

**HAZARD IDENTIFICATION AND RISK ANALYSIS**

**DOCUMENT NUMBER:** HACCP/03

**VERSION:** 1.00

Audit For: - POOJA DEHY FOODS PVT LTD. (Parent Company) Address: 1- Survey no. 158/P-2, Village Taveda, Haripara Road, Mahuva-364290, District Bhavnagar, Gujarat, India. City-Mahuva. State or County- State-Gujarat, Country-INDIA. Post or Zip Code-364290

**Hazard Identification and Risk Analysis for:**

<b>Methodology used to conduct Hazard Analysis</b>	
A	Identify and list all potential hazard associated with each process step and postproduction step Label the hazards as B (Biological), C (Chemical) or P (Physical) Identify the related Hazard Category for each.
B	Determine the Likelihood of occurrence - A <u>High Risk</u> is likely to happen – Give it a rating of 10 A <u>Medium Risk</u> could happen – Give it a rating of 5 A <u>Low Risk</u> is not likely to happen – Give it a rating of 3
C	Determine the severity of each hazard – A <u>Critical Severity</u> will automatically result in an unsafe product – Give it a rating of 10 A <u>Serious Severity</u> will likely result in an unsafe product – Give it a rating of 8 A <u>Major Severity</u> may result in an unsafe product – Give it a rating of 5 A <u>Minor Severity</u> will not result in an unsafe product – Give it a rating of 3
D	Determine the Risk Rating by multiplying Likelihood of Occurrence by the Severity of Impact
E	List general control measures to control hazards Also list the explanations / justifications for arriving at the risk rating
F	Determine the significant hazards. Any hazard with a risk rating of 30 or above is significant.

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Ingredient / Step Name, and Number	HAZARD IDENTIFICATION		RISK ANALYSIS				
	B / C / P	Details of Hazard Identified	LH D O C	SEV. IMP.	RIS K RTG.	Explanation / Justification, & Preventive Measures	S / NS
<b>Step no. 1 Receiving of raw onions</b>	B	Chances of Bacterial cross contamination like yeast. Mold and coli forms in the raw onion from the dirty vehicle carrying the Raw onions.	5	5	25	Proper instruction is given to the transporter and inspection of vehicle is done at the receiving stage.	NS
	C	Chances of Chemical cross contamination into raw onion from the vehicle carrying the raw onions along with the chemical.	3	8	24	Proper instruction is given to the transporter and inspection of vehicle is done at the receiving stage.	NS
	C	Chances of presence of pesticide & hormone residue on the surface of the fruits	3	8	24	Further processing steps like washing will reduce the likelihood of the hazard.	NS
	P	Chances of presence of dust, dirt, and other extraneous matter	5	5	25	Further processing steps like sorting, washing will reduce the likelihood of the hazard. Controlled by following SSOP for the Personal Hygiene, SSOP for cleaning and sanitation, Cleaning of food contact surfaces and maintaining clean surrounding.	NS
<b>Step no .2 Inspection</b>		NA	NA			NA.	
<b>Step no. 3 unloading &amp; transfer to the RM</b>	B	Chances of cross contamination with the workers' hands, food contact surfaces, utensils, grounds etc.	3	5	15	Controlled by following the SSOP for the Personal Hygiene, Cleaning & Disinfections, keeping the surrounding area clean.	NS

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store.	P	Chances of contamination with dust, dirt and other foreign matter	3	3	9	By maintaining cleanliness of ripening Area	NS
	C	NA					
Step no. 4 RM store	B	Chances of development of microorganisms already present on the thereby spoiling the remaining lot.	3	5	15	Controlled by sorting of the onions.	NS
	B	Chances of spoilage of the onion if over-ripened.	5	5	25	Controlled by sorting of the onions.	NS
	B	Chances of cross contamination with pest, rodents, flies etc. during Storage of the onions.	3	8	24	Controlled by proper Pest Control Program for the stores, as per the SSOP for Pest and Rodent Control.	NS
	P	Chances of contamination with the dust, dirt or other foreign material	5	5	25	Control physical contaminants by following SSOP for cleaning.	NS
Step no. 5, 7 Transfer to 1st & 2nd peeling section	B	Chances of cross contamination with the workers' hands, utensils, grounds etc.	3	5	15	Controlled by following the SSOP for the Personal Hygiene, Cleaning & Disinfections, keeping the surrounding area clean.	NS
	P	Chances of Falling Hair dust, Jewelry into the product.	3	3	9	Following SSOP personal hygiene strictly	
	P	Chances of contamination with dust, dirt and other foreign matter	3	3	9	By maintaining cleanliness of 1st peeling area.	NS

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Step no. 6 Collection in crates	B	Chances of mixing Spoiled onions with good onions causing contamination to all fruits	5	5	25	Spoiled onions are separated during unloading and discarded, good onions are stored in separate crates,	NS
	B	Chances of cross contamination with the workers' hands, food contact surfaces, utensils, grounds etc.	3	8	24	Controlled by following the SSOP for the Personal Hygiene, Cleaning & Disinfections, keeping the surrounding area clean.	NS
	P	Chances of contamination with dust, dirt and other foreign matter	3	8	24	By maintaining cleanliness of unloading material	NS
Step no. 8 Transfer to peeler directly	B	Chances of cross contamination with the workers' hands, food contact surfaces, utensils, grounds etc.	3	8	24	Controlled by following the SSOP for the Personal Hygiene, Cleaning & Disinfections, keeping the surrounding area clean.	NS
	P	Chances of Falling Hair dust, Jewelry into the product.	3	3	9	Following SSOP personal hygiene strictly	NS
	C	Chances of chemical cross contamination due to detergent residue remaining on the peeler due improper rinsing.	3	8	24	Controlled by cleaning the equipment thoroughly with the water	NS
Step no 9 Peeling by machine	B	Chances of cross contamination from the contact surface of peeler due to improper cleaning frequency.	5	5	25	Following the SSOP for Personnel Hygiene, SSOP for cleaning and disinfections and cleaning of food contact surfaces	NS
	P	Chances of contamination with any other extraneous matter that may fall in it from the top.	3	5	15	Covering the Peeler when in operation.	NS

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	C	Chances of contamination with the detergent residue	3	5	15	Ensuring the proper cleanliness of the utensils or equipment's or any other food contact surfaces. Following SSOP for cleaning & disinfections.	NS
Step no. 10 Collection of peeled onion in the SS tubs	B	Chances of cross contamination from the contact surface of SS tubs due improper cleaning frequency.	5	5	25	Following the SSOP for Personnel Hygiene, SSOP for cleaning and disinfections and cleaning of food contact surfaces	NS
	P	Physical cross contamination of the Product due to falling of hairs, Jewelry and Other foreign matter due to improper personal behavior.	5	5	25	Following SSOP personnel hygiene	NS
	C	Chances of contamination with the detergent residue	3	8	24	Ensuring the proper cleanliness of the utensils or equipment's or any other food contact surfaces. Following SSOP for cleaning & disinfections.	NS
Step no. 11 Washing with CL water 100 ppm	B	Chances of growth of Bacterial load into the final product if not washed with the Chlorinated water.	3	8	24	Washing with the chlorine sol of 100 ppm and further controlled by the washing with the 50-ppm chlorinated water and drying at 50-140 deg.	NS
	C	Chemical cross contamination due to impure grade of the chlorine so In used	3	8	24	Purchasing of the chemical from the approved supplier.	

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Step no. 12, 13 Transfer to slicer, slicing Step 14, Transfer to Dryer	B	Chances of cross contamination with the workers' hands, food contact surfaces, utensils, grounds etc.	5	8	24	Controlled by following the SSOP for the Personal Hygiene, Cleaning & Disinfections, keeping the surrounding area clean.	NS
	P	Chances of Falling Hair dust, Jewelry into the product.	3	3	9	Following SSOP personal hygiene strictly	NS
	C	Chances of chemical cross contamination due to detergent residue remaining on the slicer due improper rinsing.	3	8	24	Controlled by cleaning the equipment thoroughly with the water	NS
Step no.15 1st stage imperial drying 50- 140 deg. Step no.18 2nd Stage Bin drying 45-50 deg C	B	Growth of bacteria in the product if drying is not properly done.	3	10	30	Proper drying is ensuring by checking moisture content.	S
	C	NA					
	P	NA					
Step no.16 Collection in HDPE Bags	B	Chances of biological Contamination if the HDPE bags used for collection are unclean.	5	5	25	Always ensuring that bags are cleaned and properly stored.	NS
	B	Biological cross contamination from the unclean workers hand	3	8	24	Follow SSOP strictly.	NS
	P	Chances of falling hairs, jewelry & foreign matter if the workers personal hygiene is not good.	5	5	25	Follow SSOP strictly.	NS

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<b>Step no. 17 Transfer to bin dryer</b>	B	Chances of cross contamination with the workers' hands, food contact surfaces, utensils, grounds etc.	5	8	24	Controlled by following the SSOP for the Personal Hygiene, Cleaning & Disinfections, keeping the surrounding area clean.	NS
	P	Chances of Falling Hair dust, jewelry into the product.	3	3	9	Following SSOP personal hygiene strictly	NS
	C	Chances of chemical cross contamination due to Chlorine residue remaining on the Bin dryer due improper rinsing.	3	8	24	Controlled by cleaning the equipment thoroughly with the water	NS
<b>Step no 19 Collection in HDPE Bags and transfer to AC room for cooling and sorting.</b>	B	Chances of biological Contamination if the HDPE bags used for collection are unclean.	5	5	25	Always ensuring that bags are cleaned and properly stored.	NS
	B	Biological cross contamination from the unclean workers hand	3	8	24	Follow SSOP strictly.	NS
	P	Chances of falling hairs, jewelry & foreign matter if the workers personal hygiene is not good.	5	5	25	Follow SSOP strictly.	NS
<b>Step no. 20 Air Cooling in Bins 18-20 deg.</b>	B	Chances of cross contamination from the contact surface of Bins.	5	5	25	Following the SSOP for Personnel Hygiene, SSOP for cleaning and disinfections and cleaning of food contact surfaces	NS
	B	A chance of growth of the microbes if cooling is not done in controlled atmosphere.	3	10	30	Cooling is done in controlled atm and further moisture is checked to ensure the proper cooling.	S

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	C	Chances of contamination with the detergent residue	3	5	15	Ensuring the proper cleanliness of food contact surfaces of the Bins. Following SSOP for cleaning & disinfections.	NS
	P	Chances of contamination with the dust, dirt etc.	3	5	15	Controlled by keeping surrounding clean.	NS
<b>Step no 21 QC Moisture Check</b>		NA.					
<b>Step no. 22 Separation of dried sliced onions by separator into diff sizes.</b>	B	Chances of cross contamination from product residues on the inside parts of the Separator.	5	5	25	Ensuring clean conditions of the food contact surfaces/ equipment's by following SSOP for cleaning and disinfections.	NS
	P	Chances of contamination with dust, dirt etc., and any extraneous matter may fall while the operation is going on.	5	5	25	Controlled by ensuring the clean conditions, covering the collection bags while the operation is going on.	NS
<b>Step no 23 Transfer steel top table for manual sorting</b>	B	Chances of cross contamination with the workers' hands, food contact surfaces, utensils, grounds etc.	5	8	24	Controlled by following the SSOP for the Personal Hygiene, Cleaning & Disinfections, keeping the surrounding area clean.	NS
	P	Chances of Falling Hair dust, Jewelry into the product.	3	3	9	Following SSOP personal hygiene strictly	NS

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Step no. 24 Sorting manually	B	Chances of cross contamination of the coli form bacteria e.g., E coli from the workers' hands, food contact surfaces, utensils, grounds etc.	5	8	24	Controlled by following the SSOP for the Personal Hygiene, Cleaning & Disinfections, keeping the surrounding area clean.	NS
	P	Chances of Falling Hair dust, Jewelry into the product.	3	3	9	Following SSOP personal hygiene strictly	NS
	C	NA.					
Step no25, 37 Passing through metal detector	P	Chances of presences of metal particles in the final products if final product is not passed through the metal detector.	3	10	30	Final product is passing through the calibrated metal detector	S
	B	Chances of cross contamination from product residues on the surface of the metal detector.	5	5	25	Ensuring clean conditions of the food contact surfaces/ equipment's by following SSOP for cleaning and disinfections.	NS
Step no.26, 38 Inspection		NA.					
Step no. 28,42 Packing in HDPE liner & weighing	B	Chances of cross contamination with the workers' unclean hands, unclean bags contact surfaces etc.	5	8	24	Controlled by following the SSOP for the Personal Hygiene, Cleaning & Disinfections, keeping the surrounding area clean. Ensuring the bags cleanliness	NS
	P	Chances of Falling Hair dust, Jewelry into the product.	3	3	9	Following SSOP personal hygiene strictly	NS

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	C	Chances of chemical cross contamination if HDPE bags used for filling are of nonfood grade.	3	5	15	Only food grade bags are used and purchase from approved vendor list.	
Step no. 28 & 29 Step no. 42 & 43	B	Chances of spoilage of the final product due to absorption of the moisture if heat sealing and Seal check is not proper	3	8	24	Heat sealing is done by proper heating temp and seal check is done for proper sealing	NS
Heat sealing and seal check		NA.					
Step no. 30 Transfer to finished good storage		NA.					
Step no 31 FG storage	B	Chances of spoilage of the product if the storage conditions are not maintained properly.	3	8	24	Storage conditions are maintained properly.	NS.
	C	Chemical contamination due to storage of chemicals near the finished goods.	3	5	15	Storage of chemicals is done separately.	NS
Step no. 32 Packing in cartons		NA.					
Step no 33 Carton sealing		NA.					

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Step no. 34,35 Labeling and dispatch.	NA.						
Step no. 36 Mixing	B	Chances of cross contamination with the workers' hands, food contact surfaces, utensils, grounds etc.	5	8	24	Controlled by following the SSOP for the Personal Hygiene, Cleaning & Disinfections, keeping the surrounding area clean.	NS
	P	Chances of Falling Hair dust, jewelry into the product.	3	3	9	Following SSOP personal hygiene strictly	NS
Step no. 39 Pulversing	B	Chances of cross contamination from product residues on the inside parts of the pulverizer.	5	5	25	Ensuring clean conditions of the food contact surfaces/ equipment's by following SSOP for cleaning and disinfections.	NS
	P	Chances of contamination with dust, dirt etc., and any extraneous matter may fall while the operation is going on.	5	5	25	Controlled by ensuring the clean conditions, covering the collection bags while the operation is going on.	NS
Step no. 40 Sieving 100 mesh	B	Chances of cross contamination from product residues on the arts of the sieve.	5	5	25	Ensuring clean conditions of the food contact surfaces/ equipment's by following SSOP for cleaning and disinfections.	NS
	P	Chances of contamination with dust, dirt etc., and any extraneous matter may fall while the operation is going on.	5	5	25	Controlled by ensuring the clean conditions, covering the collection bags while the operation is going on.	NS

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HAZARD ANALYSIS FOR RECEIVING, INSPECTION & STORAGE OF PACKING MATERIAL, CHEMICAL & CONSUMABLES							
Step no. RM 1 Receiving	B	Chance cross contamination from the unclean vehicle	5	5	25	Proper instruction is given to the transporter and inspection of vehicle is done at the receiving stage.	NS
	C	Chances Chemical crosses contamination from the vehicle carrying the packing material and other consumables along with the chemical.	3	8	24	Proper instruction is given to the transporter and inspection of vehicle is done at the receiving stage.	NS
Step no. RM 2 Inspection	NA	NA.					
Step no. RM 4 Storage	B	Chances of contamination of the product if the storage conditions are not maintained properly.	3	8	24	Storage conditions are maintained properly.	NS.
	C	Chemical contamination due to storage of chemicals near the finished goods.	3	5	15	Storage of chemicals is done separately.	NS

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