DEPARTMENT OF HEALTH AND HUMAN SERVICES FOOD AND DRUG ADMINISTRATION

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SCORE CARD FOR SANITARY INSPECTION OF MILK PLANTS

DUILDING:				City State		
EQUIPMENT	No. of wagons Gallons sold daily : Milk			: Cream		
DUILDING: Location: Free from contaminating surroundings	EQUIPMENT			METHODS		
Cleanliness: Floors 2 2			Allowed			Allowe
Arrangement: Separate receiving room	UILDING:			BUILDING:		
Separate receiving room	Location: Free from contaminating surroundings	1		Cleanliness:		l
Separate handling room	Arrangement:			Floors	2	
Separate washroom	Separate receiving room	1		Walls	1	l
Separate balesroom		1		Ceilings	1	l
Separate boiler room	Separate washroom	1		Doors and Windows	1	l
Construction: Firesdom from tiles and other insects 3 EQUIPMENT, CONTAINERS, ETC.: Cleanlines: Thoroughly washed and rinsed 4 Apparatus freated with live steam or chlorine; 5 EQUIPMENT, CONTAINERS, ETC.: Cleanlines: Thoroughly washed and rinsed 4 Apparatus freated with live steam or chlorine; 5 EQUIPMENT, CONTAINERS, ETC.: Cleanlines: Thoroughly washed and rinsed 4 Apparatus freated with live steam or chlorine; 5 EQUIPMENT, CONTAINERS, ETC.: Cleanlines: Thoroughly washed and rinsed 4 Apparatus freated with live steam or chlorine; 5 EQUIPMENT, CONTAINERS, ETC.: ETC.: Cleanlines: Thoroughly washed and rinsed 4 Apparatus freated with live steam or chlorine; 5 ETC.: 5 ETC	Separate salesroom	1		Shafting, pulleys, pipes, etc.	1	l
Floors tight, sound, cleanable	Separate boiler room	1			2	l
Walls tight, smooth, cleanable Callings smooth, tight, cleanable Drainage: Floors Floors Floors Floors Floors Floors Floor septic tank Frovision for light (10 percent of floor space) Frovision for pure air Scerean Minimum of shafting, pulleys, hangers, exposed pipes, etc. PPARATUS: Boiler of sufficient capacity Approved pasteurizing equipment Appliances for cleansing & sterilizing utensils & bottles Flitter or clarifier Bottling machine Bottler or clarifier Bottler or clarifier Bottler or clarifier Bottler or clarifier Washbowl, soap, and towel in handling room Milk-handling machinery Pipes, couplings, and pumps Cans TOTAL TOTAL TOTAL Cleanliness: Thoroughly washed and rinsed Apparatus treated with live steam or chlorine; bottles properly sterilized 4 Protected from contamination 1 Provision for ilight (10 percent of floor space) 1 Provision for ilight (10 percent of floor space) 1 Rapidity of handling 1 Pasteurizing equipment operated according to approved methods 10 Freedom from undue exposure to air Cooling: Prompthess 10 Freedom from undue exposure to air Cooling: Prompthess 11 Below 45°F. (46°b 50°, 1) 2 Below 45°F. (46°b 50°, 1) 2 Capping bottles by machine 11 Bottle top protected by cover 11 Storage, below 45°F. (46°b 50°, 3, 51°h 55°, 1) 4 Protection during delivery (iced in summer) 1 Storage, below 45°F. (46°b 50°, 3, 51°h 55°, 1) 4 Protection during delivery (iced in summer) 2 Cans 1 LABORATORY AND EQUIPMENT 2 SANITARY WATER SUPPLY 2 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases Cleanliness of attendants (personal cleanliness, 1; clean washable clothing, 1) 2 CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60	Construction:			Freedom from flies and other insects	3	l
Ceilings smooth, tight, cleanable Drainage: Floors Floors Sewer or septic tank Provision for light (10 percent of floor space) Provision for gight (10 percent of floor space) 1 Provision for gight (10 percent of floor space) 1 Provision for pure air Screens 1 Minimum of shafting, pulleys, hangers, exposed pipes, etc. 1 PPARATUS: Boiler of sufficient capacity 2 Approved pasteurizing equipment 5 Appliances for cleansing & sterilizing utensils & bottles 7 Filter or clarifier 1 Bottlier panchine 1 Bottlier capping machine 1 Bottle-capping machine 1 Bottle capping machine 1 Bottle provision of pure air Screens 1 Appliances to releansing & sterilizing utensils & bottles 3 Promptness 2 Below 45°F. (46°to 50°, 1) Bottle provision of pure air Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) 4 Provision for pure air Screens 1 Bottle provision on the floor of the pasteurization, 0.5). 2 Below 45°F. (46°to 50°, 3; 51 °to 55°, 1) 4 Provision for pure air Screens 1 Bottle provision for pure air Screens 1 Bottle provision for pure air Screens 1 Bottle provision for pure air Screens 1 Pasteurizing equipment operated according to approved methods 10 Pasteurizing equipment operated according to approved methods 10 Provision for pure air Screens 10 Provision for floor floor operated according to approved methods 10 Provision for pure air Screens 10 Provision for floor floor floor floor floor from undue exposure to air Cooling: Promptness 2 Below 45°F. (46°to 50°, 1) Bottle top protected by cover 1 Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) Provision for pure air Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) Provision for pure air Screens 1 Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) Provision for pure air Screens 1 Pasteurizing equipment decording to approve the air Screens 1 Provision for floor floor floor floor floor floor floor floor floor flo	Floors tight, sound, cleanable	2		EQUIPMENT, CONTAINERS, ETC.:		l
Drainage: Flors Sewer or septic tank Provision for light (10 percent of floor space) 1 Provision for pure air Screens 1 Riminum of shatting, pulleys, hangers, exposed pipes, etc. PPARATUS: Boiler of sufficient capacity Approved pasteurizing equipment Approved pasteurizing equipment Sottles producing as terrilizing utensits & bottles Filter or clarifler Bottle-capping machine Bottle-capping machine 1 Bottle-capping machiney Pipes, couplings, and pumps Cans LABORATORY AND EQUIPMENT SANITARY WATER SUPPLY TOTAL Approvad pasteurizing equipment TOTAL Approved pasteurizing equipment 1 Bottle-capping machiney 2 Pipes, couplings, and pumps Cans LABORATORY AND EQUIPMENT SANITARY WATER SUPPLY Approved pasteurizing equipment Approved pasteurizing with live steam or chlorine; bottlete properly sterilized 4 Protected from contamination 1 HANDLING MILK Received below 50°F, (51°to 55°, 2; 56°to 60°, 1) 3 Rapidity of handling 1 Pasteurizing equipment operated according to approved methods 10 Freedom from undue exposure to air 1 Cooling: Promptness 2 Below 45°F, (46°to 50°, 1) 2 Capping bottles by machine 1 Bottle top protected by cover 1 Storage, below 45°F, (46°to 50°, 3; 51 °to 55°, 1) 4 Protection during delivery (iced in summer) 2 Pipes and towel in handling machiney 2 Producers' samples 1 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases Cleanliness of attendants (personal cleanliness, 1; clean washable clothing, 1) 2 CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60	Walls tight, smooth, cleanable	1		Cleanliness:		l
Floors	Ceilings smooth, tight, cleanable	1		Thoroughly washed and rinsed	4	
Provision for light (10 percent of floor space)	Drainage:			Apparatus treated with live steam or chlorine;		
Provision for light (10 percent of floor space)	Floors	1		bottles properly sterilized	4	l
Provision for pure air 2	Sewer or septic tank	1		Protected from contamination	1	l
Screens Minimum of shafting, pulleys, hangers, exposed pipes, etc. PPARATUS: Boiler of sufficient capacity Approved pasteurizing equipment Appliances for cleansing & sterilizing utensils & bottles Filter or clarifier Bottle-capping machine Bottle-capping machine Bottle-capping machine Milk-handling machinery Pipes, couplings, and pumps Cans LABORATORY AND EQUIPMENT SANITARY WATER SUPPLY TOTAL BOTTAL Appliances of attendants (personal cleanliness, 1; clean washable clothing, 1) CLEANLINESS OF DELIVERY OUTFIT TOTAL Bapidity of handling Pasteurizing equipment operated according to approved methods Approved rethods Approved methods Approved rethods Approved re	Provision for light (10 percent of floor space)	1		HANDLING MILK		
Minimum of shafting, pulleys, hangers, exposed pipes, etc. PPARATUS: Boiler of sufficient capacity Approved pasteurizing equipment 5 Approved pasteurizing equipment 5 Appliances for cleansing & sterilizing utensils & bottles 3 Filter or clarifler Bottler or clarifler Bottle-capping machine Bottle-capping machine 1 Condition: Milk-handling machinery Pipes, couplings, and pumps Cans LABORATORY AND EQUIPMENT SANITARY WATER SUPPLY TOTAL A0 Pasteurizing equipment operated according to approved methods 10 Preedom from undue exposure to air Cooling: Promptness 2 Below 45°F. (46°to 50°, 1) 2 Below 45°F. (46°to 50°, 1) 2 Below 45°F. (46°to 50°, 1) 2 Capping bottles by machine 1 Bottle top protected by cover 1 Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) 4 Protection during delivery (iced in summer) 2 INSPECTION: Bacteriological work: Plant samples Producers' samples 1 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases 3 Cieanliness of attendants (personal cleanliness, 1; clean washable clothing, 1) 2 CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60	Provision for pure air	2		Received below 50°F. (51°to 55°, 2; 56°to 60°, 1)	3	
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Boiler of sufficient capacity Approved pasteurizing equipment Appliances for cleansing & sterilizing utensils & bottles 3 Appliances for cleansing & sterilizing utensils & bottles 3 Below 45°F. (46°to 50°, 1) Bottling machine Bottle-capping machine Bottle-capping machine I Bottle-capping machine I Bottle-capping machine I Bottle-capping machine I Bottle-capping machine I Bottle-capping bottles by machine Bottle top protected by cover I Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) Appliances I Bottle top protected by cover I Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) Appliances I Bottle-capping machine I Bottle top protected by cover I Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) Appliances I Bottle-capping bottles by machine I Bottle top protected by cover I Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) Appliances I Bottle-capping bottles by machine I Bottle top protected by cover I Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) Appliances I Bottle-capping bottles by machine I Bottle top protected by cover I Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) Appliances I Bottle-capping bottles by machine I Bottle-top protected by cover I Storage, below 45°F. (46°to 50°, 3; 51 °to 55°, 1) Appliances I Bottle-capping bottles by machine I Bottle-capping bottles by machine I Bottle-top protected by cover I Bottle-capping bottle-storile I Bottle-capping bott	Minimum of shafting, pulleys, hangers, exposed pipes, etc.	1		Pasteurizing equipment operated according to		l
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Appliances for cleansing & sterilizing utensils & bottles Filter or clarifier Bottle capping machine Bottle-capping machine Bottle-capping machine I	Boiler of sufficient capacity	2		Freedom from undue exposure to air	1	l
Below 45°F. (46°to 50°, 1) 2	Approved pasteurizing equipment	5		Cooling:		l
Bottling machine	Appliances for cleansing & sterilizing utensils & bottles	3			2	
Bottle-capping machine 1 pasteurization (After pasteurization, 0.5). 2 Washbowl, soap, and towel in handling room 1 Condition: Milk-handling machinery 2 Storage, below 45°F. (46° to 50°, 3; 51 °lo 55°, 1) 4 Protection during delivery (iced in summer) 2 LABORATORY AND EQUIPMENT 2 Bacteriological work: SANITARY WATER SUPPLY 2 Producers' samples 2 INSPECTION: TOTAL 40 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases 3 CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60 CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60 C	Filter or clarifier	1		Below 45°F. (46°to 50°, 1)	2	l
Washbowl, soap, and towel in handling room Condition: Milk-handling machinery Pipes, couplings, and pumps Cans LABORATORY AND EQUIPMENT SANITARY WATER SUPPLY TOTAL TOTAL Capping bottles by machine Bottle top protected by cover Storage, below 45 °F. (46 °to 50 °, 3; 51 °to 55 °, 1) Protection during delivery (iced in summer) 2 INSPECTION: Bacteriological work: Plant samples Producers' samples Inspection of dairies supplying milk (once a year, 1) CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases Clean washable clothing, 1) Capping bottles by machine Bottle top protected by cover 1 I Protection during delivery (iced in summer) 2 INSPECTION: Bacteriological work: Plant samples 2 Inspection of dairies supplying milk (once a year, 1) CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases Clean washable clothing, 1) Capping bottles by machine Bottle top protected by cover 1 I Protection during delivery (iced in summer) 2 INSPECTION: Bacteriological work: Plant samples 2 Inspection of dairies supplying milk (once a year, 1) 2 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases Clean washable clothing, 1) CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60	Bottling machine	1		Milk efficiently filtered or clarified before		
Condition: Milk-handling machinery Pipes, couplings, and pumps Cans LABORATORY AND EQUIPMENT SANITARY WATER SUPPLY TOTAL TOTAL Description of dairies supplying milk (once a year, 1) CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases Clean liness of attendants (personal cleanliness, 1; clean washable clothing, 1) CLEANLINESS OF DELIVERY OUTFIT TOTAL Bottle top protected by cover Storage, below 45 ft. (46° to 50°, 3; 51 °to 55°, 1) 4 Protection during delivery (iced in summer) 2 INSPECTION: Bacteriological work: Plant samples Producers' samples 2 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases 3 Clean washable clothing, 1) 2 CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60	Bottle-capping machine	1		pasteurization (After pasteurization, 0.5).	2	l
Milk-handling machinery 2	Washbowl, soap, and towel in handling room	1		Capping bottles by machine	1	
Pipes, couplings, and pumps Cans LABORATORY AND EQUIPMENT SANITARY WATER SUPPLY TOTAL TOTAL Protection during delivery (iced in summer) 1	Condition:			Bottle top protected by cover	1	l
Cans 1 INSPECTION: LABORATORY AND EQUIPMENT 2 Bacteriological work: SANITARY WATER SUPPLY 2 Plant samples 2 Producers' samples 2 Inspection of dairies supplying milk (once a year, 1) 2 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases 3 Clean liness of attendants (personal cleanliness, 1; clean washable clothing, 1) 2 CLEANLINESS OF DELIVERY OUTFIT 1	Milk-handling machinery	2		Storage, below 45°F. (46°to 50°, 3; 51°to 55°, 1)	4	l
LABORATORY AND EQUIPMENT 2 Bacteriological work: SANITARY WATER SUPPLY 2 Plant samples 2 Producers' samples 2 Inspection of dairies supplying milk (once a year, 1) 2 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases 3 Clean washable clothing, 1) 2 CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60	Pipes, couplings, and pumps	2		Protection during delivery (iced in summer)	2	l
SANITARY WATER SUPPLY 2 Plant samples 2 Producers' samples 2 Inspection of dairies supplying milk (once a year, 1) 2 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases 3 Cleanliness of attendants (personal cleanliness, 1; clean washable clothing, 1) 2 CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60 DELIVERY OUTFIT 5 TOTAL 60 DELIVERY OUTFIT 6 TO	Cans	1		INSPECTION:		l
TOTAL 40 Producers' samples 2 Inspection of dairies supplying milk (once a year, 1) 2 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases 3 Cleanliness of attendants (personal cleanliness, 1; clean washable clothing, 1) 2 CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60	LABORATORY AND EQUIPMENT	2		Bacteriological work:		l
TOTAL 40 Inspection of dairies supplying milk (once a year, 1) 2 CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases 3 Clean liness of attendants (personal cleanliness, 1; clean washable clothing, 1) 2 CLEANLINESS OF DELIVERY OUTFIT 1	SANITARY WATER SUPPLY	2		Plant samples	2	l
CLEANLINESS AND HEALTH OF EMPLOYEES: Annual medical examination of milk handlers for communicable diseases				Producers' samples	2	
Annual medical examination of milk handlers for communicable diseases	TOTAL	40		Inspection of dairies supplying milk (once a year, 1)	2	l
communicable diseases				CLEANLINESS AND HEALTH OF EMPLOYEES:		l
Cleanliness of attendants (personal cleanliness, 1; clean washable clothing, 1) 2 CLEANLINESS OF DELIVERY OUTFIT 1 TOTAL 60				Annual medical examination of milk handlers for		l
					3	
CLEANLINESS OF DELIVERY OUTFIT 1 1				Cleanliness of attendants (personal cleanliness, 1;		l
TOTAL 60				clean washable clothing, 1)	2	l
<u> </u>				CLEANLINESS OF DELIVERY OUTFIT	1	
<u> </u>						
EQUIPMENT + METHODS = FINAL SCORE				TOTAL	60	l——
NOTE 1 If the conditions in any particular are so exceptionally bad as to be inadequately expressed by a score of 0, the inspector can make a					n mak	се а

RULES FOR USING SCORE CARD FOR SANITARY INSPECTION OF MILK PLANTS

EQUIPMENT

BUILDING:

- -- Must be located free from contaminating surroundings as determined by the inspector.
- -- To obtain full credit there must be separate rooms for receiving and handling (pasteurizing, processing, cooling, and bottling) the milk. Also separate rooms for washing and treating milk containers, separate salesroom, and separate boiler room. No credit should be given where other operations are carried on in a room which the score card specifies should be a separate room.
- -- Floors must be constructed of good quality concrete or other equally impervious material. Walls and ceilings should be finished with smooth wood, tile, smooth-surface concrete, or cement plaster, brick, or other equivalent material, with a washable light-colored surface. If of wooden construction, they should be painted at least once each year.
- -- Drainage shall be considered satisfactory when: The floor surface is smooth and sloped so that there will be no pools of standing water after flushing; the joints of the floor and walls are constructed so as to be impervious; the floors are provided with trapped drains so constructed as to minimize clogging; the plumbing is so installed that no sewage can back up into the drain and flood the floor; the drainage empties into a sewer or properly constructed septic tank of sufficient capacity.
- -- Proper and adequate toilet facilities must be provided.
- -- Artificial light may be accepted, provided it is equivalent to one 50-watt electric light per 100 square feet offloor area and is evenly distributed.
- -- Artificial means of ventilation must be supplemented for doors and windows when necessary.
- -- Unless other effective means are provided to prevent the access of flies, all openings into the outer air shall be effectively screened.
- -- Minimum of shafting, pulleys, etc.; self-explanatory, based on the minimum which it should take to operate the equipment if conditions in the plant were ideal.

APPARATUS:

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- The boiler must be of sufficient capacity to furnish steam or hot water for all pasteurizing processes and hot water and steam for the cleaning and treatment of all containers. apparatus, etc.
- -- The pasteurizing equipment must be of a type which complies with the ordinance under which it is operated and must be approved by the health department. (For details of proper pasteurizing equipment, see the U.S. Public Health Service Milk Ordinance and Code.)
- -- Appliance for cleaning and sterilizing utensils and bottles; self-explanatory.
- -- Filter or clarifier; self-explanatory.
- -- Bottling machine; self-explanatory.
- -- Bottle-capping machine; self-explanatory.
- -- A washbowl and an adequate supply of warm water and individual supply of cloth or paper towels should be available.
- -- All milk-handling machinery as well as pipes, pumps, cans, etc., shall be constructed in such a manner as to be easily cleaned and shall be kept in good repair.
- -- The laboratory must be equipped with apparatus and materials for making both chemical and bacteriological determinations.
- -- The water supply must not only be of a good, safe, sanitary quality, but must be adequate and easily accessible. Water from streams which is not filtered or treated chemically

METHODS

BUILDING:

- -- Cleanliness; self-explanatory.
- -- Freedom from odors; self-explanatory.
- -- Freedom from flies and other insects; self-explanatory.

EQUIPMENT, CONTAINERS, ETC.

- -- All milk and milk products containers, apparatus, etc., must be thoroughly cleaned after each usage and subjected to live steam or chlorine treatment immediately before each usage. Chlorine solutions must be tested frequently for strength and be free of organic matter.
- -- After bactericidal treatment, containers, apparatus, etc., must be stored as to be protected from dust and insects.

HANDLING MILK:

- -- Temperature received; self-explanatory.
- -- Rapidity of handling: All milk received for pasteurization but not pasteurized within 2 hours after it is received at the plant, shall within 2 hours of receipt be cooled to a temperature of 50 F. or less and maintained at or below that temperature until pasteurization is begun.
- -- The pasteurizing equipment must be operated in compliance with the ordinance under which it is operated and must be approved by the health department. Frequent checks on the accuracy of recording and indicating thermometers are essential.
- -- Open surface coolers shall be located in a separate, well-ventilated room or shall be provided with tight-fitting covers.
- -- Milk shall be cooled immediately after pasteurization. Temperature of cooling; self-explanatory.
- -- Filtered or clarified; self-explanatory.
- -- Capping bottles by machine; self-explanatory.
- -- Bottle top should be covered so as to completely protect the pouring lip.
- -- Storage; self-explanatory
- -- During the delivery the milk must be kept cold and protected from dust and dirt.

INSPECTION:

- -- Bacterial analysis should be made at least once per week on milk as delivered by the plant, and at least once each month as delivered to the plant from producers.
- -- Dairies supplying milk must be inspected at least every 6 months to receive full credit.

CLEANLINESS AND HEALTH OF EMPLOYEES:

-- Self-explanatory

CLEANLINESS OF DELIVERY OUTFIT:

-- Self-explanatory.

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DHHS/FDA/CFSAN 5100 Paint Branch Parkway College Park, MD 20740-3835

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