

Nampa Facility Food Safety Plan

Liquid Sugar Medium Invert Sugar

Version: 10/5/22

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Corporate Recall Plan	Intranet

Plan Approval

Plant/Warehouse Manager:

Handwritten signature of the Plant/Warehouse Manager.

Date:

10/10/22

Local HACCP Coordinator:

Handwritten signature of the Local HACCP Coordinator.

Date:

10/5/22

Facility Information

Facility Name:	Nampa Factory		
Facility Address:	138 W. Karcher Road, Nampa, Idaho 83687		
Phone:	208.466.3541		
Plant/Facility Manager:	Jason Lowry		
Local HACCP Coordinator:	Stefanie Constantinescu PCQI		
Company HACCP Coordinator:	Kelly Malone PCQI		
Number of Employees:	350 (500 campaign)	Temporary Employees:	Yes
Facility Description:	The Nampa factory was constructed in 1942. This facility produces granulated sugar which is conditioned and stored in 12 concrete silos. Stored sugar is screened and loaded or packaged and shipped or is used as an ingredient for liquid sugar or medium invert. Liquid products are shipped via bulk tanker.		

Food Safety

Products:	This site produces granulated sugar, powdered sugar, liquid sugar, medium invert sugar, coating syrup, and feed co-products. This plan addresses liquid and medium invert.		
Third Party Audit Standard:	Current SQF Version	Certification Body:	CICS-Americas
Ingredients/Raw Materials:	Sugar, Granulated Water Sodium Hydroxide, Caustic		Import Capability: No
Packaging:	Liquid Tanker		
Prerequisite Programs :	1. Personnel Practices	2. Employee Training	3. Equipment Calibration
	4. Integrated Pest Management	5. Premises & Equipment Maintenance	6. Cleaning & Sanitation
	7. Monitoring Utilities: Air & Water	8. Physical Contaminant Control	9. Warehousing, Transport, and Delivery
	10. Waste Management	11. Allergen Management	12. Chemical Control
	13. Supplier Approval	14. Visitors	

Team

Stefanie Constantinescu	Food Safety and Quality Professional	Preventive Controls Qualified Individual
Jason Lowry	Plant Manager	In-house
Craig Ashcraft	Maintenance Manager	In-house
Tyrel Murphy	Chief Chemist	HACCP 1 Day Course
Bruce Rhodes	Warehouse Maintenance Supervisor	HACCP 1 Day Course
Maria Betancourt	Warehouse Supervisor	HACCP 3 Day Course
Luis Cepeda	Production Manager	In-house
Steve Willcuts	Engineering Manager	In-house
Kelly Malone	Food Safety Systems Specialist	Preventive Controls Qualified Individual



Product Description

**NATIONAL
SUGAR
MARKETING**

Document No.: PD-03

Rev.: 0

General Product Information

Product Name:	Liquid sugar
Technical Name:	Sucrose
Product Description:	Solution of sucrose in water
Ingredients:	Crystalline sucrose and water
Intended Use:	This product is used as an ingredient in many food products and functions as a sweetener.
Intended Consumer:	Liquid sugar is distributed to food processors that provide products to the general public, including high risk groups.
Shelf Life:	30 Days
Labeling Instructions:	None
FDA Classification:	GRAS 21 CFR 184.1854
Storage:	Stored in bulk tanks
Distribution:	Distributed by liquid tanker and liquid totes shipped by trailer.

Technical Information

Chemical Formula:	$C_{12}H_{22}O_{11} + H_2O$
Water Activity (a_w):	0.86 ¹
Moisture:	32.5 to 33.5%
Sulfites:	Results equivalent to granulated sugar.
Microbiological:	Will not support the growth of vegetative pathogens. ^{2,3} Meets ISBT ⁴ and NFP ⁵ standards for use in carbonated beverages and canned foods.

Preventive Controls

Process Control:	CCP Liquid Filtration (porosity of 100 microns or less)
Allergen Control:	None
Sanitation Control:	None
Supply-Chain Control:	None

¹ [BC CDC: Water Activity of Sucrose and NaCl Solutions](#)

² [Microbial Risk Assessment: Pathogen Challenge Evaluations of Granulated and Liquid Sugar](#)

³ [Fate of Bacterial Pathogens](#)

⁴ ISBT: Liquid Sucrose

⁵ GMA Canners Standard



Product Description

**NATIONAL
SUGAR
MARKETING**

Document No.: PD-04

Rev.: 0

General Product Information

Product Name:	Invert Sugar, Medium
Technical Name:	Liquid invert sugar solution
Product Description:	Solution of sucrose, fructose, and glucose in water
Ingredients:	Crystalline sucrose and water
Intended Use:	This product is used as an ingredient in many food products and functions as a sweetener.
Intended Consumer:	Medium invert sugar is distributed to food processors that provide products to the general public, including high risk groups.
Shelf Life:	90 Days
Labeling Instructions:	None
FDA Classification:	GRAS 21 CFR 184.1859
Storage:	Stored in bulk tanks
Distribution:	Distributed by liquid tanker and liquid totes shipped by trailer.

Technical Information

Chemical Formula:	$C_{12}H_{22}O_{11} + C_{12}H_{24}O_{12} + H_2O$
Water Activity (a_w):	0.73
Moisture:	22.5 to 23.5%
Sulfites:	Results equivalent to granulated sugar.
Microbiological:	Will not support the growth of vegetative pathogens. ^{1,2} Meets ISBT ³ and NFP ⁴ standards for use in carbonated beverages and canned foods.

Preventive Controls

Process Control:	CCP Liquid Filtration (porosity of 100 microns or less)
Allergen Control:	None
Sanitation Control:	None
Supply-Chain Control:	None

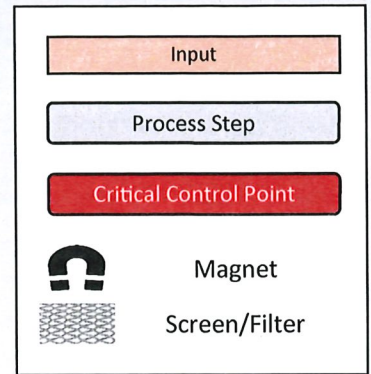
¹ [Microbial Risk Assessment: Pathogen Challenge Evaluations of Granulated and Liquid Sugar](#)

² [Fate of Bacterial Pathogens](#)

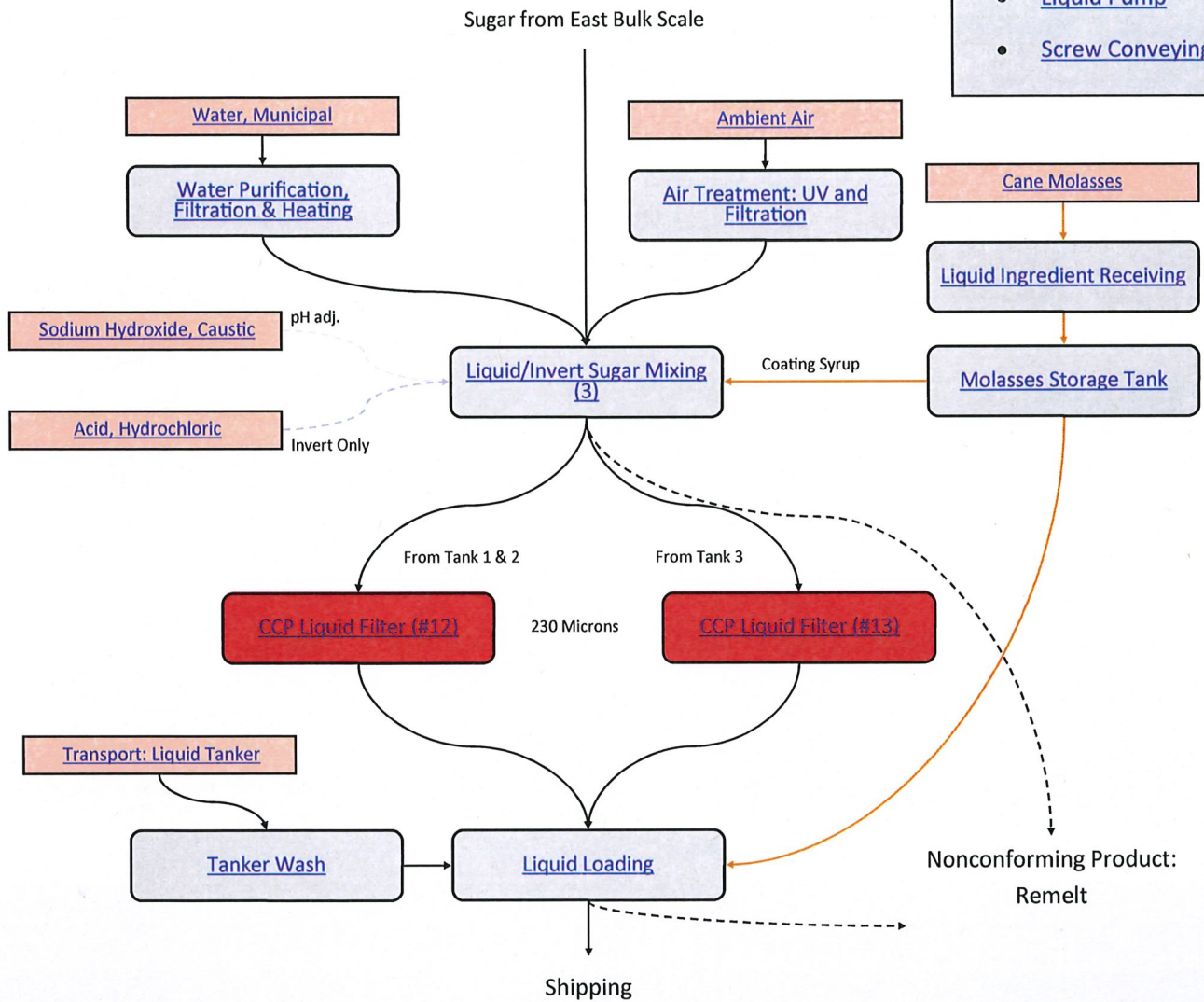
³ ISBT: Liquid Sucrose

⁴ GMA Canners Standard

Process Flowchart: Liquid Sugar, Invert Sugar, Coating Syrup, and Cane Molasses

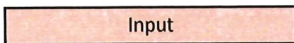
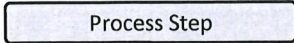





- Product Conveying Equipment & Hazard Analysis
- [Liquid Pump](#)
 - [Screw Conveying](#)

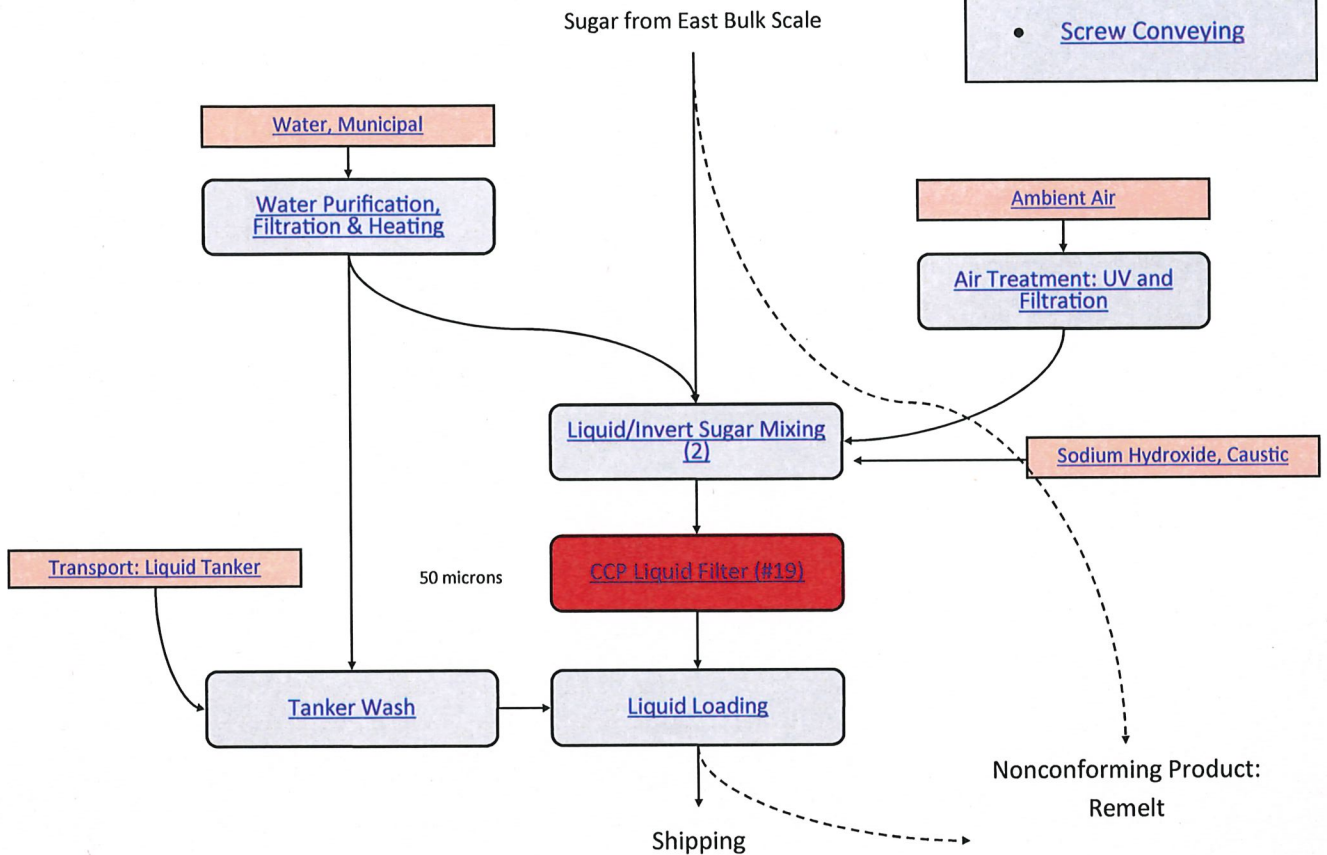


[Hazard Analysis Sheets for each step/ input are available through internal links or by customer request.](#)

Process Flowchart: Liquid Sugar (West Warehouse)

	Input
	Process Step
	Critical Control Point
	Magnet
	Screen/Filter

Product Conveying Equipment & Hazard Analysis	
•	Liquid Pump
•	Screw Conveying



[Hazard Analysis Sheets for each step/ input are available through internal links or by customer request.](#)

Process Preventive Control: Critical Control Point Summary

Process Control Step:		CCP Liquid Filter
Hazard(s):		Foreign Material (Physical Hazards)
Parameters, values, or critical limits:		Filter, 100 microns or less, is intact and in place throughout product loading
Monitoring:	What:	Final filter with a porosity of 100 microns or less.
	How:	Monitor the final filter according to SOP 6.3-02 CCP Monitoring: Liquid Filter .
	Frequency:	Conduct the inspection after loading each liquid trailer or each shipment of liquid totes.
	Who:	Trained warehouse operator.
Corrective Action:		Operator notifies supervisory personnel. Supervisory personnel complete corrective action according to SOP 6.3.4-04 HACCP Deviation: Liquid Filter .
Verification:	Monitoring Activity:	Supervisory personnel verify the monitoring activity through record review within 7 days of record generation. The review is indicated by a signature and date.
	Food Safety Plan:	The food safety plan is incorporated into annual internal audits. The plan, CCP selection, and CL determination are reviewed/assessed annually.
Validation:	Critical Control Point:	CCP selection is reevaluated annually in light of emerging technological and regulatory information. This review is documented on record 7.1-03 Validation .
	Critical Limits:	CL or parameter selection is reevaluated annually in light of emerging technological and regulatory information. This review is documented on record 7.1-03 Validation .
	Scientific & Technical Information:	Decisions for the hazard analysis, CCP selection, and CL selection have been based on scientific and technical information. This information is posted to the corporate intranet and may be accessed through this link .
Records:		Retained per Record Retention policy.

Procedural documentation is available on the corporate intranet through direct links or through the quality assurance tab. This documentation will be made available to customers upon request.

Amendments

10/522	Removed Dave Hawk and replaced with Jason Lowry. Removed NSF and added CICS-Americas. Removed HR and Safety from HACCP Team.
5/17/21	Removed Keith Brossard Added Troy Morfin. Updated Logos. Updated Maria Alvarez to Maria Betancourt.
4/21/2020	Added: Keith Brossard; Safety Manager Removed: Kimberly Tkacs; Assistant Safety Manager
06/20/19	Fixed Maria Alvarez's title to warehouse manager not assistant warehouse manager. Changed Name to Maria Betancourt Added: Luis Cepeda; Kelly Malone Removed: Tim Vandeventer; Jeremy Adamson Removed Corporate HACCP Coordinator.
02/01/19	<u>Added:</u> Dave Hawk as plant manager. <u>Removed:</u> Eric Erickson as plant manager.
07/11/2018	Updated Version to 07/11/2018. Updated Certification body to NSF. Changed Local HACCP Coordinator to Stefanie Constantinescu, added in-house training. Changed SQF ed. to 8.0. Added Stefanie Constantinescu to team and removed Lacey Messing.
10/17/2017	Added Martha Luna and removed Jaci Gibbons (HR). Added Sodium Hydroxide, Caustic as an input for liquid sugar (West Warehouse) into the mixing stage.
09/20/2017	Revised HACCP team by removing Josh Sourapas and adding Maria Alvarez.
05/24/2017	Removed the Environmental Monitoring prerequisite program. Documented a validation of change & a notification letter outlining rationale. Added Craig Ashcraft to replace Dave Hawk.
04/20/2017	Removed: Kelly Malone as the local HACCP coordinator and Mark Hyer as HACCP team member. Added: Lacey Messing as the local HACCP coordinator. Updated training portion and contact information. Also added Kimberly Tkacs to the HACCP team.
08/25/2016	<u>Removed:</u> Local organizational chart. <u>Added:</u> Links to the Corporate Recall procedure.
12/09/2015	<u>Added:</u> Training for Bruce Rhodes, Dave Hawk, Deb Kvanli, Eric Erickson, Mark Hyer, Tim Vandeventer, and Kelly Malone. <u>Changed:</u> Trent Holcombe with Deborah Kvanli as Chief Chemist.
11/20/2015	<u>Reviewed:</u> HACCP plan with team members, signed approval page and verified flow diagram.

Amendments

10/29/2014	<u>Reviewed:</u> HACCP plan changes with team members, Eric Erickson, Tim Vandeventer, Jacci Ellis-Gibbons, Trent Holcomb, Josh Sourapas, Steve Willcuts, and Kelly Malone.
10/21/2014	<u>Removed:</u> Standard operating procedures and records from Food Safety Plan. <u>Changed:</u> The Master Plan to include the new corporate procedures and records.
06/05/2014	<u>Added:</u> Members of SQF Management Team to HACCP Team list.
07/22/2014	<u>Added:</u> Flow Diagram and Hazard Analysis for new liquid system in west warehouse. <u>Added:</u> CCP 19 to HACCP Master Plan <u>Added:</u> Molasses to Finished Product Profile on Coating Syrup

Training Log

11/30/2018	Stefanie Constantinescu FSPCA Preventive Controls for Human Food Course.
07/11/2018	Stefanie Constantinescu in-house training.
08/26/2016	Lacey Messing completed FSPCA Preventive Controls for Human Food course.
02/18/2016	Lacey Messing completed Two Day: Food HACCP Plan Development.
02/14/2016	Lacey Messing completed SQF Systems certification.
01/21/2016	Kelly Malone and Jeremy Adamson completed FSPCA Preventive Controls for Human Food course.
05/14/2015	Jeremy Adamson completed Three Day: Practical Food Safety and HACCP Workshop.
05/14/2015	Kelly Malone completed Three Day: Practical Food Safety and HACCP Workshop.