



Commercial Food Sanitation LLC
Version Date: March 27, 2013

Produce Equipment Design Checklist

S = Satisfactory
M = Marginal
U = Unsatisfactory

The Score will automatically calculate on the Summary page

Date: 5/8/2018
Completed By: Alfredo Jeronimo/HMI
Location: Gilroy CA
Description: Audit of SD3000S DRYER
Review Description:

#	Description	S	M	U	NA	Comments
PRINCIPLE #1 - CLEANABLE TO A MICROBIOLOGICAL LEVEL						
1.1	Equipment is designed to be constructed & maintained in a cleanable condition to prevent the ingress, survival & multiplication of microorganisms (measured post installation).	X				Post installation swabbing required by end user.
1.2	All surfaces are cleanable as measured by <1 CFU per 25 square centimeters, <1 CFU per 10 ml when the item is rinsed, acceptable RLU (device specific) when measured by residual ATP, and/or negative for residual protein or carbohydrate when using swabs to detect residual protein or carbohydrate (measured post installation).			X		Some surfaces in the chassis still require Turntable to be spun to access
1.3	All surfaces are accessible for mechanical action during cleaning & treatment to prevent biofilms formation (measured post installation).		X			Some non food contact surfaces are accessible only after unbolting parts.
1.4	When requested, data are available to demonstrate that soiled equipment is cleanable (as defined above) by an individual using the cleaning protocol provided by the equipment supplier (measured post installation).	X				Standard sanitation procedure provided by end user.
1.5	Surfaces are clean visually and to touch, & pass pre-op inspections using sight, touch & smell (measured post installation).	X				Post installation swabbing required by end user.
1.6	A HACCP based product risk assessment was completed during the design phase to understand risks associated with the product type	X				Zone 1 food contact surfaces are all cleanable and free draining.
1.7	Method of cleaning needed for the product risk was incorporated into the chosen design of the equipment	X				Standard sanitation procedure provided by end user.
1.8	Equipment has no apparent flaws that will fail over its life and make it uncleanable	X				
		140	/160			
PRINCIPLE #2 - MADE OF COMPATIBLE MATERIALS						
		S	M	U	NA	Deficiency
2.1	Product Contact Surfaces must be made with materials which are corrosion resistant, non-toxic, and non-absorbent and approved.	X				
2.2	In general, Stainless Steel shall be A1SI 300 series or better.	X				
2.3	Composites & plastics remain intact without changes in shape, structure & function thru cleaning & sanitation protocols. These should be easily removed and replaced as needed.	X				
2.4	Plated, painted & coated surfaces are not used for food contact surfaces or for surfaces above the product zone areas.	X				
2.5	Clotm back belts are not used.				X	
2.6	Metals used are compatible with one another.	X				
2.7	Seals and O-rings will be designed to minimize product contact.	X				
2.8	Materials used in construction are compatible with the product, the environmental conditions they will be exposed and cleaning methods & chemicals.	X				
		100	/100			
PRINCIPLE #3 - ACCESSIBLE FOR INSPECTION, MAINTENANCE, & CLEANING/SANITATION						
		S	M	U	NA	Deficiency
3.1	All product zone surfaces are readily accessible for cleaning and inspection	X				
3.2	Product zone components with inaccessible surfaces can be easily dis-assembled without tools.	X				
3.3	Where access or disassembly is not possible, the entire assembled unit is cleaned via a COP (clean out of place) tank.			X		Too large
3.4	Parts remain attached or are hung on the equipment for easy cleaning & to prevent damage or loss. Separate parts carts are supplied as an alternative.	X				
3.5	Machinery and chain guards drain away from product zones and are easily removed.	X				
3.6	Product catch pans or drip pans are easily removable for clean-up so that they are not lost or separated from the equipment.		X			Gutters are fixed with hardware but still accessible and easy to clean and also will not get lost or separated from equipment
3.7	All belting is easily removable or the belt tension is released easily without tools so the surfaces underneath can be cleaned.				X	
3.8	Installation will maintain an 18" floor clearance for any product contact areas or conveyor travel paths. Equipment design has 12 inches of clearance to the floor.	X				
3.9	Equipment is located 30 inches from overhead structures and 36 inches from the nearest stationary object	X				
3.91	All air, vacuum, & product hoses are transparent or opaque, & meet product contact surface guidelines.	X				
3.92	All utility (electric, air, vacuum) lines should be separated (not bundled) or enclosed in smooth conduit or dust free enclosures to avoid soiling and/or allow for cleaning.	X				
		135	/150			
PRINCIPLE #4 - NO LIQUID COLLECTION						
		S	M	U	NA	Deficiency
4.1	All surfaces are designed to eliminate water pooling & be self-draining.	X				
4.2	Round framework is used for horizontal members wherever possible.		X			Marginal amounts of horizontal surfaces present. Top of Pedstools and bottom of Chassis
4.3	Where square or rectangular basis is are used the flat surface is turned 45 degrees to horizontal where possible.	X				
4.4	All open surface areas are made of sufficient strength to prevent warpage & subsequent pooling of water.	X				
4.5	Moisture does not drip, drain, or drawn into product zone areas.	X				
4.6	Dead spaces or dead ends are eliminated in design.	X				
4.7	Materials used shall be non-absorbent.	X				
		80	/85			

SANITARY DESIGN AUDIT

PRINCIPLE #5 - HOLLOW AREAS HERMETICALLY SEALED						
		S	M	U	NA	Deficiency
5.1	All rotating members, such as drive sprockets or belt pulleys, are to be solid or filled with dye and fully sealed with continuous welds.	X				
5.2	All stationary hollow tube construction, such as frame members or blade spacers, are fully sealed with continuous welds to prevent interior contamination.	X				
5.3	There are no fastener penetrations into hollow tube construction.	X				
5.4	Threaded leg adjustments are internal and do not penetrate the tube frame members.				X	
5.5	Name plates & tags are minimized. When attached, plates & tags are continuously welded. Rivets or screw attached plates (often sealed with caulk) are absent.	X				
5.6	Void areas do not exist that would allow a harborage and growth point.	X				
		150	/150			
PRINCIPLE #6 - NO NICHES						
		S	M	U	NA	Deficiency
6.1	Surface Texture of a product contact surface shall not exceed 32 µ-inch.	X				
6.2	Surface Texture of a non-product contact surface shall not exceed 125 µ-inch.	X				
6.3	Internal corners and angles shall have a smooth and continuous radius of atleast 2 inches (50mm), (angles of less than 135°)	X				
6.4	Hermetically sealed spacers are used to allow for space between two adjoining pieces to permit mechanical action during cleaning.	X				
6.5	All joints and welds are flush, smooth and polished and free of pits, cracks, and corrosion. There are no lap joints.	X				
6.6	Press and shrink fits are not used.	X				
6.7	Fasteners are not used in or above the product zone.		X			Screw is welded on top of the UBA to provide additional support.
6.8	Belt scrapers and support are constructed from a single piece of material without lap joints and are removed without tools.				X	
6.9	Piano hinges, knurling, braided covers, and socket head cap screws are not used.	X				
		95	/100			
PRINCIPLE #7 - SANITARY OPERATIONAL PERFORMANCE						
		S	M	U	NA	Deficiency
7.1	Buttons on control panels are easily cleaned & sanitized during operations.	X				
7.2	All compressed air used for blowing on the product or contact surfaces is filtered to a minimum of a 0.3 micron level and dried to prevent the formation of moisture in the piping system.	X				
7.3	No bearings are present in product contact zone areas.	X				
7.4	Separation between product contact & non-product contact areas prevents cross contamination during operations.	X				
7.5	All surfaces near the product contact zone areas are designed as if they were product contact zone areas.		X			Truntable needs to be spun to gain full access to surfaces
7.6	Product contact surfaces are designed to prevent build-up of product residue during operations.	X				
		92.5	/100			
PRINCIPLE #8 - HYGIENIC DESIGN OF MAINTENANCE ENCLOSURES						
		S	M	U	NA	Deficiency
8.1	Drives, chain guards, electrical control boxes, and bearings are not located over open product zones.	X				
8.2	Control and junction boxes are fastened to the frame in a manner consistent with the sanitary design principles.	X				
8.3	Utility supply lines & pipes are separated to prevent catch points and to allow for cleaning.	X				
8.4	Conduit & supply lines are not routed above product contact areas.	X				
8.5	Maintenance enclosures in direct wash down areas must be able to be exposed to water and chemicals used in cleaning & sanitation (securing with a plastic bag is not acceptable).	X				
		60	/60			
PRINCIPLE #9 - HYGIENIC COMPATIBILITY WITH OTHER SYSTEMS						
		S	M	U	NA	Deficiency
9.1	Exhaust systems have welded seams with adequate access for cleaning and inspection.	X				
9.2	Vertical duct sections have a drain (e.g., to the floor) to prevent drainage from going back into the equipment.	X				
9.3	Separate exhausts are supplied for raw and RTE product zones.	X				
9.4	Cleaning methods are supported appropriate utilities and chemical systems to allow for effective and timely cleaning.	X				
9.5	Water discharged during the production or cleaning process is capable of being being accepted by the drainage system without a resulting back up caused by soil in the discharge or hydrolic load.	X				
		50	/50			
PRINCIPLE #10 - VALIDATED CLEANING & SANITIZING PROTOCOLS						
		S	M	U	NA	Deficiency
10.1	Cleaning & sanitizing of equipment as designed is safe (for employees and food) and is completed in an effective and efficient manner.	X				
10.2	Cleaning and sanitation protocols are have been developed by the manufacturer, validated by a third party, and provided in a training manual that is easily read and understood by cleaning and sanitation employees.	X				
10.3	Equipment design and materials are capable of withstanding standard clean-up procedures. Equipment materials have been reviewed with the MSDS for the cleaning and sanitizing chemicals to assure compatibility.	X				
		45	/45			

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