



European Guide to good practice for the industrial manufacture of safe feed materials

Sector reference document on the manufacturing of safe feed materials from starch processing

Version 3.1
Effective from November 2014



Sectors covered by the European Guide

The following sector specific sector documents have been developed by the respective European sector organisations in cooperation with EFISC:

[Starch Europe](#) **Sector reference document on the manufacturing of safe feed materials from starch processing**

[FEDIOL](#) Sector reference document on the manufacturing of safe feed materials from oilseed crushing and vegetable oil refining

[EBB](#) Sector reference document on the manufacturing of safe feed materials from Biodiesel processing

This European Guide is open to other manufacturers producing feed materials by the development of a sector specific document.

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APPENDIX 3 - Sector reference document on the manufacturing of safe feed materials from starch processing

a) Introduction

The European starch industry produces a large number of products used for food and feed as an integral part of their overall business plans. Indeed, the starch industry separates the components of cereals, potatoes and peas in order to process them and meet the needs of its numerous customer industries.

It is imperative to the starch manufacturing industry that feed materials are produced in an economic and safe manner and that the products obtained are suitable for human and animal consumption as illustrated by their meeting all current European and national food and feed safety legislation requirements. Many food ingredients obtained by the starch industry are also used as feeding materials. These products are listed in the Feed catalogue (Reg. EU n°68/2013) and can be included in the scope of the operators feed safety management system.

Regarding animal feed materials, Article 20 of the European Feed Hygiene Regulation (EC) n°183/2005/EC, which came into effect on January 1st 2006, allows for the development of Sector Guides by animal feed producers, including feed materials suppliers such as the Starch Europe.

The fact that a HACCP approach to food safety risk management has been widely and successfully implemented in terms of food manufacture has highlighted the potential of such an approach within the feed industry. But a HACCP system alone is not sufficient and if the benefits of such an approach are to become a reality this must be backed by management support, traceability, as laid down in Regulation n°178/2002(EC), communication throughout the business/ sector and the internal monitoring and control of all feed production and distribution processes.

By the universal application of HACCP principles to all stages of production European starch manufacturers are able to provide animal feeds materials of plant origin which are safe for not only for the consuming animal but which also have no deleterious effect upon the safety of a human consumer further up the food chain.

The Starch Europe member companies bring to the attention the following points:

- The plant origin of raw materials processed by the starch industry and the nature of the feed materials limit risks for the feed industry and make risk management easier.
- A strong dynamic of progress is to be noted in the starch industry, which is of benefit to all its customers: indeed, most products of the starch industry are intended not only for feeding materials but also for food, pharmaceuticals and other industries.
- Starch producers very carefully comply with regulations and the quality imperatives of all their customers' fields of activity. These requirements led to the setting up of quality assurance systems, with knock-on effects on all our products.

- The starch industry is therefore very much oriented towards quality control:
 - ISO 22000:2005 and ISO/TS 22002 with a strong focus on HACCP
 - Quality improvement programs integrating the principles of the HACCP method for all products;
 - Extension of ISO certifications and/or HACCP program to all raw materials intended for feeding materials.

Particular attention has always been given to raw materials supplies: increased traceability, quality assurance procedures applying to our suppliers, surveillance scheme (e.g. mycotoxins in wheat and maize), setting up of improvement agreements, audits, etc.



TABLE OF CONTENTS

| | |
|--|-----------|
| a) Introduction | <u>1</u> |
| List of abbreviations used | <u>5</u> |
| b) Methodology of the Starch Europe food and feed chain risk assessment | <u>6</u> |
| c) Listing of Feed Materials | <u>6</u> |
| d) Overview of main processes | <u>9</u> |
| 1. Manufacture of Maize Starch | <u>10</u> |
| 2. Manufacture of Wheat Starch | <u>12</u> |
| 3. Manufacture of Potato Starch | <u>13</u> |
| 4. Manufacture of Pea starch | <u>19</u> |
| e) Summary of the risk-based approach for the starch sector | <u>21</u> |
| f) Risk assessments | |
| Table 1- a general risk assessment applicable for any of the starch industry raw material (wheat, maize, potato, pea) | <u>22</u> |
| 1.1 Raw materials | <u>20</u> |
| 1.2 Water | <u>23</u> |
| 1.3 Processing agents- chemical agents | <u>24</u> |
| 1.4 Processing agents- enzymes | <u>25</u> |
| 1.5 Processing agents- filter aids | <u>26</u> |
| 1.6 Contact materials | <u>27</u> |
| 1.7 Manufacturing process control | <u>28</u> |
| 1.8 Storage and transport control | <u>28</u> |
| Table 2- Focus on the main steps risks (reception, process, storage & loading steps) by product | |
| 2.1 Maize product | <u>29</u> |
| 2.2 Wheat product | <u>35</u> |
| 2.3 Potato product | <u>39</u> |
| 2.4 Pea product | <u>48</u> |
| g) Annex 1 Minimum monitoring requirements | <u>51</u> |



List of abbreviations used:

As: Arsenic

Cd: Cadmium

CIP: cleaning-in-place

CCP: Critical Control Point

CFU/g: Colony Forming Units per gram

DDT: Dichlorodiphenyltrichloroethane

GMP: Good Manufacturing Practice

HACCP: Hazard Analysis Critical Control Point

HCB: Hexachlorobenzene

HCH: Hexachlorocyclohexane

HCN: Hydrogen cyanide

Hg: Mercury

ISO: International Organisation for Standardisation

MRL: Maximum Residue Limits

PAH: Polycyclic aromatic hydrocarbons

Pb: Lead

PCB: Polychlorinated biphenyls

SO₂: Sulphur Dioxide

T°C: temperature degree Celsius



b) Methodology of the Starch Europe food and feed chain risk assessment

1. Starch Europe made the following crops subject to a food and feed safety chain risk assessment:

- Maize starch
- Wheat Starch
- Potato Starch
- Pea Starch

2. Starch Europe conducted the chain risk assessments according to the requirements as described in chapter 6 of the European Guide to good practice for the industrial manufacture of safe feed materials.

Starch Europe will evaluate the food and feed safety assessments of the chains of starch products on a two yearly basis.



c) Listing of Feed Materials

Feed materials from the starch industry meet the statutory definitions of raw materials (Regulation 68/2013 definitions). However, the composition of marketed products may differ, depending on production sites, production tools and processes, and market opportunities.

The following list is a non-exhaustive list of the main products of the starch industry intended for use as feed materials by feeding stuffs producers; the definitions below are extracts from Regulation 68/2013 (taking into account industrial language).

| Name | Number | Description |
|----------------------|---------|--|
| ○ Maize gluten | 1.2.8 | Product of the manufacture of maize starch. It consists principally of gluten obtained during separation of starch. |
| ○ Maize gluten feed | 1.2.9 | Product obtained during the manufacture of maize starch. It is composed of bran and maize solubles. The product may also include broken maize and residues from the oil extraction of maize germs. Other products derived from starch and from the refining or fermentation of starch products may be added. |
| ○ Maize germ meal | 1.2.12 | Product of oil manufacture, obtained by extraction of processed maize germ |
| ○ Wheat Feed | 1.11.6 | Product of flour or malting manufacture obtained from screened grains of wheat or dehusked spelt. It consists principally of fragments of the outer skins and of particles of grain from which less of the endosperm has been removed than in wheat bran. |
| ○ Wheat gluten feed | 1.11.16 | Product of the manufacture of wheat starch and gluten. It consists of bran, from which the germ may have been partially removed. Wheat solubles, broken wheat and other products derived from starch and from the refining or fermentation of starch products may be added. |
| ○ Vital wheat gluten | 1.11.18 | Wheat protein characterised by a high viscoelasticity as hydrated, with minimum 80 % protein (N × 6,25) and maximum 2 % ash on dry substance |
| ○ Potato pulp | 4.8.8 | Product of the manufacture of potato starch consisting of extracted ground potatoes. |

- Potato pulp, dried 4.8.9 Dried product of the manufacture of potato starch consisting of extracted ground potatoes.
- Potato protein 4.8.10 Product of starch manufacture composed mainly of protein substances obtained after the separation of starch.
- Potato juice, concentrated 4.8.14 Concentrated product of the manufacture of potato starch, consisting of the remaining substance after the partial removal of fibre, proteins and starch from the whole potato pulp and evaporation of part of the water.
- Pea protein 3.11.9 Product obtained from the separated pea fruit water when producing starch, or after grinding and air fractionation, maybe partially hydrolysed.
- Pea solubles 3.11.11 Product obtained from starch and protein wet extraction from peas. It is mainly composed of soluble proteins and oligosaccharides.
- Pea fibre 3.11.12 Product obtained from the separated pea fruit water when producing starch, or after grinding and air fractionation, maybe partially hydrolysed.
- Starch mixture 13.3.3 Product consisting of native and/or modified food starch obtained from different botanical sources.

The above list will be amended, if appropriate, in function of industrial developments within the starch industry, or of an evolution of the EU legislation on feed materials like e.g. a review of the Catalogue of feed materials.

The above list is non exhaustive. Other raw materials (e.g. barley and rice) and other feed materials (that can be specific to a plant or based on market demands) and all food ingredients sold also as feed materials, are considered to be within the scope of the 'Community Guide to good practice for the industrial manufacture of safe feed materials'. For all products sold as feeds materials a risk assessment in line with annex 3 needs to be available.

The exact compositions of marketed products sold to the feeding industry can be found in the marketing documents (data sheets) of each starch producer.



d) Overview of the main processes

The below manufacturing diagrams are basic schemes (i.e. examples) for the production of starch from wheat, maize, potato and pea, yet every production site may present distinctive features.

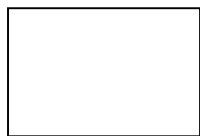
Specific feed materials are underlined in the flow charts. However all other products except ethanol can be used both for feed and food.

They must not be regarded as a standardized process to be applied by starch companies. Each company remains free to decide what design each industrial processing unit should look like.

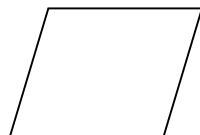
Symbols



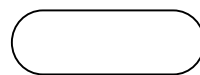
Main Process



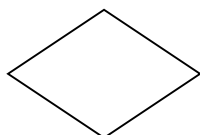
Process step



Material



Process start or terminator



Decision

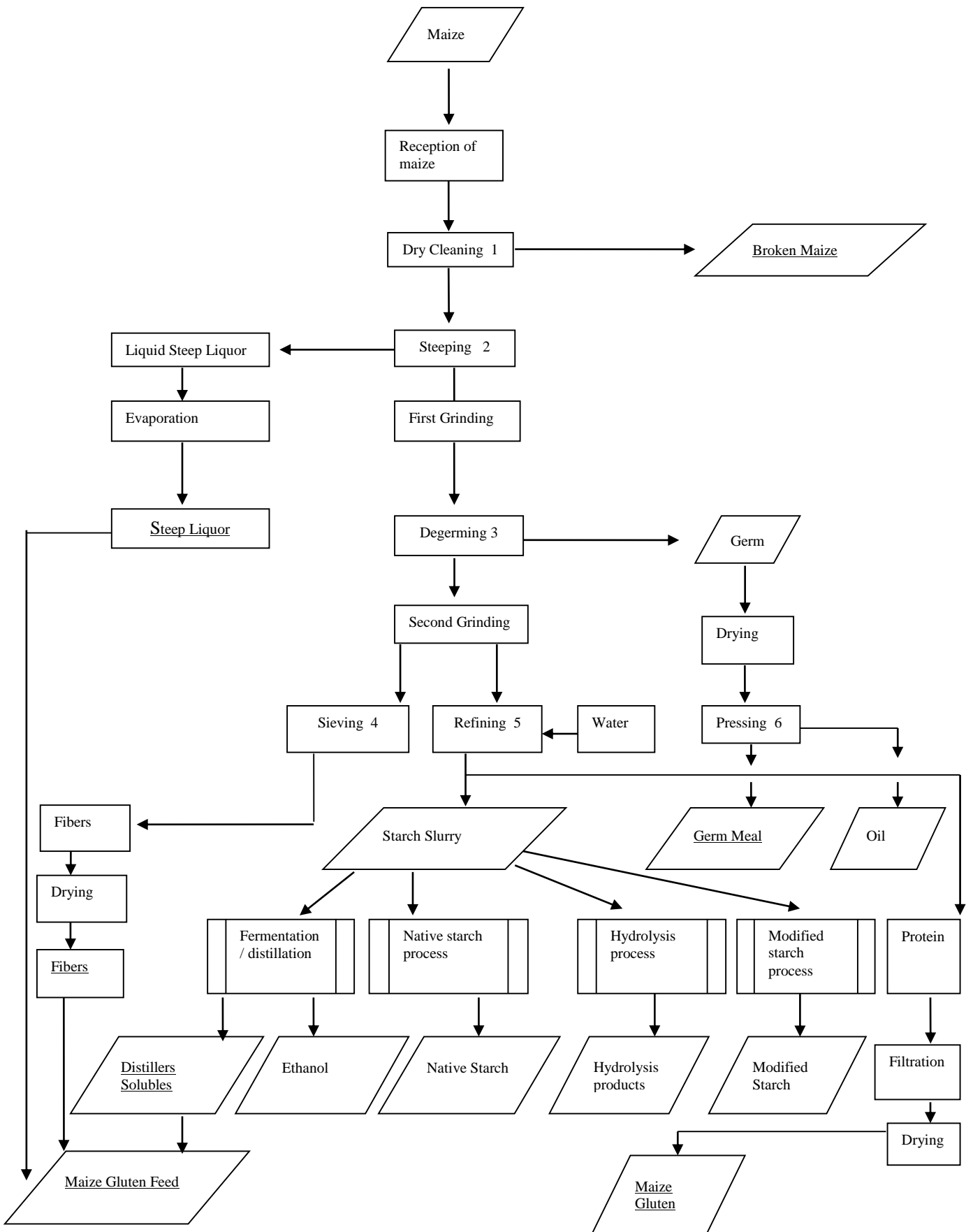


1. MANUFACTURE OF MAIZE STARCH

1. Dry cleaning: sieving and sucking up of impurities and broken grains. The parts non suitable for feed use are eliminated. The parts suitable for feed use are sold as such or incorporated in corn gluten feed.
2. Steeping: corn put into water in order to separate the soluble components (= liquid steep liquor). Micro-organism controlling agent is added to prevent from bad fermentation.
3. Degerming: germ separated from the grain thanks to density difference going through a cycloning.
4. Sieving: product goes through a sieve. Fibres particles stay on the sieve / slurry made of starch and protein goes through.
5. Refining: starch separated from protein thanks to density difference going through a centrifugal extractor.
6. Pressing: oil separated from germ thanks to mechanical pressure.



1. MANUFACTURE OF MAIZE STARCH - BASIC SCHEME

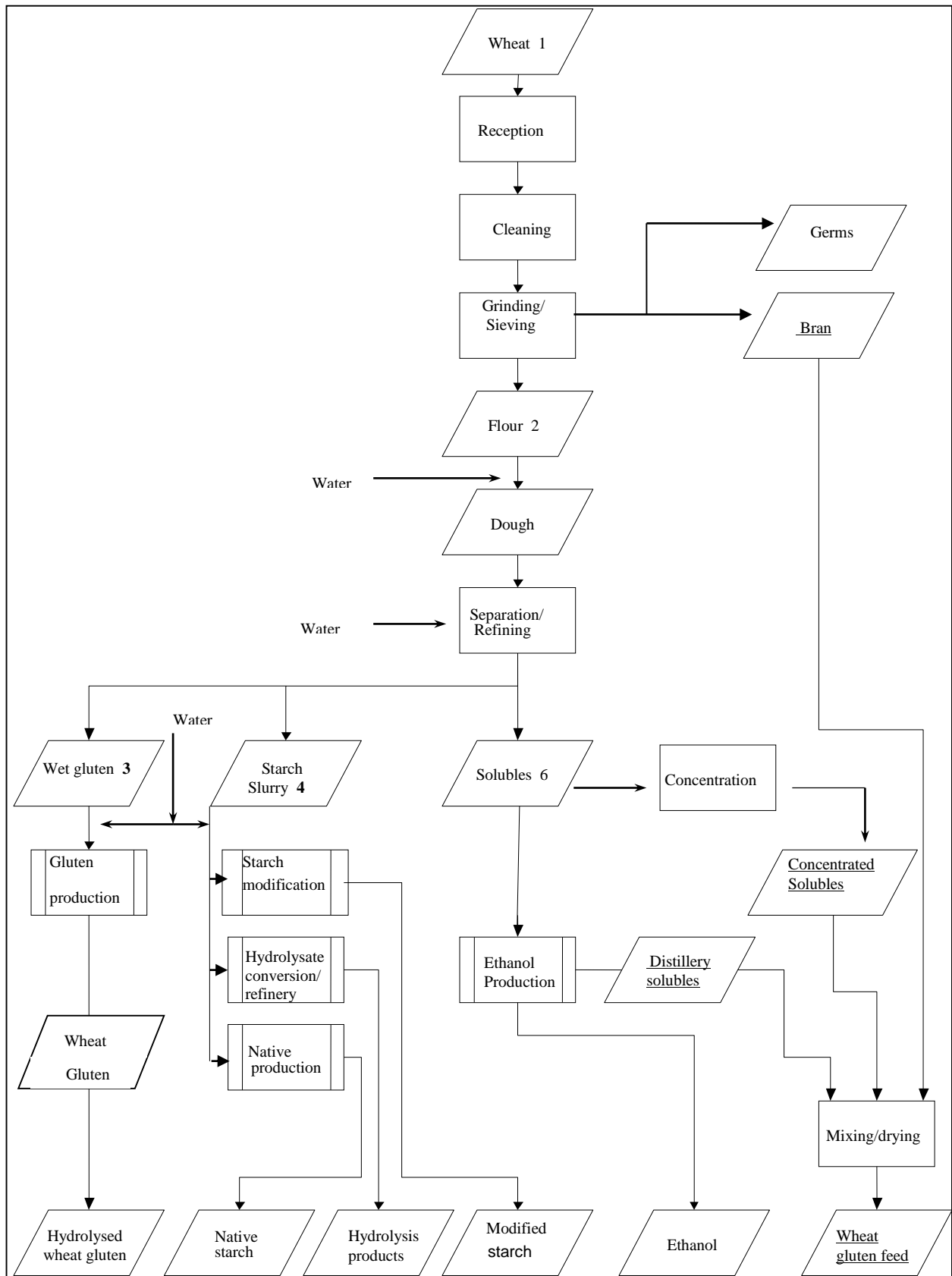


2. MANUFACTURE OF WHEAT STARCH

1. The incoming wheat is cleaned and ground to flour. The wheat bran and eventually also wheat germ are separated from the flour by sieving.
2. The flour is mixed with water to form a dough and the starch and gluten are separated by a physical process.
3. The wet gluten is washed with water to remove residual starch and dried to wheat gluten. The wet gluten can be partially hydrolysed also to produce hydrolysed wheat gluten.
4. The starch slurry is washed with water and can be:
 - Dried to produce native wheat starch;
 - Physically and/or chemically modified and dried to produce modified wheat starches;
 - Hydrolysed by acid hydrolysis and/or enzymes to produce a range of starch hydrolysis products.
5. A fraction of the starch separated during washing can be used in animal feed (liquid wheat starch) or in ethanol production (not shown in the flowdiagram).
6. A fraction of solubles from the separation of starch and gluten can be used in alcohol production, or concentrated and used as such in animal feed (wheat solubles) or added to the wheat bran to produce wheat gluten feed.
7. In ethanol production the starch is enzymatically hydrolysed to sugars and fermented to ethanol with yeast. The ethanol is separated by distillation, and the remaining solubles are concentrated and either used as such in animal feed (distillery grains and solubles) or added to the wheat gluten feed.



2. MANUFACTURE OF WHEAT STARCH - BASIC SCHEME



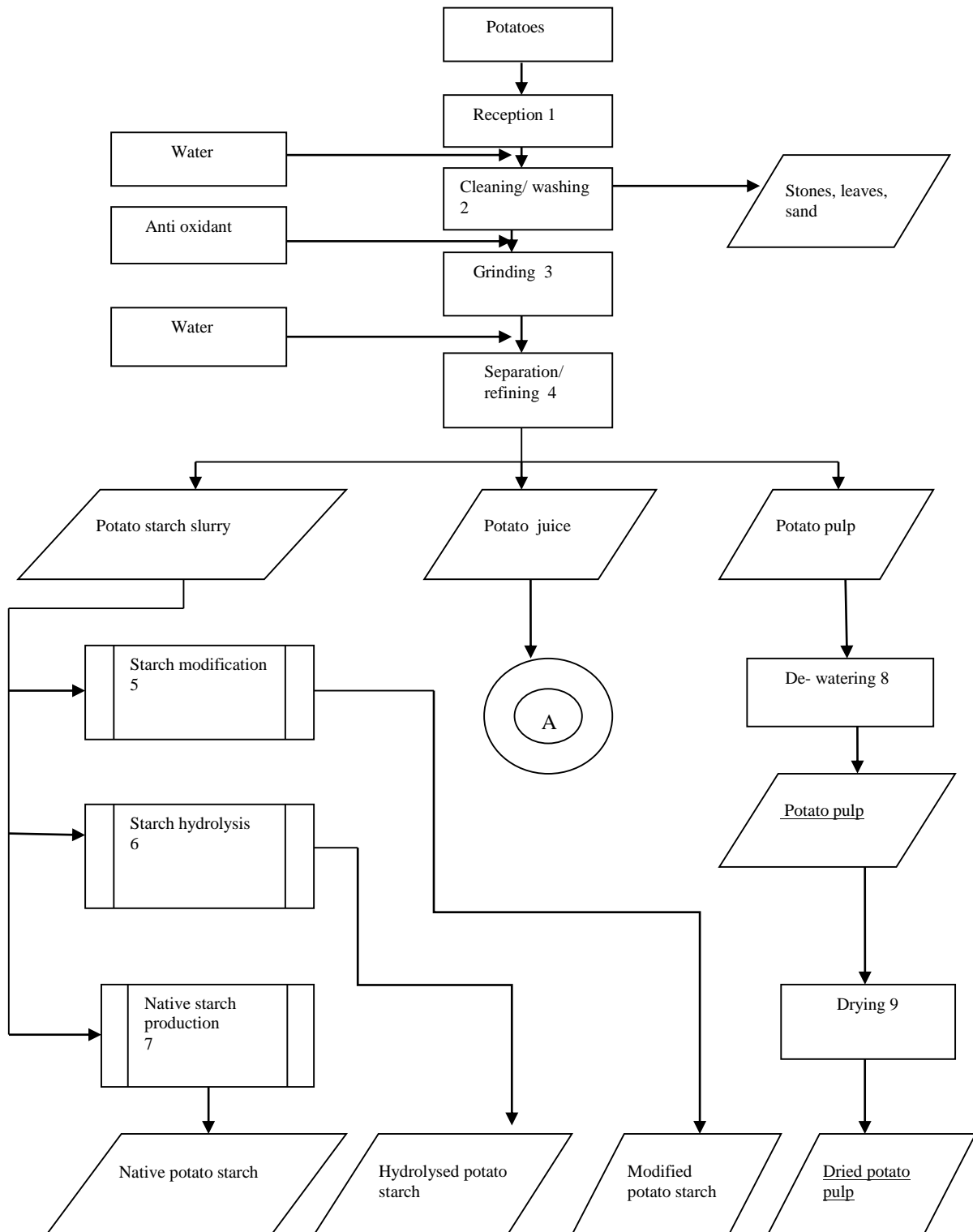
3. MANUFACTURING OF POTATO STARCH

1. At the reception of the potatoes a sample is taken to check on quality.
2. The potatoes are washed and unwanted components like sand, leaves and stones are removed. To prevent excessive foaming some food grade anti foam is added.
3. The cleaned potatoes are grinded and anti-oxidant is added.
4. The grinded potatoes are separated with gravity based techniques to potato starch slurry, potato juice and potato pulp.
5. The starch slurry is modified by chemical and/or physical techniques and dried to modified starch.
6. The starch slurry is hydrolysed with acid or enzymes and dried to hydrolysed starch.
7. The starch slurry is de-watered and dried to native potato starch.
8. The potato pulp stream is de-watered mechanically to the feed product potato pulp.
9. The regular potato pulp product can be dried further to dry pellets – dried potato pulp.
10. The potato juice is heated with steam and the protein components coagulate. To prevent excessive foaming some food grade anti foam is added.
11. The coagulated protein is separated by gravity techniques from the potato juice.
12. The protein is dried to the feed product potato protein.
13. Potato protein is mixed with water and acid for the production of potato protein (purified).
14. The mixture of water and coagulated protein is refined to remove the natural glyco alkaloids from the protein.
15. The refined protein is dewatered by gravity techniques.
16. The refined protein is dried to the feed product potato protein (purified).
17. The potato juice is heated to evaporate water and produce condensed potato juice.

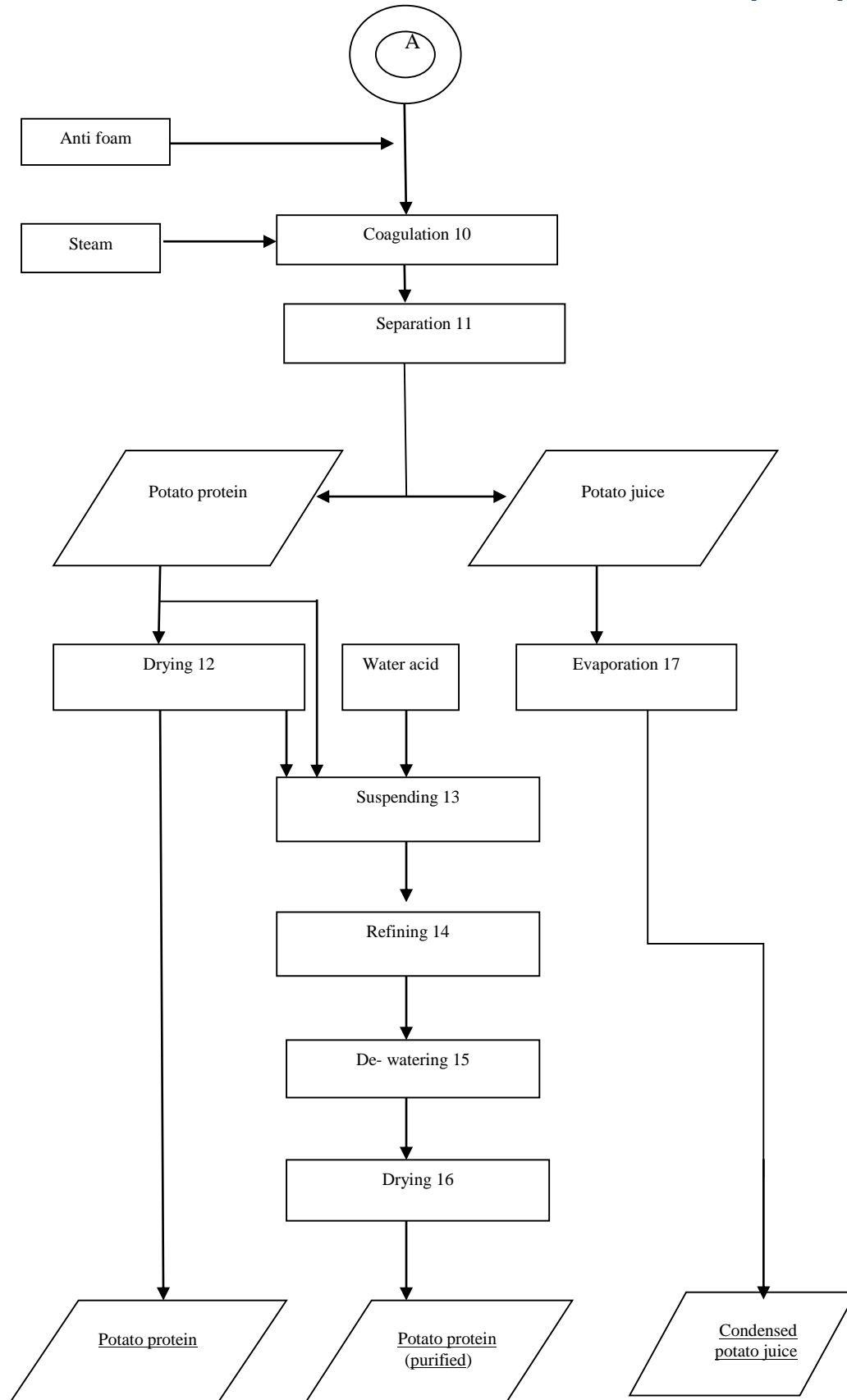
The pH is checked and corrected by pH Regulators in various stages of the production process.



3. MANUFACTURING OF POTATO STARCH - BASIC SCHEME (1 of 2)



3. MANUFACTURING OF POTATO STARCH - BASIC SCHEME (2 OF 2)

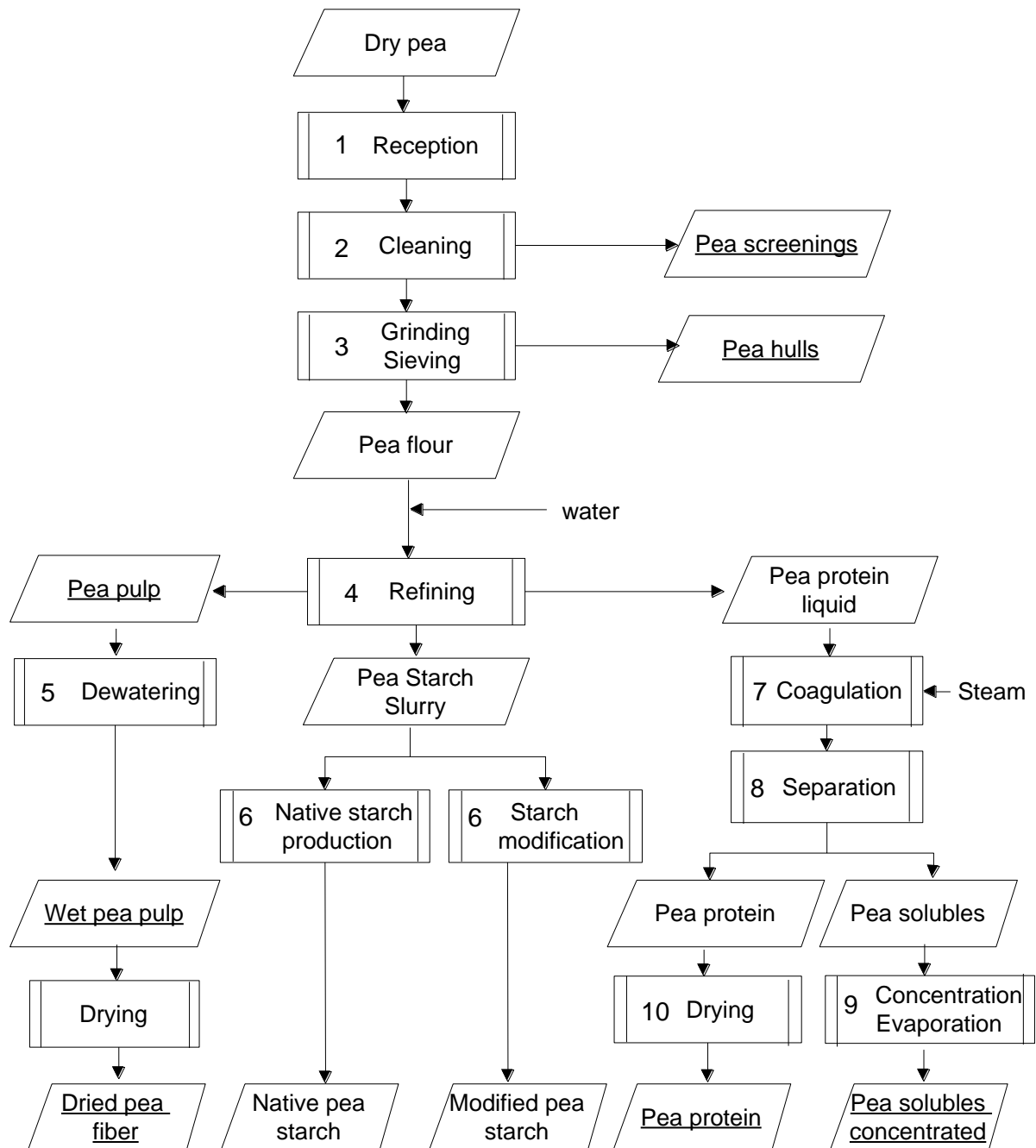


4. MANUFACTURING OF PEA STARCH

1. The incoming dry pea is sampled to check the quality.
2. Pea is cleaned to remove impurities and broken pea by sieving.
3. The cleaned peas are grinded / sieving to flour.
4. The flour is mixed with water to separate by physical process to pea starch slurry, pulp and liquid protein products.
5. Pea pulp fraction is de-watered mechanically to the feed product pea pulp.
6. The pea starch slurry is washed and can be :
 - dried to produce native pea starch,
 - physically and/or chemically modified and dried to produce modified pea starch.
7. The pea protein liquid is heated with steam and the protein components coagulate.
8. The coagulated protein fraction is separated by gravity techniques from pea protein liquid.
9. After coagulated protein fraction separation, the liquid fraction is heated to evaporate water and produce condensed pea soluble.
The pH is checked and corrected by pH regulators in various steps of the production process.
10. The pea protein fraction is dried to obtain pea protein product.



4. MANUFACTURING OF PEA STARCH - BASIC SCHEME



e) Summary of the risk-based approach for the starch sector



In establishing the list of potential hazards, an operator should take due consideration of:

- The Directive of undesirable substances in feed (2002/32/EC).
- The Regulation on genetically modified food and feed (1829/2003/EC).
- The Placing on the market Regulation (767/2009/EC)
- Commission Recommendation on the prevention and reduction of *Fusarium* toxins in cereals and cereal products (2006/576/EC).
- The Regulation on maximum residues levels of pesticides in or on food and feed of plant and animal origin (396/2005/EC).

See the European Guide chapter 7 for more information regarding the legislation.

The following list of examples is non- exhaustive and should be adapted according to the circumstances:

Biological hazards

- Relevant Vegetative Pathogens according to the GMP feed regulation and associated microbiological criteria.

Potential Chemical hazards

- Process chemicals, processing aids e.g. enzymes, micro organism controlling agents , pH regulators, antioxidants, mineral nutrients for fermentation
- Biocides
- Mycotoxins
- Phytotoxins
- Heavy metals
- Pesticides residues
- PCB, Dioxins
- Polycyclic aromatic hydrocarbons (PAH)
- Lubricants
- Noxious seeds
- Food contact packaging materials (including printing inks, paper and board, coatings...)
- Pest control chemicals

The use of processing aids is included in the hazards analysis developed by the operator according to the requirements of the section 6 of the guide.



Physical contamination hazards

- Metal
- Glass
- Hard plastic
- Any other relevant physical contamination.

Radioactivity hazard

- Radionuclides (after a nuclear accident)



f) Risk-based approach for the characterisation of hazards applicable to starch products sold as feed

The following tables present the characterisation of hazards applicable to starch products sold as feed materials. The risk level defined is based on a situation where no control measure is in place and the number obtained is an indicative number. For more understanding of the following risk assessment tables please see EFISC main text, chapter 6 HACCP system.

Those risks cannot be considered as complete and may differ amongst starch producers for example based on the origin of the raw materials and the individual and specific starch manufacturer's processing conditions and the combination of these.

Starch manufacturers have refined the risks to a level appropriate to their specific operating conditions.

Moreover, in these tables, no operational prerequisite programme (OPRP) or critical control point (CCP) is listed due to the fact that the decision leading to the establishment of such OPRP or CCP should be consistent with the reality of each plant or processing line.

Three categories of hazards were considered:

- Biological hazards (B)
- Chemical hazards (C)
- Physical hazards (P)



FEED. Risk assessment of the chain of starch manufacturing

1: GENERAL RISK ASSESSMENT APPLICABLE FOR ANY RAW MATERIAL

| 1.1 General risk based approach | | | | Ingredient: the raw materials (MAIZE, WHEAT, POTATO, PEA) coming from primary production | | | |
|--|------|----------|----------|---|---|---|---|
| Hazard | Cat. | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Foreign bodies like glass, wood, metals, etc. | P | Low | High | 3 | | In letter stages; general processing steps must be purifying (magnets, screens). | Supplier's specification. |
| Pesticide residues (authorised) above the MRL, i.e. residues of herbicides, insecticides, fungicides or rodenticides above the MRL | C | Medium | Medium | 3 | Reg. 396/2005/EC | Active participation in surveillance schemes for contaminant monitoring. A monitoring program should be in place. | Supplier's specification. Traceability from supplier's silo's- attention for the use of post-harvest pesticides. Special attention for the geographical origin. |
| Pesticides residues (unauthorised) | C | Very low | High | 2 | Directive 2002/32/EC | Active participation in surveillance schemes for contaminant monitoring. A monitoring program should be in place. | Directive 2002/32/EC sets limits for a number of pesticides residues in feeding stuff. Some of the banned pesticides may be present in the environment. |
| Mycotoxins above the specified limit | C | Medium | High | 4 | Dir. 2002/32/EC Rec. 2006/576/EC | Active participation in surveillance schemes for contaminant monitoring. A monitoring program should be in place. | Supplier's specification. Traceability from supplier's silo's. |
| Heavy metals above the specified limit | C | Low | High | 3 | Reg. 396/2005/EC Dir. 2002/32/EC Rec. 2006/576/EC | Active participation in surveillance schemes for contaminant monitoring. A monitoring program should be in place. | Supplier's specification. Special attention for the geographical origin. |



FEED. Risk assessment of the chain of starch manufacturing

| | | | | | | | |
|-------------|---|-----|--------|---|---|--|--|
| Phytotoxins | C | Low | Medium | 2 | Directive 2002/32/EC limits the maximum content of toxic weed seeds | Active participation in surveillance schemes. A monitoring program should be in place. | Supplier's specification. Special attention for the geographical origin. |
|-------------|---|-----|--------|---|---|--|--|

| 1.2 General risk based approach | | | | Ingredient: WATER | | | |
|--|----------|----------|----------|-------------------|------------------------|---|--|
| Hazard | Category | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Contaminants present in water such as PFOA and PFOS | P | Low | Medium | 2 | Regulation 183/2005/EC | A monitoring plan shall be in place for the verification of water of suitable quality for feed production. In latter stages; general processing steps are purifying, i.e. filtration. | For the manufacture of feed water used shall be of suitable quality. |
| Cross contamination | C | Low | High | 3 | Regulation 183/2005/EC | The PRP program should prevent cross contamination by use of dedicated water circuits. The chemicals used have to be authorized. | |
| Pesticide residues (authorised) above the MRL, i.e. residues of herbicides, insecticides, fungicides or rodenticides above the MRL | C | Medium | Medium | 3 | Reg. 396/2005/EC | A monitoring program should be in place. | |
| Pesticides residues (unauthorised) | C | Very low | High | 2 | Directive 2002/32/EC | A monitoring program should be in place. | |
| Heavy metals | C | Low | High | 3 | Dir. 2002/32/EC | A monitoring program should be in place. | |

FEED. Risk assessment of the chain of starch manufacturing

| | | | | | | | |
|------------------------------|---|-----|--------|---|--|---|--|
| Hydro carbons | C | Low | High | 3 | | A monitoring program should be in place. | |
| Metal leaching | C | Low | Medium | 2 | | The PRP program should include inert contact materials where applicable and the appropriate construction standards. | |
| Pathogenic micro - organisms | B | Low | High | 3 | | The PRP program should include dedicated water circuits and the possibility for disinfection treatment. A monitoring program should be in place. | |



FEED. Risk assessment of the chain of starch manufacturing

| 1.3 General risk based approach | | | | Processing agent: CHEMICAL AGENTS (antifoams, acidification or alkalisng agents, SO ₂ and derivatives, enzyme catalysing salts...) | | | |
|---------------------------------|------|--------|----------|---|-----------------|---|-------------------------|
| Hazard | Cat. | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Heavy metals | C | Low | High | 3 | Dir. 2002/32/EC | Ingredient specification. Contracts containing food adequate requirements. | Purchasing requirements |
| Cross contamination | C | Low | Medium | 2 | | The PRP program should include on-line process monitoring (pH, sensorial, consumption rates), correct labelling of chemical containers. | |



FEED. Risk assessment of the chain of starch manufacturing

| 1.4 General risk based approach | | | | Processing agent: ENZYMES (particularly those specific to usage in the scope of starch processing) | | | |
|---------------------------------|------|--------|----------|--|-------------|--|--------------------------|
| Hazard | Cat. | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Cross contamination | B | Low | Low | 1 | | The PRP programme should include on-line process monitoring (consumption rates), correct labelling of enzyme containers. | |
| Pathogenic micro-organisms | B | Low | High | 3 | | Ingredient specification Contracts containing food adequate requirements. | Purchasing requirements. |



FEED. Risk assessment of the chain of starch manufacturing

| 1.5 General risk based approach | | | | Processing agent: FILTER AIDS (filtering earth, silica, coal, cellulose fibre...) | | | |
|---------------------------------|------|--------|----------|---|-------------|--|--------------------------|
| | Cat. | Chance | Severity | Risk Class. | Legislation | Control measure | Remarks |
| Metal leaching | C | Low | Medium | 2 | | Ingredient specification. Contracts containing food adequate requirements. | Purchasing requirements. |
| Cross contamination | P | Low | Medium | 2 | | Filtration in latter process stages. | |
| Contaminants from filter aids | C | Low | High | 3 | | Ingredient specification. Contracts containing food adequate requirements. | Purchasing requirements. |

| 1.6 General risk based approach | | | | Materials: MATERIALS IN CONTACT (equipment, packaging...) | | | |
|---------------------------------|------|--------|----------|---|-------------|--|--------------------------|
| Hazard | Cat. | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Metal leaching | C | Low | Medium | 2 | | Ingredient specification. Contracts containing food adequate requirements. | Purchasing requirements. |
| Pathogenic micro - organisms | B | Low | High | 3 | | Ingredient specification. Contracts containing food adequate requirements. | Purchasing requirements. |

| 1.7 General risk based approach | Utilities: Starch processing |
|---------------------------------|------------------------------|
|---------------------------------|------------------------------|



FEED. Risk assessment of the chain of starch manufacturing

| Hazard | Cat. | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
|------------------------------------|------|--------|----------|-------------|-------------|---|--|
| Toxins from pest control materials | C | Low | High | 3 | | A pest control programme must be applied that is suitable for use in the food chain. | Poisoned grain from open boxes could end up in the food chain. |
| Cleaning agents | C | Medium | Medium | 3 | | Cleaning agents used in the production system should be flushed. Cleaning agents must be authorised for use in the food industry. | |
| Boiler chemicals | C | Medium | Medium | 3 | | Boiler chemicals used must be suitable for use in the food industry. | |
| Lubricants from equipment | C | Low | High | 3 | | The PRP program should assure that the contamination of product with non food grade lubricants is avoided and that the risk of contamination with food grade lubricants is minimised. The PRP programme could involve recording of the quantities used. | |



FEED. Risk assessment of the chain of starch manufacturing

| 1.8 General risk based approach | | | | Process stage: MANUFACTURING PROCESS CONTROL | | | |
|--|------|--------|----------|--|---|--|--|
| Hazard | Cat. | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Foreign bodies | P | Low | High | 3 | | A system should be in place that removes foreign material; general processing steps must be purifying (magnets, sieving). | |
| Phytotoxins | C | Low | Medium | 2 | Directive 2002/32/EC limits the maximum content of toxic weed seeds | Visual inspection of the incoming raw materials is recommended. | |
| Insects and rodents | B | Medium | Medium | 3 | | The PRP program should address closed buildings, windows and doors. The PRP program should include a pest control program. | Proper sanitation should be in place. |
| Flying-in birds | B | Low | Medium | 2 | | The PRP program should address closed buildings, windows and doors. The PRP program should include a pest control program. | |
| Lack of Hygiene | B | Low | High | 3 | | Staff hygiene training shall be provided and the appropriate sanitation, clothing, work instructions and material regarding cleaning foreseen. | Hygiene prerequisite program. |
| Pathogenic microbiological organisms, including Salmonella | B | Low | High | 3 | | The PRP programme should provide closed lines. Low probability of growth via raw material by stages with higher temp routes and lower | A monitoring program should be in place. |



FEED. Risk assessment of the chain of starch manufacturing

| | | | | | | | |
|--|---|-----|--------|---|-------------------------------------|---|--|
| | | | | | | pH ranges. Regular monitoring of finished products. | |
| Heavy metals | C | Low | High | 3 | Dir. 2002/32/EC | Knowledge regarding the distribution of chemical contaminants from raw material into the end product, including the concentration factor. Regular monitoring of the finished products. | A monitoring program should be in place. |
| Mycotoxins | C | Low | High | 3 | Dir. 2002/32/EC Rec. 2006/576/EC | Knowledge regarding the distribution of chemical contaminants from raw material into the end product, including the concentration factor. Regular monitoring of the finished products. | A monitoring program should be in place. |
| Pesticide residues above the MRL, i.e. residues of herbicides, insecticides, fungicides or rodenticides above the MRL. | C | Low | High | 3 | Reg. 396/2005/EC Dir. 2002/32/EC | Knowledge regarding the distribution of chemical contaminants from raw material into the end product, including the concentration factor. Regular monitoring of the finished products. | A monitoring program should be in place. |
| Direct drying (PAH, nitrous oxides, dioxins) | C | Low | High | 3 | Dir. 2002/32/EC Reg. 183/2005/EC | Good burner maintenance practices. Avoid formation of soot. An in depth HACCP study should be in place in combination with good maintenance practices. Regular monitoring of the finished products. | A monitoring program should be in place. |
| Cross contamination | C | Low | Medium | 2 | | The PRP programme should foresee dedicated circuits and the dedicated storage of chemicals. | |



FEED. Risk assessment of the chain of starch manufacturing

| | | | | | | | |
|----------------------------------|---|-----|--------|---|--|--|----------------------------|
| Lubricants from equipment | C | Low | High | 3 | | Use of food grade lubricants where applicable. Control and registration of the quantities used. Good maintenance programme. | Purchasing specifications. |
| Cleaning and disinfection agents | C | Low | Medium | 2 | | The PRP programme should address the cleaning and sanitation. The cleaning agents and disinfection agents used should be authorised and suitable for use in the food industry. | Purchasing specifications. |

| 1.9 General risk based approach | | | | Process stage: STORAGE and TRANSPORT CONTROL | | | |
|--|------|--------|----------|--|-------------------------------------|--|---|
| Hazard | Cat. | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Foreign bodies | P | Low | High | 3 | | Closed process, sieving, staff hygiene, glass procedure, good maintenance practices | Visual checks |
| Cross contamination | C | Medium | Medium | 3 | | The PRP program should address the requirements for storage and loading. Verification and control of the previous loads and cleaning regime. | Transport specifications and contractual agreement with service provider. |
| Mycotoxins formation | C | Low | High | 3 | Dir. 2002/32/EC Rec. 2006/576/EC | Appropriate storage control should be in place. The PRP programme should foresee closed storage areas. Humidity & T controls when necessary. The finished product should be monitored on mycotoxins. | Good storage practices for bulk storage Monitoring program should be in place. |
| Pesticide residues above the MRL, i.e. | C | Low | High | 3 | Reg. 396/2005/EC Dir. 2002/32/EC | The fumigation of silo's to be done by qualified persons. | Good storage practices. |



FEED. Risk assessment of the chain of starch manufacturing

| | | | | | | | |
|---|---|--------|--------|---|--|---|---|
| residues of herbicides, insecticides, fungicides or rodenticides above the MRL. | | | | | | Regular finished products monitoring should be in place. | |
| Pathogenic micro – organisms, including Salmonella | B | Low | High | 3 | | Appropriate storage control should be in place. The PRP programme should foresee closed storage areas. Humidity & T controls when necessary. The finished product should be monitored on pathogenic micro-organism, including Salmonella. | Good storage practices for bulk storage Monitoring program. |
| Insects and rodents | | Medium | Medium | 3 | | The PRP programme should provide for a closed storage areas and covered loading area. A pest control system should be in place. | Sanitation and Pest control prerequisite. |



FEED. Risk assessment of the chain of starch manufacturing

EXAMPLE 2.1: A MAIZE PRODUCT, FOCUS ON RECEPTION, PROCESS, STORAGE AND LOADING STEPS

| | |
|---|--|
| RISK BASED APPROACH FOR MAIZE PROCESSING | Process stage: RECEPTION (Cereal Maize) |
|---|--|

| Hazard | Category | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
|---|----------|--------|----------|-------------|------------------|--|----------------------------|
| Foreign bodies like glass, metals, stones, etc. | P | Low | High | 3 | | Closed process, maize cleaning (sieving, magnets), staff hygiene, glass procedure, good maintenance practices. | Visual checks. |
| Phytotoxins | C | Low | Medium | 2 | Dir. 2002/32/EC | PRP for incoming raw materials Analysis via monitoring programme. Visual checks. Aggregate sampling. | Product specification. |
| Heavy Metals | C | Low | High | 3 | Dir.2002/32/EC | PRP for incoming raw materials. Analysis via monitoring programme. | Purchasing specifications. |
| Pesticide residues above the MRL (authorised), i.e. residues of herbicides, insecticides, fungicides or rodenticides above the MRL. | C | Medium | Medium | 3 | Reg. 396/2005/EC | PRP for incoming raw materials taking into account geographical origin. Analysis via monitoring programme. | Purchasing specifications. |



FEED. Risk assessment of the chain of starch manufacturing

| | | | | | | | |
|------------------------------------|---|----------|--------|---|-------------------------------------|--|---|
| Pesticides residues (unauthorised) | C | Very low | High | 2 | Directive 2002/32/EC | A monitoring program should be in place. | Directive 2002/32/EC sets limits for a number of pesticides residues in feeding stuff. Some of the banned pesticides may be present in the environment. |
| Mycotoxins above the MRL | C | Medium | High | 4 | Dir. 2002/32/EC Rec. 2006/576/EC | PRP for incoming raw materials taking into account geographical origin. Analysis via monitoring programme. | Purchasing specifications. |
| PAH, nitrous oxides, dioxins | C | Low | High | 3 | Dir. 2002/32/EC Reg. 183/2005/EC | Regular monitoring of the incoming material products. | Due to drying of the maize at primary level. A monitoring program should be in place. |
| Lubricants from equipment | C | Low | High | 3 | | PRP for maintenance. Use of food grade lubricant Recording of the quantities used. | Purchasing specifications. |
| Pests | B | Medium | Medium | 3 | | Closed buildings. The PRP programme should include pest control | Regular checks on pest activity. |



FEED. Risk assessment of the chain of starch manufacturing

| RISK BASED APPROACH FOR MAIZE PROCESSING | | | | | Process stage: PROCESS (Dry cleaning, Steeping, Grinding, Degerming, Sieving, Drying, Mixing, Drying) | | |
|--|----------|--------|----------|------------|---|--|----------------------------|
| Hazard | Category | Chance | Severity | Risk Class | Legislation | Control Measure | Remarks |
| Foreign bodies | P | Low | High | 3 | | Closed process, sieving, dedicated transport lines, dry cleaning of maize, staff hygiene , glass procedure, good maintenance practices PRP for personal hygiene. | Visual checks. |
| Lubricants from equipment | C | Low | High | 3 | | PRP for maintenance Use of Food grade lubricant Recording of the quantities used. | Purchasing specifications. |
| Processing aids | C | Low | High | 3 | | On-line monitoring (follow up excessive use of processing aids) pH control, SO ₂ content control, ISO9001 plans, work instructions and training of the personnel. | |
| Cleaning and disinfection agents | C | Low | Medium | 2 | | PRP for cleaning and sanitation Use of food contact authorized. | Purchasing specifications. |
| Neoformed compounds (direct dryer) | C | Medium | Medium | 3 | Dir. 2002/32/EC | Gas specifications. End-product analyses (according to the dryer type). | |
| Water contamination | B/C | Low | High | 3 | Reg. 183/2005/EC | PRP for layout of premises and workspace. Analysis via monitoring programme. Disinfection treatment. | |
| Pests | B | Medium | Medium | 3 | | PRP for Pest control Closed process and buildings. | Checks on pest activity. |
| Pathogenic Microbiological organisms | B | Low | High | 3 | | Process control (Temperature, pH, Time and Moisture content). Process cleaning instruction. Process monitoring on micro organisms. Final product monitoring on micro organisms. | |



FEED. Risk assessment of the chain of starch manufacturing

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|--|--|--|--|--|--|---|--|
| | | | | | | Drying/evaporating steps: Control moisture content of product. Hygiene prerequisite program. | |
|--|--|--|--|--|--|---|--|



FEED. Risk assessment of the chain of starch manufacturing

| RISK BASED APPROACH FOR MAIZE PROCESSING | | | | Process stage: STORAGE AND LOADING | | | |
|--|----------|--------|----------|------------------------------------|-------------------------------------|--|--|
| Hazard | Category | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Foreign bodies | P | Low | High | 3 | | Closed process, sieving, staff hygiene, glass procedure, good maintenance practices | Visual checks. |
| Lubricants from equipment | C | Low | High | 3 | | PRP for maintenance Use of food grade lubricant Recording of the quantities used. | Purchasing specifications. |
| Pests | B | Medium | Medium | 3 | | PRP for pest control, closed buildings | Regular checks on pest activity. |
| Pathogenic microbiological organisms, including Salmonella | B | Medium | High | 4 | | PRP for pest control, PRP for personal hygiene, PRP for cleaning and PRP for maintenance, monitoring programme. Control of temperature and ventilation | Good storage practices for bulk storage |
| Mycotoxins formation | C | Low | High | 3 | Dir. 2002/32/EC Rec. 2006/576/EC | Appropriate storage control should be in place. The PRP programme should foresee closed storage areas. Humidity & T controls when necessary. The finished product should be monitored on mycotoxins. | Good storage practices. Monitoring program should be in place. |
| Cross contamination during transport | B | Medium | Medium | 3 | | Cleaning of transport means + verification previous loads | Service provider specification. |



FEED. Risk assessment of the chain of starch manufacturing

EXAMPLE 2.2: FOR A WHEAT PRODUCT, FOCUS ON RECEPTION, PROCESS, STORAGE AND LOADING STEPS

| RISK BASED APPROACH FOR WHEAT PROCESSING | | | | Process stage: RECEPTION (Cereal wheat) | | | |
|---|----------|--------|----------|---|------------------|---|----------------------------|
| Hazard | Category | Chance | Severity | Risk Class | Legislation | Control Measure | Remarks |
| Foreign bodies | P | Low | High | 3 | | Closed process, Sieving, dedicated lines, Cleaning steps, magnets, glass policy PRP for personal hygiene. | Visual checks. |
| Toxic plants / seeds Botanic impurities | C | Low | Medium | 2 | Dir. 2002/32/EC | PRP for incoming raw materials. Analysis. Product specification. | Visual checks. |
| Heavy metals | C | Low | High | 3 | Dir.2002/32/EC | PRP for incoming raw materials. Analysis via monitoring programme. | Purchasing specifications. |
| Pesticide residues (authorised) above the MRL, i.e. residues of herbicides, insecticides, fungicides or rodenticides above the MRL. | C | Medium | Medium | 3 | Reg. 396/2005/EC | PRP for incoming raw materials. Analysis via monitoring programme. | Purchasing specifications. |



FEED. Risk assessment of the chain of starch manufacturing

| | | | | | | | |
|------------------------------------|---|----------|--------|---|-----------------------------------|--|---|
| Pesticides residues (unauthorised) | C | Very low | High | 2 | Directive 2002/32/EC | A monitoring program should be in place. | Directive 2002/32/EC sets limits for a number of pesticides residues in feeding stuff. Some of the banned pesticides may be present in the environment. |
| Mycotoxins above MRL | C | Medium | High | 4 | Dir.2002/32/EC Rec.2006/576/EC | PRP for incoming raw materials Analysis via monitoring programme Raw material specification contracts. | Purchasing specifications. |
| Lubricants from equipment | C | Low | High | 3 | | PRP for maintenance. Use of food grade lubricant. | Purchasing specifications. |
| Pest | B | Medium | Medium | 3 | | Closed buildings, PRP for pest control. | Regular checks on pest activity. |

| | |
|---|--|
| RISK BASED APPROACH FOR WHEAT PROCESSING | Process stage: PROCESS (Dry Cleaning, Grinding, Sieving, Refining, Concentration, Mixing, Drying) |
|---|--|



| Hazard | Category | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
|--------|----------|--------|----------|-------------|-------------|-----------------|---------|
|--------|----------|--------|----------|-------------|-------------|-----------------|---------|

FEED. Risk assessment of the chain of starch manufacturing

| | | | | | | | |
|---|------|--------|--------|---|------------------|--|----------------------------|
| Foreign bodies | P | Low | High | 3 | | Closed process, sieving, dedicated lines, cleaning steps, magnets, glass policy in place. | Visual inspection. |
| Lubricants from equipment | C | Low | High | 3 | | PRP for maintenance. Use of Food grade lubricant. | Purchasing specifications. |
| Processing Aids | C | Low | High | 3 | | On-line monitoring of usage (follow up excessive use of processing aids) Non toxic processing aids, pH control, ISO9001 plans, work instructions and training personnel. | |
| Cleaning and disinfection agents | C | Low | Medium | 2 | | PRP for cleaning and sanitation Use of food contact authorized cleaning agents. | Purchasing specifications. |
| Neoformed compounds | C | Medium | Medium | 3 | Dir.2002/32/EC | Gas specifications. End-product analyses. (according to the dryer type). | |
| Water contamination | B/ C | Low | High | 3 | Reg. 183/2005/EC | PRP for layout of premises and workspace. Analysis via monitoring programme. | |
| Pest | B | Medium | Medium | 3 | | PRP for pest control. Closed process and buildings. | Checks on pest activity. |
| Pathogenic microorganisms, including Salmonella | B | Low | High | 3 | | Process control (Temperature, pH, Time and Moisture content). Process monitoring on hygiene indicator micro-organisms. Final product monitoring on micro-organisms. Drying/evaporating steps: control moisture content of product. | |

| | |
|---|--|
| RISK BASED APPROACH FOR WHEAT PROCESSING | Process stage: STORAGE & LOAD OUT |
|---|--|



| Hazard | Category | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
|----------------|----------|--------|----------|-------------|-------------|---|----------------|
| Foreign bodies | P | Low | High | 3 | | Protected storage, sieving, staff hygiene, glass procedure, good maintenance practices. | Visual checks. |

FEED. Risk assessment of the chain of starch manufacturing

| | | | | | | | |
|--|---|--------|--------|---|-------------------------------------|---|---|
| Lubricants from equipment | C | Low | High | 3 | | PRP for maintenance. Use of Food grade lubricant. | Purchasing specifications. |
| Pests | B | Medium | Medium | 3 | | PRP for Pest control. | Checks on pest activity. |
| Pathogenic microbiological organisms, including Salmonella | B | Medium | High | 4 | | PRP for Pest control, PRP for Personal hygiene, PRP for cleaning and PRP for maintenance. Control of temperature and ventilation. A monitoring programme shall be in place | Good storage practices for bulk storage |
| Mycotoxins formation | C | Low | High | 3 | Dir. 2002/32/EC Rec. 2006/576/EC | Appropriate storage control should be in place. The PRP programme should foresee closed storage areas. Humidity & T controls when necessary. Monitoring program should be in place. | Good storage practices for bulk storage |
| Cross contamination during transport | B | Medium | Medium | 3 | | Cleaning of transport means + verification previous loads. | Service provider specification. |



FEED. Risk assessment of the chain of starch manufacturing

EXAMPLE 2.3 : POTATO PROCESSING; STARCH AND CO-PRODUCT MANUFACTURING

| GENERAL RISK BASED APPROACH FOR POTATO PROCESSING | | | Process stage: 1 RECEPTION (POTATOES) | | | | |
|---|----------|----------|---------------------------------------|-------------|-----------------------------------|--|---|
| Hazard | Category | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Bad rotten potatoes | B | Medium | Low | 2 | | Portal control, Inspection truck loads, removal of rotten potatoes. | Visual inspection. Product specifications. |
| Stones, glass, plastics, wood, metal, carton, sand, soil | P | Medium | Medium | 3 | | Portal control. Inspection of the truck loads. Cleaning of the potatoes and removal of contaminants with sieving and magnets equipment | Visual inspection. Product specifications. |
| Pesticide residues (authorised) above the MRL, i.e. residues of herbicides, insecticides, fungicides or rodenticides above the MRL. | C | Medium | Medium | 3 | Dir. 91/414/EC Reg.396/2005/EC | Certified potato growers. PRP for incoming materials. Analysis via monitoring programme. | Product specifications. Regulatory compliance. |
| Pesticides residues (non authorised) | C | Very low | High | 2 | Directive 2002/32/EC | A monitoring program should be in place. | Directive 2002/32/EC sets limits for a number of pesticides residues in feeding stuff. Some of the banned pesticides may be present in the environment. |



FEED. Risk assessment of the chain of starch manufacturing

| | | | | | | | |
|---------------------------------|---|--------|--------|---|------------------|--|--|
| Heavy metals above MRL | C | Medium | Medium | 3 | Dir. /2002/32/EC | PRP for incoming raw materials. Analysis via monitoring programme. | Product specifications. Regulatory compliance. |
| Natural contaminants (solanine) | C | Medium | Medium | 3 | Dir. 2002/53/EC | Certified potato growers. Allowed potato varieties listed in National Varieties List. Monitoring solanine content of the potato protein. | Product specifications. Regulatory compliance. |
| Pests | B | Medium | Medium | 3 | | Closed buildings, PRP for Pest control. Covered storage and loading. | Checks on pest activity. |



FEED. Risk assessment of the chain of starch manufacturing

| GENERAL RISK BASED APPROACH FOR POTATO STARCH PROCESSING | | | Process stage: (Process (CLEANING/WASHING, GRINDING, SEPARATION/REFINING, DE-WATERING, DRYING, COAGULATION, SUSPENDING, REFINING, DE- WATERING, DRYING, EVAPORATION)) | | | | |
|--|----------|--------|---|-------------|------------------|--|---|
| Hazard | Category | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Foreign bodies | P | Low | High | 3 | | Cleaning and washing, dedicated transport lines. Glass procedure. | Visual checks. |
| Lubricants from equipment | C | Low | High | 3 | | PRP for maintenance. Use of food grade lubricants. Good maintenance practices. | |
| Water contamination | C | Low | High | 3 | Reg. 183/2005/EC | Water monitoring. Dedicated water circuits. Chemicals used have to be authorised. | Apply water of suitable quality. |
| Water contamination | B | Medium | High | 4 | Reg. 183/2005/EC | Water monitoring, CIP. Dedicated water circuits. Monitoring programme should be in place. | Apply water of suitable quality. |
| Neoformed chemicals | C | Low | Medium | 2 | | Burner control direct dryers. Gas specifications. End product analysis (according to the dryer type). | |
| Excessive use of processing aids | C | Low | Medium | 2 | | Online monitoring of the use of processing aids. pH control, control ready product, food grade antifoam. Work instructions and training personnel. | Product specifications, food grade antifoam |
| Pathogenic microorganisms | B | Medium | High | 4 | | Process control temperature and time. Drying/evaporating steps: Control moisture content of product. | |

FEED. Risk assessment of the chain of starch manufacturing

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|-----------------|---|--------|--------|---|--|--|----------------------------------|
| | | | | | | A monitoring programme should be in place. | |
| Cleaning agents | C | Low | Medium | 2 | | PRP for cleaning and sanitation. Control of consumption rates. Use of Food contact authorized. | Purchasing specifications. |
| Pests | B | Medium | Medium | 3 | | PRP for pest control. | Regular checks on pest activity. |

| RISK BASED APPROACH FOR POTATO STARCH PROCESSING | | | | Process stage : STORAGE & LOAD OUT | | | |
|--|----------|--------|-------------|------------------------------------|-------------|--|---|
| Hazard | Category | Chance | Seriousness | Risk Class. | Legislation | Control Measure | Remarks |
| Foreign bodies | P | Low | High | 3 | | Protected storage, sieving. | Visual checks. |
| Lubricants from equipment | C | Low | High | 3 | | PRP for maintenance. Use of food grade lubricant. | Purchasing specifications. |
| Pests | B | Medium | Medium | 3 | | PRP for pest control. Covered storage and loading. | Regular checks on pest activity. |
| Pathogenic microbiological organisms, including Salmonella | B | Low | High | 3 | | PRP for pest control, PRP for personal hygiene, PRP for cleaning and PRP for maintenance. Control of temperature and ventilation. A monitoring plan shall be in place | Good storage practices for bulk storage |
| Cross contamination during transport | B | Medium | Medium | 3 | | Cleaning of transport means and the verification of previous loads. | Service provider specification. |

EXAMPLE 2.4: A PEA PRODUCT, FOCUS ON RECEPTION, PROCESS, STORAGE AND LOADING STEPS

FEED. Risk assessment of the chain of starch manufacturing

| RISK BASED APPROACH PEA PROCESSING | | | | Process stage: RECEPTION (Pea) | | | |
|--|----------|----------|-------------|--------------------------------|----------------------|--|---|
| Hazard | Category | Chance | Seriousness | Risk Class. | Legislation | Control Measure | Remarks |
| Foreign bodies | P | Low | High | 3 | | Closed process, sieving, magnets, cleaning steps. | Visual checks. |
| Toxic plants / seeds | C | Low | Medium | 2 | Dir. 2002/32/EC | PRP for incoming raw materials. Analysis via monitoring programme. | Visual checks. |
| Heavy Metals | C | Low | High | 3 | Dir.2002/32/EC | PRP for incoming raw materials. Analysis via monitoring programme. | Purchasing specifications. Regulatory compliance. |
| Pesticides residues (authorised) above MRL | C | Medium | Medium | 3 | Reg. 396/2005/EC | PRP for incoming raw materials. Analysis via monitoring programme. | Purchasing specifications Regulatory compliance. |
| Pesticides residues (unauthorised) | C | Very low | High | 2 | Directive 2002/32/EC | A monitoring program should be in place. | Directive 2002/32/EC sets limits for a number of pesticides residues in feeding stuff. Some of the banned pesticides may be present in the environment. |
| Mycotoxins | C | Low | High | 3 | Dir. 2002/32/EC | PRP for incoming raw materials. Analysis via monitoring programme. | Purchasing specifications. Regulatory compliance. |
| Lubricants from equipment | C | Low | High | 3 | | PRP for maintenance. Use of food grade lubricant | Purchasing specifications. Prerequisite program. |
| Pests | B | Medium | Medium | 3 | | Closed buildings, PRP for Pest control. Covered storage and loading | Checks on pest activity. |



FEED. Risk assessment of the chain of starch manufacturing

| RISK BASED APPROACH FOR PEA PROCESSING | | | | Process stage: PROCESS (Dry cleaning, Grinding, Sieving, Refining, Drying) | | | |
|--|----------|--------|-------------|---|------------------|---|----------------------------------|
| Hazard | Category | Chance | Seriousness | Risk Class. | Legislation | Control Measure | Remarks |
| Foreign bodies | P | Low | High | 3 | | Closed process, sieving, dedicated transport lines, dry cleaning of pea. Glass procedure. Good maintenance practices PRP for personal hygiene clothes). | Visual checks. |
| Lubricants | C | Low | High | 3 | | PRP for maintenance. Use of food grade lubricant. | Purchasing specifications. |
| Processing aids | C | Low | Medium | 2 | | On-line monitoring (follow up excessive use of processing aids) pH control, work instructions and training personnel. | Purchasing specifications. |
| Cleaning and disinfection agents | C | Low | Medium | 2 | | PRP for cleaning and sanitation Consumption rates. Use of food contact authorized. | Purchasing specifications. |
| Neoformed Chemicals (direct drying) | C | Medium | Medium | 3 | | Burner control. Gas specifications. End-product analyses. Indirect dryer. | |
| Contaminants in water | B/ C | Low | High | 3 | Reg. 183/2005/EC | Analysis via monitoring programme. | Apply water of suitable quality. |
| Pests | B | Low | Medium | 2 | | PRP for Pest control. Closed process / closed workshops. | Checks on pest activity. |
| Pathogenic microbiological organisms, including Salmonella | B | Low | High | 3 | | Process control (Temperature, pH. Time and Moisture content). PRP for cleaning and sanitation. Drying/evaporating steps: control moisture content of product. Process monitoring on micro organisms. Final product monitoring on micro organisms. | |



FEED. Risk assessment of the chain of starch manufacturing

| RISK BASED APPROACH FOR PEA PROCESSING | | | | Process stage: STORAGE AND LOADING | | | |
|--|----------|--------|----------|------------------------------------|-------------|--|---|
| Hazard | Category | Chance | Severity | Risk Class. | Legislation | Control Measure | Remarks |
| Foreign bodies | P | Low | High | 3 | | Closed process, sieving. | Visual checks. |
| Lubricants | C | Low | High | 3 | | PRP for maintenance. Use of food grade lubricant. | Purchasing specifications. |
| Pests | B | Medium | Medium | 3 | | PRP for Pest control. | Checks on pest activity. |
| Pathogenic microbiological organisms, including Salmonella | B | Low | High | 3 | | PRP for personnel hygiene, PRP for cleaning and PRP for maintenance. Control of temperature and ventilation. A monitoring programme shall be in place. | Good storage practices for bulk storage |



FEED. Risk assessment of the chain of starch manufacturing

g) Annex Minimum monitoring requirements- Sector Starch

EFISC system participants shall implement a monitoring plan as described in the EFISC Code §4.4.3.

In case insufficient data is available for a risk assessment the following minimum monitoring requirements shall apply. The total minimum number of analysis will depend on the volume of feed materials in tons manufactured in one location as shown in the tables below.

1. Control plan for starch production, their products and co products.

Table A. Corn

| Annual production in tons/ Parameter | <200.000 | ≥200.000 |
|---|----------|----------|
| Aflatoxine B1 | 4-8 | 6-12 |
| DON | 4 | 6 |
| ZEA | 4 | 6 |
| Dioxin | 2 | 2 |
| Dioxin like PCB | 2 | 2 |
| PCB | 2 | 2 |
| Salmonella | 3-6 | 4-8 |
| Heavy metals (Pb, As, Hg, CD) | 4 | 6 |
| Pesticides* | 4 | 6 |

*Analysis within inspection of incoming raw materials in unprocessed primary products



FEED. Risk assessment of the chain of starch manufacturing

Table B. Wheat

| Annual production in tons/ Parameter | <200.000 | ≥200.000 |
|--------------------------------------|----------|----------|
| DON | 4-8 | 6-12 |
| ZEA | 4 | 6 |
| Dioxin | 2 | 2 |
| Dioxin like PCB | 2 | 2 |
| PCB | 2 | 2 |
| Salmonella | 3-6 | 4-8 |
| Heavy metals (Pb, As, Hg, CD) | 4 | 6 |
| Pesticides* | 4 | 6 |

*Analysis within inspection of incoming raw materials in unprocessed primary products

Table C. Potatoes

| Annual production in tons/ Parameter | <200.000 | ≥200.000 |
|--------------------------------------|----------|----------|
| Dioxin | 2 | 2 |
| Dioxin like PCB | 2 | 2 |
| PCB | 2 | 2 |
| Salmonella | 3-6 | 4-8 |
| Heavy metals (Pb, As, Hg, CD) | 4 | 6 |
| Pesticides* | 4 | 6 |

*Analysis within inspection of incoming raw materials in unprocessed primary products



FEED. Risk assessment of the chain of starch manufacturing

Table D. Peas

| Annual production in tons/ Parameter | <200.000 | ≥200.000 |
|---|--------------------|-----------------|
| DON | 4-8 | 6-12 |
| ZEA | 4 | 6 |
| Dioxin | 2 | 2 |
| Dioxin like PCB | 2 | 2 |
| PCB | 2 | 2 |
| Salmonella | 3-6 | 4-8 |
| Heavy metals (Pb, As, Hg, CD) | 4 | 6 |
| Pesticides* | 4 | 6 |

* Analysis within inspection of incoming raw materials in unprocessed primary products

