

HYGIENIC DESIGN FOR PRODUCE FARMS

Introduction

The purpose of hygienic design is to intentionally create or improve spaces and equipment so that they can be cleaned and sanitized as appropriate. The motivation for this is the reality that microorganisms such as human pathogens are small and can persist in even the tiniest of spaces in the right conditions. The role of hygienic design is to prevent this by incorporating, often passive, design features into equipment and buildings to minimize or eliminate harborage of human pathogens.

The **5 key principles of hygienic design*** related to produce farms include:

1. **Visible and Reachable Surfaces** - If you can't see it and can't reach it... you can't clean or sanitize it.
2. **Smooth and Cleanable Surfaces** - Surfaces should be smooth and cleanable to enable efficient and complete cleaning.
3. **No Collection Points** - Niches, sandwich joints, lap joints, and flat or concave horizontal surfaces should be avoided to prevent the collection of water and material.
4. **Compatible Materials** - Materials should be compatible with the product being handled and the cleaning and sanitization processes used.
5. **Preventing Contamination** - Handling systems and buildings should protect the product from contamination.

Visible and Reachable Surfaces

A surface must be visible and reachable in order to be adequately maintained, including cleaning. This does not mean the surface must *always* be accessible. For example, often drive components of a machine have protective covers

* This is a summarized list of hygienic design principles intended for produce growers limited to on-farm washing and packing operations. There are complete courses that address the topic, more detailed publications, and also lengthy industry checklists that can be consulted for more in-depth coverage. For more information, please see the references noted in each section and at the end of this document.

The inside of this produce brush washer has areas that are hard to reach and see which makes cleaning challenging.



to prevent worker injury. However, these covers should be able to be removed to allow for cleaning of equipment on a regular basis.

If tools are required to partially disassemble a machine prior to appropriate cleaning, the tools should be clearly marked for that purpose, a **standard operating procedure (SOP)** should be developed for the steps involved, and employees responsible for the process should be trained accordingly.

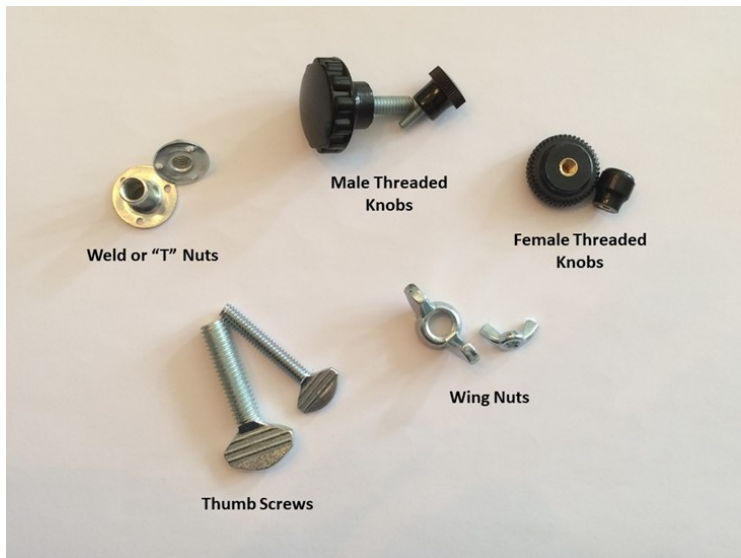
It may be helpful to purchase a mirror for inspection and a flashlight to improve your ability to see some of the far



This produce rinse conveyor is normally run in a horizontal position, but opens up with a hinge and pneumatic cylinders to allow access, visibility, and cleaning of the conveyor belt and tanks underneath.

corners inside and under equipment.

Cleaning procedures may require partial disassembly of equipment for adequate cleaning of food contact surfaces. It may be possible to replace nuts and bolts on guards and shields with other “tool free” fasteners (e.g., weldnuts, weldstuds, wingnuts, camlocks, or twist locks) that are easier to remove or operate and don’t require tools. Some fasteners allow for disassembly without resulting in loose parts, which can reduce mechanical contamination risk. Consult with the manufacturer and the equipment manual before making changes. Always disconnect power, shut off equipment water supply, and de-energize all other relevant



▲ There are fasteners beyond nuts and bolts that can make disassembly and reassembly easier and reduce the risk of losing parts. The fasteners above are available from most hardware stores.



▲ The use of clamping handles can allow for tool-less disassembly and reassembly with fasteners that stay connected to the equipment.

What is an SOP?

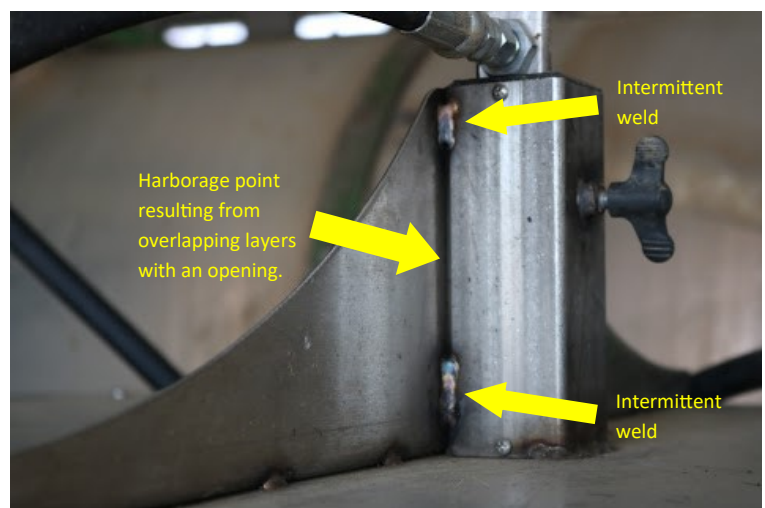
A Standard Operating Procedure (SOP) is a document that captures the standard set of steps and actions required to perform a routine task. An SOP is intended to ensure that multiple people can perform the same job, at the same level of quality with a predictable outcome. This document can take many forms include photographic, written, video, wall poster, or permanent labeling on a machine. An SOP is usually accompanied by an activity log to document the activity that was completed with date, time, person responsible and any significant challenges or findings.

utilities before cleaning. Let others in the work area know that you will be cleaning the machine and that the utilities are off for a good reason and should not be turned back on until the cleaning is complete. Consider implementing a lock-out, tag-out (LOTO) procedure and training employees in it.

It may be helpful to purchase a mirror for inspection and a flashlight to improve your ability to see some of the far corners inside and under equipment.

Smooth and Cleanable Surfaces

Often the best hygienic design elements are passive. Smooth, filleted or rounded welds at the corner of tanks lead to more effective cleaning. Favor continuous welds over intermittent welds. Grind and sand the welds smooth to improve cleaning. Avoid hollow member construction and areas with sandwiched or lapped layers of material such as the space



▲ This joint illustrates how intermittent welds lead to a gap, or sandwich joint that can lead to harborage. A continuous weld that is then ground smooth would lead to a seal and be easier to clean, sanitize, and dry completely.

inside the top edge of tank formed by rolled or crimped sheet metal. Another common practice is to avoid flat horizontal surfaces in structural members of a machine opting for circular tube construction or rotated square stock instead. Rotating square stock to a 45° angle reduces areas where water and soil can collect.

No Collection Points

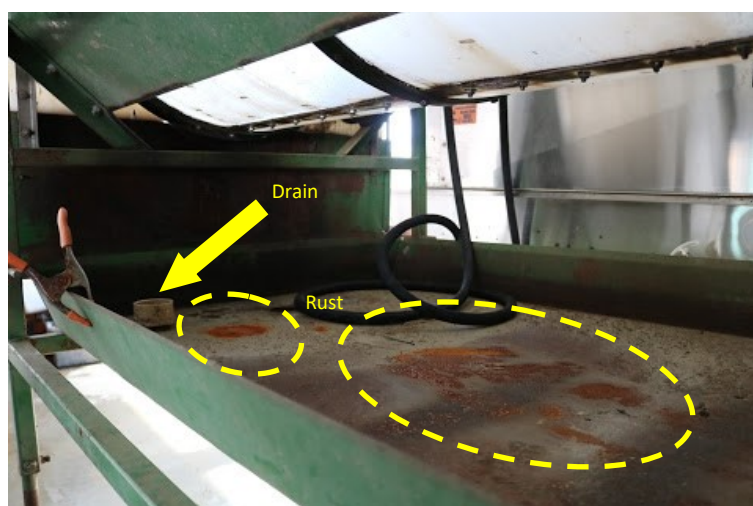
Another key principle of hygienic design is avoiding spaces where water and other material can collect. This includes niches and sandwich joints. Sandwich joints are common where two surfaces are brought together in an assembly and are not completely sealed with a continuous weld that is then ground smooth. A narrow harborage site results

What is harborage point?

Harborage sites are places where water and pathogens can enter and be protected from cleaning, and sanitizing, and drying. This can lead to cross-contamination between batches and can also lead to premature corrosion and rot of equipment materials.

between two surfaces. These harborage sites allow water and solids to accumulate. This provides conditions that support the growth of microorganisms including human pathogens.

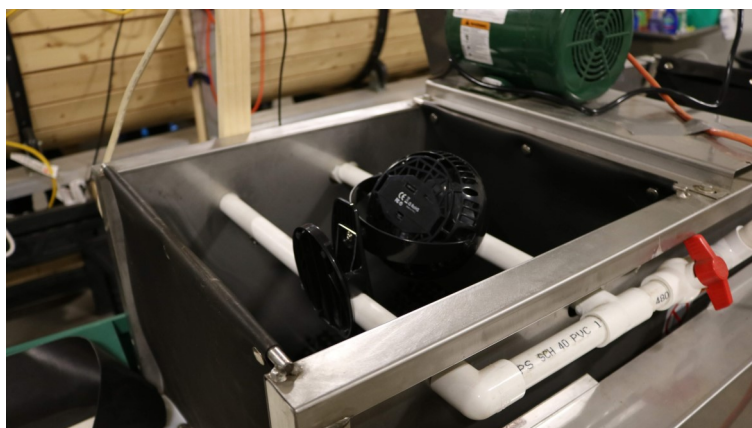
Hollow spaces, such as the interior of tube or square stock



▲ This collection pan is an intentional collection point that should allow for collected water to easily drain. The rust spots are evidence that it doesn't drain completely and therefore doesn't dry easily. An increased pitch in the pan or a "break" in the sheet could create more aggressive draining and better cleaning, sanitizing and drying as a result. The rust also suggests the material isn't compatible with the use.

structural members, can also become harborage locations if they are not completely sealed. A little bit of seepage of water and organic matter with each day of produce washing can accumulate in a hollow space over time. These spaces hold moisture and also promote rusting of steel equipment.

Collection points are, unfortunately, very common on produce equipment. They result from assembly practices that are favored because they are relatively inexpensive and easy. Some ways to address existing collection points may include adjusting the legs on equipment to achieve a slight



▲ A small clip-on fan is attached to this brush washer following a cleaning and sanitizing procedure to push air into the enclosed portion of the machine to promote drying.

pitch to encourage flow to a drain, re-breaking (bending with cross diagonals) or replacing sheet metal collection pans with more aggressive drain pitch, adding bottom drain ports to



▲ A variety of cleaning tools may be needed to easily reach and completely clean produce wash equipment. From left to right: extension sticks with scrubbers on the end, stiff short brush, toilet brushes, large bottle brush, paint scraper, scrub pads, assorted bottle brushes large to small, long scrub brush, inspection mirror, small bottle brushes, assorted test strips.

equipment with difficulty draining from existing side ports, and including a squeegee and towel dry step to a cleaning SOP for particularly challenging areas.

Fans and blowers can be very helpful in promoting drying of equipment after cleaning and sanitizing. This drying step is very important as a means to remove the availability of water that can promote pathogen survival and growth. The wash/pack area can be warmed slightly with a space heater to reduce the relative humidity of the air and increase the air's capacity to carry water away as vapor which speeds and deepens the drying. Floor fans or blowers designed for drying floors and carpets are portable and inexpensive tools for supplying large amounts of air flow to the inside of equipment that may otherwise be difficult to dry. It is also important to provide some ventilation of the wash/pack area to encourage air exchange. The air that is made humid from drying equipment needs to be exhausted outside and fresh, relatively dry air needs to be drawn in from outside. The relative humidity of the air can be reduced by heating to improve rate and efficacy of drying.

Special cleaning tools may be helpful in reaching far corners that are not easily accessible or for fitting into small areas that are otherwise hard to clean. It may take some experimentation and ingenuity to find the right tool. Ladders may also be helpful for getting above the equipment to inspect for cleanliness and to complete the cleaning process. Finally, it may be helpful to turn certain machines on their side or upside down to access certain hard to reach areas. Some of this work may require a second or third partner to be completed safely.

Compatible Materials

The materials used in the construction of equipment must be compatible with both the product the machine is handling and also the cleaning and sanitizing procedures used. Appropriate materials are generally smooth, durable, corrosion resistant, and impermeable to water. This includes being compatible with cleaners and sanitizers and generally favors stainless steels and food grade plastics since these materials have been developed specifically for this type of use.

Incompatible materials will degrade more quickly due to nicks, cracks, corrosion and other wear. Painted carbon steel may not hold up well to water and eventually the paint will

flake and the steel will rust. Both of these could become mechanical and/or chemical contaminants and will result in the surfaces not being cleanable.

Consider the chemicals in the cleaners and sanitizers you use relative to the materials in your equipment. Think beyond the obvious food contact surfaces and consider rubber seals, bearings, drive components, electrical housings, etc.

Preventing Contamination

The layout, construction, and materials used in handling equipment and buildings should prevent the contamination of product from the environment, the building, the equipment and by cross-contamination among the product itself.

This includes excluding animals that may introduce fecal or other contaminants. Passive measures can be very effective at excluding birds (rafter netting) and rodents (wire mesh or hardware cloth in framing). Maintaining a clean area around the building helps to reduce attraction and cover for wildlife pests. Keeping cull piles to a minimum and locating away from the wash/pack area, trimming grass, and keeping items in storage at least 6" from the walls can all help to reduce attraction and cover for pests. Exterior baiting and exterminating can be used as a final option.

Evaluating Equipment and Buildings for Hygienic Design

The principles of hygienic design can be readily applied to any piece of equipment or building. The accompanying checklist has been developed tailored to farm-based produce handling equipment and buildings. It is based on other, more extensive guides from the processing industry. This checklist provides for a focused evaluation against the principles outlined above. The checklist is available as a spreadsheet that will sum the ratings based on the reviewer's assessment. It is also attached as the last pages of this guide as a hand-written sheet.

Conclusion... It is Never Done.

Hygienic design is a process of continual improvement. The checklists available are meant to aid in evaluating equipment and buildings as a "snapshot" of one point in time. The act of reviewing the equipment or building should motivate a plan for improving certain areas of design. Once those changes are made and put into practice, the team can review the

equipment again. These checklists can also be helpful in identifying either preventive or reactive maintenance of equipment and buildings that may not be obvious during normal operation. A team approach to review is encouraged to provide multiple perspectives from multiple users with different skills and ideas.

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Acknowledgments

Funding for this statement, publication, press release, etc. was made possible, in part, by the Food and Drug Administration through grant PAR-16-137 and by the USDA's National Institute of Food and Agriculture through the Specialty Crops Research Initiative under award number 2016-51181-25402 and Food Safety Outreach Program award 2016-70020-25792 accession 1010528. The views expressed in the written materials or publications and by speakers and moderators do not necessarily reflect the official policies of the U.S. Department of Health and Human Services or the U.S. Department of Agriculture; nor does any mention of trade names, commercial practices, or organization imply endorsement by the United States Government.



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Hygienic Design Checklist - On-Farm Equipment and Buildings Used for Handling and Washing Produce

INSTRUCTIONS

Step 1 - Complete the Background Information. Use one sheet for each piece of equipment.

On-Farm Hygienic Design Review Checklist v1.1.xlsx - Excel

File Home Insert Page Layout Formulas Data Review View Developer Team Tell me what you want to do...

P5

Hygienic Design Checklist - On-Farm Equipment and Buildings Used for Handling and Washing Produce

Reviewer: C. Callahan Date: 30-May-19

Farm: Mirkey Holler Rydye Farm

Piece of Equipment: Apple wash line #1

Function (crops handled, what does the machine do?): Apples, initial dump, brush section, drying conveyor

Overall Rating: 148 / 260 ___ / 260 Add all five sections

55% ___ % Divide by 260

Visible and Reachable Surfaces - If you can't see it and can't reach it... you can't clean or sanitize it.	Rating Range	Rating Given	Notes & Follow-up Plan of Action
1 All primary food contact surfaces (Zone 1) are visible and reachable without significant effort or tools. ... are not visible and reachable, but can be made so with ease (e.g. no tools needed, steps are obvious).	7-10 3-6	8	

Step 2 - Evaluate the piece of equipment and its surroundings following the prompts.

These prompts are to help you think about which category of hygienic design to consider.

The rating ranges are provided to guide your assessment of the hygienic design.

Function (crops handled, what does the machine do?): Apples, initial dump, brush section, drying conveyor

Overall Rating: 55% ___ % Divide by 260

Visible and Reachable Surfaces - If you can't see it and can't reach it... you can't clean or sanitize it.	Rating Range	Rating Given	Notes & Follow-up Plan of Action
1 All primary food contact surfaces (Zone 1) are visible and reachable without significant effort or tools. ... are not visible and reachable, but can be made so with ease (e.g. no tools needed, steps are obvious).	7-10 3-6	8	
2 All secondary food contact surfaces (Zone 2) are visible and reachable without significant effort or tools. ... are not visible and reachable, but can be made so with ease (e.g. no tools needed, steps are obvious).	7-10 4-6	5	We should have a 120" roller...
3 All other equipment surfaces (Zone 3) are visible and reachable without significant effort or tools. ... are not visible and reachable, but can be made so with ease (e.g. no tools needed, steps are obvious).	7-10 4-6	2	We should put covers on the rollers...
4 Personnel responsible for cleaning and sanitizing are trained in and capable of performing the standard operating procedures required to adequately complete the tasks required to ensure visibility and reachability are achieved.	10 40	21	55% Need to schedule this...

Smooth and Cleanable Surfaces - Surfaces should be smooth, cleanable, and dryable to enable efficient and complete cleaning.

Smooth and Cleanable Surfaces - Surfaces should be smooth, cleanable, and dryable to enable efficient and complete cleaning.	Rating Range	Rating Given	Notes & Follow-up Plan of Action
1 All food contact surfaces are smooth and cleanable.	0-10	9	New belt upgrade is working well.
2 Fasteners used do not introduce harborage sites.	0-10	8	
3 All food contact surfaces dry well without supplemental drying step or additional air flow.	0-10	6	Need to add a fan for drying the deep corners.
4 All interior, non-food contact surfaces are easily cleanable without significant effort or tools. ... are not easily cleanable, but can be made so with ease (e.g. no tools needed, steps are obvious).	7-10 4-6	5	We need more of those special brushes and they need to be stored in one place.
5 All other equipment surfaces (Zone 3) are easily cleanable without significant effort or tools. ... are not visible and reachable, but can be made so with ease (e.g. no tools needed, steps are obvious).	7-10 4-6	4	It'd be great to have an easier way of removing panel B for cleaning. Clamping handle?
6 Building design, including fresh surfaces allows for cleaning and drying.	0-10	7	Timbers...
7 Personnel responsible for cleaning and sanitizing are trained in and capable of performing the standard operating procedures required to adequately complete the tasks required to ensure adequate cleaning, sanitizing and drying are achieved.	0-10 70	3	The SOP needs more detail about what brushes to use and what "clean" really looks like.

No Collection Points - Niches, sandwich joints, lap joints, and flat or concave horizontal surfaces should be avoided to prevent the collection of debris.

Notes and Instructions Checklist - Blank Checklist - Example Revision History

NOTE: The green boxes with bold outlines are where you enter your data. The bold groupings indicate that only one of multiple cells / rating brackets should be entered.

The "Notes and Follow-up Plan of Action" section is a place to make note of specific things you considered in determining your rating and/or specific action you plan to take to improve the hygienic design.

Step 3 - Review each section's total score and the overall score. Take stock of your notes and develop an overall action plan to implement improvements

On-Farm Hygienic Design Review Checklist v1.1.xlsx - Excel

File Home Insert Page Layout Formulas Data Review View Developer Team Tell me what you want to do...

P5

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Reviewer: C. Callahan Date: 30-May-19

Farm: Mirkey Holler Rydye Farm

Piece of Equipment: Apple wash line #1

Function (crops handled, what does the machine do?): Apples, initial dump, brush section, drying conveyor

Overall Rating: 148 / 260 ___ / 260 Add all five sections

55% ___ % Divide by 260

Visible and Reachable Surfaces - If you can't see it and can't reach it... you can't clean or sanitize it.	Rating Range	Rating Given	Notes & Follow-up Plan of Action
1 All primary food contact surfaces (Zone 1) are visible and reachable without significant effort or tools. ... are not visible and reachable, but can be made so with ease (e.g. no tools needed, steps are obvious).	7-10 3-6	8	

On-Farm Hygienic Design Checklist

Hygienic Design Checklist - On-Farm Equipment and Buildings Used for Handling and Washing Produce

Reviewer: _____
 Farm: _____
 Piece of Equipment: _____
 Function (crops handled,
 what does the machine do?): _____

Date: _____

Overall Rating: 0 / 260 ____ / 260 Add all five sections

0% ____ % Divide by 260

Visible and Reachable Surfaces - If you can't see it and can't reach it... you can't clean or sanitize it.		Rating Range	Rating Given	Notes & Follow-up Plan of Action
1	All primary food contact surfaces (Zone 1) are visible and reachable without significant effort or tools.	7-10		
2	... are not visible and reachable, but can be made so with ease (e.g. no tools needed, steps are obvious).	3-6		
3	... are not visible and reachable, but can be made so with some effort (e.g. tools and skill required).	0-2		
4	All secondary food contact surfaces (Zone 2) are visible and reachable without significant effort or tools.	7-10		
5	... are not visible and reachable, but can be made so with ease (e.g. no tools needed).	4-6		
6	... are not visible and reachable, but can be made so with some effort (e.g. tools and skill required).	0-3		
7	All other equipment surfaces (Zone 3) are visible and reachable without significant effort or tools.	7-10		
8	... are not visible and reachable, but can be made so with ease (e.g. no tools needed, steps are obvious).	4-6		
9	... are not visible and reachable, but can be made so with some effort (e.g. tools and skill required).	0-3		
10	Personnel responsible for cleaning and sanitizing are trained in and capable of performing the standard operating procedures required to adequately complete the tasks required to ensure visibility and reachability are achieved.	10		

40

0

0%

Smooth and Cleanable Surfaces - Surfaces should be smooth, cleanable, and dryable to enable efficient and complete cleaning.		Max Rating	Rating Given	Notes & Follow-up Plan of Action
1	All food contact surfaces are smooth and cleanable.	0-10		
2	Fasteners used do not introduce harborage sites.	0-10		
3	All food contact surfaces dry well without supplemental drying step or additional air flow.	0-10		
4	All interior, non-food contact surfaces are easily cleanable without significant effort or tools.	7-10		
5	... are not easily cleanable, but can be made so with ease (e.g. no tools needed, steps are obvious.)	4-6		
6	... are not easily cleanable, but can be made so with some effort (e.g. tools and skill required)	0-3		
7	All other equipment surfaces (Zone 3) are easily cleanable without significant effort or tools.	7-10		
8	... are not visible and reachable, but can be made so with ease (e.g. no tools needed, steps are obvious).	4-6		
9	... are not visible and reachable, but can be made so with some effort (e.g. tools and skill required).	0-3		
10	Building design, including finish surfaces allows for cleaning and drying.	0-10		
11	Personnel responsible for cleaning and sanitizing are trained in and capable of performing the standard operating procedures required to adequately complete the tasks required to ensure adequate cleaning, sanitizing and drying are achieved.	0-10		

70

0

0%

On-Farm Hygienic Design Checklist

No Collection Points - Niches, sandwich joints, lap joints, and flat or concave horizontal surfaces should be avoided to prevent the collection of water and material.		Max Rating	Rating Given	Notes & Follow-up Plan of Action
1	Equipment is designed to allow for drainage of all water and complete drying.	6-10		
2	... has relatively few points where water can occasionally collect and be dried.	0-5		
3	Utilities such as electrical, air and water supplies do not introduce harborage areas.	0-10		
4	Personnel responsible for cleaning and sanitizing are trained in and capable of performing the standard operating procedures required to ensure adequate cleaning, sanitizing and drying are achieved in consideration of any specific harborage potential on this	0-10		
		30	0 0%	

Compatible Materials - Materials should be compatible with the product being handled and the cleaning and sanitization processes used.		Max Rating	Rating Given	Notes & Follow-up Plan of Action
1	Equipment is made of materials that are compatible with use and planned cleaning materials and methods.	6-10		
2	... includes coatings (e.g. paint) over base material that are compatible with use and planned cleaning materials and methods.	0-5		
3	Moving parts are supported by bearings designed for long-term use in food applications.	0-10		
4	Equipment is made of materials that will not chip, flake, or otherwise break off and become a contaminant in food.	0-10		
5	Equipment is inspected on a regular basis for wear and repair needs, and maintenance is completed in a timely and skillful manner.	0-10		
		40	0 0%	

Preventing Contamination - Handling systems and buildings should protect the product from contamination.		Max Rating	Rating Given	Notes & Follow-up Plan of Action
1	Water supply is from a known source of safe and adequate sanitary quality.	0-10		
2	Condensation, dripping, leaks, and pooling / standing water are avoided and/or managed to prevent food contact (e.g. cooler evaporator drains, cold water supplies).	0-10		
3	Animal intrusion is prevented (e.g. birds, rodents, domestic animals).	0-10		
4	Ventilation and pneumatic air systems do not introduce contaminants (e.g. filters and screens).	0-10		
5	Drains are functional and cleanable.	0-10		
6	Drains do not direct effluent water to production areas (e.g. fields), handling areas (e.g. other washing areas), traffic areas, storage areas, bodies of water, or other areas that could result in produce contamination.	0-10		
7	Product flow and movement of people is conducted in a manner that prevents cross contamination.	0-10		
8	Buildings are in good repair, free of chipping, flaking or other loose matter that could become product contamination.	0-10		
		80	0 0%	