables to avoid contaminating the produce.

5.2.2.3 Cooling of fresh fruits and vegetables

- Condensate and defrost water from evaporator type cooling systems (e.g. vacuum cooling, cold rooms) should not drip onto fresh fruits and vegetables. The inside of the cooling systems should be maintained clean.
- Potable water should be used in cooling systems where water or ice is in direct contact with fresh fruits and vegetables (e.g. hydro cooling, ice cooling). The water quality in these systems should be controlled and maintained.
- Forced-air cooling is the use of rapid movement of refrigerated air over fresh fruits and vegetables in cold rooms. Air cooling systems should be appropriately designed and maintained to avoid contaminating fresh produce.

5.2.2.4 Cold storage

- When appropriate, fresh fruits and vegetables should be maintained at low temperatures after cooling to minimize microbial growth. The temperature of the cold storage should be controlled and monitored.
- Condensate and defrost water from the cooling system in cold storage areas should not drip on to fresh fruits and vegetables. The inside of the cooling systems should be maintained in a clean and sanitary condition.

5.2.3 Microbiological and other specifications

Refer to the General Principles of Food Hygiene.

5.2.4 Microbial cross-contamination

Refer to the General Principles of Food Hygiene.

5.2.5 Physical and chemical contamination

Refer to the General Principles of Food Hygiene.

5.3 INCOMING MATERIAL REQUIREMENTS

Refer to the General Principles of Food Hygiene.

5.4 PACKING

Refer to the General Principles of Food Hygiene.

5.5 WATER USED IN THE PACKING ESTABLISHMENT

Refer to the General Principles of Food Hygiene.

5.6 MANAGEMENT AND SUPERVISION

Refer to the General Principles of Food Hygiene.

5.7 DOCUMENTATION AND RECORDS

Where appropriate, records of processing, production and distribution should be kept long enough to facilitate a recall and food borne illness investigation, if required. This period could be much longer than the shelf life of fresh fruits and vegetables. Documentation can enhance the credibility and effectiveness of the food safety control system.

- Growers should keep current all relevant information on agricultural activities such as the site of production, suppliers' information on agricultural inputs, lot numbers of agricultural inputs, irrigation practices, use of agricultural chemicals, water quality data, pest control and cleaning schedules for indoor establishments, premises, facilities, equipment and containers.
- Packers should keep current all information concerning each lot such as information on incoming materials (e.g. information from growers, lot numbers), data on the quality of processing water, pest control programmes, cooling and storage temperatures, chemicals used in post-harvest treatments, and cleaning schedules for premises, facilities, equipment and containers, etc.

5.8 RECALL PROCEDURES

Refer to the General Principles of Food Hygiene.

In addition, where appropriate:

- Growers and packers should have programs to ensure effective lot identification. These programs should be able to trace the sites and agricultural inputs involved in primary production and the origin of incoming material at the packing establishment in case of suspected contamination.
- Growers information should be linked with packers' information so that the system can trace products from the distributor to the field. Information that should be included are the date of harvest, farm identification, and, where possible, the persons who handled the fresh fruits or vegetables from the primary production site to the packing establishment.

6. PACKING ESTABLISHMENT: MAINTENANCE AND SANITATION

Refer to the General principles of Food Hygiene.

7. PACKING ESTABLISHMENT: PERSONAL HYGIENE

Refer to the General Principles of Food Hygiene.

8. TRANSPORTATION

Refer to the General Principles of Food Hygiene and to the Code of Hygienic Practice for the Transport of Food in Bulk and Semi-Packed Food.

9. PRODUCT INFORMATION AND CONSUMER AWARENESS

Refer to the General Principles of Food Hygiene.

10. TRAINING

Refer to the General Principles of Food Hygiene except for section 10.1 and 10.2.

10.1 AWARENESS AND RESPONSIBILITIES

Personnel associated with growing and harvesting should be aware of GAPs, good hygienic practices and their role and responsibility in protecting fresh fruits and vegetables from contamination or deterioration. Agricultural workers should have the necessary knowledge and skills to enable them to carry out agricultural activities and to handle fresh fruits and vegetables and agricultural inputs hygienically.

Personnel associated with packing should be aware of GMPs, good hygienic practices and their role and responsibility in protecting fresh fruits and vegetables from contamination or deterioration. Packers should have the necessary knowledge and skills to enable them to perform packing operations and to handle fresh fruits and vegetables in a way that minimizes the potential for microbial, chemical, or physical contamination.

All personnel who handle cleaning chemicals or other potentially hazardous chemicals should be instructed in safe handling techniques. They should be aware of their role and responsibility in protecting fresh fruit and vegetables from contamination during cleaning and maintenance.

10.2 TRAINING PROGRAMMES

Factors to take into account in assessing the level of training required in growing, harvesting and packing activities include:

- The nature of the fruit or vegetable, in particular its ability to sustain growth of pathogenic microorganisms.
- The agricultural techniques and the agricultural inputs used in the primary production including the probability of microbial, chemical and physical contamination.
- The task the employee is likely to perform and the hazards and controls associated with those tasks.
- The manner in which fresh fruits and vegetables are processed and packaged including the probability of contamination or microbial growth.
- The conditions under which fresh fruits and vegetables will be stored.
- The extent and nature of processing or further preparation by the consumer before final consumption.

Topics to be considered for training programmes include, but are not limited to, the following:

- The importance of good health and hygiene for personal health and food safety.
- The importance of hand washing for food safety and the importance of proper hand washing techniques.
- The importance of using sanitary facilities to reduce the potential for contaminating fields, produce, other workers, and water supplies.

- Techniques for hygienic handling and storage of fresh fruits and vegetables by transporters, distributors, storage handlers and consumer.

ANNEX I

ANNEX FOR READY-TO-EAT FRESH PRE-CUT FRUITS AND VEGETABLES

INTRODUCTION

The health benefits associated with fresh fruits and vegetables combined with the on-going consumer interest in the availability of a variety of ready-to-eat foods have contributed to a substantial increase in the popularity of pre-cut fruits and vegetables. Because of the increased convenience and consumption of pre-cut fruits and vegetables in and away from the home, the preparation of these products has moved from the point of consumption to the food processor or retailer. The processing of fresh produce without proper sanitation procedures in place in the manufacturing environment may enhance the potential for contamination by microbiological pathogens. The potential for pathogens to survive or grow may be enhanced by the high moisture and nutrient content of fresh-cut fruits and vegetables, the absence of a lethal process to eliminate them, and the potential for temperature abuse during processing, storage, transport, and retail display.

Some of the microbiological pathogens associated with fresh fruits and vegetables include *Salmonella* spp., *Shigella* spp., pathogenic strains of *Escherichia coli*, *Listeria monocytogenes*, Norwalk-like virus and hepatitis A virus and parasites such as *Cyclospora*. Some of these pathogens are associated with the agricultural environment, whereas others are associated with infected workers or contaminated water. Because of the ability for pathogens to survive and grow on fresh produce, it is important for the pre-cut industry to follow good hygienic practices to ensure the microbiological safety of its products.

1. OBJECTIVE

Hygienic recommendations for the primary production of fresh fruits and vegetables are covered under the *Code of Practice for Fresh Fruits and Vegetables*. This Annex recommends the application of Good Manufacturing Practices (GMPs) for all stages involved in the production of ready-to-eat fresh pre-cut fruits and vegetables, from receipt of raw materials to distribution of finished products.

The primary objective of this Annex is to identify GMPs that will help control microbiological, physical, and chemical hazards associated with the processing of fresh pre-cut fruits and vegetables. Particular attention is given to minimizing microbiological hazards. This Annex provides elements that should be taken into account in the production, processing and distribution of these foods.

2. SCOPE, USE AND DEFINITIONS**2.1 SCOPE**

This Annex specifically applies to ready-to-eat fresh fruit and vegetables that have been peeled, cut or otherwise physically altered from their original form but remain in the fresh state and particularly those that are intended to be consumed raw. This Annex applies irrespective of where the operations take place (e.g. in the field, at the farm, at the retailer, at the wholesaler, at the processing establishment, etc.).

For some establishments that process fresh pre-cut fruit and vegetables, this Annex will cover all operations from receipt of raw material to the distribution of the final product. For other establishments, (e.g. those that use ready-to-eat pre-cut fresh fruit and vegetables in combination with other products, such as sauces, meat, cheese, etc.) only the specific sections that relate to the processing of the fresh pre-cut fruit and vegetable components will apply.

This Annex does not directly apply to fresh fruit and vegetables that have been trimmed leaving the food intact. Nor does it apply to other fresh fruit and vegetables that are pre-cut but are destined for further processing that would be expected to eliminate any pathogen that may be present (e.g. cooking, juice processing, fermentation) nor to fresh fruit or vegetable juices. However, some of the basic principles of the Annex could still be applicable to such products.

Packaging includes single serving containers (e.g., sealed pouches or plastic trays), larger consumer or institutional size packages and bulk containers. This Annex concentrates on microbial hazards and addresses physical and chemical hazards only in so far as these relate to GMPs.

2.2 USE

This document follows the format of the Recommended International Code of Practice -- General Principles of Food Hygiene CAC/RCP 1-1969, Rev 3 (1997) and should be used in conjunction with the General Principles of Food Hygiene and the Code of Hygienic Practice for Fresh Fruits and Vegetables.

2.3 DEFINITIONS

Processor - the person responsible for the management of the activities associated with the production of ready-to-eat fresh pre-cut fruits and vegetables.

3. PRIMARY PRODUCTION

Refer to the Code of Hygienic Practice for Fresh Fruits and Vegetables.

4. ESTABLISHMENT: DESIGN AND FACILITIES

Refer to the General Principles of Food Hygiene. In addition:

4.4 FACILITIES

4.4.2 Drainage and Waste Disposal

The processing of products covered by this Annex generates a large quantity of waste that can serve as food and shelter for pests. It is therefore very important to plan an effective waste disposal system. This system should always be maintained in good condition so it does not become a source of product contamination.

5. CONTROL OF OPERATIONS

Refer to the Code of Hygienic Practice for Fresh Fruits and Vegetables. In addition:

5.1 CONTROL OF FOOD HAZARDS

For the products covered by this Annex it should be recognised that while processing may reduce the level of contamination initially present on the raw materials, it will not be able to guarantee elimination of such contamination. Consequently, the processor should ensure that steps are taken by their suppliers (growers, harvesters, packers and distributors) to minimise contamination of the raw materials during primary production. It is recommended that processors ensure that their suppliers have adopted the principles outlined in the *Code of Hygienic Practice for Fresh Fruits and Vegetables*.

There are certain pathogens, *Listeria monocytogenes* and *Clostridium botulinum*, which present specific concern in relation to ready to eat fresh pre-cut vegetables packaged in a modified atmosphere. Processors should ensure that they have addressed all relevant safety issues relating to the use of such packaging.

5.2 KEY ASPECTS OF CONTROL SYSTEMS

5.2.2 Specific Process Steps

5.2.2.1 Receipt and inspection of raw materials

During unloading of raw material, verify the cleanliness of the food transportation unit and raw materials for evidence of contamination and deterioration

5.2.2.2 Preparation of raw material before processing

Physical hazards (such as the presence of animal and plant debris, metal, and other foreign material) should be removed through manual sorting or the use of detectors, such as metal detectors. Raw materials should be trimmed to remove any damaged, rotten or mouldy material.

5.2.2.3 Washing and microbiological decontamination

Refer to section 5.2.2.1 of the Code of Hygienic Practice for Fresh Fruits and Vegetables. In addition:

- Water used for final rinses should be of potable quality, particularly for these products as they are not likely to be washed before consumption.

5.2.2.4 Pre-cooling Fresh Fruits and Vegetables

Refer to section 5.2.2.3 of the Code of Hygienic Practice for Fresh Fruits and Vegetables.

5.2.2.5 Cutting, slicing, shredding, and similar pre-cut processes

Procedures should be in place to minimize contamination with physical (e.g. metal) and microbiological contaminants during cutting, slicing, shredding or similar pre-cut processes.

5.2.2.6 Washing after cutting, slicing, shredding, and similar pre-cut processes

Washing cut produce with potable water may reduce microbiological contamination. In addition, it removes some of the cellular fluids that were released during the cutting process thereby reducing the level of available nutrients for microbiological growth. The following should be considered:

- Water should be replaced at sufficient frequency to prevent the build-up of organic material and prevent cross-contamination.
- Antimicrobial agents should be used, where necessary, to minimize cross-contamination during washing and where their use is in line with good hygienic practices. The antimicrobial agents levels should be monitored and controlled to ensure that they are maintained at effective concentrations. Application of antimicrobial agents, followed by a wash as necessary, should be done to ensure that chemical residues do not exceed levels as recommended by the Codex Alimentarius Commission.
- Drying or draining to remove water after washing is important to minimize microbiological growth.

5.2.2.7 Cold Storage

Refer to section 5.2.2.4 of the Code of Hygienic Practice for Fresh Fruits and Vegetables. In addition:

- Pre-cut fresh fruits and vegetables should be maintained at low temperatures at all stages, from cutting through distribution to minimise microbiological growth.

5.7 DOCUMENTATION AND RECORDS

Where appropriate, records should be maintained to adequately reflect product information, such as product formulations or specifications and operational controls. Maintaining adequate documentation and records of processing operations is important in the event of recall of fresh pre-cut fruits and vegetables. Records should be kept long enough to facilitate recalls and foodborne illness investigations, if required. This period will likely be much longer than the shelf life of the product. Some examples of records to keep are the following:

- Fresh fruit and vegetable supplier records
- Water quality and supply records
- Equipment monitoring and maintenance records
- Equipment calibration records

- Sanitation records
- Product processing records
- Pest control records
- Distribution records

5.8 RECALL PROCEDURES

Refer to the General Principles of Food Hygiene.

6. ESTABLISHMENT: MAINTENANCE AND SANITATION

Refer to the General Principles of Food Hygiene.

7. ESTABLISHMENT: PERSONAL HYGIENE

Refer to the General Principles of Food Hygiene.

8. TRANSPORTATION

Refer to the General Principles of Food Hygiene and the Code of Hygienic Practice for Fresh Fruits and Vegetables.

9. PRODUCT INFORMATION AND CONSUMER AWARENESS

Refer to the General Principles of Food Hygiene.

10. TRAINING

Refer to the General Principles of Food Hygiene and the Code of Hygienic Practice for Fresh Fruits and Vegetables. In addition:

10.2 TRAINING PROGRAMS

To evaluate the level of training required of persons responsible for the production of fresh pre-cut fruits and vegetables, the additional following factors should be taken into account:

- the packaging systems used for fresh pre-cut fruits and vegetables, including the risks of contamination or microbiological growth involved in this method;
- the importance of temperature control and GMPs.

ANNEX II**ANNEX FOR SPROUT PRODUCTION****INTRODUCTION**

In recent years the popularity of sprouted seeds has increased dramatically and are favoured by many for their nutritional value. However, the recent increase in reports of food borne illness associated with raw sprouts has raised concerns from public health agencies and consumers about the safety of these products.

The microbial pathogens associated with sprouted seeds are for example *Salmonella* spp, pathogenic *E. coli*, *Listeria monocytogenes*, and *Shigella* spp. Outbreak investigations have indicated that microorganisms found on sprouts most likely originate from the seeds. Most seeds supplied to sprout producers are produced primarily for forage or animal grazing where the Good Agricultural Practices (GAPs) necessary to prevent microbial contamination of seeds intended for sprouting are not followed, especially through the misuse of natural fertilizers or contaminated irrigation water. As a result, the seeds may be contaminated in the field or during harvesting, storage or transportation. Typically, the germination process in sprout production involves keeping seeds warm and moist for two to ten days. In these conditions, if low levels of microbial contaminants are present on seeds, they can quickly reach levels high enough to cause illness.

The scientific literature proposes microbiological decontamination of seeds treatments which can achieve different levels of pathogen reduction. There is currently no treatment available that can guarantee pathogen free seeds. Research is in progress to find efficient microbiological decontamination treatments which would provide sufficient pathogen reduction on seeds especially if pathogens are internalized.

1. OBJECTIVES

This annex recommends control measures to occur in two areas: during seed production and during sprout production. During seed production, conditioning and storage, the application of Good Agricultural Practices (GAPs) and Good Hygienic Practices (GHPs) are aimed at preventing microbial pathogen contamination of seeds. During sprout production, the microbiological decontamination of seeds step is aimed at reducing potential contaminants and the good hygienic practices at preventing the introduction of microbial pathogens and minimizing their potential growth. The degree of control in these two areas has a significant impact on the safety of sprouts.

2. SCOPE, USE AND DEFINITION**2.1 SCOPE**

This annex covers the hygienic practices that are specific for the primary production of seeds for sprouting and the production of sprouts for human consumption in order to produce a safe and wholesome product.

2.2 USE

This annex follows the format of the Recommended International Code of Practice – General Principles of Food Hygiene CAC/RCP 1-1969, Rev 3 (1997) and should be used in conjunction with the General Principles of Food Hygiene and the Code of Hygienic Practice for Fresh Fruit and Vegetables.

2.3 DEFINITIONS

Seed producer - any person responsible for the management of activities associated with the primary production of seeds including post-harvest practices.

Seed distributor - any person responsible for the distribution of seeds (handling, storage and transportation) to sprout producers. Seed distributors may deal with single or multiple seed producers and can be producers themselves.

Sprout producer - any person responsible for the management of the activities associated with the production of sprouted seeds.

Spent irrigation water - water that has been in contact with sprouts during the sprouting process.

3. PRIMARY PRODUCTION OF SEEDS

Refer to the Code of Hygienic Practice for Fresh Fruits and Vegetables. In addition:

3.2 HYGIENIC PRODUCTION OF SEEDS

3.2.1.2 Manure and biosolids

When seeds are destined for the production of sprouts for human consumption, wild or domestic animals should not be allowed to graze in the fields where seeds are grown (e.g., employing sheep for spring clip back of alfalfa).

It is particularly important to prevent microbial contamination during the production of seeds which will be used to produce sprouts for human consumption because of the potential for pathogens to grow during the sprouting process. Consequently, manure, biosolids and other natural fertilizers should only be used when they have undergone treatments which achieve a high level of pathogen reduction.

3.2.1.4 Agricultural chemicals

Seed producers should only use chemicals (e.g., pesticides, desiccants) which are acceptable for seeds intended for the production of sprouts for human consumption .

3.2.4 Equipment associated with growing and harvesting

Prior to harvest, harvesting equipment should be adjusted to minimize soil intake and seed damage and should be cleaned from any debris or earth. Diseased or damaged seeds, which could be susceptible to microbial contamination, should not be used for the production of sprouts for human consumption.

3.3 HANDLING, STORAGE AND TRANSPORT

Seeds produced for the production of sprouts for human consumption should be segregated from product to be seeded or planted for animal feed (e.g., for forage or animal grazing) and clearly labelled.

Recognising that seeds are vulnerable to microbial pathogens during thrashing and drying, adequate care is needed to maintain sanitation in drying yards, and exposure of seeds to mist, high humidity and fog should be avoided.

3.4 ANALYSES

Seed producers, distributors, and sprout producers should test lots of seeds for microbial pathogens using internationally accepted analytical methods. Sprouting seeds before testing increases the possibility of finding pathogens that may be present. If lots of seeds are found to be contaminated, they should not be sold or used for the production of sprouts for human consumption. Because of the limitations associated with sampling methods and analytical tests, failure to find contamination does not guarantee that the seeds are pathogen free. However, if contamination is found at this stage, it allows seeds to be diverted or destroyed before entering sprout production for human consumption. Seed producers, distributors and sprout producers should refer to the *Principles for the Establishment and Application of Microbiological Criteria for Foods*, CAC/GL 21-1977, for guidance on establishing a sampling plan.

3.5 RECALL PROCEDURES

Seed producers for the production of sprouts for human consumption should ensure that records and recall procedures are in place to effectively respond to health risk situations. Procedures should enable the complete and rapid recall of any implicated seed. The procedures should also assist in providing detailed information for the identification and investigation of any contaminated seeds and sprouts. The following should be adopted:

- Seed production and distribution practices should be in place to minimize the quantity of seed identified as a single lot and avoid the mixing of multiple lots that would complicate recalls and provide greater opportunity for cross-contamination. Seed producers and distributors and sprout producers should maintain records for each lot. The lot number, producer and country of origin should be indicated on each container.
- Seed producers should have a system to: effectively identify lots, trace the production sites and agricultural inputs associated with the lots, and allow physical retrieval of the seeds in case of a suspected hazard.
- Where a lot has been recalled because of a health hazard, other lots that were produced under similar conditions (e.g., on the same production sites or with the same agricultural inputs) and which may present a similar hazard should be evaluated for safety. Any lot presenting a similar risk should be recalled. Blends containing potentially contaminated seeds must also be recalled.
- Seeds which may present a hazard must be held and detained until they are disposed of properly.

4. ESTABLISHMENT FOR SPROUT PRODUCTION

Refer to the General Principles of Food Hygiene. In addition:

4.2.1 Design and layout

Where appropriate, the internal design and layout of sprout establishments should permit Good Hygiene Practices, including protection against cross-contamination between and during operations. Storage, seed rinsing and microbiological decontamination, germination and packaging areas should be physically separated from each other.

5. CONTROL OF OPERATION

Refer to the General Principles of Food Hygiene. In addition:

5.2.2 Specific process steps in sprout production

5.2.2.1 *Water use during sprout production*

Water quality management will vary throughout all operations. Sprout producers should follow GMPs to minimize the potential for the introduction or spread of pathogens in processing water. The quality of water used should be dependent on the stage of the operation. Because of the potential for pathogen proliferation during the sprouting process, clean water could be used for initial washing stages, whereas water used later in the sprout production process (i.e., for the rinse following the microbiological decontamination of seed, and subsequent operations) should be preferably of potable quality or at least clean water.

5.2.2.2 *Initial rinse*

The seeds should be rinsed thoroughly before the microbiological decontamination treatment to remove dirt and increase the efficiency of this treatment.

- Seeds should be rinsed and thoroughly agitated in large volumes of clean water, in such a way to maximize surface contact. The process should be repeated until most of the dirt is removed and rinse water remains clear.

5.2.2.3 Microbiological decontamination of seeds

Due to the difficulty of obtaining seeds which can be guaranteed as pathogen free, it is recommended that seeds be treated prior to the sprouting process. Although there are other options like the use of lactic acid bacteria, liquid microbiological decontamination treatment is generally used. During this treatment sprout producers should adhere to the following:

- All containers used for microbiological decontamination of seeds should be cleaned and disinfected prior to use.
- Seeds should be well agitated in large volumes of antimicrobial agent to maximise surface contact.
- The duration of treatment and the concentration of antimicrobial agent used should be accurately measured and recorded.
- Strict measures should be in place to prevent re-contamination of seeds after the microbiological decontamination treatment.
- Antimicrobial agent should be used according to manufacturer's instructions for their intended use.

5.2.2.4 Rinse after seed treatment

As appropriate, seeds should be thoroughly rinsed after the microbiological decontamination treatment with potable water or at least clean water. Rinsing should be repeated sufficiently to eliminate antimicrobial agent.

5.2.2.5 Pre-germination soak

Soaking is often necessary to improve germination. When soaking, the sprout producer should adhere to the following:

- All containers used for soaking should be cleaned and disinfected prior to use.
- Seeds should be soaked in cleaned water for the shortest possible time to minimize microbial growth.
- This step may also employ antimicrobial agents.
- After soaking, seeds should be rinsed thoroughly with potable water or at least clean water.

5.2.2.6 Germination

During germination, keep the environment and equipment clean to avoid potential contamination. All equipment should be cleaned and disinfected before each new batch.

- Only potable water should be used.
- Where necessary and when used, soils or other matrices should be treated (e.g., pasteurized) to achieve a high degree of microbial reduction.

5.2.2.7 Harvesting

All equipment should be cleaned and disinfected before each new batch. Harvesting should be done with cleaned and disinfected tools dedicated for this use.

5.2.2.8 Final rinse and cooling

A final water rinse will remove hulls, cool product, and may reduce microbial contamination on sprouts. The following should be adopted:

- As appropriate, sprouts should be rinsed in cold potable water to lower sprout temperature and slow down microbial growth.
- Water should be changed, as needed (e.g., between batches), to prevent cross-contamination.
- Sprouts should be drained using appropriate equipment (e.g. food grade centrifugal dryer) that is clean and disinfected prior to use.
- If additional cooling time is necessary, steps should be taken to facilitate rapid cooling (e.g., placed in smaller containers with adequate air flow between containers).

5.2.2.9 Storage of finished product

- Where appropriate, sprouts should be kept under cold temperature (e.g. 5⁰C) that will minimize microbial growth for the intended shelf life of the product. Regular and effective monitoring of temperature of storage areas and transport vehicles should be carried out.

5.2.3 Microbiological and other specifications

It is recommended that seed and sprouts or spent irrigation water be tested for the presence of pathogens.

5.2.3.1 Testing of seed lots before entering production

It is recommended that each new lot of seeds received at the sprouting facility is tested before entering production (i.e. before the microbiological decontamination of seeds).

- The seed sample selected for testing should be sprouted prior to analysis to increase the potential to detect pathogens if present. Analysis may be performed on the sprouted seeds or the water used to sprout the sample.
- Seed samples for microbial analysis should not be subject to any microbiological decontamination treatment at the sprouting facility.

5.2.3.2 Testing of sprouts and/or spent irrigation water

Current seed treatments cannot guarantee total elimination of pathogens. Further, if even a few pathogens survive the microbiological decontamination treatment, they can grow to high numbers during sprouting. Therefore, producers should have in place a sampling/testing plan to regularly monitor for pathogens at one or more stages after the start of germination.

- Analyses can be performed during the germination process (e.g., spent irrigation water or sprouts) and/or finished product may be analysed after harvest.
- Testing spent irrigation water is a good indicator of microbial conditions of sprouts. It is homogeneous and is simpler to analyse. Further, sampling spent irrigation water (or sprouts) during germination allows earlier results compared to testing finished product.
- Because of the sporadic nature of seed contamination, it is recommended that producers test every production lot.

5.2.4 Microbiological cross-contamination

Sprout producers should adhere to the following:

- The traffic pattern of employees should prevent cross-contamination of sprouts. For example: the employees should avoid going back and forth to various areas of production. The employees should not go from a potentially contaminated area to the germination and/or packaging area unless they have washed their hands and changed to clean protective clothing.

5.3 INCOMING MATERIAL REQUIREMENTS

5.3.1 Specifications for incoming seeds

- Sprout producers should recommend that seed producers adopt good agricultural practices and provide evidence that the product was grown according to section 3 of this Annex and the *Code of Hygienic Practice for Fresh Fruits and Vegetables*.
- Seed and sprout producers should obtain assurance from seed producers or distributors that chemical residues of each incoming lot are within the limits established by the Codex Alimentarius Commission and, where appropriate, they should obtain certificates of analysis for microbial pathogens of concern.

5.3.2 Control of incoming seeds

Seed containers should be examined at their arrival to minimize the potential for introducing obvious contaminants in the establishment.

- Seed containers should be examined for physical damage (e.g., holes from rodents) and signs of contamination (e.g., stains, rodent, insects, faeces, urine, foreign material, etc.). If found to be damaged, contaminated or potentially contaminated, its contents should not be used for the production of sprouts for human consumption.
- If seed lots are analysed for the presence of microbial pathogens of concern, these should not be used until results of analysis are available.

5.3.3 Seed storage

Seeds should be handled and stored in a manner that will prevent damage and contamination.

- Seeds should be stored off the floor, away from walls and in proper storage conditions to prevent mould and bacterial growth and facilitate pest control inspection.
- Open containers should be stored in such a way that they are protected from pests and other sources of contamination.

5.7 DOCUMENTATION AND RECORDS

Refer to the Code of Hygienic Practice for Fresh Fruits and Vegetables. In addition:

Written records that accurately reflect product information and operational controls should be available to demonstrate the adequacy of the production activities.

- Upon receipt of seeds, records should be maintained of the seed supplier, the lot number and the country of origin to facilitate recall procedures.
- Records should be legible, permanent and accurate. Records should include written procedures, controls, limits, monitoring results and subsequent follow-up documents. Records must include: seed sources and lot numbers, water analysis results, sanitation checks, pest control monitoring, sprout lot codes, analysis results, production volumes, storage temperature monitoring, product distribution and consumer complaints.

- Records should be kept long enough to facilitate recalls and food borne illness investigation, if required. This period will likely be much longer than the shelf life of the product.

6. ESTABLISHMENT: MAINTENANCE AND SANITATION

Refer to the General Principles of Food Hygiene.

7. ESTABLISHMENT: PERSONAL HYGIENE

Refer to the General Principles of Food Hygiene.

8. TRANSPORTATION

Refer to the General Principles of Food Hygiene.

9. PRODUCT INFORMATION AND CONSUMER AWARENESS

Refer to the General Principles of Food Hygiene.

10. TRAINING

Refer to the General Principles of Food Hygiene. In addition:

10.1 AWARENESS AND RESPONSIBILITIES

Refer to the Code of Hygienic Practice for Fresh Fruits and Vegetables. In addition:

- The producer should have a written training program that is routinely reviewed and updated. Systems should be in place to ensure that food handlers remain aware of all procedures necessary to maintain the safety of sprouts.