

HALAL RISK PLAN SUMMARY – LAY HONG FOOD CORPORATION

a) Primary Processing

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
MCP 1 Determination of <i>Hayat Mustaqhirah</i>	Birds which do not meet <i>hayat mustaqirah</i> criteria and not alive before slaughtered.	Visual inspection, pulling the bird head for every bird in every load by the slaughter man to confirm the bird still alive before incision of the neck region is made	Every bird, record in every load Monitor the incision of the neck and checked the quantity also the knives condition of all slaughter man	Slaughter man	Immediate action: Birds which that do not meet <i>hayat mustaqirah</i> criteria will be taken down from the line by the slaughterman. Corrective Action: Retraining slaughterman about MCP 1 determination of <i>hayat mustaqirah</i>	WI 96 Penentuan Hayat Mustaqirah PF73 Daily Halal Poultry Processing Record PF74 Determination Hayat Mustaqhirah
MCP 2 Incision of the neck using sharp knife	The knife which not sharp can occur the trachea, and blood vessels not fully severed/ (terputus) and limited number of knife for slaughter man	Slaughter man will change the knife with sharp knife when the cutting is not sharp and monitor the incision is conducted at	Checks quantity and condition of the knives for every 15 to 20 minutes for each load before slaughtering.	Slaughter man and slaughter man leader	Immediate Action: Immediately change the knife. Corrective Action: Retraining to improve competency in	WI 99 Pemantauan Cara Sembelihan dan Penggunaan Pisau PF75 Sharp Knife Checklist

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		<p>one stroke by Halal checker</p> <p>Slaughter man leader checks the quantity and the condition of the knives at each slaughter man.</p>			sharpening and halal slaughter.	
MCP 3 Halal Checking before Scalding	The esophagus, trachea, and blood vessels at the neck are not fully severed/cut (terputus)	Visual inspection made by Halal Checker to ensure the trachea, esophagus, and blood vessels at the neck region of each bird area fully severed before scalding.	Checks the trachea, esophagus, and blood vessels at the neck region of each bird and record every load (MCP 3).	Halal Checker	<p>Immediate action: The birds which are not properly slaughtered shall be removed from shackles and discarded as non-proper slaughter.</p> <p>Corrective action: Training of Halal Checker and Halal Supervisor so that they are able to identify severed blood vessels, esophagus and trachea.</p>	<p>WI 97 Halal Checking before Scalding</p> <p>PF56 Daily Production Record</p> <p>PF76 Halal Checking before Scalding</p>

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MCP 4 Post Mortem Inspection	Chicken which is unfit for human consumption	Visual inspection every carcass and removal of unfit whole, parts and organ of each bird.	Visual inspection every bird and every load.	QC	<p>Immediate Action: Trim or condemn affected part and the organ will be removed then place into the condemn bin.</p> <p>Corrective Action: Training of Post-mortem Inspectors for competency in meat inspection.</p>	<p>WI 42 Dropping Carcass Sterilization</p> <p>WI 54 Judgement Post Mortem</p> <p>WI 56 Key Welfare Indicator</p> <p>WI 100 Pengurusan Ayam dan Organ condemn</p> <p>WI 110 Method of Manual Evisceration</p> <p>PF16 Daily Post mortem inspection checklist</p>
MCP 5 In out washer	The chlorine usage not achieve min 35 ppm and max 50 ppm of free chlorine, can increase possibility of bacteria grow like salmonella, E.coli	Check available free chlorine for every load using chemical test kit by QC.	Check available free chlorine for every batch, prior to start the new lot.	QC	<p>Immediate action: <u>A.Machine Breakdown</u></p> <p>1. QC Supervisor and Production Supervisor identify and</p>	<p>WI 50 In Out Washer Monitoring</p> <p>PF08 CCP monitoring sheet – CCP 1 In out washer</p>

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					<p>segregate affected product.</p> <p>2. The affected birds are dipped in chlorine solution manually for 2 minutes and re-hang on shackle.</p> <p>3. Maintenance personnel replace the chlorine machine with spare unit.</p> <p>B. <u>When critical is < 35 ppm or > 50 ppm</u></p> <p>1. QC Supervisor informs Maintenance personnel and Production Manager on the deviation.</p> <p>2. Maintenance</p>	

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					<p>personnel will replace the chlorine machine with the spare.</p> <p>3. QC Supervisor verifies chlorine dosage after machine has been replaced.</p> <p><u>Inadequate rinsing of carcass</u></p> <p>1. Processing line is temporarily suspended on the directive of QA Officer after receiving deviation report from QC Supervisor.</p> <p>2. Maintenance is responsible to repair or replace the nozzle to the satisfaction of</p>	

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					<p>QA Officer.</p> <p>3. QC Supervisor to immediately check chlorine level in sprayed water. If within specification monitor the pressure and immediately inform Production Executive.</p> <p>4. Production Executive to inform maintenance to monitor the level of water.</p> <p>5. QC Supervisor verifies chlorine dosage after machine has been replaced.</p> <p>6. If both chlorine</p>	

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					<p>machines breakdown, Production Manager or Executive will suspend production. Affected chlorine machine will be immediately repaired.</p> <p>7. The level of the free chlorine is verified by QC Supervisor.</p>	
MCP 6 Final Inspection and Carcass Washing	Carcass not clean, and still have <i>najis</i> on carcass	Visual inspection for each bird in every load. Quality QC monitors and records the finding.	Visual inspection each bird in every load and every load before entering air chilling room.	QC	<p>Immediate action: The chicken which found with <i>najis</i> shall be taken out from the line, wash to remove <i>najis</i> and place it back on to the line.</p> <p>Corrective action: To give briefing</p>	<p>WI 102 Inspection of carcass cleanliness</p> <p>PF77 Final Inspection and Carcass Washing</p>

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					or retraining to QC about carcass cleanliness inspection.	
MCP 7 Air chill	Product temperature $\geq 4^{\circ}\text{C}$ after air chill. Can increase possibility of bacteria grow like salmonella, E.coli.	QC monitors the product temperature upon exit from the air chiller by checking the core temperature of the deep breast muscle hourly.	Monitors hourly the product temperature upon exit from the air chiller.	QC, Qc Supervisor (calibrate thermometer), Maintenance (calibration)	Immediate action: a. QA Officer advises Production Manager or Supervisor to suspend production and the air chill line. b. Products that have exited air chiller to be kept in the basket covered with ice to reduce temperature. c. QC check product temperature in the basket after $\frac{1}{2}$ hour to ensure temperature achieved $\leq 4^{\circ}\text{C}$ before	WI 17 Air chill monitoring WI 36 Corrective Action - Microbe Test Result of Specification WI 60 Meat temperature monitoring PF09 CCP monitoring sheet – CCP 2 Air chilling

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					<p>work on the carcass resumed.</p> <p>d. If the carcass temperature is still >4 °C, transfer affected carcass to chill room and keep until temperature reduce.</p> <p>Corrective Action: Maintenance Refrigerator is responsible to investigate and identify the problem on the air chiller. Select the following options for corrective action:</p> <ul style="list-style-type: none"> • Check the leak and welding the affected area. • Change the solenoid coil. • Change the solenoid. 	

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					<ul style="list-style-type: none"> Defrost the coil and run the system. Repair the compressor. 	
MCP 8 Metal detector	Metal detector not working well and not able to detect test piece – Ferrous: 2.5mm, Non Ferrous: 3.0mm and Stainless Steel: 4.0mm. Possible sharp metal contaminations can occurred.	<p>QC ensure the metal detector is turned “ON”, working accordingly and check hourly by running a test piece through functional metal detector:–</p> <ul style="list-style-type: none"> Ferrous: 2.5mm, Non Ferrous: 3.0mm Stainless Steel: 4.0mm <p>The metal detector needed to be able to detect the test piece.</p>	<p>The metal detector should be “ON”, and check hourly by running a test piece whether be able to detect through functional metal detector:-</p> <ul style="list-style-type: none"> Ferrous: 2.5mm, Non Ferrous: 3.0mm Stainless Steel: 4.0mm 	QC ,Maintenance (preventive maintenance)	<p>Immediate Action:</p> <p>a. QC segregates the products from the last calibration, check and keep as ‘on hold’ product.</p> <p>b. QC Supervisor informs maintenance personnel to investigate and repair metal detector.</p> <p>c. The QC to do calibration after repairing completed.</p> <p>d. If necessary call supplier to repair metal</p>	<p>WI 61 Metal Detector Monitoring</p> <p>WI 62 Metal Detector Calibration</p> <p>WI 109 Disposition of Foreign Object</p> <p>PF10 CCP monitoring sheet – CCP 3 Metal detector</p> <p>PF39 Metal detector calibration record</p>

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					<p>detector.</p> <p>e. Run the 'on hold' product through metal detector.</p>	
MCP 9 Chill/Cold Room	<p>Temperature chill room $\geq 4^{\circ}\text{C}$</p> <p>Temperature for cold room is $\geq -18^{\circ}\text{C}$</p> <p>Can increase possibility of bacteria grow like salmonella, E.coli.</p>	QC monitors the room temperature hourly by reading the temperature sensor.	Monitors the room temperature hourly by reading the temperature sensor.	QC, Maintenance (calibration)	<p>Immediate action:</p> <p>a. QC Supervisor informs QA Officer, Maintenance Refrigeration and Store Executive on the deviation.</p> <p>b. Maintenance Refrigeration to investigate the possible cause of breakdown and carry out repairs accordingly.</p> <p>c. Store Supervisor to close the door. QC check the product temperature every $\frac{1}{2}$ an</p>	<p>WI 23 Chilled Room Monitoring</p> <p>WI 105 Penyusunan produk di dalam chill room</p> <p>WI 108 Cold Room Monitoring</p> <p>SOP-PRP-11 Product Storage and Distribution</p> <p>PF11 CCP monitoring sheet – CCP 4 Chilled room and transit room</p>

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					<p>hour.</p> <p>d. If the product temperature >4 °C, transfer product to transit room.</p> <p>Corrective Action: QA Officer creates awareness on the need of cold room door to be closed at all time.</p>	

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b) Further Processing

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
MCP 1 Verification Of Ingredients and Raw Materials On Arrival At the Plant	Invalid Halal certificate or Non Halal ingredients enter the premise.	1. Halal cum QA Executive verifies the validity of the Halal certificate of ingredients including COA, product specification 2. For raw materials must come with valid Halal Certificate by verify it on arrival for each consignment and QC will check and monitor of raw materials upon arrival at the plant and record it. 3. For ingredients, Store keeper to check on the P/O and D/O and ensure that ingredient tally with P/O and D/O meanwhile QC will monitor the ingredient closely including the	Checks every receiving	Halal cum QA Executive , QC	Immediate Action: 1. Hold the ingredient until the Halal Certificate is obtained and segregate the ingredient, sealed and labeled. 2. The Halal status of the ingredient is not verified will be rejected, reported to purchasing and returned to the supplier. Corrective Action: 1. To give briefing or retraining to QC, and Store Keeper about verification of	WI18 Checking Raw Meat Upon Receiving WI35 Imported frozen chicken MDM, SBB, Carcass receiving storage WI36 Ingredient receiving and storage PF42 Incoming Raw Material Checklist PF43 Incoming Raw Meat Checklist Purchase Order Halal Certificates Technical Document (COA, Product Specification)

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
		<p>vehicles condition upon arrival at the plant and record it.</p> <p>4. For raw materials and ingredient Halal Certificate must be obtain during purchase.</p> <p>5. QC Supervisor will verify the record of monitoring.</p> <p>6. Vehicles used by supplier are dedicated to halal and clean.</p>			ingredients and raw materials upon arrival.	
MCP 2 Weighing and Coding of the functional ingredient	Weighing the wrong amount and coding of ingredient.	<p>1. For monitoring of the weighing and coding of the ingredient, QC will check the weight and code no of the ingredient and QC Supervisor will verify the ingredient.</p> <p>2. Maintenance to do calibration of weighing</p>	Checks every batch	QC	<p>Immediate Action:</p> <ol style="list-style-type: none"> 1. On Hold the ingredient 2. Re-adjust the correct amount 3. Verify the correct amount 4. Verify and check the weighing machine <p>Corrective</p>	<p>WI-46 Penyediaan Bahan Pra Campuran</p> <p>WI-51 Prosedur Pemantauan Bahan Ramuan Kritikal</p> <p>WI-66 Prosedur Menimbang Bahan Mentah dan Bahan Ramuan Lain</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
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		machine as per calibration schedule.			Action: <u>Incorrect weight of ingredient</u> 1. QC On Hold incorrect weight of critical functional ingredient 2. QC inform person in charge immediately to adjust the correct amount 3. QC verify the weight after correction <u>Weighing machine not accurate</u> 1. QC inform Maintenance Maintenance to do calibration of weighing scale	PF19 OPRP 2 Monitoring Record Frankfurter PF31 OPRP 2 Monitoring Record Nugget PF40 OPRP 2 Monitoring Record Fried Chicken Certificate of Analysis (COA)
MCP 3 Grinding of Skin, MDM and SBB and Emulsifying of frankfurter (Bowl cutter)	Uses damage or contaminated skin, MDM and SBB.	For monitoring of the grinding of skin, MDM and SBB, and emulsifying, QC will check temperature of the final	Monitor every batch	QC	Immediate Action 1. Re-adjust the bowl cutter machine Corrective Action:	WI-52 Rework WI-63 Prosedur Mengadun di dalam bowl cutter PF22 Daily Quality

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
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(Premium Product)		emulsion. QC check on the consistency and texture of the final emulsion,			1. Preventive maintenance on emulsifier machine. 2. To give training on the operating of the machine and process	Inspection Frankfurter
MCP 4 Emulsifying Frankfurter (Non Premium Product)	Final emulsion temperature $\geq 10^{\circ}\text{C}$	For the monitoring of the emulsifying, QC will check temperature of the final emulsion. QC check on the consistency and texture of the final emulsion.	Monitor and checks every batch	QC	Immediate Action: 1. Re-adjust the emulsifier machine Corrective Action: 1. Preventive maintenance on emulsifier machine. 2. To give training on the operating of the machine and process	WI-67 Prosedur Pengemulsian PF22 Daily Quality Inspection Frankfurter
MCP 5 Grinding, Mixing and Freezing of Nugget (Nitrogen liquid)	Product temperature after forming $\geq -4^{\circ}\text{C}$ Operator not handling the liquid nitrogen correctly	For the monitoring of the grinding, mixing and freezing of nugget, QC will check the temperature of the emulsion dough after freezing.	Monitor and check every batch	QC , Safety Officer (training)	Immediate Action: 1. Re-adjustment the mixer machine 2. Adjust the setting of the usage of liquid nitrogen	WI-72 Proses Mengadun Nugget PF33 Daily Quality Inspection Nugget PF34

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
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		<p>Safety handling of liquid nitrogen by gives the training to the worker in charge of the mixer machine.</p> <p>Monitoring:</p> <ul style="list-style-type: none"> • QC check temperature of the nugget dough after complete freezing process. • Operator s follows the procedure of safety handling of liquid nitrogen during process of mixing & freezing nugget. 			<p>Corrective Action:</p> <ol style="list-style-type: none"> 1. Preventive maintenance on the mixer machine. 2. To give training on the operating of the machine and process 	Daily Quality Inspection Tempura
MCP 6 Cooking	Product core temperature <73°C	For monitoring of the cooking process, QC will check internal core temperature of product after	Monitor performed every hourly after cooking	QC , Maintenance (calibration)	<p>Immediate Action:</p> <ol style="list-style-type: none"> 1. Re-cook if temperature product not achieve 73°C 	<p>WI-49 Re-cook process for Frankfurter</p> <p>WI-28 Cooking</p>

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		<p>cooking by using thermometer display at smoke house and thermometer probe. QC will record into the checklist</p> <p>The monitoring are performed every hourly.</p>			<p>2. QC or Production inform maintenance if smoke house problem</p> <p>3. Inform Production Manager and Plant Manager if problem still not solve.</p> <p>Preventive/ Corrective Action: 1. To give briefing and retraining to QC, and Production about CCP verification of cooking.</p>	<p>Monitoring Procedure Frankfurter</p> <p>PF14 CCP 1 Monitoring Record Frankfurter</p> <p>Calibration record</p> <p>Certificate of Analysis (COA)</p>
MCP 7 Spiral Freezing	Product temperature is ≥ -18	<p>For the monitoring of the spiral freezer, QC will check the spiral freezer room temperature every hourly by observe the spiral freezer sensor reading.</p> <p>QC also check</p>	Monitor performed every hourly	QC , Maintenance (calibration)	<p>Immediate Action: 1. Stop the production line immediately until room & product temperature achieve.</p> <p>Corrective Action:</p>	<p>WI-68 Spiral Freezing Monitoring</p> <p>PF15 CCP 2 Monitoring Record Frankfurter</p> <p>PF26 CCP 1 Monitoring Record Nugget &</p>

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		product temperature exit the spiral freezer by using thermometer every hour.			<ol style="list-style-type: none"> 1. If temperature more than action limit, stop the production line immediately 2. Production to Inform maintenance personnel to investigate and proceed with repair if spiral freezer breakdown 3. Production Supervisor to Inform Production Manager and Plant Manager immediately 4. If breakdown more than 2 hours, product will On Hold and rework 	<p>Fried Chicken</p> <p>Calibration Record</p> <p>Certificate of Analysis (COA)</p>
MCP 8 Metal Detecting	Metal detector not working well and not able to detect test piece – Ferrous: 2.5mm, Non Ferrous: 3.0mm and Stainless Steel: 4.0mm	The monitoring of the metal detecting function are by calibration of metal test piece consist of ferrous, non ferrous and stainless steel on	The metal detector should be “ON”, and check hourly by running a test piece whether be able to detect through metal detector:-	QC ,Maintenance (preventive maintenance)	<p>Immediate Action:</p> <ol style="list-style-type: none"> 1. Stop the packing process line. 2. Segregate the affected product. 	<p>WI-42 Metal detector calibration</p> <p>WI-30 Disposition of foreign object</p> <p>WI-40 Metal Contaminant</p>

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		<p>every hourly basis.</p> <p>Frankfurter</p> <ul style="list-style-type: none"> • QC ensure the metal detector "ON" and working accordingly and check hourly by running a test-piece through functional metal detector; Ferrous: 2.0 mm, Non-ferrous: 3.0 mm, and Stainless steel: 4.5 mm • The metal detector need to be able to detect the test-piece. <p>Nugget & Fried Chicken</p> <ul style="list-style-type: none"> • QC ensure the metal detector "ON" and working accordingly and check hourly by 	<ul style="list-style-type: none"> • Ferrous: 2.5mm, • Non Ferrous: 3.0mm • Stainless Steel: 4.0mm 		<p>3. On Hold the affected product.</p> <p>4. Disposed the affected product and packaging.</p> <p>Corrective Action:</p> <p>1. QA Executive advises the Production Manager to suspend the metal detector line and On Hold the product.</p> <p>2. The Production Manager informs maintenance personnel to investigate and repair metal detector</p> <p>3. QC to do calibration after repairing complete by Maintenance personnel</p> <p>4. If necessary call supplier to</p>	<p>Investigation</p> <p>PF16 CCP 3 Monitoring Record Frankfurter</p> <p>PF27 CCP 2 Monitoring Record Nugget</p> <p>PF37 CCP 2 Monitoring Fried Chicken</p> <p>Metal detector calibration record</p>

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		running a test-piece through functional metal detector; Ferrous: 1.5 mm, Non-ferrous: 2.0 mm, and Stainless steel: 2.5 mm • The metal detector need to be able to detect the test-piece.			repair metal detector 5. Check the affected product as per no. (3) procedure	

HALAL RISK PLAN SUMMARY – LHLE MERU

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
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MCP 1 Ingredient receiving	Invalid Halal certificate or non-halal ingredients enter the premise	<p>1. QA checks the Halal status of ingredients upon purchase.</p> <p>2. All consignment of ingredient should carry D/O, COA and invoices and shall be tally with the requisition made by the plant.</p> <p>3. The ingredient complied with specification according to SOP-SYS-12 Inspection & Test Plan.</p> <p>4. Vehicles used by supplier are dedicated to halal and clean.</p>	Every receiving	Halal cum QA Executive	<p>Immediate action:</p> <p>1. If found any nonconformance of quality parameters, insufficient documents of D/O, COA, invoices and non valid Halal certificate, QA Executive to make decision to On Hold and label the items 'On Hold'.</p> <p>2. On Hold items before return back to supplier. Any nonconformance shall be report back to purchasing and supplier.</p> <p>3. Label the conformance ingredients with the information of production date, receiving date, expiry date and quantity.</p> <p>4. Storekeeper arranges the ingredient or packaging material in the store and follows FIFO.</p>	<p>WI-38 Receiving Area Instruction</p> <p>WI-82 Receiving of ingredient and Packaging</p> <p>PF01 Incoming Inspection Record</p> <p>Halal Certificates, Technical Document (COA and Product Specification)</p>

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					<p>Corrective Action:</p> <p>1. QA personnel communicate with Purchasing department to obtain valid Halal certificate from supplier</p> <p>2. Sr.Plant Manager/ Halal Executive/ QA Executive to give briefing or retraining on the importance of obtaining sufficient documents to QC and Store Keeper, and details of verification process of ingredients upon arrival.</p>	
MCP 2: Egg Cleaning (Washing & Sanitizing)	Chlorine concentration and water pressure out of specification	<p>1. The chlorine test strip is used to check the chlorine concentration 4 times per day.</p> <p>2. Check the meter pressure of the sprayer 4 times per day. Setting conveyer speed not more than 80%.</p> <p>3. Daily preventive maintenance for brush &</p>	Every 2 hours	Production worker	<p>Immediate action:</p> <p>1. Check auto dosing pump.</p> <p>2. Check the expiry date of chlorine chemical & chlorine test strip.</p> <p>3. Check water supply at washer.</p> <p>4. QC checks the solution.</p>	<p>WI-33 XY-12 Chlorine Testing</p> <p>WI-63 OPRP 1 Egg Washing and Sanitizing</p> <p>WI-72 Preventive Maintenance Optiloader</p> <p>PF09 Egg Cleaning, Washing and</p>

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		sprayer by maintenance			<p>Corrective Action:</p> <p>1. QC check whether the chlorine concentration. If the chlorine is out of specification, QA/Plant Manager decide to stop the conveyor and maintenance will check and repair auto dosing pump condition.</p> <p>2. When the critical limit of chlorine concentration is out:</p> <p>i) In case the Chlorine concentration is < 50ppm</p> <ul style="list-style-type: none"> • Workers reset the auto dosing pump to increase the dosage <p>ii) In case the Chlorine concentration > 100ppm</p> <ul style="list-style-type: none"> • QC check the pH of harvested liquid egg. Reject if the pH of 	<p>Sanitizing Monitoring Record</p> <p>PF26 Chemical Concentration Checklist</p>

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					liquid egg higher than specification • Continue process if the pH liquid of egg product is within specification iii) Workers adjust the setting of the pressure washing machine refer to the critical limit 50 - 100ppm iv) Workers setting the speed of conveyor below or at 80% ($\leq 80\%$)	
MCP 3: Filtration	Pressure gauge reading exceeds 5 Bar	1. Visual inspection on filter condition (cleanliness, no broken mesh) by the trained worker before start production. 2. CIP the filter before start the production 3. Monitor pressure gauge reading hourly (Max: 2 bar)	Hourly	Production worker	Immediate action: 1. If the pressure is above 2 bar (egg white) or 5 bar (egg yolk and whole egg), stop production. 2. On hold & segregate the affected product for rework. 3. Clean the filter & inform	WI-59 (CCP1 Filtration) WI-73 Preventive Maintenance - Optibreaker PF02 CCP 1 - Filtration Monitoring Record

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		<p>by worker.</p> <p>4. If pressure gauge reading <1.0 bar (normal reading) for more than 10 minutes, need to stop the process and check the pressure gauge condition or filter mesh.</p> <p>5. If pressure gauge reading >2.0 bar, stop the production, immediately clean the filter and reinstall back the filter.</p> <p>6. Preventive maintenance of filtration system weekly</p>			<p>QC to verify the cleaned filter in good condition.</p> <p>4. If OK, resume the production.</p> <p>5. If not OK, inform maintenance & production supervisor to troubleshoot the error.</p> <p>Corrective Action:</p> <p>1. If pressure gauge reading >5 bar, workers stop the production and immediately clean the filter and reinstall back the filter.</p> <p>2. If pressure gauge reading <1.0bar (normal reading) for >10 minutes, workers need to stop the process and check the pressure gauge condition or filter mesh.</p> <p>3. Maintenance checks the pressure gauge condition.</p>	<p>Calibration certificate</p> <p>PF24 Microbiological Testing Record</p> <p>PF20 On Hold</p> <p>PF37 Rework</p>

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					Decide either : <ul style="list-style-type: none"> • To change the gauge meter or; • To change the filter If necessary or; • Calibrate and do realignment for the breaking machine conveyer 4. When the critical limit of pressure reading is out; <ol style="list-style-type: none"> i) Discharge and segregate the affected product ii) Rework the product 	
MCP 4: Holding (Raw Tank)	Raw tank temperature out of specification	1. Monitor unpasteurized liquid egg temperature hourly by using RTD Sensor at raw tank. 2. The temperature and holding time of unpasteurized liquid egg in raw tank must be: <ul style="list-style-type: none"> • ≤ 7 °C (not exceed 8 hours); 	Hourly	Production worker	Immediate action: 1. On hold & segregate the affected product 2. Inform maintenance & production supervisor to troubleshoot the error by: <ul style="list-style-type: none"> • Check chilling system setting. • Check thermometer condition and change if required 	WI-64 (OPRP2 Holding- Raw Tank) PF06 OPRP2 –Raw Tank Temperature Record PF24 Microbiological Testing Record PF20 On Hold

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		<ul style="list-style-type: none"> <4°C (exceed 8 hours) 			<p>3. If major breakdown, contact supplier to fix the chilling system.</p> <p>Corrective Action:</p> <p>1. Maintenance service and repair chilling system if it is required.</p> <p>2. When the critical limit is out:</p> <ul style="list-style-type: none"> Worker discharge out the product. Worker will keep product in the chill room, segregate from other products and label. QA/QC will take sample and check for pH & smell. If: <ul style="list-style-type: none"> i) pH is within specification & no odd smell = REWORK (Finished goods of rework batch only release if within the 	<p>PF37 Rework</p> <p>Calibration certificate.</p> <p>External lab testing record</p>

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		Method	Frequency	Person In Charge		
					<p>microbiological testing specification, Salmonella absent)</p> <p>ii) pH is out of specification & have odd smell = WITHDRAW</p> <p>3. Retrain workers on OPRP monitoring procedure.</p>	
MCP 5: Pasteurization	The pasteurization does not reach the set time and temperature	<p>1. Monitor holding temperature on display panel hourly. Monitor flow rate reading on display panel hourly. <u>Temperature & time</u></p> <p>i. Whole Egg, Salted Whole Egg, Sugared Whole Egg; Pasteurizer 1: 65 ±1°C at 3.5 minutes, Pasteurizer 2: 65.5 ±1°C at 3.5 minutes</p> <p>ii. Egg Yolk, Salted Egg Yolk, Sugared Egg Yolk:</p>	Hourly	Production worker	<p>Immediate action:</p> <p>1. Stop production.</p> <p>2. On hold & segregate the affected product.</p> <p>3. Inform maintenance & production supervisor to troubleshoot the error by:</p> <ul style="list-style-type: none"> • Check boiler condition, restart the boiler. • Confirm temperature setting. • Check the flow meter function. 	<p>WI-60 (CCP2 Pasteurization)</p> <p>WI-20- CIP - Pasteurizer (Pasteurization Room)</p> <p>PF03 CCP2 & 3 Pasteurization & Cooling Temperature Record</p> <p>PF24 Microbiological Testing Record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
		<p>Pasteurizer 1: 65 ±1°C at 3.5 minutes, Pasteurizer 2: 65.5 ±1°C at 4.2 minutes</p> <p>iii. Egg White, Egg White (Whipping); Pasteurizer 1: 57 ±1°C at 9 minutes, Pasteurizer 2: 57.5±1°C at 4.2 minutes</p> <p><u>Flow meter speed</u></p> <p>i. Whole Egg, Egg White, Salted Whole Egg, Sugared Whole Egg;</p> <p>Pasteurizer 1:2000±30 L/hr; Pasteurizer 2: 3000±50 L/hr</p> <p>ii. Egg Yolk, Salted Egg Yolk; Pasteurizer 1:1000±30 L/hr; Pasteurizer 2: 1300±50L/hr</p> <p>iii. Egg White, Egg White (Whipping)</p>			<p>Corrective Action:</p> <p>1. Maintenance service and repair the boiler if there is required.</p> <p>2. Maintenance service and repair the pasteurizer accordingly if there is required.</p> <p>3. Maintenance service and repair flow meter accordingly if required.</p> <p>4. Maintenance monitors temperature and test for position valve function.</p> <p>5. When CL is out: a) <u>> pasteurization (holding temperature), > flow rate</u></p> <ul style="list-style-type: none"> • Discharge out the product • Keep product in 	<p>PF20 On Hold</p> <p>PF37 Rework</p> <p>Calibration certificate.</p> <p>External lab testing record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
		Pasteurizer 1:2000±30 L/hr; Pasteurizer 2: 2500±50 L/hr			<p>the chill room, segregate from other products.</p> <ul style="list-style-type: none"> • QA/QC will take sample for physical & microbiological testing. • If : <ul style="list-style-type: none"> i. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph. aureus</i> result out, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> within specification = REWORK ii. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph aureus</i>, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C.</i> 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p><i>perfringens</i>, within specification = USE AS IT IS</p> <p>iii. <i>Salmonella, L. monocytogenes, B.cereus & C. perfringens</i> out = WITHDRAW</p> <p>b) <u>>pasteurization (holding temperature), <flow rate</u></p> <ul style="list-style-type: none"> • Discharge out the product • Keep product in the chill room, segregate from other products. • QA/QC will take sample for physical & microbiological testing. • If : <p>i. pH, total soluble solid, TPC, Yeast</p>	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>& Mold, <i>E.coli</i>, Coliform, <i>Staph. aureus</i> result out, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> within specification = REWORK</p> <p>ii. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph aureus</i>, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i>, within specification = USE AS IT IS</p> <p>iii. <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> out = WITHDRAW</p> <p>c) <u><pasteurization</u> <u>(holding</u></p>	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p><u>temperature), > flow rate</u></p> <ul style="list-style-type: none"> • Discharge out the product • Keep product in the chill room, segregate from other products. • QA/QC will take sample for physical & microbiological testing. • If : <ul style="list-style-type: none"> i. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph. aureus</i> result out, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> within specification = REWORK ii. pH, total soluble solid, TPC, Yeast 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>& Mold, <i>E.coli</i>, Coliform, <i>Staph aureus</i>, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i>, within specification = USE AS IT IS</p> <p>iii. <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> out = WITHDRAW</p> <p>d) <u><pasteurization(holding temperature), < flow rate</u></p> <ul style="list-style-type: none"> • Discharge out the product • Keep product in the chill room, segregate from other products. • QA/QC will take sample for 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					physical & microbiological testing. <ul style="list-style-type: none"> • If : <ol style="list-style-type: none"> i. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph. aureus</i> result out, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> within specification = REWORK ii. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph aureus</i>, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i>, within specification = USE AS IT IS iii. <i>Salmonella</i>, <i>L. monocytogenes</i>, 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p><i>B.cereus</i> & <i>C. perfringens</i> out = WITHDRAW</p> <p>6. Retrain workers on MCP monitoring procedure.</p>	
MCP 6: Cooling	Outlet temperature exceed 4°C	1. Monitor cooling temperature of pasteurized liquid eggs at ≤4 °C on display panel hourly.	Hourly	Production worker	<p>Immediate action:</p> <ol style="list-style-type: none"> 1. Stop production. 2. On hold & segregate the affected product. 3. Inform maintenance & production supervisor to troubleshoot the error by: <ul style="list-style-type: none"> • Check cooling temperature. • Check chilling system pump running status. • Check circulation pump status. • Check thermometer condition and change if required. <p>Corrective Action:</p> <ol style="list-style-type: none"> 1. Maintenance service, 	<p>WI-61 CCP3 Cooling</p> <p>PF03 CCP2 & 3 Pasteurization & Cooling Temperature Record</p> <p>PF24 Microbiological Testing Record</p> <p>PF20 On Hold</p> <p>PF37 Rework</p> <p>Calibration Certificate.</p> <p>External lab testing record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>repair and do maintenance of chilling system if there is required.</p> <p>2. When the critical limit is out:</p> <ul style="list-style-type: none"> • Worker discharge out the product. • Worker will keep product in the chill room, segregate from other products and label. • QA/QC will take sample for physical & microbiological testing. • If: <ul style="list-style-type: none"> • Discharge out the product • Keep product in the chill room, segregate from other products. • QA/QC will take sample for 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					physical & microbiological testing. <ul style="list-style-type: none"> • If : iv. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i> , Coliform, <i>Staph. aureus</i> result out, <i>Salmonella</i> , <i>L. monocytogenes</i> , <i>B.cereus</i> & <i>C. perfringens</i> within specification = REWORK v. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i> , Coliform, <i>Staph aureus</i> , <i>Salmonella</i> , <i>L. monocytogenes</i> , <i>B.cereus</i> & <i>C. perfringens</i> , within specification = USE AS IT IS vi. <i>Salmonella</i> , <i>L. monocytogenes</i> ,	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p><i>B.cereus</i> & <i>C. perfringens</i> out = WITHDRAW</p> <p>3. Retrain workers on MCP monitoring procedure.</p>	
MCP 7: Storage (Filling Tank)	Filling tank temperature exceed 4°C	1. Monitor product temperature in filling tank on display panel and ensure the temperature ≤ 4 °C hourly.	Hourly	Production worker	<p>Immediate action:</p> <ol style="list-style-type: none"> 1. On hold & segregate the affected product. 2. Inform maintenance & production supervisor to troubleshoot the error by: <ul style="list-style-type: none"> • Check chilling system setting. <p>Check thermometer condition and change if required</p> <p>Corrective Action:</p> <ol style="list-style-type: none"> 1. Maintenance service and repair chilling system if there is required. 2. When the critical limit is out: <ul style="list-style-type: none"> • Worker immediately 	<p>WI-65 OPRP3 Storage- Filling tank</p> <p>PF05 OPRP 3 Filling Tank Temperature Record</p> <p>PF24 Microbiological Testing Record</p> <p>PF20 On Hold</p> <p>PF37 Rework</p> <p>Calibration Certificate</p> <p>External lab testing record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>pack the affected products.</p> <ul style="list-style-type: none"> • Worker will keep the products in the chill room, QA/QC put ON-HOLD label and segregate from other products • QA/QC will take sample for physical & microbiological testing • If: <ul style="list-style-type: none"> a) pH, total soluble solid & yeast & mold within specification, TPC (<2000 cfu/g), <i>E.coli</i>, Coliform, <i>Staph. aureus</i>, <i>L. monocytogenes</i>, <i>B.cereus</i>, <i>C.perfringens</i> & <i>Salmonella</i> absent = USE AS IT IS b) pH, total soluble solid & yeast & 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>mold within specification, TPC (3000-5000 cfu/g), <i>E.coli</i>, Coliform, <i>Staph. aureus</i>, <i>L. monocytogenes</i>, <i>B.cereus</i>, <i>C.perfringens</i> & <i>Salmonella</i> absent = REWORK (Finished goods of rework batch only release if the TPC, yeast & mold within the specification, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i>, <i>C.perfringens</i> <i>E.coli</i>, Coliform & <i>Staph. aureus</i> absent)</p> <p>c) TPC and yeast & mold, <i>E.coli</i>, Coliform & <i>Staph. Aureus</i> out of specification,</p>	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>Salmonella, <i>L. monocytogenes</i>, <i>B.cereus</i>, & <i>C.perfringens</i> absent = REWORK (Finished goods of rework batch only release if the TPC, yeast & mold within the specification, <i>Salmonella, L. monocytogenes, B.cereus, C.perfringens, E.coli</i>, Coliform & <i>Staph. aureus</i> absent)</p> <p>d) <i>Salmonella, L. monocytogenes, B.cereus, & C.perfringens</i> present = WITHDRAW</p> <p>3. Retrain workers on MCP monitoring procedure.</p>	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
MCP 8: Chill Storage	Outlet temperature exceed 4°C	<p>1. Finished products are labeled or tagged for every batch and product type.</p> <p>2. Monitor room temperature hourly and ensure the temperature ≤ 4 °C</p> <p>3. Preventive maintenance of refrigeration system daily.</p> <p>4. The physical and microbiological test will be carried out for every batch of finished product samples according to WI-45 Physical testing and WI-46 Microbiological Testing.</p>	Hourly	Production worker	<p>Immediate action:</p> <ol style="list-style-type: none"> 1. Close the chill room door and make sure the curtain strip overlap. 2. Inform maintenance and production supervisor to troubleshoot the problems by: <ul style="list-style-type: none"> • Check cooling temperature. • Check chilling system pump running status. • Check blower & compressor condition. • Condition and change temperature if required. <p>Corrective Action:</p> <ol style="list-style-type: none"> 1. Maintenance service, repair and do maintenance for chilling system if there is required. 	<p>WI-62 Chill room</p> <p>WI-42 Chill Monitoring Procedure</p> <p>WI-45 Physical Testing</p> <p>WI-46 Microbiological Testing</p> <p>PF04 CCP 4 Chill Room Temperature Record</p> <p>PF24 Microbiological Testing Record</p> <p>PF20 On Hold</p> <p>PF37 Rework</p> <p>Calibration Certificate</p> <p>External lab testing</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>2. When the critical limit is out:</p> <ul style="list-style-type: none"> • Segregate the affected products from others • QC/QA will take temperature of the product • If: <ul style="list-style-type: none"> • Discharge out the product • Keep product in the chill room, segregate from other products. • QA/QC will take sample for physical & microbiological testing. • If : <ul style="list-style-type: none"> i. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph. aureus</i> result out, <i>Salmonella</i>, <i>L.</i> 	record

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p><i>monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> within specification = REWORK</p> <p>ii. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph aureus</i>, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i>, within specification = USE AS IT IS</p> <p>iii. <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> out = WITHDRAW</p> <p>3. Retrain workers on MCP monitoring procedure.</p>	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<ul style="list-style-type: none"> • QC immediately check and inspect the lorry condition, and pre-chill the cold truck. • QA/QC check on the product temperature & cold truck • If the segregated product temperature is $<4^{\circ}\text{C}$ = Use as it is • If the segregated product temperature is $>4^{\circ}\text{C}$, QA/QC immediately takes sample for microbiological testing • If the cold truck temperature is $\leq 20^{\circ}\text{C}$ after pre-chill, the cold truck is permitted to be used for delivery <p>When the critical limit of product is out:</p> <ul style="list-style-type: none"> • Worker segregate the product in the chill 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					room and QA/QC put ON-HOLD label <ul style="list-style-type: none"> • QA/QC conduct microbe testing on on-hold product, • If: <ol style="list-style-type: none"> i. TPC (<2000 cfu/g), absent E.coli, coliform & Salmonella = USE AS IT IS ii. TPC (3000-5000 cfu/g), absent E.coli, coliform & Salmonella = REWORK (Finish goods for rework batch only release if within the microbiological testing specification) iii. Microbiological result is out of specification = WITHDRAW 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					Retrain workers on OPRP monitoring procedure.	

HALAL RISK PLAN SUMMARY - LHLE JOHOR

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
MCP 1 Ingredient receiving	Invalid Halal certificate or non-halal ingredients enter the premise	<p>1. QA checks the Halal status of ingredients upon purchase.</p> <p>2. All consignment of ingredient should carry D/O, COA and invoices and shall be tally with the requisition made by the plant.</p> <p>3. The ingredient complied with specification according to SOP-SYS-12 Inspection & Test Plan.</p> <p>4. Vehicles used by supplier are dedicated to halal and clean.</p>	Every receiving	Halal cum QA Executive	<p>Immediate action:</p> <p>1. If found any nonconformance of quality parameters, insufficient documents of D/O, COA, invoices and non valid Halal certificate, QA Executive to make decision to On Hold and label the items 'On Hold'.</p> <p>2. On Hold items before return back to supplier. Any nonconformance shall be report back to purchasing and supplier.</p> <p>3. Label the conformance ingredients with the information of production date, receiving date, expiry date and quantity.</p> <p>4. Storekeeper arranges the ingredient or packaging material in the store and follows FIFO.</p>	<p>WI-38 Receiving Area Instruction</p> <p>WI-82 Receiving of ingredient and Packaging</p> <p>PF01 Incoming Inspection Record</p> <p>Halal Certificates, Technical Document (COA and Product Specification)</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>Corrective Action:</p> <p>1. QA personnel communicate with Purchasing department to obtain valid Halal certificate from supplier</p> <p>2. Sr.Plant Manager/ Halal Executive/ QA Executive to give briefing or retraining on the importance of obtaining sufficient documents to QC and Store Keeper, and details of verification process of ingredients upon arrival.</p>	
MCP 2: Egg Cleaning (Washing & Sanitizing)	Chlorine concentration and water pressure out of specification	<p>1. The chlorine test strip is used to check the chlorine concentration 4 times per day.</p> <p>2. Check the meter pressure of the sprayer 4 times per day. Setting conveyer speed not more than 80%.</p> <p>3. Daily preventive maintenance for brush & sprayer by maintenance</p>	Every 2 hours	Production worker	<p>Immediate action:</p> <p>1. Check auto dosing pump.</p> <p>2. Check the expiry date of chlorine chemical & chlorine test strip.</p> <p>3. Check water supply at washer.</p> <p>4. QC checks the solution.</p> <p>Corrective Action:</p>	<p>WI-33 XY-12 Chlorine Testing</p> <p>WI-63 OPRP 1 Egg Washing and Sanitizing</p> <p>WI-72 Preventive Maintenance Optiloader</p> <p>PF09 Egg Cleaning, Washing and</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>1. QC check whether the chlorine concentration. If the chlorine is out of specification, QA/Plant Manager decide to stop the conveyor and maintenance will check and repair auto dosing pump condition.</p> <p>2. When the critical limit of chlorine concentration is out:</p> <p>i) In case the Chlorine concentration is < 50ppm</p> <ul style="list-style-type: none"> • Workers reset the auto dosing pump to increase the dosage <p>ii) In case the Chlorine concentration > 100ppm</p> <ul style="list-style-type: none"> • QC check the pH of harvested liquid egg. Reject if the pH of liquid egg higher than specification • Continue process if the 	<p>Sanitizing Monitoring Record</p> <p>PF26 Chemical Concentration Checklist</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>pH liquid of egg product is within specification</p> <p>iii) Workers adjust the setting of the pressure washing machine refer to the critical limit 50 - 100ppm</p> <p>iv) Workers setting the speed of conveyor below or at 80% ($\leq 80\%$)</p>	
MCP 3: Filtration	Pressure gauge reading exceeds 6 Bar	<p>1. Visual inspection on filter condition (cleanliness, no broken mesh) by the trained worker before start production.</p> <p>2. CIP the filter before start the production</p> <p>3. Monitor pressure gauge reading hourly (Max: 6 bar) by worker.</p> <p>4. If pressure gauge reading < 1.0 bar (normal reading) for more than 10</p>	Hourly	Production worker	<p>Immediate action:</p> <p>1. If the pressure is above 6 bar, stop production.</p> <p>2. On hold & segregate the affected product for rework.</p> <p>3. Clean the filter & inform QC to verify the cleaned filter in good condition.</p> <p>4. If OK, resume the production.</p> <p>5. If not OK, inform maintenance & production</p>	<p>WI-59 (CCP1 Filtration)</p> <p>WI-73 Preventive Maintenance - Optibreaker</p> <p>PF02 CCP 1 - Filtration Monitoring Record</p> <p>Calibration certificat</p> <p>PF24 Microbiological Testing Record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
		<p>minutes, need to stop the process and check the pressure gauge condition or filter mesh.</p> <p>5. If pressure gauge reading >6 bar, stop the production, immediately clean the filter and reinstall back the filter.</p> <p>6. Preventive maintenance of filtration system weekly</p>			<p>supervisor to troubleshoot the error.</p> <p>Corrective Action:</p> <p>1. If pressure gauge reading >6 bar, workers stop the production and immediately clean the filter and reinstall back the filter.</p> <p>2. If pressure gauge reading <1.0bar (normal reading) for >10 minutes, workers need to stop the process and check the pressure gauge condition or filter mesh.</p> <p>3. Maintenance checks the pressure gauge condition. Decide either :</p> <ul style="list-style-type: none"> • To change the gauge meter or; • To change the filter If necessary or; • Calibrate and do realignment for the breaking machine conveyer 	<p>PF20 On Hold</p> <p>PF37 Rework</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					4. When the critical limit of pressure reading is out; i) Discharge and segregate the affected product ii) Rework the product	
MCP 4: Holding (Raw Tank)	Raw tank temperature out of specification	<p>1. Monitor unpasteurized liquid egg temperature hourly by using RTD Sensor at raw tank.</p> <p>2. The temperature and holding time of unpasteurized liquid egg in raw tank must be:</p> <ul style="list-style-type: none"> • ≤ 7 °C (not exceed 8 hours); • < 4°C (exceed 8 hours) 	Hourly	Production worker	<p>Immediate action:</p> <p>1. On hold & segregate the affected product</p> <p>2. Inform maintenance & production supervisor to troubleshoot the error by:</p> <ul style="list-style-type: none"> • Check chilling system setting. • Check thermometer condition and change if required <p>3. If major breakdown, contact supplier to fix the chilling system.</p> <p>Corrective Action:</p> <p>1. Maintenance service and repair chilling system if it is required.</p> <p>2. When the critical limit is</p>	<p>WI-64 (OPRP2 Holding- Raw Tank)</p> <p>PF06 OPRP2 – Raw Tank Temperature Record</p> <p>PF24 Microbiological Testing Record</p> <p>PF20 On Hold</p> <p>PF37 Rework</p> <p>Calibration certificate.</p> <p>External lab testing record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>out:</p> <ul style="list-style-type: none"> • Worker discharge out the product. • Worker will keep product in the chill room, segregate from other products and label. • QA/QC will take sample and check for pH & smell. • If: <ul style="list-style-type: none"> i) pH is within specification & no odd smell = REWORK (Finished goods of rework batch only release if within the microbiological testing specification, Salmonella absent) ii) pH is out of specification & have odd smell = WITHDRAW <p>3. Retrain workers on</p>	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					OPRP monitoring procedure.	
MCP 5: Pasteurization	The pasteurization does not reach the set time and temperature	<p>1. Monitor holding temperature on display panel hourly. Monitor flow rate reading on display panel hourly. <u>Temperature & time</u></p> <p>i. Whole Egg, Salted Whole Egg, Sugared Whole Egg: Pasteurizer : 66.5 ±1°C at 3.5 minutes</p> <p>ii. Egg Yolk, Salted Egg Yolk & Sugared Egg Yolk: Pasteurizer: 65.5 ±1°C at 4.8 minutes</p> <p>iii. Egg White Pasteurizer: 57±1°C at 9 minutes</p> <p><u>Flow meter speed</u></p> <p>i. Whole Egg, Egg White, Salted Whole Egg, Sugared Whole Egg;</p>	Hourly	Production worker	<p>Immediate action:</p> <ol style="list-style-type: none"> 1. Stop production. 2. On hold & segregate the affected product. 3. Inform maintenance & production supervisor to troubleshoot the error by: <ul style="list-style-type: none"> • Check boiler condition, restart the boiler. • Confirm temperature setting. • Check the flow meter function. <p>Corrective Action:</p> <ol style="list-style-type: none"> 1. Maintenance service and repair the boiler if there is required. 2. Maintenance service and repair the pasteurizer accordingly if there is required. 	<p>WI-60 (CCP2 Pasteurization)</p> <p>WI-20- CIP - Pasteurizer (Pasteurization Room)</p> <p>PF03 CCP2 & 3 Pasteurization & Cooling Temperature Record</p> <p>PF24 Microbiological Testing Record</p> <p>PF20 On Hold</p> <p>PF37 Rework</p> <p>Calibration certificate.</p> <p>External lab testing record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
		Pasteurizer: 3000±50 L/hr ii. Egg Yolk, Salted Egg Yolk & Sugared Egg Yolk: Pasteurizer: 1500±50L/hr			3. Maintenance service and repair flow meter accordingly if required. 4. Maintenance monitors temperature and test for position valve function. 5. When CL is out: e) <u>> pasteurization (holding temperature), > flow rate</u> <ul style="list-style-type: none"> • Discharge out the product • Keep product in the chill room, segregate from other products. • QA/QC will take sample for physical & microbiological testing. • If : iv. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i> ,	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>Coliform, <i>Staph. aureus</i> result out, <i>Salmonella, L. monocytogenes, B.cereus & C. perfringens</i> within specification = REWORK</p> <p>v. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli, Coliform, Staph aureus, Salmonella, L. monocytogenes, B.cereus & C. perfringens</i>, within specification = USE AS IT IS</p> <p>vi. <i>Salmonella, L. monocytogenes, B.cereus & C. perfringens</i> out = WITHDRAW</p> <p>f) <u>>pasteurization (holding temperature), <flow rate</u></p> <ul style="list-style-type: none"> • Discharge out the 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					product <ul style="list-style-type: none"> • Keep product in the chill room, segregate from other products. • QA/QC will take sample for physical & microbiological testing. • If : <ul style="list-style-type: none"> iv. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph. aureus</i> result out, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> within specification = REWORK v. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph aureus</i>, <i>Salmonella</i>, <i>L. monocytogenes</i>, 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p><i>B.cereus</i> & <i>C. perfringens</i>, within specification = USE AS IT IS</p> <p>vi. <i>Salmonella, L. monocytogenes, B.cereus</i> & <i>C. perfringens</i> out = WITHDRAW</p> <p>g) <u><pasteurization (holding temperature), > flow rate</u></p> <ul style="list-style-type: none"> • Discharge out the product • Keep product in the chill room, segregate from other products. • QA/QC will take sample for physical & microbiological testing. • If : <p>iv. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>,</p>	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>Coliform, <i>Staph. aureus</i> result out, <i>Salmonella, L. monocytogenes, B.cereus & C. perfringens</i> within specification = REWORK</p> <p>v. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli, Coliform, Staph aureus, Salmonella, L. monocytogenes, B.cereus & C. perfringens</i>, within specification = USE AS IT IS</p> <p>vi. <i>Salmonella, L. monocytogenes, B.cereus & C. perfringens</i> out = WITHDRAW</p> <p>h) <u><pasteurization(holding temperature), < flow rate</u></p>	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<ul style="list-style-type: none"> • Discharge out the product • Keep product in the chill room, segregate from other products. • QA/QC will take sample for physical & microbiological testing. • If : <ul style="list-style-type: none"> vii. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph. aureus</i> result out, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> within specification = REWORK viii. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph aureus</i>, <i>Salmonella</i>, 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p><i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i>, within specification = USE AS IT IS</p> <p>ix. <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> out = WITHDRAW</p> <p>6. Retrain workers on MCP monitoring procedure.</p>	
MCP 6: Cooling	Outlet temperature exceed 4°C	1. Monitor cooling temperature of pasteurized liquid eggs at ≤4 °C on display panel hourly.	Hourly	Production worker	<p>Immediate action:</p> <p>4. Stop production.</p> <p>5. On hold & segregate the affected product.</p> <p>6. Inform maintenance & production supervisor to troubleshoot the error by:</p> <ul style="list-style-type: none"> • Check cooling temperature. • Check chilling system pump running status. • Check circulation pump status. • Check thermometer 	<p>WI-61 CCP3 Cooling</p> <p>PF03 CCP2 & 3 Pasteurization & Cooling Temperature Record</p> <p>PF24 Microbiological Testing Record</p> <p>PF20 On Hold</p> <p>PF37 Rework</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>condition and change if required.</p> <p>Corrective Action:</p> <ol style="list-style-type: none"> Maintenance service, repair and do maintenance of chilling system if there is required. When the critical limit is out: <ul style="list-style-type: none"> Worker discharge out the product. Worker will keep product in the chill room, segregate from other products and label. QA/QC will take sample for physical & microbiological testing. If: <ul style="list-style-type: none"> Discharge out the product Keep product in the chill room, segregate from other products. QA/QC will take 	<p>Calibration Certificate.</p> <p>External lab testing record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>sample for physical & microbiological testing.</p> <ul style="list-style-type: none"> • If : <p>x. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph. aureus</i> result out, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> within specification = REWORK</p> <p>xi. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph aureus</i>, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i>, within specification = USE AS IT IS</p> <p>xii. <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C.</i></p>	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p><i>perfringens</i> out = WITHDRAW</p> <p>3. Retrain workers on MCP monitoring procedure.</p>	
MCP 7: Storage (Filling Tank)	Filling tank temperature exceed 4°C	1. Monitor product temperature in filling tank on display panel and ensure the temperature ≤ 4 °C hourly.	Hourly	Production worker	<p>Immediate action:</p> <p>3. On hold & segregate the affected product.</p> <p>4. Inform maintenance & production supervisor to troubleshoot the error by:</p> <ul style="list-style-type: none"> • Check chilling system setting. • Check thermometer condition and change if required <p>Corrective Action:</p> <p>1. Maintenance service and repair chilling system if there is required.</p> <p>2. When the critical limit is out:</p> <ul style="list-style-type: none"> • Worker immediately pack the affected products. 	<p>WI-65 OPRP3 Storage- Filling tank</p> <p>PF05 OPRP 3 Filling Tank Temperature Record</p> <p>PF24 Microbiological Testing Record</p> <p>PF20 On Hold</p> <p>PF37 Rework</p> <p>Calibration Certificate</p> <p>External lab testing record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<ul style="list-style-type: none"> • Worker will keep the products in the chill room, QA/QC put ON-HOLD label and segregate from other products • QA/QC will take sample for physical & microbiological testing • If: <ul style="list-style-type: none"> e) pH, total soluble solid & yeast & mold within specification, TPC (<2000 cfu/g), <i>E.coli</i>, Coliform, <i>Staph. aureus</i>, <i>L. monocytogenes</i>, <i>B.cereus</i>, <i>C.perfringens</i> & <i>Salmonella</i> absent = USE AS IT IS f) pH, total soluble solid & yeast & mold within specification, TPC (3000-5000 cfu/g), 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p><i>E.coli</i>, Coliform, <i>Staph. aureus</i>, <i>L. monocytogenes</i>, <i>B.cereus</i>, <i>C.perfringens</i> & <i>Salmonella</i> absent = REWORK (Finished goods of rework batch only release if the TPC, yeast & mold within the specification, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i>, <i>C.perfringens</i> <i>E.coli</i>, Coliform & <i>Staph. aureus</i> absent)</p> <p>g) TPC and yeast & mold, <i>E.coli</i>, Coliform & <i>Staph. Aureus</i> out of specification, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i>, & <i>C.perfringens</i></p>	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>absent = REWORK (Finished goods of rework batch only release if the TPC, yeast & mold within the specification, <i>Salmonella, L. monocytogenes, B.cereus, C.perfringens, E.coli</i>, Coliform & <i>Staph. aureus</i> absent)</p> <p>h) <i>Salmonella, L. monocytogenes, B.cereus, & C.perfringens</i> present = WITHDRAW</p> <p>3. Retrain workers on MCP monitoring procedure.</p>	
MCP 8: Chill Storage	Outlet temperature exceed 4°C	<p>1. Finished products are labeled or tagged for every batch and product type.</p> <p>2. Monitor room temperature hourly and ensure the temperature <4</p>	Hourly	Production worker	<p>Immediate action:</p> <p>4. Close the chill room door and make sure the curtain strip overlap.</p> <p>5. Inform maintenance and production supervisor to troubleshoot the</p>	<p>WI-62 Chill room</p> <p>WI-42 Chill Monitoring Procedure</p> <p>WI-45 Physical</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
		<p>°C</p> <p>3. Preventive maintenance of refrigeration system daily.</p> <p>4. The physical and microbiological test will be carried out for every batch of finished product samples according to WI-45 Physical testing and WI-46 Microbiological Testing.</p>			<p>problems by:</p> <ul style="list-style-type: none"> • Check cooling temperature. • Check chilling system pump running status. • Check blower & compressor condition. • Condition and change temperature if required. <p>Corrective Action:</p> <p>1. Maintenance service, repair and do maintenance for chilling system if there is required.</p> <p>2. When the critical limit is out:</p> <ul style="list-style-type: none"> • Segregate the affected products from others • QC/QA will take temperature of the product • If: <ul style="list-style-type: none"> • Discharge out the product • Keep product in the chill room, 	<p>Testing</p> <p>WI-46 Microbiological Testing</p> <p>PF04 CCP 4 Chill Room Temperature Record</p> <p>PF24 Microbiological Testing Record</p> <p>PF20 On Hold</p> <p>PF37 Rework</p> <p>Calibration Certificate</p> <p>External lab testing record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					segregate from other products. <ul style="list-style-type: none"> • QA/QC will take sample for physical & microbiological testing. • If : <ul style="list-style-type: none"> iv. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph. aureus</i> result out, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i> within specification = REWORK v. pH, total soluble solid, TPC, Yeast & Mold, <i>E.coli</i>, Coliform, <i>Staph aureus</i>, <i>Salmonella</i>, <i>L. monocytogenes</i>, <i>B.cereus</i> & <i>C. perfringens</i>, within specification = USE AS IT IS 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					vi. <i>Salmonella, L. monocytogenes, B.cereus & C. perfringens</i> out = WITHDRAW 3. Retrain workers on MCP monitoring procedure.	
MCP 9: Loading	Product temperature, loading area temperature and loading time does not meet specification	1. Check the product type, quantity and production date 2. Monitoring truck temperature at display panel & loading area; and ensure the temperature below or at 20°C ($\leq 20^{\circ}\text{C}$). 3. Monitoring the start and end time of the truck loading process and ensure the duration loading process less than 1 hour 4. Monitor the product temperature and ensure the temperature $\leq 4^{\circ}\text{C}$	Every 15 minutes Every truck loading involved On each delivery	QC/QA	Immediate action: If truck or loading area temperature above 20°C and loading time more than 1 hour, QC will test the product temperature and if the product temperature $< 4^{\circ}\text{C}$, proceed loading. If the product temperature $> 4^{\circ}\text{C}$, transfer the product to chill room. Corrective Action: Maintenance service and repair blower system (truck and loading area) if there is required. QC always monitor and remind workers to minimize the door opening.	WI-66 OPRP4 Loading PF07 Loading Inspection Checklist PF24 Microbiological Testing Record PF 20 On Hold PF37 Rework Calibration certification

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>When the critical limit of Cold Truck is out:</p> <ul style="list-style-type: none"> • Worker unload back the product into Chill Room • QC immediately check and inspect the lorry condition, and pre-chill the cold truck. • QA/QC check on the product temperature & cold truck • If the segregated product temperature is $<4^{\circ}\text{C}$ = Use as it is • If the segregated product temperature is $>4^{\circ}\text{C}$, QA/QC immediately takes sample for microbiological testing • If the cold truck temperature is $\leq 20^{\circ}\text{C}$ after pre-chill, the cold truck is permitted to be used for delivery 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>When the critical limit of product is out:</p> <ul style="list-style-type: none"> • Worker segregate the product in the chill room and QA/QC put ON-HOLD label • QA/QC conduct microbe testing on on-hold product, • If: <ul style="list-style-type: none"> iv. TPC (<2000 cfu/g), absent E.coli, coliform & Salmonella = USE AS IT IS v. TPC (3000-5000 cfu/g), absent E.coli, coliform & Salmonella = REWORK (Finish goods for rework batch only release if within the microbiological testing specification) 	

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					vi. Microbiological result is out of specification = WITHDRAW Retrain workers on OPRP monitoring procedure.	

HALAL RISK PLAN SUMMARY - LHLE KAPAR

A) Boiled Egg

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
MCP 1 Ingredient receiving	Invalid Halal certificate or Non Halal ingredients enter the premise	<p>Halal cum QA Executive verifies the validity of the Halal certificate of ingredients including COA.</p> <p>All consignment of ingredient should carry D/O and invoices and shall be tally with the requisition made by the plant done by the Administrative.</p> <p>The ingredient complied to specification according to SOP-SYS-12 Inspection & Test Plan.</p> <p>Vehicles used by supplier are dedicated to halal and clean.</p>	Every receiving	Halal cum QA Executive	<p>Immediate action: On hold the raw material without valid halal certificate.</p> <p>Corrective Action: 1. Halal cum QA Executive communicates with Purchasing department to obtain valid Halal certificate from supplier.</p> <p>2. Sr Plant Manager/ Halal cum QA Executive to give briefing or retraining on the importance of obtaining sufficient documents to QC and store keeper and details of verification process of ingredients upon arrival.</p>	<p>SOP-SYS-12 Inspection & Test Plan</p> <p>WI-29 Raw Material, Ingredients & Packaging Material Receiving Instruction.</p> <p>PF 05- Incoming Inspection Record.</p>
MCP 2 Egg Cleaning (Washing & sanitizing)	Chlorine concentration and conveyor speed not within specification.	<p>Monitor auto pump dosage and conveyor speed.</p> <p>Chlorine concentration</p>	Every 2 hours	Production worker	<p>Immediate action: 1. On hold the non conformance egg and remove the non-conformance shell egg from</p>	WI 35- OPRP Monitoring- OPRP 1 Egg Washing and Sanitizing.

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
		checking by using chlorine test strip.			<p>the processing line.</p> <p>Corrective Action:</p> <p>1. When the critical limit of chlorine concentration is out:</p> <p>i) In case the chlorine concentration is < 50ppm</p> <ul style="list-style-type: none"> • Check and repair auto dosing condition if required • Worker reset the auto dosing pump to increase the dosage. <p>ii) In case the chlorine concentration > 100ppm</p> <ul style="list-style-type: none"> • Check and repair auto dosing condition if required • Worker reset the auto pump to reduce the dosage <p>iii) Trained workers adjust the setting of the pressure washing</p>	PF01- HCP 2 & OPRP 1- Egg Cleaning, Washing & Sanitizing Monitoring Record

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>machine refer to the critical limit 50 - 100ppm.</p> <p>3) In the case conveyor speed >80%, technician will adjust the conveyor speed and only resume production when the conveyor speed achieves ≤ 80%.</p>	
MCP 3 Cooking	Product core temperature and holding time is <70 °C for < 3.5 s.	Worker monitors and checks product internal core temperature and holding time every hour of production.	Hourly	Production worker	<p>Immediate action: 1. QC On Hold the affected batch.</p> <p>Corrective action: 1. Maintenance to check and repair the cooker machine immediately. 2. QC to monitor closely and verify the problem until resume to normal condition.</p>	<p>WI32- CCP Monitoring – CCP (Egg Cooking)</p> <p>PF01 CCP 1 & OPRP 2 Cooking and Cooling Monitoring Record</p>
MCP 4 Cooling	Chill water and product core temperature >7°C.	Worker to check the chill water temperature (0-7°C) hourly	Hourly	QC	<p>Immediate action: 1. QC On Hold the affected batch.</p> <p>Corrective action: 1. Production Executive decrease the water chiller setting to cool down the</p>	<p>WI 36- OPRP Monitoring- OPRP 2 Egg Cooling</p> <p>PF02 - CCP1 & OPRP2 - Cooking &</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>water inside cooling tank.</p> <p>2. Maintenance to check and repair the chiller unit or thermocouple.</p> <p>3. QC to assess the core temperature of the eggs before it proceeds for peeling.</p> <p>5. QC to increase monitoring frequency of the chilled water temperature until resume to stable condition.</p>	Cooling Monitoring Record
MCP 5 Egg Peeling	Shell egg still remains on the boiled egg.	Production worker monitor the boiled egg after undergo peeling process	Every batch	Production worker	<p>Immediate action:</p> <p>1. On hold the affected product.</p> <p>Corrective action:</p> <p>1. Manually peel the boiled egg.</p> <p>2. Maintenance repair peeler machine if the peeler machine is problem.</p>	None
MCP 6 Retort	Retort process does not achieve the sterilization condition (116°C, 30 minutes)	Worker to monitor retort temperature and time for every batch of production.	Every batch	Production worker	<p>Immediate action:</p> <p>1. On hold the affected batch.</p> <p>Corrective action:</p> <p>1. Maintenance to</p>	<p>WI 33- CCP Monitoring – CCP2 (Retort)</p> <p>PF03 - CCP2 -</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					immediately check and repair the retort machine. 2. QC to monitor closely and verify the problem until resume to normal condition.	Retort Monitoring Record
MCP 7 Chill Storage	Chiller and product temperature not achieve $\leq 4^{\circ}\text{C}$	Worker to monitor chill room temperature	Hourly	Production worker	<p>Immediate action:</p> <p>1. QC to on hold the affected product and seal the chill room until resume to normal condition.</p> <p>Corrective action:</p> <p>1. QC informs maintenance personnel to investigate and proceed with repair if chill room breakdown due to compressor breakdown. 2. Halal cum QA Executive creates awareness on the need the cold room door to be closed all the time.</p>	<p>WI 34- CCP Monitoring – CCP (Chill room)</p> <p>PF04 - CCP3 - Chill Room Temperature Monitoring Record</p>
MCP 8 Loading	<p>i. Truck temperature & loading area temperature $>15^{\circ}\text{C}$</p> <p>ii. Loading</p>	<p>1. QC to inspect the loading area for $\leq 15^{\circ}\text{C}$ every loading activity</p> <p>2. QC to monitor the loading time for not more than 1h per loading</p>	<p>Every 15 minutes</p> <p>Every truck loading involved</p>	QC	<p>Immediate action:</p> <p>1. QC to stop loading activity and close the loading bay until the temperature is resume to within specification</p>	<p>WI37- OPRP Monitoring – OPRP 3 Loading.</p> <p>PF06 - OPRP 3 Loading Inspection</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
	<p>process more than 1 hour</p> <p>iii. Product temperature >4°C</p>	<p>3. QC to monitor product temperature for not more than 4°C during loading</p> <p>4. QA to verify the OPRP record daily</p>	Every delivery		<p>Corrective action:</p> <p>1. QC to stop loading activity and inform maintenance to check and repair the compressor.</p> <p>2. QC to monitor and verify the temperature until resume to within specification</p> <p>3. QC to access the product temperature and seal the product inside the lorry truck until temperature is within specification.</p>	Checklist

B) Sanitized Egg

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
MCP 1 Ingredient receiving	Invalid Halal certificate or Non Halal ingredients enter the premise	<p>Halal cum QA Executive verifies the validity of the Halal certificate of ingredients including COA.</p> <p>All consignment of ingredient should carry D/O and invoices and shall be tally with the requisition made by the plant done by the Administrative.</p> <p>The ingredient complied to specification according to SOP-SYS-12 Inspection & Test Plan.</p> <p>Vehicles used by supplier are dedicated to halal and clean.</p>	Every receiving	Halal cum QA Executive	<p>Immediate action: On hold the raw material without valid halal certificate.</p> <p>Corrective Action: 1. Halal cum QA Executive communicates with Purchasing department to obtain valid Halal certificate from supplier. 2. Sr Plant Manager/ Halal cum QA Executive to give briefing or retraining on the importance of obtaining sufficient documents to QC and store keeper and details of verification process of ingredients upon arrival.</p>	<p>SOP-SYS-12 Inspection & Test Plan</p> <p>WI-29 Raw Material, Ingredients & Packaging Material Receiving Instruction.</p> <p>PF 05- Incoming Inspection Record.</p>
MCP 2 Egg Cleaning (Washing & sanitizing)	Chlorine concentration and conveyor speed not within specification.	<p>Monitor auto pump dosage and conveyor speed.</p> <p>Chlorine concentration checking by using chlorine test strip.</p>	Every 2 hours	Production worker	<p>Immediate action: 1. On hold the non conformance egg and remove the non-conformance shell egg from the processing line.</p>	<p>WI 35- OPRP Monitoring- OPRP 1 Egg Washing and Sanitizing.</p> <p>PF01- HCP 2 &</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>Corrective Action:</p> <p>1. When the critical limit of chlorine concentration is out:</p> <p>i) In case the chlorine concentration is < 50ppm</p> <ul style="list-style-type: none"> • Check and repair auto dosing condition if required • Worker reset the auto dosing pump to increase the dosage. <p>ii) In case the chlorine concentration > 100ppm</p> <ul style="list-style-type: none"> • Check and repair auto dosing condition if required • Worker reset the auto pump to reduce the dosage <p>iii) Trained workers adjust the setting of the</p>	OPRP 1- Egg Cleaning, Washing & Sanitizing Monitoring Record

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					<p>pressure washing machine refer to the critical limit 50 - 100ppm.</p> <p>3) In the case conveyor speed >80%, technician will adjust the conveyor speed and only resume production when the conveyor speed achieves ≤ 80%.</p>	
MCP 3 Chill storage	Chiller and product temperature not achieve ≤ 4°C	Worker to monitor chill room temperature	Hourly	Production worker	<p>Immediate action:</p> <p>1. QC to on hold the affected product and seal the chill room until resume to normal condition.</p> <p>Corrective action:</p> <p>1. QC informs maintenance personnel to investigate and proceed with repair if chill room breakdown due to compressor breakdown.</p> <p>2. Halal cum QA Executive creates awareness on the need</p>	<p>WI 34- CCP Monitoring – CCP3 (Chill room)</p> <p>PF04 - CCP3 - Chill Room Temperature Monitoring Record</p>

Major Control Point	Halal Risk	Control Mechanism			Corrective Action	WI and Records
		Method	Frequency	Person In Charge		
					the cold room door to be closed all the time.	
MCP 4 Loading	<ul style="list-style-type: none"> i. Truck temperature & loading area temperature >15°C ii. Loading process more than 1 hour iii. Product temperature >4°C 	<ul style="list-style-type: none"> 1. QC to inspect the loading area for $\leq 15^{\circ}\text{C}$ every loading activity 2. QC to monitor the loading time for not more than 1h per loading 3. QC to monitor product temperature for not more than 4°C during loading 4. QA to verify the OPRP record daily 	<ul style="list-style-type: none"> Every 15 minutes Every truck loading involved Every delivery 	QC	<p>Immediate action:</p> <ul style="list-style-type: none"> 1. QC to stop loading activity and close the loading bay until the temperature is resume to within specification <p>Corrective action:</p> <ul style="list-style-type: none"> 1. QC to stop loading activity and inform maintenance to check and repair the compressor. 2. QC to monitor and verify the temperature until resume to within specification 3. QC to access the product temperature and seal the product inside the lorry truck until temperature is within specification. 	<ul style="list-style-type: none"> WI37- OPRP Monitoring – OPRP 3 Loading PF06 - OPRP 3 Loading Inspection Checklist