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NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA

GB 8953-2018

**National food safety standard -
Hygienic regulation for soy sauce**

食品安全国家标准

酱油生产卫生规范

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National food safety standard - Hygienic regulation for soy sauce

1 Scope

This standard specifies the basic requirements and management guidelines for the sites, facilities and personnel in the procurement, processing, packaging, storage and transport of raw-materials in the production process of soy sauce.

This standard applies to the production of soy sauce.

2 Terms and definitions

The terms and definitions as defined in GB 14881-2013 apply to this document.

3 Selection of site and plant environment

It shall comply with the relevant provisions of clause 3 of GB 14881-2013.

4 Factory building and workshops

4.1 Design and layout

4.1.1 It shall comply with the provisions of 4.1 of GB 14881-2013.

4.1.2 According to the needs of the production process of soy sauce, it may set such working stages as raw-material processing, mold-starter propagation, brewing, spraying, blending, sterilization, filling and so on.

4.1.3 Each production workshop or internal area shall be divided into a cleaning operation area (filling room), a quasi-cleaning operation area (mold-starter propagation, fermentation, spraying, blending, sterilization, etc.), a general working area (raw-material warehouse and finished product warehouse). The production workshop shall be provided with personnel channels and material transport channels, respectively.

4.2 Internal structure and materials of building

4.2.1 General requirements

that needs to be kept dry.

5.1.5.3 Handwashing facilities shall contain dispensers for close-free cleaning detergents and disinfectants, dryers or paper towels. For disinfection of hands, if a chlorine disinfectant is used, the concentration of free chlorine shall reach to 50 mg/kg.

5.1.5.4 The drainage of hand-washing facilities shall be directly connected to the sewer pipe, where there is a device to prevent backflow, harmful animal intrusion, or odor.

5.1.5.5 If the toilet is set up in the locker room of the production workshop, the door of the toilet shall not face the door of production workshop. There shall be a flushing device and pedal-type or inductive hand washing facilities in the toilet, as well as good ventilation and lighting facilities.

5.1.6 Ventilation facilities

5.1.6.1 It shall comply with the relevant provisions of 5.1.6 of GB 14881-2013.

5.1.6.2 Brewing, packaging and storage places shall be well ventilated to prevent excessive indoor temperature, steam condensation or odor. If necessary, it shall be equipped with the ventilation equipment.

5.1.6.3 The mold-starter propagation room shall have air-conditioning facilities.

5.1.6.4 Ventilation & exhaust devices shall be easy to disassemble for cleaning, repair or replacement, the vents shall have anti-corrosion mesh covers. The air inlet must be more than 2 m above the ground and away from sources of pollution and exhaust.

5.1.6.5 Exhaust equipment with sufficient capacity shall be installed in places of steaming & boiling, mold-starter propagation, oil spraying.

5.1.6.6 The air inlet of mechanical ventilation shall be fitted with a corrosion-resistant open-close protective cover that is easy to clean and replace, and away from pollution sources and exhaust outlets.

5.1.7 Lighting facilities

5.1.7.1 It shall comply with the relevant provisions of 5.1.7 of GB 14881-2013.

5.1.7.2 If there is a light inspection facility in the filling process, it shall meet the lighting inspection conditions.

5.1.8 Warehousing facilities

5.1.8.1 It shall comply with the relevant provisions of 5.1.8 of GB 14881-2013.

It shall comply with the relevant provisions of 5.2.2 of GB 14881-2013.

5.2.3 Maintenance and repair of equipment

5.2.3.1 It shall comply with the relevant provisions of 5.2.3 of GB 14881-2013.

5.2.3.2 The water supply and drainage systems for the factory buildings, equipment, other mechanical facilities shall, under normal conditions, be subjected to the overall overhauling, maintenance, repair at least once a year.

6 Hygiene management

6.1 Hygiene management system

It shall comply with the relevant provisions of 6.1 of GB 14881-2013.

6.2 Hygiene management for factory buildings and facilities

6.2.1 It shall meet the requirements of 6.2 of GB 14881-2013.

6.2.2 The workshop and equipment shall be cleaned and disinfected regularly.

6.2.3 The mold-starter propagation room and mold-starter seeding room shall be cleaned and disinfected regularly. It shall take measures to prevent the mold-starter seeding and the finished mold-starter from being contaminated by bacteria.

6.3 Health management and hygiene requirements for food processing personnel

6.3.1 Health management of food processing personnel

6.3.1.1 It shall establish and implement the health management system for food processing personnel.

6.3.1.2 Food processing personnel shall be subjected to health checks every year and obtain health certificates. They shall receive hygiene training before going to their posts.

6.3.1.3 If the food processing personnel have diseases that are harmful to food safety as prescribed by relevant national laws and regulations, they shall be arranged to other posts that do not affect food safety.

6.3.2 Hygienic requirements for food processing personnel

6.3.2.1 It shall comply with the relevant provisions of 6.3.2 of GB 14881-2013.

6.3.2.2 Workers in the finished product filling workshop shall wear clean work

7.2.4 The warehousing and use of raw-materials of food shall follow the principle of “early-in, early-out”. It shall be stored separately according to different batches of raw-materials of food. Pay attention to avoid moisture and mildew during storage, perform regular or irregular inspections, remove the raw-materials which have signs of deterioration and mildew in time.

7.2.5 If there are special storage conditions for the raw-materials of food, the storage conditions shall be controlled and recorded.

7.2.6 Qualified raw-materials of food and unqualified raw-materials of food shall be stored separately. They shall be marked clearly to distinguish them.

7.3 Food additives

It shall comply with the provisions of 7.3 of GB 14881-2013.

7.4 Food-related products and others

It shall comply with the provisions of 7.4 and 7.5 of GB 14881-2013.

8 Food safety control in production process

8.1 Risk control for product contamination

8.1.1 It shall comply with the provisions of 8.1 of GB 14881-2013.

8.1.2 It is encouraged to use the Hazard Analysis and Critical Control Point Systems (HACCP) to control the key control points (such as temperature, time, pressure, disinfection concentration, etc.) in the processing of soy sauce.

8.1.3 When it finds abnormality in the production monitoring, it shall find the causes quickly, make corrections in time, take records.

8.1.4 All products shall be stored under the conditions the comply with the relevant production operation regulations or relevant standards. It shall take effective measures to prevent secondary contamination during production or storage.

8.1.5 Equipment, containers and tools which are used for conveying, loading and storing raw-materials, semi-finished products and finished products shall be operated, used and maintained to avoid contamination of products during processing or storage.

8.2 Control of biological pollution

8.2.1 General requirements

8.2.1.1 It shall comply with the provisions of 8.2 of GB 14881-2013.

After the mold-starter is released, clean the mold-starter propagation pool and floor to keep it clean. Disinfect it if necessary.

8.2.4.2 When culturing finished mold-starter, it shall be performed strictly according to the process provisions. The duration of mold-starter propagation shall be determined according to the applied strain, the mold-starter propagation process, the fermentation process.

8.2.4.3 The finished mold-starter shall be timely blended into saline water and transferred into a fermentation container, to prevent contamination from the bacteria as caused by excessive temperature. Outdoor fermentation containers shall be protected from rain and insects entering the fermentation containers.

8.2.5 Fermentation

8.2.5.1 The edge of the fermentation container (pool, tank, barrel, cylinder) shall be more than 15 cm above the floor, to prevent the sewage from flowing into the container during cleaning. The outdoor fermentation container shall have rain and insect proof devices. The paint in the container shall be non-toxic and harmless.

8.2.5.2 For the fermentation tanks which are thermally insulated by water bath, the thermal insulation water shall be replaced regularly and free from odor.

8.2.5.3 Oil storage tanks, salt washing tanks (or salt dissolving tanks), salt water tanks (pools), oil-spraying tanks shall be cleaned frequently, to avoid sediments.

8.2.6 Oil-spraying (or pressing), sterilization, sedimentation

8.2.6.1 The oil-spraying (or pressing) device shall be kept clean and hygienic, to prevent contamination by bacteria or foreign matter.

8.2.6.2 If heating sterilization is used, it shall control the sterilization temperature, time or flow rate, to ensure the sterilization effect.

8.2.6.3 Sterilization equipment shall be cleaned regularly and cleaned as necessary. Storage tanks, salt washing pools (or salt dissolving pools), salt water tanks (pools), oil-spraying tanks shall be cleaned in time and kept clean.

8.2.6.4 Soy sauce after sterilization (or disinfection) shall be injected into a sedimentation tank for sedimentation. Take the supernatant for filling operation.

8.2.7 Blending

The blending container shall be cleaned and disinfected according to relevant requirements and kept clean.

8.2.8 Filling

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