

nants which may adversely affect the purity, quality, and wholesomeness of milk or milk products. The device shall be constructed so that it can be sealed by the department to prevent the changing of its sensitivity functioning level. The device shall automatically reject and make unusable any container which exceeds the sensitivity functioning level of the device, so as to prevent the further use or filling of the container with milk or milk products. The device shall be interconnected so that the system will not operate unless the detecting device is in proper operating condition. The dairy plant shall use a test solution standard consisting of 0.5 ppm petroleum distillate, or other standard approved by the department, for daily testing of the device to ensure that it is functioning at the proper detection level.

(13) **STORAGE OF CLEANED CONTAINERS AND EQUIPMENT.** Containers and other utensils used in the handling, storage, or transportation of milk or milk products shall, unless stored in bactericidal solution, be so stored as to drain dry and so as not to become contaminated before being used.

(14) **STORAGE OF SINGLE-SERVICE ARTICLES.** Single-service caps, cap stock, parchment paper, containers, gaskets, and other single-service articles for use in contact with milk and milk products shall be purchased and stored in sanitary tubes, wrapping, or cartons; shall be kept therein in a clean, dry place until used; and shall be handled in a sanitary manner.

(15) **PROTECTION FROM CONTAMINATION.** (a) Milk plant operations shall be conducted and equipment so located within the plant to prevent overcrowding and contamination of milk and milk products, ingredients, equipment and utensils and cleaned and sanitized containers.

(b) All milk or milk products or ingredients which have been spilled, overflowed, or leaked shall be discarded.

(c) Air and steam used to process products by direct introduction into the product shall be clean and of safe quality.

(d) Newly installed processing equipment shall be located at least 24 inches from any wall or any other piece of equipment more than 48 inches long. This does not apply to storage or silo tanks where the face of the tank extends through a wall into a processing room.

(e) During processing, pipelines and equipment containing or used to conduct milk and milk products shall be effectively separated from tanks or circuits containing cleaning or sanitizing solutions.

(f) Milk and milk products drained from processing equipment at the end of a run, or collected from a packaging defoamer system which does not continuously return the collected product to the filler bowl, may be salvaged for sale if the milk or milk products are collected and handled in a sanitary manner, held at a temperature of 45° F. or less, and repasteurized.

(g) All openings, including valves and piping attached to milk storage and milk tank trucks, pumps or vats shall be capped or otherwise protected to prevent contamination. During inside unloading at a receiving or transfer station or pasteurization plant, a suitable filter shall be used to cover the manhole opening unless the dust cover and the manhole cover are opened slightly and held in this position by the metal clamps used to close the covers.

(h) If air under pressure is used for the agitation or movement of milk, or is directed at a milk contact surface, the air shall be free of oil, dust, rust, excessive moisture, extraneous materials and odor. The use of steam containing a toxic substance is prohibited. If steam is used in contact with milk or milk products, it shall be of culinary quality. Steam and air under pressure shall originate from systems approved by the department.

(i) Standardization shall be completed before the pasteurization process is begun, but this does not preclude the standardization of pasteurized milk and milk products if protected against contamination. In no case shall pasteurized milk or milk products be standardized with unpasteurized milk unless the standardized product is subsequently repasteurized. Reconstituted or recombined milk and milk products shall be pasteurized after reconstitution or recombining of all ingredients.

(j) No poisonous or toxic materials, insecticides, rodenticides, sanitizers, caustic compounds and medicinal agents may be present in a dairy plant except as necessary for dairy plant maintenance and operations. These products and materials shall not be stored in any room where milk or milk products are received, processed, or stored, or where equipment, containers or utensils are washed or stored, or single-service containers, closures or caps are stored.

(k) Only insecticides and rodenticides approved for use by and registered with the department or the U.S. environmental protection agency shall be used for insect and rodent control. Insecticides and rodenticides may be used only in accordance with the manufacturer's label directions and in a manner which will prevent the contamination of milk and milk products, milk containers and closures, equipment or utensils.

(16) PASTEURIZATION. (a) All pasteurization equipment shall meet standards and requirements for the equipment as provided under s. Ag 31.06 (3), Wis. Adm. Code. The equipment shall be operated in a manner which will ensure that all products, during the pasteurization process, meet the criteria set forth in s. Ag 71.01 (5) or (6), Wis. Adm. Code.

(b) Grade A dairy plant operators shall maintain records of pasteurization of all milk or dairy products processed by them in the past 6 months. Records shall consist of recording charts, or records accurately showing the date of pasteurization, the time and temperature at which pasteurized, and the signature of the operator of the pasteurization equipment. The records shall include a record of a daily check of the recording thermometer for accuracy, the date on which the check was made, and the name of the person who checked the thermometer.

(17) COOLING OF MILK. (a) All raw milk and milk products shall be maintained at a temperature of 45° F. or less until processed.

(b) All pasteurized milk and milk products except those to be cultured, shall be cooled in approved equipment immediately after pasteurization to a temperature of 45° F. or less. All pasteurized milk and milk products shall be stored at a temperature of 45° F. or less.

(c) Every room or tank in which milk or milk products are stored shall be equipped with an accurate thermometer.

(d) Recirculated cooling water shall be of safe bacteriological quality and protected from contamination. It shall be tested every 6 months by a laboratory approved by the department. Freezing point depressants, if used in recirculating systems, shall be nontoxic.

(18) **BOTTLING AND PACKAGING.** (a) Bottling and packaging of milk and milk products shall be done at the place of final pasteurization.

(b) Packaging shall be performed in a sanitary manner with approved mechanical equipment.

(c) A drip deflector shall be installed on each filler valve. The drip deflector shall be designed and adjusted to divert condensation away from the open container.

(d) Container infeed conveyors to bottling or packaging machines shall have overhead shields to protect the bottles or packages from contamination. The shields shall extend from the bottle washer discharge or, where single-service containers are used, from the beginning of the conveyor to the bottle feed star on the filler.

(19) **CAPPING.** (a) Capping or closing of milk and milk product containers shall be done in a sanitary manner by approved mechanical capping or closing equipment.

(b) Hand capping is prohibited.

(c) The cap or closure for grade A milk and milk products shall protect the pouring lip or opening rim of the container to at least its largest diameter. Single-service containers shall be so constructed that the product, the pouring lip, and the opening rim and area are protected from contamination during handling, storage and the initial opening of the container.

(d) The cap or closure for fluid milk product containers shall be designed and constructed so that the container cannot initially be opened without breaking the cap or closure seal, or leaving other readily apparent evidence of the fact that the container has been opened.

(e) The contents of bottles and containers which have been imperfectly capped or closed shall be emptied into a sanitary container. The milk and milk products shall be repasteurized before repackaging, or be discarded.

(20) **PERSONNEL; CLEANLINESS.** (a) Dairy plant employes shall thoroughly wash their hands before beginning work and as often as necessary to remove soil and contamination. No employes shall resume work after visiting the toilet room without thoroughly washing their hands.

(b) All persons engaged in the processing, pasteurization, handling, storage, or transportation of milk, milk products, containers, equipment, and utensils shall wear clean outer garments.

(c) The use of tobacco by any person while engaged in the processing, pasteurization, handling, or storage of milk or milk products is prohibited.

(d) All persons shall wear clean head coverings while engaged in the processing, pasteurization, handling, and storage of milk or milk prod-

ucts, containers, equipment or utensils. Persons having a beard or sideburns shall also wear hair restraints for the beard or sideburns.

(21) **VEHICLES.** (a) All vehicles used for the transportation of pasteurized milk and milk products shall have fully enclosed bodies with well-fitted solid doors and be provided with sufficient refrigeration to maintain the temperature of the milk and milk products at 45° F. or less while on the transportation vehicle. The vehicle shall be kept clean and operated so that the milk or milk products are maintained at 45° F. or less, and are protected from the sun, freezing, and from other contamination.

(b) No contaminating substances are to be transported in a vehicle used for the transportation of pasteurized milk and milk products.

(22) **SURROUNDINGS.** Milk plant surroundings shall be kept neat, clean, and free from conditions which might attract or harbor flies, other insects, and rodents or which otherwise constitute a nuisance.

(23) **GRADE A TRANSFER STATION REQUIREMENTS.** Grade A transfer stations shall meet all applicable items of compliance as set forth in this section except those that apply to processing and storage of milk and milk products. All bulk milk tank trucks shall be inside the transfer station during the time milk is transferred from one tank truck to another.

(24) **INSTALLATION, CLEANING AND CONSTRUCTION OF C-I-P SYSTEMS AND PIPELINE CIRCUITS.** The construction and installation of C-I-P systems and pipeline circuits shall conform to the requirements of s. Ag 31.06 (4) (b) through (i) and (5) (b) through (j), Wis. Adm. Code. Cleaning and sanitizing procedures shall be as prescribed in s. Ag 31.07 (2), Wis. Adm. Code.

(25) **GRADE A DAIRY PLANT RECORDS.** In addition to other records required to be kept under this chapter, every dairy plant operator shall keep for at least one year, records of each producer showing the results of farm inspections, all milk quality tests conducted by the plant, and the date and quantity of any insanitary or adulterated milk rejected by the plant.

**History:** Cr. Register, August, 1967, No. 140, eff. 9-1-67; cr. (23), (24), Register, December, 1971, No. 192, eff. 1-1-72; am. (1) (intro.), (3) (b), (4), (5) (a), (6) (a) and (c), (7) (a), (8), (10) (b), (12) (a), (15) (a), (16) (a), (17) (a) (b) and (d), (18) (b), (19) (c), (20) (a) and (c), (21) (a) and (b) and (23), r. and recr. (5) (c), (7) (d), (11) (b), (12) (b) and (c) and (24), renum. (9) to be (9) (a) and am., cr. (4) (c), (5) (d) and (e), (7) (e), (9) (b), (10) (d) and (e), (11) (d) to (i), (12) (d) to (i), (15) (d) to (k), (16) (b), (18) (c) and (d), (19) (d) and (e), (20) (d) and (25), Register, November, 1980, No. 299, eff. 12-1-80.

**Ag 80.09 Animal health.** All milk shall be from herds which comply with animal health control provisions of ch. 95, Stats., and ch. Ag 10, Wis. Adm. Code.

**History:** Cr. Register, August, 1967, No. 140, eff. 9-1-67; am. Register, November, 1980, No. 299, eff. 12-1-80.

**Ag 80.10 Facilities for ungraded products.** (1) No grade A dairy plant shall receive any milk or milk products in or through equipment with which ungraded milk or milk products have been in contact unless the equipment has been first effectively cleaned and sanitized, and a record of the cleaning and sanitizing has been made as required under s. Ag 80.08 (12) (b), Wis. Adm. code.

Register, July, 1981, No. 307