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SUPERSEDING

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MILITARY STANDARD  
SANITARY STANDARDS  
FOR  
FOOD PLANTS



FSC 89GP

MIL-STD-668E

8 April 1982

DEPARTMENT OF DEFENSE  
Washington, D.C. 20301

## Sanitary Standards for Food Plants

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1. This Military Standard is approved for use by all Departments and Agencies of the Department of Defense.
2. Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commandant, Academy of Health Sciences, US Army, ATTN: HSHA-IVS, Fort Sam Houston, TX 78234, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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## 1. SCOPE

1.1 Purpose. This standard establishes the general sanitary requirements for plants that supply subsistence items to the Armed Forces.

1.2 Application. This standard is applicable to all types of plants supplying subsistence items destined for Armed Forces procurement and for which detailed standards relating to specific types of food establishments are not available or applicable. Compliance with this standard is mandatory for the listing of plants in the Directory of Sanitarily Approved Food Establishments for Armed Forces Procurement as provided in AR 40-657/NAVSUPINST 4355.4C/AFR 163-2/MCOP 10110.31D. This standard is also applicable to Army Troop Issue Subsistence Activities (AR 30-18).

1.3 Objectives. This standard is intended to insure clean, wholesome, food products free from chemical, microbiological, and physical contaminants and to prevent the transmission of foodborne disease to members of the Armed Forces.

1.4 Limitations. This standard will not be used to determine the capability of an establishment to produce or furnish products or services which are in compliance with specifications or other purchase descriptions.

## 2. REFERENCED DOCUMENTS

2.1 Issues of documents. The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this standard to the extent specified herein.

### LAW AND REGULATIONS

#### Environmental Protection Agency (EPA)

National Interim Primary Drinking Water Regulations

(Application for copies should be addressed to Superintendent of Public Documents, US Government Printing Office, Washington, DC 20402.)

#### US Department of Agriculture (USDA)

Code of Federal Regulations (CFR), Title 7, Agriculture, and Regulations Promulgated Thereunder

List of Chemical Compounds Authorized for Use Under USDA Inspection and Grading Programs

(Application for copies should be addressed to Superintendent of Public Documents, US Government Printing Office, Washington, DC 20402.)

#### US Department of Health and Human Services (HHS)

Code of Federal Regulations (CFR), Title 21, Food and Drug, and Regulations Promulgated Thereunder

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(Application for copies should be addressed to Superintendent of Public Documents, US Government Printing Office, Washington, DC 20402.)

#### Military Publications

AR 30-18, Army Troop Issue Subsistence Activity Operating Procedures

DOD 4145.19-R-1, Storage and Materials Handling

(Copies of regulations and technical manuals may be obtained from normal military publication channels.)

2.2 Other publications. The following documents form a part of this standard to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply.

#### Illuminating Engineering Society (IES)

IES Lighting Handbook

(Application for copies should be addressed to Illuminating Engineering Society, 40 United Engineering Center, 345 East 47th Street, New York, NY 10017.)

#### National Sanitation Foundation (NSF)

NSF Standard 37 for Air Curtains

NSF Standard C-6 for Continuous Cloth Towel Dispensers

(Application for copies should be addressed to the National Sanitation Foundation, PO Box 1468, Ann Arbor, MI 48106.)

(Technical society and technical specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

### 3. DEFINITIONS

#### 3.1 General

3.1.1 Adequate. Methods which are needed to accomplish the intended purpose in keeping with accepted public health practices.

3.1.2 Adulterated. Adulterated shall mean the condition of a food (a) if it bears or contains any poisonous or deleterious substance in a quantity which may render it injurious to health; (b) if it bears or contains added poisonous or deleterious substance for which no safe tolerance has been officially established, or in excess of such tolerance if one has been established; (c) if it consists in whole or part of any filthy, putrid, or decomposed substance, or if it is otherwise unfit for human consumption; (d) if it has been processed, prepared,

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packed, or held under insanitary conditions, whereby it may have become contaminated with filth, or whereby it may have been rendered injurious to health; (e) if it is in whole or in part the product of a diseased animal, or an animal which had died otherwise than by slaughter; or (f) if its container is composed in whole, or in part of any poisonous or deleterious substance which may render the contents injurious to health.

3.1.3 Cleaning. The physical removal of food residues, ingredients, and other soiling materials.

3.1.4 Contamination. Contamination shall be the act or process of exposing the product to an adulterant or unwholesome material.

3.1.5 Food. Any raw, cooked, or processed edible substance, ice, beverage, or ingredient used or intended for use or sale in whole or in part for human consumption.

3.1.6 Plant. The building or buildings or parts thereof, used for or in connection with the manufacturing, processing, packaging, labeling, or holding of human food.

3.1.7 Processing. Processing is all steps in the manufacture or preparation of a product into its final form.

3.1.8 Production area. The room or area in which processing occurs.

3.1.9 Product area. The production area and all other areas where the product, ingredients, and packaging materials are handled or stored.

3.1.10 Product zone (food contact surface). The surface of any equipment, utensils, or other material that contacts the unpackaged product or ingredients during processing.

3.1.11 Sanitize. An adequate treatment of clean product zones by a process that is effective in destroying vegetative cells of pathogenic bacteria and in substantially reducing other microorganisms. Such treatment shall not adversely affect the product and shall be safe for the consumer.

3.1.12 Warehouse. For the purpose of this standard, a warehouse is a structure or room where food and/or packaging and packing materials are stored.

3.1.13 Wholesome. That characteristic possessed by a food product that is conducive to good health and well being in the consumer.

#### 4. GENERAL REQUIREMENTS

4.1 Sanitary compliance rating (SCR). Establishments that attain an SCR of 90 or more shall be recommended for listing in the Directory of Sanitarily Approved Food Establishments for Armed Forces Procurement, provided no critical defects, determined in accordance with 4.2.1, are recorded. When a critical defect is recorded, an SCR shall not be computed and the plant shall not be recommended for listing

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or retention in the Directory of Sanitarily Approved Food Establishments for Armed Forces Procurement. Reporting procedure, responsibility, and authority will be in accordance with regulations and directions of the applicable military service.

4.2 Plant sanitary compliance checklist. The sanitary requirements are set forth in this military standard and itemized as sanitation defects in column 1 of the checklist (see Appendix). The individual defects are given assigned points in column 2 of the checklist, with some being designated as critical.

4.2.1 Recording of defects. The inspector designates as critical or numerically rates the observed sanitation defects. The numerical rating shall be within the numerical range of the assigned defect points in column 2 and recorded in column 3. Any defect entry and related defect points that are not applicable to the plant shall be deleted by lining out the nonapplicable defect and assigned defect points. Nonapplicable defect points shall not be included when totaling column 2. In instances where the inspector considers a defect to be of such magnitude as to constitute a serious health hazard, the numerical rating shall be deleted in column 2 and the word 'critical' shall be recorded in columns 2 and 3. Numerical and critical defects shall be explained in the remarks section in sufficient detail so as to clearly describe the condition which resulted in the disrating. Also, any other deficiencies observed and considered by the inspector to be of sufficient importance to affect the SCR shall be explained in this section.

4.2.2 Computation of the sanitary compliance rating (SCR). If a critical defect is recorded, an SCR shall not be computed. If no critical defects are found, columns 2 and 3 are totaled and the SCR shall be computed using the following formula:

$$\frac{\text{Sum of column 2} - \text{Sum of column 3}}{\text{Sum of column 2}} \times 100 = \text{SCR}$$

4.2.3 Checklist reproduction. Reproduction of the checklist locally is authorized.

## 5. DETAILED REQUIREMENTS

5.1 Premises. The premises shall present a clean and orderly appearance. They shall be well drained, free of environmental conditions and/or materials that are a nuisance or a hazard to sanitation. The area shall be free of weeds, debris, and unused equipment and materials. The area shall be free of waste materials that are stored or handled in such a manner as to be a potential health hazard. The presence of any harborage, attractant, and/or breeding area for insects, rodents, or birds shall not be permitted. If the plant grounds are bordered by grounds not under the plant operator's control, care must be exercised in the plant by inspection, extermination, or other means to effect exclusion of pests, dirt, and other filth that may be a source of food contamination. The approaches to receiving and shipping docks shall be kept clean and maintained to minimize dust.

5.2 Raw materials. All raw materials must be obtained from approved sources as required by AR 40-657/NAVSUPINST 4355.4C/AFR 163-2/MCOP 10110.31D. Food which shows evidence of adulteration, contamination, active insect infestation, or any condition that from a public health or aesthetic standpoint renders the product unfit for human consumption, shall not be accepted by the plant.



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5.2.1 Single-service articles and packaging materials. Single-service articles and packaging materials shall be free of contamination and maintained in sanitary boxes, cartons, tubes, or otherwise protected and handled in a sanitary manner.

5.3 Construction of building. The building shall be large enough to accommodate the operation without hampering sanitary practices. Floors, walls, and ceilings shall be constructed of materials that can readily be kept clean, sanitary, and in good repair. An unnecessary clutter of wiring, pipes, hangers, ducts, etc., shall be avoided. Pipe openings, vents, etc., through walls shall be sealed or otherwise protected to prohibit entrance of vermin. Ceilings shall be free of peeling paint (painted ceilings shall be avoided) and condensates. The exterior openings, including doors, windows, conveyor openings, pipe openings, and vents, shall be clean and in good repair. Where practicable, exterior openings shall be equipped with screens or other effective means (for example, air curtains, overlapping plastic strips) to prevent the entrance of insects, birds, and/or other animals. When the screening of openings is impracticable, such as in receiving areas, flying insect entry may be controlled by properly positioned air curtains or overlapping plastic strips large enough to cover the total door opening. Air curtains shall comply with the National Sanitation Standard No. 37 for Air Curtains for Entrances in Food Establishments. Screen doors shall open outward and be self-closing. Rooms in the processing areas shall not open directly into any barns or stables, living quarters, toilets, garages, or heavy maintenance shops.

5.4 Lighting. Each room shall have sufficient natural or artificial lighting for the purpose for which it is to be used. Lighting intensities shall conform to the intensities established in the latest edition of the IES Lighting Handbook. Lights in the processing areas shall be equipped with protective shields or shall be of such construction that they will not shatter if broken.

5.5 Ventilation and humidity. Humidity shall be regulated in conjunction with ventilation or air movement to control condensation, objectionable odors, and mold growth on ceilings and walls in all areas. Air for ventilation shall be adequately filtered as appropriate to prevent contamination. Ventilation systems shall be kept clean and maintained in good repair.

5.6 Water supply. The water supply shall be readily accessible, of a sufficient quantity, and have an acceptable sanitary quality, as established in the National Interim Primary Drinking Water Regulations or individual military service regulations. The water heater shall be of such capacity so as to be able to furnish an undiminished supply of hot water for a complete food plant cleaning procedure at all times throughout a working day. There shall be mixing valves at all scullery sinks and hose connections. There shall be no cross-connection between potable and nonpotable lines. There shall be protection against possible back-siphonage. There shall be effective protection of wells from contamination by surface drainage or floods. Bacteriological examination and water test results shall be maintained at the plant to show that the water supply has been approved by Federal, state, or local health authorities within the past six months.\* Within CONUS, Hawaii, and Alaska, a water supply approved by a Federal, state,

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or local health authority will be considered potable, and certification of potability will normally not be required. Nonpotable water outlets, if present, shall be located and identified by color code and labeled non-potable so as to preclude the use of nonpotable water for other than the purposes designated. The color code used shall be readily identifiable, prominently displayed, and clearly understood by plant personnel.\*\*

\*If Federal, state, or local health authorities do not have such evidence of water potability, applicable military regulations governing potable water supplies will be followed to approve the water supply(ies).

\*\*The use of nonpotable water is permitted for the flushing of urinals and commodes, for boilers, and for such other similar uses provided it does not directly, nor indirectly, contact the ingredients, product, packaging materials, general product area, or personnel handling the product.

5.7 Ice (if used). Ice shall be made from a supply of potable water which meets the requirements of 5.6. It shall be manufactured, handled, stored, and used in a sanitary manner.

5.8 Disposal of wastes. Liquid wastes shall be conveyed to a public sewer through inclosed piping or shall be disposed of in another sanitary sewage system approved by local/state health authorities. Floor drains shall be functional and properly trapped. Dry and product waste shall be placed in suitable covered receptacles conveniently located throughout the plant and premises. All waste shall be collected and disposed of at frequent intervals in a sanitary manner to prevent insect and rodent attraction and development of objectionable odors.

5.9 Toilet, dressing room, and handwashing facilities. A sufficient number of sanitary toilets or privies shall be provided. Employee toilet facilities required:

<u>Persons of same sex</u>	<u>Toilet bowls required</u>
1-15 inclusive	1
16-35 inclusive	2
36-55 inclusive	*3
56-80 inclusive	*4
For each additional 30 persons in excess of 80	*1

\*Urinals may be substituted for toilet bowls but only to the extent of one-third of the total number of bowls stated.

Toilet rooms shall be conveniently located, constructed of materials which can be easily and satisfactorily cleaned, adequately lighted, and separately vented to the outside. They shall be constructed so that they do not open directly into rooms or areas where components or products are processed or stored. The doors shall be tight-fitting and self-closing. A sign directing employees to wash their hands before returning to work shall be conspicuously posted in all toilet

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rooms. Handwashing signs shall be multilingual, as appropriate. Handwashing facilities with running water at a suitable temperature for handwashing, soap (liquid or powder), soap dispenser, and sanitary single-service towels, clean individual sections of continuous cloth toweling, or hot air blower-type hand dryers will be conveniently located in the toilet rooms and throughout the processing areas. Continuous cloth towel dispensers shall comply with the National Sanitation Standard No. C-6 for Continuous Cloth Towel Dispensers. Toilets, dressing rooms, and handwashing facilities will be maintained in a clean, orderly manner. There shall be a sanitary waste receptacle in each toilet room. Restrooms shall not be used for storage of cleaning equipment. Privies shall be separate from the processing building, and of a sanitary type, location, and construction. Each employee shall be furnished a locker or other suitable facility, and lockers and dressing rooms shall be kept clean and orderly.

5.10 Construction and repair of equipment and utensils. Equipment and utensils shall be designed, constructed, and used so as to preclude the adulteration of food with toxic lubricants, fuel, metal fragments, contaminated water, and any other contaminants. Lubricants used on contact surfaces of moving parts to pumps, product handling and processing equipment shall be edible and nontoxic and shall be used sparingly. The only lubricants authorized for use are those listed in the USDA publication, "List of Chemical Compounds Authorized for Use Under USDA Inspection and Grading Programs".

5.10.1 Equipment and utensils. All equipment and utensils shall be designed and be of such material and workmanship so as to be smooth, easily cleanable, and durable. The food contact surfaces of such equipment and utensils shall, in addition, be easily accessible for cleaning, nontoxic, corrosion-resistant, and consist of nonabsorbent material. Food contact surfaces and solder shall be corrosive-resistant and shall not contain antimony, bismuth, cadmium, lead, zinc, and/or other toxic materials. Solder on the food contact surface shall be hard solder or such formulation so as to be nontoxic under use conditions. Equipment shall be so located as to provide adequate space for cleaning, maintenance, and inspection.

5.11 Cleaning and sanitizing treatment. The methods used for cleaning and sanitizing shall be such that the product shall not be contaminated or adulterated. All products shall be moved sufficiently far away or otherwise protected prior to the start of cleaning to avoid contamination or adulteration by splashing. All multiple-service containers, equipment, and utensils used in handling, processing, storing, or transporting of exposed product shall be disassembled, as applicable, cleaned thoroughly, and sanitized after use. Chemicals used in cleaning and sanitizing treatments shall be properly labeled and stored. Cleaning and sanitizing chemicals shall be used IAW the manufacturer's recommendation. The only chemical compounds authorized for use are those listed in the USDA publication, "List of Chemical Compounds Authorized for Use Under USDA Inspection and Grading Programs". When chemical sanitizers are used, a test kit or other device that accurately measures the correct concentration of the solution shall be provided and used. If water is to be

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used as the sanitizer, it must be not less than 170°F (77°C). All rooms and areas used to receive, process, or store components or the finished product shall be maintained in a clean, sanitary manner so as to preclude the possibility of microbiological, chemical, or physical contamination.

5.12 Methods. Methods used in the processing, handling, and storage of foods shall be conducted in a sanitary manner so as to prevent contamination or adulteration, and not contribute to deterioration of the product from a public health standpoint.

5.13 Public health controls. When applicable, means shall be provided to assure adequate public health control of the raw materials and finished product. The means shall include physical, chemical, and microbiological examinations and/or tests necessary to establish that product has not been adulterated or contaminated. Evidence that all necessary examinations and/or tests have been performed and records of such examinations and/or tests shall be on file and made available to the military inspector.

5.14 Cooling and refrigeration. Cooler rooms shall be free from objectionable odors and from mold. They also shall be maintained in a sanitary condition. The coolers and freezers shall be capable of maintaining temperature and humidity necessary for the preservation of the foods being stored or processed. The equipment shall be of such design that the product shall not be subjected to contamination or adulteration. Frozen food storage facilities shall be capable of maintaining a product temperature of 0°F (-18°C) or lower. Cabinet type frozen food storage facilities shall be defrosted as frequently as necessary to maintain refrigeration efficiency, and shall be equipped with an accurate (+3°F (+2°C)) thermometer indicating a representative air temperature. Frozen food storage facilities shall be adequately maintained to insure circulation of refrigerated air and shall be defrosted as frequently as necessary to maintain refrigeration efficiency. Such facilities shall be equipped with an accurate (+3°F (+2°C)) thermometer, the sensing element of which shall be located within the upper third of the distance between the floor and ceiling, but not placed in a direct blast of air from the cooling unit, cooling coils, heat exchange units, or near the entrance door.

5.15 Storage facilities. Storage facilities shall be provided for storing raw materials, packing and packaging materials, and finished products. They shall be clean, sanitary, and in good repair. Storing methods which minimize deterioration and prevent contamination shall be used. Shelves, cabinets, and dunnage or pallets shall be used where necessary to protect materials from contamination. Equipment used in the breakdown of bulk foods (for example, scales, knives, saws, and scoops, etc.) shall be cleaned immediately after use. Food product spillage will be removed on a daily basis to prevent insect and rodent attraction. Floors in the warehouse shall be swept and cleaned on a weekly basis, or more often if necessary. Cleaning utensils and equipment shall be stored in a dedicated space or rack separate from storage areas. Storage practices in Army Troop Issue Subsistence Activities (TISA) shall be in accordance with AR 30-18 and DOD 4145.19-R-1.

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5.16 Control of insects, birds, and animals. Insects, birds, and/or other animals shall be excluded from the plant. Effective measures for the control of insects, birds, and/or other animals shall be maintained at all times. Operations or procedures which produce rodent harborages or insect breeding areas are prohibited. Insecticides and rodenticides, if used, shall be only those which appear in the USDA publication, "List of Chemical Compounds Authorized for Use Under USDA Inspection and Grading Programs". These products shall be used IAW labeled directions and shall be handled and stored in a safe manner.

5.17 Vehicles and transportation facilities. Vehicles and transportation facilities shall be constructed and operated to protect contents from contamination and deterioration. They shall be kept clean and in good repair. The load hauling area of all vehicles used for transporting food shall be covered. When canvas-covered vehicles are used, the rear flap shall be lowered and secured. Completely inclosed or refrigerated vehicles are required for transporting perishable foods where dust or a temperature rise above recommended levels, or other detrimental effects are encountered. The temperature of frozen foods shall not be allowed to rise above 10°F (-12°C) during delivery. The temperature of chilled foods shall not be allowed to rise above 45°F (7°C) during delivery. All vehicles used to move subsistence items must be provided with pallets or duckboards that will elevate the supplies three or four inches above the bed of the truck. Vehicles used to transport food must not be used concurrently to carry trash, garbage, petroleum products, or other materials that might contaminate subsistence supplies.

5.18 Cleanliness and health of personnel.

5.18.1 Cleanliness. All employees shall wash their hands before beginning work and upon returning to work after using toilet facilities, eating, smoking, or otherwise soiling their hands. They shall keep their hands clean and follow acceptable hygienic practices while on duty. Eating, expectorating, or use of tobacco in any form shall be prohibited in each room and compartment where any food products or supplies are prepared, stored, or otherwise handled. Personnel shall not wear fingernail polish or insecure jewelry. All persons engaged in receiving, testing, processing, manufacturing, packaging, or handling food products shall wear clean, white, or light-colored washable or disposable outer garments. Hair nets, caps, beard nets, or other effective hair restraints to effectively cover hair shall be worn so as to prevent contamination of food and food contact surfaces. Employee's personal effects shall not be stored in production areas.

5.18.2 Health. No person afflicted with, or a carrier of, a communicable disease shall be permitted in any room or compartment where products are prepared, manufactured, or otherwise handled. No person who has a discharging or infected wound, sore, or lesion on hands, arms, or other exposed portion of the body shall work in any processing rooms or in any capacity resulting in contact with the processing or handling of products, containers, or equipment. Where health authorities require health certificates, they shall be kept on file at the plant office. Plant personnel shall receive appropriate training in proper

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food handling techniques, disease control, and food protection principles and will be cognizant of the danger of poor personal hygiene and insanitary practices.

Custodians:

Army - GL  
Navy - SA  
Air Force - 50

Preparing activity:

Army - GL  
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Review activities:

Army - MD  
Navy - MS, SA  
Air Force - 50

Copies of this standard for military use may be requisitioned on DD Form 1425 (Specification and Standard Requisition) and submitted to Commanding Officer Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120. The title and identifying symbol should be stipulated when requesting copies of military standard.



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FOOD PLANT SANITARY COMPLIANCE CHECKLIST		PAGE 1 of 3 Pages	
REFERENCE: MIL-STD-668E This appendix is an integral part of MIL-STD-668E and its application is mandatory.			
NAME AND ADDRESS OF ESTABLISHMENT INSPECTED:		DATE INSPECTED:	
NAME AND TITLE OF ACCOMPANYING INDIVIDUAL:		INSPECTOR: (Name, Grade, Unit, Telephone No.)	
SANITATION DEFECTS (1)		ASSIGNED DEFECT POINTS (2)	INSPECTION POINTS (3)
1. PREMISES			
A. Not clean or well organized-----		3	
B. Not well drained-----		3	
C. Not free from nuisances and sources of contamination-----		5	
2. RAW MATERIALS			
A. Not obtained from approved source-----		Critical	
B. Not inspected upon receipt and at other times as needed for determination of adulteration, contamination, or infestation-----		5	
C. Single-service articles and packaging materials not protected-----		4	
3. CONSTRUCTION OF BUILDING			
A. Not large enough to accommodate the operation without hampering sanitary practices-----		4	
B. Walls, floors, ceilings not in good repair or not constructed of materials that can easily be kept clean and sanitary-----		4	
C. Unnecessary clutter of wiring, pipes, hangers, ducts, etc.-----		4	
D. Exterior openings not clean and in good repair-----		4	
E. Exterior openings do not prevent the entrance of insects, birds, or animals-----		4	
F. Air curtains, if used, not in compliance with NSF standards-----		3	
G. Screen doors not outward opening and not self-closing-----		3	
H. Processing area opens directly into living quarters, garages, heavy maintenance shops, etc.-----		4	
4. LIGHTING			
A. Insufficient lighting-----		4	
B. Lights in processing areas not equipped with shields when required-----		5	
5. VENTILATION AND HUMIDITY			
A. Insufficient control of ventilation or air movement-----		5	
B. Presence of mold on walls or ceilings in processing or storage areas-----		5	
C. Accumulation of condensates in processing or storage areas-----		5	
D. Ventilation system not kept clean and maintained in good repair-----		3	
E. Air not filtered and not directed outward when required-----		5	
6. WATER SUPPLY			
A. Not easily accessible-----		4	
B. Inadequate in quantity-----		5	
C. Undiminished supply of hot water not available-----		5	
D. Mixing valves not available at all scullery sinks and hose connections-----		4	
E. Cross-connection exists between potable and nonpotable water supply or sewage-----		Critical	
F. Not adequate protection against possible back-siphonage-----		5	
G. Potability certificate not current or available-----		5	
H. Potable water supply found to be nonpotable-----		5	
I. Nonpotable water outlets not identified by prominently displayed color code and labels-----		Critical	
7. ICE (IF USED)			
A. Not made from potable water which meets requirements-----		Critical	
B. Not manufactured, handled, stored, or used in a sanitary manner-----		5	
8. DISPOSAL OF WASTES			
A. Liquid wastes not disposed of in a sanitary manner-----		5	
B. Floor drains not functional or properly trapped-----		3	
C. Waste not collected in suitable, properly covered containers and disposed of at frequent intervals and/or in a sanitary manner-----		4	
9. TOILET, DRESSING ROOM, AND HANDWASHING FACILITIES			
A. Sufficient number of toilets or privies not provided-----		5	
B. Toilet rooms not conveniently located or constructed of materials not easily cleaned-----		4	
C. Toilet rooms not adequately lighted-----		2	
D. Toilet rooms not separately vented to the outside-----		5	
E. Toilet rooms open directly into processing area-----		5	
F. Doors not self-closing and tight-fitting-----		3	
G. Absence of handwashing sign-----		3	
H. Absence of suitable temperature water, soap, soap dispenser, or appropriate hand-drying facilities, conveniently located-----		5	
I. Continuous cloth towel dispensers, if used, not in compliance with NSF standards-----		3	
J. Sanitary waste receptacles not present-----		3	
K. Toilets, dressing rooms, and handwashing facilities not maintained in a clean, orderly fashion-----		4	
L. Restrooms used for storage of cleaning equipment-----		3	
M. Privies not separate from the processing building-----		Critical	
N. Privies not of sanitary type, location, and construction-----		5	
O. Each employee not furnished a locker or other suitable facility-----		5	
10. CONSTRUCTION AND REPAIR OF EQUIPMENT AND UTENSILS			
A. Design, construction, and use of such equipment and utensils does not preclude the adulteration of food-----		Critical	
B. Product-contact surfaces not of impervious material, not smooth, nor of corrosion-resistant material-----		4	
C. Product-contact surfaces not of nontoxic material-----		Critical	
D. Not clean or not in good repair-----		5	

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SANITATION DEFECTS (1)		ASSIGNED DEFECT POINTS (2)	INSPR'S DEFECT POINTS (3)
E. Not constructed so that all surfaces can be readily sanitized-----		5-----	
F. Equipment not easily accessible for cleaning, maintenance, and inspection-----		5-----	
11. CLEANING AND SANITIZING TREATMENT			
A. Cleaning or sanitizing methods do not prevent product contamination or adulteration-----		Critical-----	
B. All products not moved away or protected prior to equipment or area cleaning to avoid contamination or adulteration-----		Critical-----	
C. All multiservice containers, equipment, and utensils not cleaned and sanitized after use-----		5-----	
D. Cleaning and sanitizing chemicals not properly labeled or stored-----		5-----	
E. Unauthorized chemical compounds used for cleaning and sanitizing-----		Critical-----	
F. Test kit or other device not used when chemical sanitizers are utilized-----		5-----	
G. Water used as sanitizer less than 170°F (77°C)-----		5-----	
H. Rooms and areas not maintained in a clean, sanitary manner-----		5-----	
12. METHODS			
A. Methods permit contamination/adulteration of product-----		Critical-----	
B. Methods permit deterioration of product-----		5-----	
13. PUBLIC HEALTH CONTROLS			
A. When applicable, examinations not performed to assure adequate public health control of the raw materials and finished products-----		5-----	
B. Records of examination and tests of raw materials and finished products not available-----		5-----	
14. COOLING AND REFRIGERATION			
A. Cooler rooms not free from objectionable odors and from mold-----		5-----	
B. Cooler rooms not maintained in a sanitary condition-----		5-----	
C. Product not stored at proper temperature and humidity-----		5-----	
D. Design of equipment permits contamination/adulteration of product-----		Critical-----	
E. Accurate thermometer not indicating a representative air temperature-----		3-----	
15. STORING AND STORAGE FACILITIES			
A. Storage facilities not clean, sanitary, or in good repair-----		3-----	
B. Storing methods do not minimize deterioration/contamination-----		5-----	
C. Shelves, cabinets, or dunnage not used where necessary to prevent contamination or deterioration-----		5-----	
D. Floors not swept and cleaned at least weekly or more if necessary-----		3-----	
E. Cleaning equipment and utensils not properly stored-----		5-----	
F. TISA storage practices not in accordance with AR 30-18 and DOD 4145.19-R-1-----		5-----	
16. CONTROL OF INSECTS, BIRDS, AND ANIMALS			
A. Presence of insects, birds, and/or other animals in production area-----		Critical-----	
B. Presence of insects, birds, and/or other animals in nonproduction area-----		5-----	
C. Effective measures for control of insects, birds, and/or other animals not maintained at all times-----		3-----	
D. Rodent harborages or insect breeding places present-----		4-----	
E. Unauthorized insecticides or rodenticides used-----		Critical-----	
F. Insecticides or rodenticides not used IAW labeled directions-----		5-----	
G. Insecticides or rodenticides are handled or stored in an unsafe manner-----		5-----	
17. VEHICLE AND TRANSPORTATION FACILITIES			
A. Not constructed or operated to protect contents from contamination or deterioration-----		Critical-----	
B. Not properly maintained or not clean-----		3-----	
C. Supplies not elevated three or four inches above truck bed-----		2-----	
D. Vehicles used to transport food are used to carry materials that might contaminate subsistence supplies-----		5-----	
18. CLEANLINESS AND HEALTH OF PERSONNEL			
A. Employees not washing hands after contamination-----		Critical-----	
B. Failure of employees to be hygienically clean-----		4-----	
C. Personnel not prohibited from eating, smoking, chewing tobacco, or expectorating in product handling areas-----		5-----	
D. Fingernail polish and insecure jewelry worn by plant personnel-----		3-----	
E. Employees not wearing garments/hair restraints suitable for work being performed-----		5-----	
F. Storage of employee's personal effects in production rooms-----		3-----	
G. Employees affected with, or a carrier of a communicable or infectious disease not excluded from product areas-----		Critical-----	
H. Plant employees having an infectious wound, sore, or lesion on hands, arms, or other exposed parts of the body not excluded from contacting ingredients, products, or product zone-----		Critical-----	
I. Prescribed medical examinations of personnel not being made and/or records of such not available-----		4-----	
J. Plant personnel not instructed in acceptable hygienic practices, disease control, and proper sanitary rules of food handling-----		Critical-----	
19. TOTALS			
20.a. SCR COMPUTATION	b. SCR ASSIGNED	c. NUMBER OF CRITICAL DEFECTS	



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21. REMARKS/RECOMMENDATIONS		
TYPED NAME, GRADE, AND TITLE OF INSPECTOR		SIGNATURE OF INSPECTOR

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