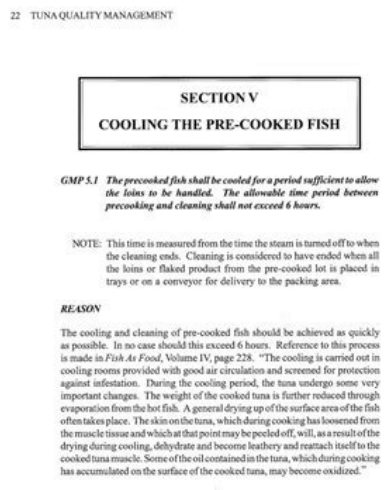

22 TUNA QUALITY MANAGEMENT

SECTION V
COOLING THE PRE-COOKED FISH

GMP 5.1 The precooked fish shall be cooled for a period sufficient to allow the loins to be handled. The allowable time period between precooking and cleaning shall not exceed 6 hours.

NOTE: This time is measured from the time the steam is turned off to when the cleaning ends. Cleaning is considered to have ended when all the loins or flaked product from the pre-cooked lot is placed in trays or on a conveyor for delivery to the packing area.

REASON

The cooling and cleaning of pre-cooked fish should be achieved as quickly as possible. In no case should this exceed 6 hours. Reference to this process is made in *Fish As Food*, Volume IV, page 228. "The cooling is carried out in cooling rooms provided with good air circulation and screened for protection against infestation. During the cooling period, the tuna undergo some very important changes. The weight of the cooked tuna is further reduced through evaporation from the hot fish. A general drying up of the surface area of the fish often takes place. The skin on the tuna, which during cooking has loosened from the muscle tissue and which at that point may be peeled off, will, as a result of the drying during cooling, dehydrate and become leathery and reattach itself to the cooked tuna muscle. Some of the oil contained in the tuna, which during cooking has accumulated on the surface of the cooked tuna, may become oxidized."

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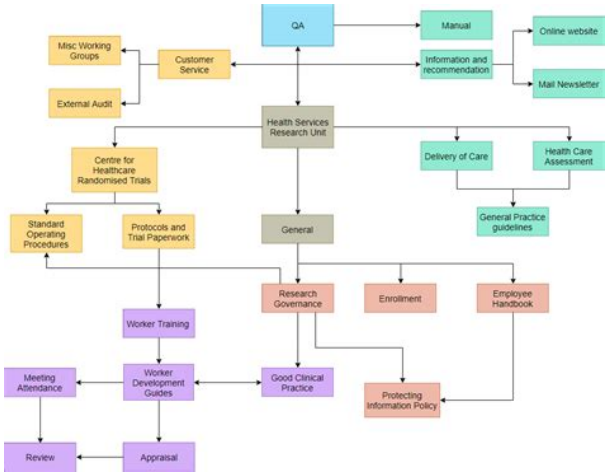
Book Descriptions:

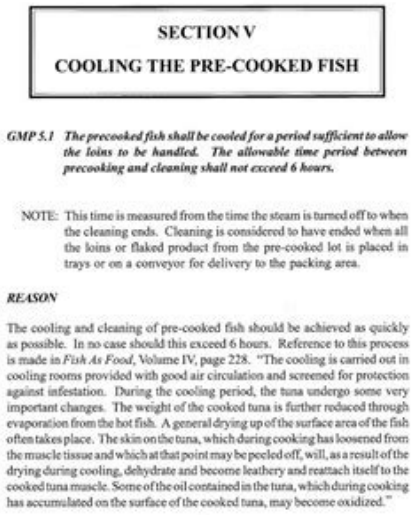
canned tuna quality management manual

Archived information is provided for reference, research or recordkeeping purposes only. It is not subject to the Government of Canada Web Standards and has not been altered or updated since it was archived. For current information visit Food. It defines minimum acceptability of canned tuna for taint, decomposition, unwholesomeness and other requirements other than weight, as defined in the Fish Inspection Regulations, and describes methods for determining that acceptability. In containers of 450 g one pound or less of net contents, such segments are cut into lengths suitable for packing into one layer. In containers of more than 450 g net contents, such segments may be cut into lengths suitable for packing in one or more layers of equal thickness and no layer shall have a thickness less than 2.5 cm. Segments are placed in the can with the planes of their transverse cut ends parallel to the ends of the can. A piece of segment may be added if necessary to fill a container. This is approximately equivalent to 6.3 Munsell units. This is approximately equivalent to 5.3 Munsell units. The sampling plans dictate the minimum sample size to be taken. If necessary, in the opinion of the inspector, more than the minimum sample size specified may be taken. Flaked Greater than 20% grated or shredded. This is approximately equivalent to 6.3 Munsell units. This is approximately equivalent to 5.3 Munsell units. Ensure that the smaller pieces of tuna are moved to the top of a mesh opening to allow them to fall through or be retained on the screen. This weight will be used, by difference, to establish the weight of solid plus chunk tuna. This weight can be used to establish the weight of solid tuna by difference. If the contents are to be evaluated for style of pack, that procedure must be performed first, using the method outlined in section 6.1 of this standard.http://cmoxgermany.com/upimages/dj-196-manual.xml

- **canned tuna quality management manual.**



Subtract the weight of the collecting dish from the total weight of the dish and honeycombed flesh to obtain the weight of honeycombed flesh. A sample shall consist of at least the minimum number of sample units outlined in the sampling plans. It defines minimum acceptability of canned sardines for taint, decomposition, unwholesomeness and other requirements, other than weight, as defined in the Fish Inspection Act and Regulations and describes methods for determining that acceptability. Vegetable broth may also be prepared from hydrolysed vegetable protein, but a broth so prepared requires that its components be declared in a list of ingredients. Examples of such ingredients are spices, herbs, vegetable seasonings, vinegar and wine and vegetables and fruits for decorative and flavouring purposes only. The sampling plans dictate the minimum sample size to be taken. If necessary, in the opinion of the inspector, more than the minimum sample size specified may be taken. Open can and complete net weight determination according to the defined procedures. Examine can interior for presence of foreign material, smut, struvite, and corrosion or other can interior defects. Examine backbone for hardness it should be easily crushed between thumb and forefinger. Examine texture. Examine fish for the presence of large amounts of feed. It defines minimum acceptability of canned shrimp for taint, decomposition, unwholesomeness and other requirements, other than weight, as defined in the Fish Inspection Act and Regulations and describes methods for determining that acceptability. Salt, lemon juice, citric acid, seasonings, sugars and other ingredients, such as permitted additives, may be present. Also, this may denote product containing more than the permitted percentage of broken shrimp. The sampling plans dictate the minimum sample size to be taken. If necessary, in the opinion of the inspector, more than the minimum sample size specified may be taken.http://saigonradio.com/userfiles/dj-bobo-manual-somebody-dance-with-me.xml



SECTION V

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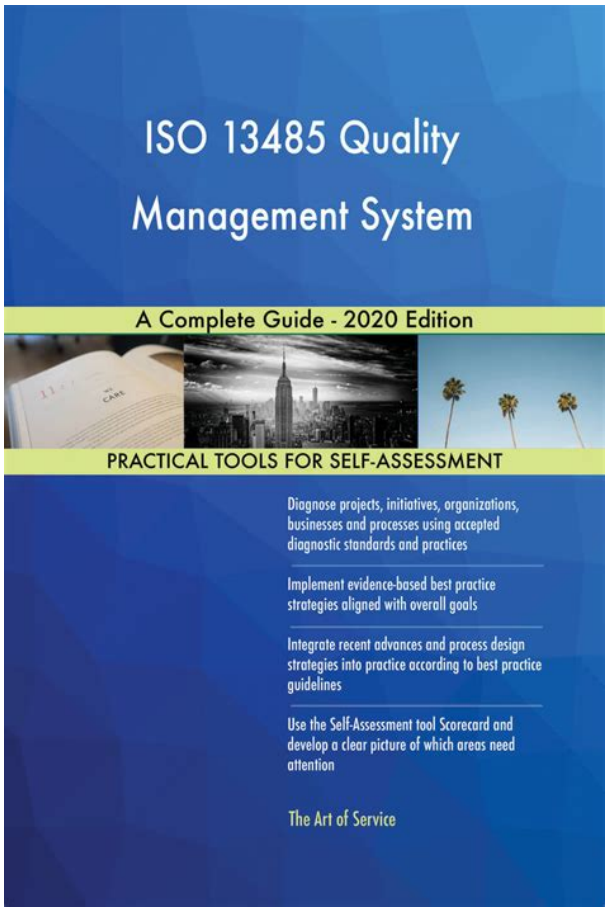
REASON

The cooling and cleaning of pre-cooked fish should be achieved as quickly as possible. In no case should this exceed 6 hours. Reference to this process is made in *Fish As Food*, Volume IV, page 228. "The cooling is carried out in cooling rooms provided with good air circulation and screened for protection against infestation. During the cooling period, the tuna undergo some very important changes. The weight of the cooked tuna is further reduced through evaporation from the hot fish. A general drying up of the surface area of the fish often takes place. The skin on the tuna, which during cooking has loosened from the muscle tissue and which at that point may be peeled off, will, as a result of the drying during cooling, dehydrate and become leathery and reattach itself to the cooked tuna muscle. Some of the oil contained in the tuna, which during cooking has accumulated on the surface of the cooked tuna, may become oxidized."

A drained weight determination should only be conducted on samples which have equilibrated at room temperature for several hours. This will ensure that any gelled brine has liquified. Examine can interior for presence of foreign material, sulphide blackening, struvite, and corrosion or other can interior defects. Assess colour. Calculate the whole shrimp present per 100 g using the following formula The percentage of broken shrimp may be calculated using the following formula It defines minimum acceptability of canned crab for taint, decomposition, unwholesomeness and other requirements, other than weight, as defined in the Fish Inspection Act and Regulations and describes methods for determining that acceptability. The sampling plans dictate the minimum sample size to be taken. If necessary, in the opinion of the inspector, more than the minimum sample size specified may be taken. A drained weight determination should only be conducted on samples which have equilibrated at room temperature for several hours. This will ensure that any gelled brine has liquified. Where parchment paper has been wrapped around the product, care should be taken to ensure product is free to drain properly. Examine can interior for presence of foreign material, sulphide blackening, struvite, and corrosion or other can interior defects. It defines minimum acceptability of canned clams for taint, decomposition, unwholesomeness and other requirements, other than weight, as defined in the Fish Inspection Act and Regulations and describes methods for determining that acceptability. The sampling plans dictate the minimum sample size to be taken. If necessary, in the opinion of the inspector, more than the minimum sample size specified may be taken. Examine can interior for presence of foreign material, sulphide blackening, struvite crystals, and corrosion or other can interior defects. Assess colour of clams and liquid.

It defines minimum acceptability of canned shellfish for taint, decomposition, unwholesomeness and other requirements, other than weight, as defined in the Fish Inspection Act and Regulations and describes methods for determining that acceptability. It is intended to be used for the inspection of canned shellfish products for which specific Canadian product standards have not been elaborated. The sampling plans dictate the minimum sample size to be taken. If necessary, in the opinion of the inspector, more than the minimum sample size specified may be taken. Depending on the species,

abnormal colours may include blue, black, green, grey, or yellowish to orange colours. Examine can interior for presence of foreign material, smut, struvite, and corrosion or other can interior defects. It defines minimum acceptability for taint, decomposition, unwholesomeness and other requirements, other than weight, as defined in the Fish Inspection Act and Regulations and describes methods for determining that acceptability. It is intended to be used for the inspection of canned finfish species for which specific Canadian product standards have not been elaborated. Vegetable broth may also be prepared from hydrolysed vegetable protein but a broth so prepared requires its components to be declared in a list of ingredients; The species from which the oil is derived should be noted on the product label. Examples of such ingredients are spices, herbs, vegetable seasonings, vinegar and wine, and vegetables and fruits for decorative and flavouring purposes only. The sampling plans dictate the minimum sample size to be taken. If necessary, in the opinion of the inspector, more than the minimum sample size specified may be taken. Open can and complete net weight determination, according to defined policies and procedures for these examinations. Carefully remove fish from can to examination tray.



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Inspect can contents for presence of foreign material or other undesirable parts, carefully separating fish as necessary. It defines minimum acceptability for taint, decomposition, unwholesomeness and other requirements, other than weight, as defined in the Fish Inspection Act and Regulations and describes methods for determining that acceptability. It is intended to be used for the inspection of canned salmon prepared from any of the following species The species from which the oil is derived should be noted on the product label. The sampling plans dictate the minimum sample size to be taken. Open container and complete net weight determination, according to the defined policies and procedures for these examinations. Carefully remove fish from container to examination tray.

Compare product form with standard product form. Inspect container contents for presence of foreign material or other undesirable parts, carefully separating fish as necessary. Assess the odour, flavour and texture as required. European tuna sector is vertically integrated, bringing together fishing companies, canners and retailers. It directly provides 20 140 jobs and creates 60 660 indirect jobs in supporting sectors. However, this sector is fully traditional, and mechanisation levels are very low. The loins are extracted from whole frozen tuna pieces. Currently the tuna preparation step in which the loins are extracted is done manually. It involves the usage of industrial saws, with frozen, bulky and slippery material, which entails high risk for the operators. Then, they are analysed using NIRs and hyperspectral image analysis, obtaining biometric parameters and exerting quality control of each piece with nondestructive methods.

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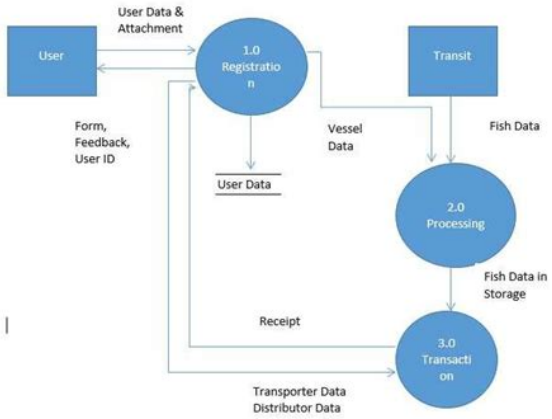

Currently, we need to finetune its design, calibrate the hyperspectral image analysis INFAIMON and scale up its capacity to meet industrial needs, in order to validate it in a fullscale industrial environment in LA GONDOLA's plant, and ultimately attain the final design of its commercial version, which will be marketed by EMENASA. Only on their approval does the product get shipped to the warehouse, the marketplace, and your table. And routine audits performed by the Canadian Food Inspection Agency CFIA confirm this high level of product safety and quality, year after year. Clover Leaf will only source product from manufacturing facilities that meet or exceed Canadian government regulations. In fact, Clover Leaf is the only marketer of canned seafood products in Canada that has full time quality assurance and procurement staff in South East Asia where the majority of tuna and specialty products are sourced, leading to greater assurance of product quality and safety. Further, all facilities are routinely put through a rigorous inspection to ensure that they are continuing to measure up to our standards. If not, the facility is no longer permitted to supply products that will bear the Clover Leaf name. This team is comprised of. The applicationConsider incorporating the HACCP systemA description of various qualityIn the past they have required a positive approach of using Good Manufacturing. Practices GMP, producing food in a hygienic manner, and by inspectionThis requirement might be incorporatedThe management of the establishment must thenAmerica will have to implement such a programme. If you cannot demonstrateCommission has recommended HACCPs adoption as a system for ensuringThroughout the world, the World Trade Organizations. Agreement on the Application of Sanitary and Phytosanitary Measures andPrior to the development of HACCP plans, there is a requirement for establishmentsPrerequisite programmes may be defined as universalFor example, when Sanitation.

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Standard Operating Procedures SSOPs are in place, HACCP can be moreHowever, when aspects of hygiene directly impact food safety, it may beEffective prerequisite programmesControl Points such as Defect Action Points DAPs exist. These areDAPs could be determined through aThe second thing is to ensureSafety Hazards that are likely to occur in your processing operation But what does it meanPOINTS at which hazards may occur PrinciplesI. Task 1 A. PUT TOGETHER A TEAM with knowledge and expertize required for theFor example HACCP to a given operation, consideration should be given to steps precedingChemical hazards which include, among others, natural toxins, pesticides,Physical hazards which include objects such as bones,In this case, this could be dealtFor example, productDuring the hazard analysis, the potentialThe HACCP team has the responsibility toPlan. Only genuinelyHazards for which regulatoryThe term hazard in thisHACCP Plan. Quality concerns should be incorporated in another controlControl measures areMore than one controlExamples of controlGeneral hygiene procedures like wearing protectiveIt is not always easy to decide if aII, which indicates a logic reasoning approach. The use of a decisionWhile this model has been found to beCCPs, it is not specific to all food operations eg.If no proceed to the next question.If no identify how the identifiedIn other words, is it likely that thisIf yes proceedIf no proceed to the next identified hazard inIf no proceed to theIf no this processCCPs.

This can be due to differences in each facility such as layout, equipment,Generic HACCPThese parameters, if maintained withinLag time 2 hrs Finally, you should validate thatFor example, microbiological analyses areMoreover they areFood processing includes line workers,In addition to training and knowledge in their area of competence, prerequisiteThey are concernedThey must be conversant with the techniquesIt is not expectedLike any management system,This verification willCCPs must be signed by the persons doing the monitoring and by a responsibleCCP determination and critical limit determination; records of criticalThe later is important for product traceability.Its the records that provide the big picture. Its the records and action taken on them that ensure theOthers may not. The point is. Every species, product and process will have its own planServices will periodically conduct audits of your HACCP system, to assureIf you haveThus there mayThe most effective HACCP system will be oneAppendix II of the report ofNov 1996 Washington DC.National Advisory Committee on Microbiological Criteria for Foods. International. Journal of Food Microbiology, 16 1992 1 23; HACCP Hazard AnalysisSea Grant publication UNCSG02, N. C. State University 1997; Vol 1 3, 1992 1994; Analysis Critical Control Point System to Food Processing and Manufacturing.ASEANCanada. Fisheries PostHarvest Technology Project Phase II. 1997; Canned Tuna Quality Control. Management Manual. ASEANCanada Fisheries PostHarvest

Technology ProjectHACCP A practicalCTI Publications. Inc.

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Maryland 1996; Project EndofProject Conference 16 18 September 1996; Food Import and Export Inspection and Certification Systems 17 21 FebruaryInspection As stated earlier, all companiesAs the quality control function advancedIn other words, QA is a strategic management function which establishesControl QC are operational techniques and activities that are used toHowever, as both functions areIn the 1970s a management tool called Quality Circles was developed. ItsThese workers attend classes in group communication processes, qualityThis trainingIn the 1980s a management tool called. Total Quality Management TQM became popular. TQM is a systematic wayThe two main rolesIt was firstLike FMEA, HACCP looks for hazards,Control and managementHowever, in 1985 a study commissioned by several. US agencies strongly endorsed HACCP and recommended that regulators andBased on these 1985 recommendations,In 1988 the. International Commission on Microbiological Specification for Foods publishedCommittee on Food Hygiene CCFH started to prepare a draft guideline forThis guide has evolved somewhat overHACCP is compatibleISO 9000 are generally recognized by customers, HACCP is recognized byMore importantly, HACCP is an internationally recognizedCAC, unless higher levels of protection can be justified. The Codex CommitteeThere has been some concern that there is a danger in customization of. HACCP programmes by governments or industries due to valid social, economicHACCP is an excellent, though narrowly defined food safety system thatThese additional factorsQuality Hazard Analysis Hazard Analysis identifies regulatory quality and fair marketing practicesAssessment and Accreditation of Food Import and Export Inspection and Certification.

Systems, states that the principles of HACCP developed by the CCFH provideThe use of a HACCP approach by food businessesThe voluntary utilization of quality controlGovernments do, however, retainThe degree to which industryThe following is taken from the compulsory requirements of DFO Canada inIn cases where each fish isThose lots with a defect levelNote In cases where the finalNumbers for the Inspection of Fish Divide the averageBased on the total numberOnce the rejection number has been exceeded,Please note this plan does not apply toInspection Form not from DFO Project and by other organizations. These can be used as examples or guidelines. Once selected, specific generic modelsThe example is from the Project. Thailand. We would appreciate any comments and suggestions for making thisPlease send informationHave processCheck competence of operation. We firmly line up against relocation, in order to guarantee our Made in Italy quality. Successively, defrosting is carried on through room temperature water flows and tuna is directed to the separation line for cutting. Tuna is successively cooled down, transferred to the conditioning rooms and dried at a controlled temperature. For the production of tuna fillets in glass jars, our company only uses the 50% of all processed steaks, in order to ensure Callipo quality to consumers. Once filled, all jars are directed under the salt measuring device and the olive oil filling machine. At the end of this stage, a number of samples are taken and destined to laboratory checks. This system ensures food chain traceability, by summarizing purchase lots for each components of finished products and the identifying numbers of corresponding suppliers. Callipo pays specific attention to aging time, which is far longer than required by certification bodies.

Both are designed to establish quality and safety requirements, as well as the operational criteria for companies operating in the food industry, in order to comply with all current legislations and consumer protection laws. The award was offered to four Italian companies, one for each sector, with the most solid achievements and a generational continuity in managing their business. This certification is only awarded to products satisfying extremely rigorous quality standards and complying, in term of ingredients, production and packaging procedures, with the restrictive Kasheruth laws. Callipo only uses Yellowfin, clearly labelled on the pack The manufacturing of our

products is carried out in Italy, in the premises located in Maierato VV Calabria, where the processing of tuna is made according to a 106 year tradition. Still nowadays some formats such as Tuna fillets are manufactured by hand by our female workers in full compliance with the strictest food safety measures. We will be glad to answer you promptly. We are a familybased fishing business located in the Comox Valley, Vancouver Island, British Columbia specializing in British Columbia Wild Albacore Tuna. We harvest and sell premiumquality, chilled, and flash frozenatsea Albacore tuna that has been filleted and vacuumpacked in a HAACP approved plant. OMG this stuff is absolutely delicious, clean, fresh and totally unlike store bought cans. The smoked tuna is killer. Starting to pass samples to friends so expect some mail.Due to high demand and limited availability of B.C. canned sockeye, we have now sourced Alaskan Sockeye as well. In our taste tests, we found both excellent. During the life cycle of the B.C. Nass River sockeye salmon, they migrate into the waters of S.E. Alaska. It is only where they are caught that makes them designated as British Columbian or Alaskan Salmon. So the salmon we offer were caught at the mouth of the Nass River, or in S.E. Alaska. Read the full Sockeye Salmon story.

Buying Estevan Tuna provides you with ultimate traceability at a fair price. Check the Where to Buy section for listings. We catch the fish; we sell the fish. Many consumers are concerned about seafood sources today. Buying our tuna provides you with ultimate traceability as well as a great price. Nothing added except one teaspoon of organic extra virgin olive oil. This gives a more moist tuna meat, and is an excellent healthy choice for your family. Our Tuna has no water or other vegetable oil added. Order some today! All the loins are skinless and will weigh between.75 and 2.0 pounds. They may contain a few small bones at the abdominal cavity crease, which are easily felt with the fingers and pulled out or trimmed out in a vertical cut with a small sharp knife. The back pieces are boneless and sometimes preferred for barbecuing because of their more compact triangular shape that doesn’t include the belly flap. An equal number of bellies and backs are included in our 25pound wholesale cases unless custom ordered otherwise. We supply many independent stores, farm markets, etc. We have wholesale pricing and good shipping rates.We catch the younger West Coast albacore which have more natural oils than the more mature, larger whitefleshed tuna processed in the big canneries, so with the tuna we sell, you end up with more fish oil, and more flavor, in the can. The little guys’ “natural” or “raw pack” means it’s cooked just once, in the can. Commercial canneries thaw and cook the fish before canning, drain off the oils, then pack it in cans with water or vegetable oil. Then they cook it a second time during processing. Doublecooking hides bruising and other flaws in lowerquality albacore. It turns the albacore a uniform white color, and allows canneries to get more meat off the fish. But there’s no comparing the taste. It’s such a radical difference between precooked and raw pack. Order our tuna products and try them out, risk free.

If, for any reason, you are not satisfied within 60 days of purchase, email us for a Return Authorization Number. Return your item with this number and we will refund your product cost in full shipping excluded. Order some today! You were there two weekends ago. I was so impressed by this fish. It was one of the best meals I can remember last. We ate half of it sashimi style and the other half ponzo style. Awsome awsome awsome. We looked on the market schedule and your web site for your next visit. No mention of next dates. Could you please send a list of your future visits in the area so I can purchase more of your tuna. I will be at tomorrows market hoping to find you. Thanks again for the tasty experience.” Daniel Salvador De Sousa Fax 2503342929 Some of their initiatives include Components of the program include the following A Wahldesigned vessel with classic West Coast lines, it was built in 1973 and it was mostly used as an Albacore tuna boat stateside. When Bruce brought it up from Oregon in 2005, it was ready for a major overhaul, which was done with vital body parts from a shipwrecked sister vessel, “Larissa” from BC. The transformation took place at Shelter Island Marina and the boat was reborn as the “M.V. Estevan”, a graceful, solid and serviceable wooden Canadian tuna vessel having an overall length of 50 feet. The CHMSF is currently conducting an international recipe contest; check out their website For current

pricing and orders, please contact us Deckhand proudly holding two large fresh tuna. The fishing vessel ESTEVAN in dry dock. Deckhands holding freshlycaught tuna. Tuna fishing in the Estevan cockpit. ESTEVAN at dockside waiting for next tuna run. Dangerous foggy weather with freighters. Clear ocean waters. Fishing for tuna on a grey day. Sunset tuna fishing on the Pacific Ocean. This tuna was bitten by shark just before being brought onboard sharks lurk nearby hoping for an easy catch. Captain and crew of the ESTEVAN.

Another tuna fishing boat speeds by. Extra large tuna today. Close encounter with another tuna boat in rough seas. Beautiful sunsets on a calm ocean make tuna fishing wonderful. Frozen tuna in fish hold. Caught tuna just before hauling over back of boat. Tuna cooling down in cooling checkers. TABLE Product First letters of code marking 1. Salmon Blueback B Chum K Coho C Pink P Sockeye S Spring T Steelhead H Mixed species of minced salmon M 2. Lobster L 3. Tomalley or lobster paste LT 4. Lobster cocktail LC 2 A copy of the key to every code marking required by this section shall be sent to the President of the Agency each year before the commencement of processing operations. PART IV Canned Fish 34 1 Canned fish shall be sterilized by a method approved by the President of the Agency. 2 All registered establishments that conduct canning process operations shall comply with all thermal process requirements set out in the Facilities Manual. Lobster Cocktail 38 1 Lobster cocktail shall be prepared from fresh, wellwashed fish in combination with sound lobster meat that is free from inedible parts. 2 More than 50 per cent of the drained weight of the contents of a can of lobster cocktail shall be lobster meat. Tomalley 39 1 Tomalley shall be prepared from clean, sound roe, green liver and lobster meat free from inedible parts. 2 No can of tomalley shall contain filler or any other ingredient. Lobster Paste 40 1 Lobster paste shall be prepared from those parts of lobsters used in the preparation of tomalley. 2 Lobster paste shall be ground to a smooth consistency, shall be uniform in colour and may contain spices, artificial colouring and filler not exceeding a maximum of two per cent by weight of the finished paste. TABLE Markings on Containers Length of Smelts in Containers 1. Small size under 100 mm 2. Medium size 100 mm but less than 140 mm 3. No. 1 size 140 mm but less than 180 mm 4.

Extra size 180 mm and over 2 The length of a frozen Atlantic smelt shall be determined by measuring from the tip of the nose to the round of the tail of the smelt. Pickled Headless Split Herring 85 A pickled headless split herring shall be graded as a “Headless Split”, if it is a firm, whitebellied, properly split headless herring that is bright in colour and from which all entrails and the blood along the backbone have been removed; or b “Substandard Headless Split”, if it is a split headless herring that does not meet the requirements of paragraph a. Pickled Dressed Herring 86 A pickled dressed herring shall be graded as a “Dressed”, if it is a firm, headless herring that is bright in colour and from which the entrails and a strip of belly, extending from the neck to the anal fin, have been removed in such a manner that no bones protrude; or b “Substandard”, if it is a dressed, headless herring that does not meet the requirements of paragraph a. Pickled Herring Fillets 87 A pickled herring fillet shall be graded as a “No. 1”, if it is a clean, firm, bright herring fillet that is free from rust and discoloration and from which the backbone and fins have been removed; or b “No. 2”, if it is a herring fillet that does not meet the requirements of paragraph a. Scotch Cure 88 A scotch cure pickled herring shall be graded as a “Full”, if it is a properly gutted, firm herring that is bright in colour and shows the roe or the milt at the throat; or b “Fillings”, if it is a properly gutted, firm herring that is bright in colour and does not show the roe or the milt at the throat. Pickled Split Turbot 89 A pickled split turbot shall be graded as a “No. 1”, if it is a white, properly split turbot that is clean on the back and face and free from blood along the backbone; or b “No. 2”, if it is a split turbot that does not meet the requirements of paragraph a and is not sour, “pink” or “red”, rusty or heavily sunburned.