

**RULES AND REGULATIONS PRESCRIBING  
MINIMUM STANDARDS FOR  
SEAFOOD PROCESSING, STORAGE AND TRANSPORTATION**

[R23-1-SF]

STATE OF RHODE ISLAND AND PROVIDENCE PLANTATIONS

Department of Health

April 1971

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the provisions of section 42-35-4.1 of the  
Rhode Island General Laws, as amended)**

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**Authority:** Chapters 23-1, 21-27 and 21-31, of the General Laws of 1956 as amended

**R23-1-SF1 PERMITS**

- A. No person shall conduct within this state any seafood processing business without a permit from the Director of the Department of Health.
- B. The Director shall, upon receipt of application for a permit to conduct a seafood processing business, cause the applicant's seafood processing business facilities to be investigated, and, if they are found to comply with these regulations, shall issue a permit. All permits shall expire on December thirty-first of the year issued unless sooner suspended or revoked for cause. Permits issued hereunder may be suspended or revoked for violation of any provision of these regulations.

**R23-1-SF2 DEFINITIONS**

- A. The word "department" shall be construed to mean the state Department of Health.
- B. The word "director" shall be construed to mean the director of the state Department of Health or his duly appointed agents.
- C. The work "person" shall be construed to mean any individual, firm, co-partnership, association, or private or municipal corporation.
- D. The work "approved" shall be construed to mean approved by the director.
- E. The word "fish" shall be construed to mean any aquatic animal, including amphibians or part thereof capable of use as human food.
- F. The words "process," "processed," "processing" with respect to fish or fishery products mean to harvest, handle, store, prepare, produce, manufacture, process, pack, transport, or hold such products.
- G. The word "gurry" shall be construed to mean fish offal.
- H. "Sanitize" means adequate bactericidal treatment of cleaned food-contact surfaces by a process that is generally recognized as effective in destroying microorganisms including pathogens.
- I. The word "adequate" shall mean in conformance with local, state and Federal requirements or recommendations. In the absence of such requirements or recommendations, "adequate" means in keeping with good public health practice.
- J. The words "corrosion-resistant material" shall mean a material that maintains its original surface characteristic under repeated and prolonged exposure to food products, food ingredients, cleaning compounds, and sanitizing solutions to which it is normally subjected.
- K. The words "easily cleanable" shall mean easily accessible and of such design, material, and finish that residues from or caused by processing operations may be completely removed by normal, safe cleaning methods.
- L. The word "plant" shall be construed to mean the building or buildings, or parts thereof, used for or

in connection with the manufacturing, processing, packaging, labeling, or storage of human food.

- M. The term "vessel" means any watercraft of any description which is engaged primarily in the processing of fish for human consumption in this state, and any such craft used for harvesting and/or transporting seafood.
- N. The word "fresh" shall mean any seafood that has been newly gathered; has not been preserved in any manner except by refrigeration; has not been frozen and has not had its original qualities or characteristics impaired.
- O. The word "Whelk" (conches, winkles) shall be construed to mean Channeled Whelks and/or Knobbed Whelks.
- P. The word "lobster" shall mean a sea product of the species "Homarus americanus."
- Q. "Seafood product" shall mean any animal, plant, or other material, or part, or an animal, plant or portion of other material any part of which was originally taken from the sea.
- R. "Fish-smoking establishment" (plant) shall mean the premises, buildings, structures, and equipment employed or used in connection with the processing, storage, or handling of fish, fish products, or ingredients for smoking and/or the smoking and subsequent processing, storage, or handling of the smoked fish, fish product, or fish ingredients within the plant.
- S. "Smoked fish or fish products" shall mean a fish or fish product which, for the prime purpose of taking on the flavor and/or color of smoke, has been (1) subjected to the direct action of smoke or smoke flavor from the burning of wood, wood sawdust, or similar burning material; (2) immersed in or sprayed with a smoke-flavored solution.
- T. "Transportation" shall mean the physical movement, or the acceptance for physical movement, of seafood products by a carrier.
- U. A "day boat" shall mean any fishing boat or vessel that leaves and returns to port on the same day.

### **R23-1-SF3 ADULTERATION**

- A. Only wholesome and accepted seafood products and ingredients shall be used by the processor. "Wholesome" shall mean in sound condition, clean, free from adulteration, and otherwise suitable for use as human food.
- B. "Adulterated" shall mean the condition of fish, fish products or ingredients, (a) if they bear or contain any poisonous or deleterious substance in a quantity which may render them injurious to health; (b) if they bear or contain any added poisonous or deleterious substance for which no safe tolerance has been established by regulation, or in excess of such tolerance if one has been established; (c) if they consist in whole or in part of any filthy, putrid, or decomposed substance, or if they died by other than the conventional and approved method of killing, or are otherwise unfit for human consumption; (d) if they have been processed, prepared, packaged, or held under unsanitary conditions whereby they may have become contaminated with filth, or whereby they may have been rendered injurious to health; (e) if they are in whole or in part the product of a diseased fish; or (f) if their container is composed in whole or in part of any poisonous or deleterious substance which may render the contents injurious to health.

- C. Products shall be deemed to be misbranded if they are so-labeled as to deceive. All seafood products offered for sale shall be clearly identified by specie or generic name.
- D. Seafood may be sampled or examined while in the possession of any person catching, handling, packaging, preserving, transporting or storing seafood products intended for sale and consumption as human food. Laboratory examination may be made as often as may be necessary to ascertain the wholesomeness of the product and to detect adulteration and/or misbranding. No seafood intended for human consumption shall be sold or offered for sale that is unsafe or in any way likely to injure the public health. Seafood may be condemned or destroyed or otherwise disposed of at the discretion of the Director of the Department of Health for cause. (Sec. 21-31-6 and Sec. 21-31-7).
- E. No person shall sell, or represent for the purpose of sale, or imply as fresh, seafood which has been frozen at any time.
- F. No seafood shall be stored in a frozen state for more than twelve (12) successive months except by permission of the Director. Immediately upon being frozen, seafood shall be clearly labeled with the date of freezing and such label shall accompany said product at all times and shall not be removed or defaced.
- G. No person shall sell, or represent for the purpose of sale, seafood as being "fresh" unless it is as defined.

#### **R23-1-SF4 PLANT CONSTRUCTION, EQUIPMENT AND LOCATION**

##### **A. Plant Arrangement:**

Plants in which fish are filleted and packed, or lobsters, crabs, and whelks are picked, handled and packed shall, if feasible, be so located that said establishment shall not be subjected to flooding by high tides. If plant floors become flooded, processing shall be discontinued until after waters have receded and the building cleaned and properly sanitized.

1. The room used for the picking of lobster, crab or whelk meat shall be separated from other rooms or areas in the building by a suitable full partition or walls. Doors to such rooms shall be self-closing.
2. Packing rooms shall be large enough to permit sanitary handling of seafood and for the proper arrangement and thorough cleaning of equipment.
3. A separate room or rooms, or lockers which have adequate capacity for storing employees' street clothing, aprons, gloves and personal articles shall be provided.

##### **B. Dry Storage:**

Fish, cooked lobsters, crabs or whelks in dry storage shall be protected from contamination. Floor wastes from a seafood storage area shall be discharged through a separate drainage system, or if discharged into a general drainage system carrying sanitary wastes, an air gap shall be provided which shall be located between the sewage system and drain(s).

1. The storage-area floor shall be constructed of impervious material, shall be free from cracks and uneven surfaces, and shall be graded to assure complete and rapid drainage of water (no less than 1/4 inch per foot).
2. Walls of storage rooms shall be smooth and of material which will not deteriorate under repeated washing.
3. Storage areas shall be so constructed that they will not receive drainage water from other portions of the plant. All the seafood shall be stored on racks and/or pallets no less than 6" off the floor. Storage areas should not serve as an entry way to other areas of the establishment. Storage areas shall be protected against sewage backflow by the installation of an air gap in the waste line or by provision of a separate drain system. In no event shall racks, pallets or shelving prevent proper cleaning and sanitizing of floor areas.
4. Conveyances or devices used in the transport of seafood shall be so constructed that they may be easily cleaned. (Use of impervious material is recommended wherever possible).

C. Floors:

Floors shall be constructed of concrete or other impervious material and shall be graded to drain quickly, shall be free from cracks and uneven surfaces, and shall be maintained in good condition and kept clean.

1. The floors of all rooms in which seafood is processed or packed or in which utensils are washed shall be constructed of concrete of good quality or of equally impervious tile laid closely with impervious joint material, or of metal surfacing with impervious joints, or of any other material which is equivalent to good quality concrete; the floors shall be maintained in good repair.
2. The floor surface shall be smooth and graded to drain; the junctions between floors and walls, impervious to water.

D. Walls and Ceilings:

Walls and ceilings shall be smooth, washable and kept clean. If painted, it shall be kept covered with a light colored paint or otherwise with suitable impervious material.

E. Fly-Control Measures:

All outer openings to toilet and wash rooms, filleting, picking and packing rooms, utensil cleaning and storage rooms, and locker rooms shall be effectively screened using a 16" mesh screening during the seasons when flies are present, unless other effective means approved by the department are provided for preventing the entrance of flies and other insects. Effective and safe in-plant fly-control measures shall be used to destroy or capture flies which may enter the plant despite the screening. Storage rooms shall be screened as necessary to prevent the entrance of flies into the other portions of the plant. All interior doors or other openings into the packing rooms should be screened whenever necessary to keep the packing room free of flies.

1. Screen doors shall open outwardly and be self-closing.

F. Lighting:

Ample natural and/or artificial light, of at least 50 foot-candle power, shall be provided in all working and storage rooms.

G. Heating and Ventilation:

Working rooms shall be properly ventilated, and, shall be heated when necessary.

1. Proper ventilation reduces condensation and aids in retarding the growth of mold.

H. Water Supply:

The water supply shall be under pressure, easily accessible, adequate, and of a safe and sanitary quality and shall be approved by the Department of Health.

1. All seafood storage rooms, filleting, picking and packing rooms, and utensil washrooms shall be provided with water outlets properly located.
2. An automatically regulated hot-water system shall be provided with sufficient capacity to furnish water at a constant temperature of at least 170°F during all hours of plant operation and plant clean-up if this water is to be used for the sanitization of equipment and utensils.
3. Sufficient water shall be available for all plant needs when operating at maximum capacity. (Non-pressure supplies will not constitute compliance).
4. Hot and cold water outlets shall be provided at each sink compartment.

I. Plumbing and Related Facilities:

Plumbing shall be installed in compliance with local plumbing ordinances, or in the absence of such ordinances, shall be substantially equivalent to the recommendations contained in the AMERICAN STANDARD NATIONAL PLUMBING CODE ASA A40.0--1955. Lavatory facilities shall have running hot and cold (or warm) water and shall be so located that said facility can be readily observed and used by plant personnel. Signs shall be posted in toilet rooms and near lavatories, directing employees to wash their hands before starting work and after each interruption. Conveniently located, separate toilets shall be provided for each sex.

1. There shall be no cross-connections between the approved pressure water supply and water from a non-approved source; nor shall there be any fixtures or connections through which the approved pressure supply might be contaminated by back-siphonage.
2. There shall be at least one lavatory for every 20 employees among the first 100 employees, and at least one lavatory for each 25 employees in excess of the first 100. (Twenty-four lineal inches of wash sink or eighteen inches of a circular basin when provided with water outlets for such space will be considered equivalent to one lavatory).
3. The lavatories shall be provided with hot water (at least 100°F either from a controlled-temperature source with a maximum temperature of 115°F or from a hot-and-cold mixing or combination valve. (Steam water mixing or steam-water combination valves are not acceptable).

4. Supplies of soap and single-service hand towels must be available near the lavatory. (Other sanitary drying devices, if approved by the Department of Health, are also acceptable).
5. The toilet-room doors shall be tight fitting and self-closing, and vestibules shall be provided unless specifically exempted by the Director.  
Where facilities have been approved without a vestibule, mechanical means of ventilation to the outside shall be provided.
6. The toilet rooms shall be kept clean and in good repair.
7. A supply of toilet paper shall be available in the toilet rooms at all times.
8. At least 5-foot-candle illumination (natural or artificial) shall be provided in toilet rooms.
9. Toilet rooms shall be ventilated by a direct opening to the outer air, or by an approved mechanical ventilating system. (Exhaust fans, if used, should have a minimum capacity 2 cubic feet a minute per square foot of floor area). Air vents should be screened or have self-closing louvers.
10. Conveniently located, separate toilets shall be provided for each sex. The number of water closets provided must comply with applicable state laws. In the absence of such laws, the following number of water closets should be provided:

<u>Number of Employees</u>	<u>Number of Water Closets (1)</u>	
	<u>Male</u>	<u>Female</u>
1 to 9	1	1
10 to 24	2	2
25 to 49	3	3
50 to 74	4	4
75 to 100	5 (2)	5 (2)

(1) Wherever urinals are provided, one water closet less than number specified may be provided for each urinal installed, except that the number of water closets in such care should not be reduced to less than two-thirds of the minimum specified.

(2) A 24-inch trough will be considered equivalent to one urinal. One additional fixture for every 30 employees over the first 100.

11. No unprotected drainpipes or wastepipes shall be located over food processing or storage areas, or over areas in which containers or utensils are stored or washed. (Drip troughs (shields) draining to the floor is an approved method of preventing contamination from drainpipes).

J. Sewage Disposal:

Sewage shall be discharged into public sewers wherever possible. Where private sewage disposal systems must be utilized, they shall be constructed according to the state requirements as provided in Health Department Regulation R23-1-SD which established the minimum standards relating to location, design, construction, and maintenance of individual sewage disposal systems.

K. Rodent Control:

Seafood processing plants shall be free from rodents.

1. The plant shall be constructed so as to prevent the entrance of rodents.
2. Rodenticides which are highly toxic to humans shall not be stored in seafood processing plants, and shall not be used except under the supervision of a licensed pest control operator or other qualified specialist with the approval of the Health Department. (Rodenticides which have a low toxicity for humans should be identified, stored, and may be used, after the approval of the Health Department, in such a manner as to prevent contamination of the product, ingredients, and equipment, and to cause no health hazards to employees.
3. All openings accessible to rodents shall be rodent-proofed by using a 1/4" hardware mesh (screen).

L. Construction of Breaking, picking or Filleting Benches and Tables:

The tops of processing benches and tables, and contiguous walls to a height of at least two feet above the bench top, shall be of smooth concrete, corrosion-resistant metal, or other durable, non-absorbent material, free from cracks, and so constructed that drainage is complete, rapid and is directed away from the stored meats. Filleting or picking blocks shall be easily cleanable. Wooden blocks, if used, shall be of solid, one-piece construction, and shall be easily removable. Blocks of lead or other toxic materials are prohibited. Stands or stalls, if any, shall be of painted, finished material.

Stools used by pickers shall have no attached padding, and shall be so constructed as to be easily cleaned.

Plants shall not have processing benches or other equipment attached to wall areas.

**R23-1-SF5 CLEANING AND SANITIZING**

A. Construction and Cleaning of Utensils and Equipment:

Food contact surfaces of utensils and equipment used for ice handling, shall be smooth, corrosion-resistant, impervious, and non-toxic material which will not readily disintegrate or crack and shall be so constructed as to be easily cleaned, and shall be kept in good repair.

1. Knives, cleavers and other tools or implements shall be maintained in a sanitary condition.
2. The use of enameled, tinned, or galvanized material in any food contact equipment other than single-service shipping containers is not permitted.

3. There shall be no exposed screw, bolt, or rivetheads in the parts touching or draining to the food, and all joints shall be welded or soldered flush and have a smooth surface. (The use of welded joints which have been ground smooth is recommended because soldered joints have been proven to be generally unsatisfactory for equipment used in the Seafood Industry).
4. Containers shall be clean, fabricated of non-toxic metal, waxed paper, glass, or other impervious material and be so designed and fabricated that the contents will be protected from contamination during shipping and storage. Covers of returnable containers shall be so designed as to protect the pouring lip of the container and shall be sealed so that tampering can be detected.
5. Tanks, tubs, and picked-meat storage containers shall be so located that their top rim is at least two feet above the floor.
6. All utensils and equipment shall be in good repair.
7. Containers used to convey lobsters, crabs and whelks into picking rooms shall not be placed on tables or benches therein. Uncovered containers holding cooked lobsters, crabs, whelks, or the meat therefrom shall not be stacked.
8. Cooking vessels and wire baskets used to contain the cooked lobsters, crabs, or whelks shall be of stainless steel.

B. General Cleanliness:

Premises shall be kept clean and free of litter and rubbish. Miscellaneous and unused equipment and articles which are not necessary to plant operations shall not be stored in rooms used for fish or seafood picked-meat storage, fish filleting, picking, packing, or repacking. No domestic animal or fowl shall be permitted in a processing plant. The seafood picked-meat or fish storage, filleting, breaking or picking and packing portions of the plant, when in operation, shall be restricted to the handling of fish, lobsters, crabs, or whelks. Unauthorized persons shall be excluded from the plant.

1. Filleters or pickers shall not go into or through the packing room for any purpose. (An exception may be made in small operations, where an employee may work in both the packing room and the picking or filleting room. In such cases, the employee should be required to change aprons and wash his hands thoroughly before entering the packing room).
2. Employees in processing rooms shall wear clean outer garments, and all persons entering such rooms shall wear a cap or hair net confining the hair.
3. Smoking or other use of tobacco is prohibited.
4. Use of jewelry and finger nail polish is prohibited.
5. Breast pockets should not contain pens, pencils, or other articles that may drop onto the product.

C. Cleaning of Buildings and Equipment:

Benches, stools, floors and walls of the storage rooms and packing and filleting or picking rooms shall be cleaned within two hours after the day's operations have ceased. Windows and skylights shall be kept clean. Refrigerators shall be kept clean. All equipment, utensils, work surfaces, and knives, cleavers, picks, forks and other tools or implements shall be cleaned by scrubbing with water and detergent and rinsed with potable water within two hours after the day's operations, and shall be maintained in a sanitary condition.

1. Scales, filleting or meat-picking tables, packing tables, benches, and all other equipment of similar nature shall be made of non-corrodible material or kept painted. Cutting boards shall be removable and should be kept in a reasonably smooth condition; badly split boards are prohibited. Approved rubber base composition boards should be used when possible. Conveyors and all other equipment shall be of a design that permits easy and thorough cleaning.
2. Wash sinks, detergents and brushes, including special brushes needed for cleaning equipment, must be available and used according to the requirements of the Department.

#### SINK WASHING

Wash sinks should be made of impervious, non-toxic material. Sink compartments should be large enough to permit the complete immersion of the largest utensil to be sink washed. A second compartment should be provided in the sink for clean water rinsing, unless some other acceptable method, such as a spray rinse, is provided. In the case of bactericidal treatment by immersion in hot water, both the bactericidal treatment and rinse may be accomplished simultaneously in the second compartment. If bactericidal treatment by means of immersion in chemical solutions is selected, a separate or third compartment should be provided for this operation.

#### IN PLACE WASHING

Utensils and equipment which have to be washed "in place" will require pre-rinse, wash, rinse, and bactericidal treatment. A watertight container is best washed by preparing a solution of the detergent in the container itself and using this to scrub all parts of the unit. Rinsing, preferably would be accomplished either by complete filling or by thorough spray rinse. The bactericidal treatment methods are described in Item 4.

- a. Cleaned benches, blocks, and stalls should be flushed or sprayed as often as necessary, and at least once each week with a solution containing not less than 100 parts per million of available chlorine or other disinfecting agents in effective concentrations as approved by the Department of Health.
- b. All shelves, tables and other equipment in the filleting or meat-picking and packing rooms shall be clean.
- c. Periodic clean-water flushing of filleting or breaking/picking benches, utensils, table surfaces and other equipment during working periods is recommended.
- d. Periodic in-plant chlorinated (break point) water for flushing of filleting benches, etc., is recommended.

#### D. Bactericidal Treatment of Utensils and Equipment

All utensils and equipment in the processing and packing rooms which come into contact with filleted fish or pickled-meats shall be subjected to an effective bactericidal treatment at the end of each day's operation. Containers which have been subjected to bactericidal treatment should have a residual bacterial plate count of not more than 1 per milliliter of capacity, and equipment not over 100 colonies per 8 square inches (i.e. 2 per sq. cm.) of food contact surface, in three out of four samples (Reference, Standard Methods - American Public Health Association, for information on apparatus and procedure for making rinse and swab counts).

Large equipment which might be recontaminated before use shall be cleaned at the end of each day's operation and shall be subjected to effective bactericidal treatment immediately before use.

Returnable shipping containers, if used, shall be subjected to an effective bactericidal treatment the day they are to be used and shall be protected against contamination until filled.

##### Approved Methods of Bactericidal Treatment:

1. All utensils and other equipment shall be treated by one or more of the following methods:

a. Immersion in hot water of at least 170°F for at least one-half minute. (An accurate indicating thermometer must be provided and used). A booster heater or other devices may be necessary for water to be maintained at 170°F.

b. Chemical Sanitization:

Immersion for at least one minute in or exposure for at least one minute to a flow of a solution containing not less than 50 parts per million of free chlorine at the end of the run. All product-contact surfaces must be thoroughly treated by prolonged wetting by the bactericidal solution, and piping, if so treated, must be filled and have the acceptable residual concentration at the end of the piping system. Bactericidal sprays containing not less than 100 parts per million of free chlorine may be used for large equipment. If atomized into said equipment, it shall be done in such a manner as to assure complete coverage of the internal surfaces with a 200 ppm chlorine residual. Bactericidal treatment with chemicals is not effective unless the surface has been thoroughly cleaned.

c. Exposure for at least 15 minutes at a temperature of at least 170°F, or for at least five minutes at a temperature of at least 200°F, in a steam cabinet equipped with an indicating thermometer located in the coldest zone. (Absence of a thermometer violates this item). A vent or valve must be installed at the bottom of large steam cabinets to permit the discharge of cold air when steam is admitted.

**BACTERICIDES OTHER THAN CHLORINE WILL NOT BE ACCEPTED UNTIL OFFICIAL TESTS ARE MADE OR APPROVED BY THE HEALTH DEPARTMENT.**

#### E. Storage of Equipment:

Equipment and utensils which have been cleaned and given bactericidal treatment shall be stored so that they are thoroughly drained and protected against any environmental contamination. The utensils can be stored in a steam chest; in a special cabinet; or otherwise in the packing room on

clean shelves, stands, tables, or racks. Storage racks should be at least three feet above the floor.

F. Handling of Single-Service Containers:

All single-service containers shall be stored and handled in a sanitary manner, and, if necessary, shall be given bactericidal treatment immediately prior to filling.

1. Single-service containers in the packing room shall be kept on stands or tables at least two feet above the floor and shall be protected against contamination from splash.

**R23-1-SF6 SEAFOOD**

A. Packing of Seafood:

Filleted fish or picked meats shall be packed without exposing them to contamination. Seafood shall be packed and shipped in clean, single-service containers of impervious material, or in clean, properly designed, returnable containers so sealed that tampering can be detected. Returnable containers will be accepted only for interplant shipment of seafood. Each individual package of fresh or frozen fish, lobster, crab or whelk meat shall have permanently recorded on the package or label so as to be easily visible the name and address, certificate number and State of the packer, repacker or distributor. Packages of frozen fish shall show the date or code of packing. The explanation of any code shall be available to the consumer upon request.

1. Wording, such as "Packed for" or "Distributed by" shall be used wherever necessary to clarify the name on the label. Packing into containers with other plant certification numbers will not be permitted. Recording identification information on containers by use of a rubber stamp will not be acceptable. Returnable shipping containers may be identified with tags of at least 2 5/8 x 5 1/4 inches in size and made of substantial waterproof stock.
2. The packing code should be made available at the request of the Department of Health. Code dating of non-frozen products is also recommended.

B. Candling of Fish Fillets:

Fish fillets shall be placed over a light of suitable intensity for the detection of any parasites, cysts, etc. These foreign items shall be removed from the fillets before packaging.

C. Handling of Gurry:

Barrels or any other receptacles for waste or gurry shall be water-tight, kept covered and shall be thoroughly cleaned and sanitized after each emptying. All gurry shall be removed from the premises at least once a day.

D. Open Air Processing:

Fish shall be processed only within the enclosure of an approved establishment maintained as provided in these regulations.

E. Shell Disposal:

Shells from which meats have been removed shall be removed promptly from the picking room and disposed of in an approved manner.

F. Use of Containers:

Containers used to take lobsters, crabs into picking rooms shall not be placed on tables or benches therein. Uncovered containers of cooked lobsters, crabs, whelks, or the meat therefrom, shall not be stacked.

Cooking vessels and wire baskets used to contain the cooked lobsters, crabs, or whelks, during processing and plant handling thereafter shall be of stainless steel.

G. Picking of Lobsters, Crabs and Whelks:

Meat from lobsters, crabs, or whelks shall be picked into containers or onto surfaces which have been properly sanitized with a chlorine solution of not less than 50 parts per million of free chlorine.

H. Retail Seafood Display:

All unwrapped or unenclosed seafood on display shall be protected by glass or otherwise from public handling or other contamination and kept at below 45°F at all times.

**R23-1-SF7 REFRIGERATION**

A. Refrigeration of Filleted Fish:

Filleted fish shall be cooled to an internal temperature of 45°F or less with two hours after packing and stored and shipped under similar temperature conditions. Further cooling to a temperature not exceeding 40°F is recommended.

Seafood which will not be packed within one hour after delivery to the packing room shall be cooled to an internal temperature of 45°F or less within two hours.

B. Refrigeration of Lobsters, Crabs and Whelk Meats:

Meat from lobsters, crabs, whelks, or parts thereof not immediately removed from the shells after cooking shall not be sold, given away, or used for food purposes unless such lobsters, crabs, whelks, or parts thereof have been kept in sanitary containers and refrigerated at less than 45°F.

Shucked lobster, crab, or whelk meat shall be cooled to a temperature of 45°F or less within two hours after picking. Containers of such products shall be packed in cracked ice or otherwise suitably refrigerated at a temperature of 40°F or below until sold.

A temperature of 0°F shall be maintained in the frozen-storage rooms.

1. Picked lobster, crab, or whelk meat shall be cooled to an internal temperature of 45°F or less within two hours after packing and stored and shipped under similar temperature conditions. (Five pound containers will ordinarily have to be stored in crushed or flaked ice immediately after packing, to attain this degree of cooling. For containers holding more than five pounds,

shucked meats will ordinarily require cooling prior to placement in containers).

2. Packaged fish, lobster, crab, or whelk meat to be frozen shall be properly stacked to insure rapid freezing, and frozen at an ambient air temperature of 0°F or less, with packages frozen solid within 12 hours after the start of freezing, and frozen meats shall be handled in such a manner as to remain frozen solid and held at 0°F or less until sold to the final consumer, if sold as a frozen product.

C. Ice:

Ice shall be obtained from sources approved by the Department of Health and shall be stored and handled in a clean manner.

D. Fresh Fish Shipments:

Fresh fish shipments should be packed in ice for delivery and should be well iced when received. Finely crushed ice should be used in preference to large pieces to avoid bruising the fish. Fish should be handled carefully to avoid bruises and punctures of the flesh which cause quality breakdown.

E. Thawing Frozen Seafood:

Frozen seafood shall be thawed at refrigerator temperatures of 45°F or below or under cool, potable running water (70°F or below), or quick thawed as part of the cooking process, or by any other method satisfactory to the Director.

**R23-1-SF8 FISHING VESSELS**

A. Holds:

The holds of all fishing boats and vessels used for the taking of transportation of fish for food purposes shall at all times be maintained in a sanitary condition. Pen boards shall be thoroughly washed with chlorinated water containing at least twenty parts per million, or a "detergent-sanitizer" having equivalent sanitizing capabilities, and shall be scrubbed immediately after coming out of the hold. Pen boards which are cracked, splintered, or otherwise punctured, so as to be unsanitary, shall not be used. Holds shall be thoroughly washed and scrubbed with chlorinated water or water containing a suitable "detergent-sanitizer."

Holds and pen boards of all vessels, excepting those engaged in lobster dragging operations, shall be thoroughly cleaned, dried, and painted at least once a year or more often, if necessary, with a lead-free paint.

B. Handling and Storage:

All fish of the following species shall be eviscerated as they are caught and before being packed: Haddock, Cod, Pollock, or any other fish which may be so designated.

1. The gutting of fish at sea shall be thorough and complete with the removal of all the internal matter from the body cavity. Fish shall be thoroughly washed before being iced. Ice shall be used, so that all fish are kept apart in the center of the pens. Ice must be in actual and

continuous contact with the fish. It shall effectively separate all fish from bulkheads, sheathing, shelves, and pen boards, and must be in quantity to last for the duration of the storage period and assure the preservation of said seafood.

2. Gills must be removed on all fish mentioned above from April 1st to November 1st on all boats other than "Day" Boats.
3. Forks shall not be used for the transferring of fish from one receptacle to another or from the holds of vessels into unloading receptacles. If picks are used, only the head area of the fish shall be penetrated.

C. Toilets and Lavatories:

Ship's personnel must use the facilities provided aboard vessels for personal cleanliness; signs requiring employees to wash their hands before returning to work after any absence shall be conspicuously posted in such facilities.

(Item B3 of this section will take effect three (3) months after the acceptance of these regulations.)

## **R23-1-SF9 SMOKED - FISH PROCESSING**

A. Brining of Fish:

Only clean refined salt, or filtered brine of a temperature not exceeding 50°F shall be used in the brining of fish.

Where necessary to prevent contamination of fish, covers shall be provided for tanks, and containers, including brining and thawing tanks.

B. Fuel:

Fuel used for smoking (wood, excelsior, etc.) shall be clean and shall be stored away from fish, fish products or ingredients.

C. Use of Preservatives for Fish:

Only salt, sugar, wood smoke, vinegar, pure spices, spice flavorings, and sodium benzoate may be used as fish preservatives. The quantity of sodium benzoate shall not exceed one-tenth of one percent by weight of product and must be designated on the label.

The use of the salts of nitrate and the salts of nitrite in fish for any purpose is prohibited.

D. Use of Coloring Matter on Fish:

The use of any matter which imparts color to fish is prohibited.

E. Drip Pans:

In an establishment engaged in preparing, preserving, or smoking fish, metal drip pans shall be

provided and placed under racks of smoked fish in order to catch the drippings. The pans shall be kept clean and in good repair.

### **R23-1-SF10 CLAM JUICE**

#### **A. Construction and Cleaning of Utensils and Equipment:**

The parts of utensils and equipment which come in contact with the juice being processed or which may drain into equipment containing juice, including equipment used for pasteurization, shall be made of smooth, corrosion-resistant, impervious, non-toxic material which will not readily disintegrate or crack and shall be so constructed as to be easily disassembled and cleaned and shall be kept in good repair.

1. The use of enameled, tinned, or galvanized material in any juice contact equipment other than approved single-service shipping containers is not acceptable.
2. There shall be no exposed screw, bolt, or rivet heads in the parts touching or draining to the juice and all joints shall be welded or soldered with lead free solder, flush and have a smooth surface. (The use of welded joints which have been ground smooth is recommended; soldered joints are not recommended and have been proven to be generally unsatisfactory).
3. Containers shall be clean, fabricated of non-toxic metal, or be of waxed paper composition, glass or other impervious material, and so designed and fabricated that the contents will be protected from contamination during shipping and storage. Covers of returnable containers shall be so designed as to protect the pouring lip of the container and shall be sealed so that tampering can be detected.

#### **B. Pasteurization of Clam Juice:**

No clam juice intended for human consumption shall be sold or offered for sale without first being pasteurized in equipment approved by the Department.

Clam juice is to be heated for at least 30 minutes at no less than 143°F to insure proper pasteurization. A proper timer and thermometer, approved by the Department, shall be used to insure that the time and temperature is achieved.

#### **C. Refrigeration:**

Clam juice shall be cooled to a temperature of 45°F or less within two hours after processing. The containers of juice shall be packed in cracked ice or otherwise suitably refrigerated at a temperature of 40°F or less until sold.

Frozen clam juice shall be handled in such a manner as to remain frozen solid and held at 0°F or less until sold to the final consumer if sold as a frozen product.

### **R23-1-SF11 TRANSPORTATION**

#### **A. Transit and Storage of Seafood:**

All fish and fishery products whether inside or outside any establishment or in transit shall at all times be kept iced or otherwise properly cooled and kept in containers or display cases which are

sanitary and protected from the direct rays of the sun and other elements conducive to spoilage or contamination. To prevent spillage trucks, boxes, containers, receptacles and mechanical conveyors, shall not be overloaded. During processing, storage and/or transportation, fish or fish products shall not be allowed to come in direct contact with the floors of the plant and/or transportation facility.

1. Seafood while being transported shall be in an enclosed conveyance with doors closed securely or such products must be in covered containers or otherwise wrapped or packaged to insure protection from contamination. Potentially hazardous foods shall be kept at safe temperature during all periods of transportation and delivery.
  2. Insulated containers may be used for transportation of frozen seafood, provided that the internal temperature of the frozen seafood at no time exceeds zero degrees Fahrenheit except during brief periods of loading and unloading when temperatures shall not exceed 10°F.
- B. Vehicles used for transporting seafood shall not be used for any purpose other than that for which it was intended.
- C. Vehicles of transportation shall be equipped as follows:
1. Insulation and a mechanical refrigeration system or other refrigeration method or facilities capable of maintaining an air and product temperature of 0°F or lower while loaded with any frozen food; and no higher than 45°F for refrigerated seafood products.
  2. With a thermometer or other appropriate means of temperature measurement indicating air temperature inside the vehicle. The dial or reading element of the thermometer shall be mounted on the outside of the vehicle.
  3. Vehicles used for route delivery shall comply with all equipment provisions herein specified for vehicles of transportation and shall be equipped with curtains or flaps in the doorway area or with port doors to maintain refrigeration during stops.
- D. Handling Practices for Over-the-Road Transportation:
1. Vehicles for frozen products transportation shall be precooled to an air temperature of 20°F or lower before loading.
  2. Frozen food shipments shall not be accepted for transportation when the internal product temperature exceeds 0°F.
  3. Frozen food shall be loaded within a vehicle of transportation to provide for free circulation of refrigerated air at the front, rear, top, bottom, and both sides of the load except for vehicles of envelope-type construction wherein refrigerated air circulates within walls of said vehicles.
  4. The mechanical refrigerating unit of vehicles shall be turned on and doors of vehicles shall be kept closed during any time interval when loading or unloading operations cease.
  5. The average product temperature of any shipment of frozen food shall be determined during loading and unloading by adequate temperature readings.

E. Handling Practices for Route Delivery:

1. In addition to all provisions specified in Section FF6.2 of R23-1-FF, entitled Frozen Food Products, the following provisions shall be met:
  - a. Each lot for individual consignment shall be refrigerated by maintaining an air and product temperature of 0°F or lower;
  - b. Insulated containers shall be precooled to a temperature of 20°F or lower before being loaded with frozen food;
  - c. Doors of vehicles shall be kept closed during any time interval that loading or unloading operations cease.

F. Sanitary Provisions:

1. All interior surfaces of vehicles and devices used for transporting frozen food shall be clean and free of objectionable odors before being loaded with frozen food.
2. Frozen food shall be securely packaged or wrapped in a sanitary manner before they are accepted for transportation.

**R23-1-SF12 MISCELLANEOUS**

A. Records:

Complete and accurate records shall be kept by every fish dealer of all business transactions.

B. Health of Personnel:

Any person known to be infected with any disease in a communicable form, to be a carrier of any disease which can be transmitted through the handling of fish, or who has an infected wound or open lesion on any exposed portion of his body shall be excluded from the filleting or packing plant. Any owner or manager who has reason to suspect that any employee has contracted a communicable disease shall immediately notify the proper health officials. Pending appropriate action by the health officials, said employee shall be excluded from the plant.

C. Supervision:

The management shall designate a reliable individual to be accountable for compliance with the items of these regulations having to do with plant and personnel cleanliness.

D. Cleanliness of Employees:

Employees shall wash their hands with a liquid or powdered dispensed soap and water before beginning work and again after each interruption and before returning to work.

1. When manual handling of filleted fish or picked seafood meats becomes necessary, sanitized rubber gloves shall be worn, or the hands shall be washed and disinfected immediately before such manual handling.

2. Finger cots, gloves, and/or shields if worn by filleters or pickers shall be sanitized as often as necessary and at least twice daily. (Use of waterproof finger cots or shields is recommended as preferable to those made of an absorbent material). Any person who handles seafood shall wear a clean apron or coat. Rubber aprons shall be washed daily and hung so as to dry easily when not in use.