

devices or facilities to prevent foreign substances from falling into the product.

(3) Design and Construction-Non-Food Product Zone:

- (a) All safety or gear guards shall be removable for cleaning and inspection.
- (b) All external surfaces shall be free of open seams, gaps, crevices, unused holes, and inaccessible recesses.
- (c) Horizontal ledges and frame members shall be kept to a minimum; external angles shall be rounded and internal angles shall be avoided.
- (d) Where lubrication of equipment is required, provision shall be made to prevent leaking or dripping into the food product zone.

5. Installation of Equipment:

- a. All equipment shall be installed on a foundation of durable, easily cleanable material.
- b. Equipment shall be placed at least 18 inches<sup>14</sup> from walls and ceiling, or sealed watertight thereto. All portions of the equipment shall be installed sufficiently spaced above the floor on a minimum number of supporting members to provide access for inspection and cleaning, or be installed completely sealed (watertight) to the floor.
- c. Whenever equipment passes through walls or floors, it shall be sealed thereto or sufficient clearance shall be allowed to permit inspection, cleaning and maintenance.
- d. Where necessary, drains and catch pans shall be provided and shall be of such dimensions to collect all spill and drip and be readily accessible or readily removable for cleaning.
- e. Where pipes pass through ceilings of processing areas, pipe sleeves shall be inserted in the floor above so that their upper periphery is at least 2 inches above the floor.

6. Connections:

- a. All electrical connections, such as switch boxes, control boxes, conduit and bx cables, shall be installed a minimum of  $\frac{3}{4}$  inch away from the equipment and walls, or be completely sealed to the equipment or wall.

*SECTION E. Operating Practices for the Commercial Manufacture of Frozen Food*

1. Handling and Storage of Materials:

- a. Foods—All food ingredients received at the plant shall be wholesome. Storage shall be in rooms completely separate from food preparation and processing operations. Storage conditions shall preclude contamination from rodents, insects, and other sources. Temperature of storage shall be in accordance with the following practices:
  - (1) Ingredients requiring refrigeration shall be stored at an air temperature of 40° F. or lower;
  - (2) Frozen ingredients shall be stored at an air temperature of 0° or lower.
- b. Packaging Materials—Storage shall be in rooms completely separate from food preparation and processing operations. Conditions of storage shall preclude contamination from rodents, insects, and other sources.
- c. General Housekeeping—Plant and premises shall be maintained so as to present a neat and orderly appearance at all times.

2. Personnel Hygiene:

- a. The services of an employee with any open sore on an exposed portion of the

<sup>14</sup> Space between walls or ceiling and equipment should be 30 inches preferably.