

Establishment Inspection Report

Blue Bell Creameries, LP
Broken Arrow, OK 74014-2900

FEI: 1000118167
EI Start: 03/30/2011
EI End: 03/30/2011

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SUMMARY

This inspection of a large ice cream manufacturer was conducted under DAL-DO FY11 work plans, FACTS assignment # 1221410, and CPs 7303.803, 7304.803, and 7309.803 Domestic Food Safety Program Inspections.

The previous inspection of this firm 7/24/09 by the State Oklahoma Department of Agriculture, Food and Forestry was classified NAI.

The current inspection revealed the firm continues to manufacture a variety of ice cream and sherbet products, but has discontinued manufacturing ice cream novelties. FDA 483, Inspectional Observations, was not issued. The only objectionable condition observed was no soap at the hand sink in the (b) (4) room. All product in this area is enclosed.

There were no refusals. No samples were collected.

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ADMINISTRATIVE DATA

Inspected firm: Blue Bell Creameries, LP
Location: 8201 E Highway 51
Broken Arrow, OK 74014-2900
Phone: 918-258-5100
FAX:
Mailing address: 8201 E Hwy 51
Broken Arrow, OK 74014

Dates of inspection: 3/30/2011
Days in the facility: 1
Participants: Janice M. Hickok, Investigator

On 3/30/11, I showed my credentials and issued FDA 482, Notice of Inspection, to Mr. Marty L. Kilgore, General Manager.

HISTORY

The firm is a limited partnership with corporate offices located at 1101 S. Blue Bell Rd., Brenham, TX 77834. Current corporate officers are:

- Paul Kruse – President
- Greg Bridges – Vice President of Operations

The firm’s office hours are 7 AM to 4:30 PM weekdays. The production hours are generally (b) (4) (b) (4). The firm (b) (4) milk on (b) (4) (b) (4).

FDA correspondence should be sent to Mr. Marty L. Kilgore, General Manager, Blue Bell Creameries, LP, 8201 E. Hwy 51, Broken Arrow, OK 74014.

INTERSTATE COMMERCE

This firm is one of three manufacturing plants operated by Blue Bell Creameries. The firm receives raw milk from (b) (4). This milk is produced in (b) (4). All dry ingredients and finished novelty items are received from the corporate headquarters in Brenham, TX.

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The firm distributes (b) (4)% of finished products to Blue Bell Creameries distribution warehouses in the following cities:

(b) (4)

Approximately (b) (4)% of product manufactured at this location is distributed locally in an approximately (b) (4) mile radius of (b) (4). (b) (4) and (b) (4) are the two cities furthest from (b) (4) that are included in local distribution. The firm also distributes novelty items locally that are manufactured in Brenham, TX.

JURISDICTION

The firm manufactures ice cream and sherbet under the Blue Bell Creameries label. **Exhibit 1** contains labels for products being manufactured during the inspection.

INDIVIDUAL RESPONSIBILITY AND PERSONS INTERVIEWED

Upon entering the firm, I showed my credentials and issued FDA 482, Notice of Inspection, to Mr. **Marty L. Kilgore**, General Manager. Mr. Kilgore accompanied me on the inspection and provided most of the information for this report. Mr. Kilgore is the most responsible person at this location. Mr. Kilgore reports to Mr. **Greg Bridges**, Vice President of Operations at the corporate headquarters in Brenham, TX.

Mr. **Jeff Martin**, Processing/Quality Control Manager, also accompanied me on the inspection and provided information for this report. Mr. Martin reports to Mr. Mary Kilgore, General Manager.

FIRM'S TRAINING PROGRAM

(b) (4) the firm trains all employees on food defense in a (b) (4) class. This class covers GMPs, allergens, HACCP, and chemical safety. All new hires are trained by their department on their specific duties.

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MANUFACTURING/DESIGN OPERATIONS

The firm receives raw milk from (b) (4). This milk is produced primarily in (b) (4). The firm receives some cream from (b) (4) in (b) (4). The incoming milk is tested for (b) (4). All dry products such as sugar and cocoa powder are received from the Brenham, TX plant. The firm maintains about a (b) (4) supply of raw ingredients at this location.

The incoming raw milk is placed into one of (b) (4) gallon silos. The raw milk is used within (b) (4) and the silos are cleaned every (b) (4). Some of the raw milk is (b) (4) before use. Milk is (b) (4) on (b) (4). The seals on the (b) (4) and (b) (4) were examined and were intact. Even though the (b) (4) milk is pasteurized, the firm considers (b) (4) milk to be (b) (4) and it will (b) (4) before being used in ice cream. (b) (4) milk then (b) (4).

In the blend room, all ingredients for the ice cream (b) (4) and add-ins such as chocolate chips and nuts are placed into a batch. Dry ingredients are blended and added to the batch tank along with raw milk and (b) (4) milk. The mix is placed into batch tank (b) (4) until a batch is completed. The batch tank has an (b) (4) to keep the product blended until it is (b) (4).

At the pasteurizer, the product is (b) (4) and (b) (4) a (b) (4) for high temperature short time pasteurization. After pasteurization, the product is cooled and stored in holding tanks in the basement of the firm until needed for freezing and packaging. The product is usually (b) (4) in one of (b) (4) stainless steel holding tanks and is (b) (4) before further processing. The pasteurizer seals on the thermometer, control panel, (b) (4), pump, etc. were examined and all were intact.

The firm's Quality control lab conducts tests on the pasteurized mix. Tests include (b) (4) homogenization, (b) (4), plate counts, and (b) (4) counts.

In the production area, the pasteurized mix is pumped from the basement into one of (b) (4) gallon mix tanks. The firm can manufacture (b) (4) different types of ice cream at one time. In the mix tank, the colors and flavors are added. It takes about (b) (4) minutes to (b) (4), depending upon the size of container in which the product is packaged. The mix goes to a freezer that (b) (4) (b) (4) from about (b) (4) to about (b) (4). The frozen mix then goes to the filler where it placed into cartons. Depending upon the flavor of product being produced, fruits, nuts, marshmallows, cookies, etc. may be added to the product before it is packaged. Depending upon the size of container being produced, (b) (4) feed into (b) (4). If the firm is making 3 oz. cups of ice cream, (b) (4) is used (b) (4), but (b) (4) are used (b) (4) if the firm is making ½ gallons of ice cream.

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The firm has a color code system for labeling products containing allergens. The labels are added to the (b) (4) buckets and vats. The firm uses different colors of labels for products containing almonds, pecans, strawberries, etc. The firm also labels product for (b) (4) and (b) (4). The (b) (4) buckets collect product (b) (4). The (b) (4) buckets are taken to the firm's kitchen for processing before being (b) (4). The (b) (4) is run (b) (4). The (b) (4) is then added to batches of products containing the same type of allergen either (b) (4) or frozen for use at a later date. All (b) (4) is considered (b) (4) and is (b) (4) (b) (4).

The filled cartons are conveyed into a (b) (4) freezer with a (b) (4). The product is held until a core temperature of (b) (4) is reached. The frozen ice cream is conveyed to a palletizing system which uses (b) (4) robots to place product on the pallets. The completed pallets are shrink-wrapped and stored in the holding freezer. The holding freezer was (b) (4) during the inspection.

The firm has (b) (4) CIP systems for cleaning equipment. (b) (4) of the systems are used to clean equipment holding raw product and the (b) (4) system is used to clean equipment handling pasteurized product. Almost all equipment is cleaned in place except for a few items such as (b) (4). The cleaners and sanitizers used in the CIP systems are from (b) (4).

Pest control is supplied by (b) (4). (b) (4) treats the firm for rodents, insects, and any other pests.

The firm has third party audits performed by (b) (4)

MANUFACTURING CODES

The firm stamps the manufacturing code onto the cartons of ice cream. The code from the (b) (4) (b) (4) is removed from the carton and attached to the batch record for the product. From the batch record, the firm can determine the lot number of everything used in the product, including packaging.

An example of a batch record in use on the day of the inspection was:

03 30 13 O where:

03=month of March

30=day produced

13=(b) (4)

O=operation producing the product as well as Broken Arrow plant

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The possible letters that can be used in the code are Q,R,S,T,O, and P. If the letter is a (b) (4), it indicates that the product (b) (4). If the firm (b) (4) the (b) (4) and the (b) (4). If the firm is (b) (4) on (b) (4) and (b) (4).

Blue Bell Creameries plant in Brenham, TX uses the letters A through G and the Sylacauga, AL plant uses the letters U-Z for coding product.

COMPLAINTS

All customer complaints are received at the corporate headquarters in Brenham, TX. The corporate headquarters sends a customer concern alert to the plant in Broken Arrow. The Broken Arrow plant does an investigation into the cause of the complaint.

RECALL PROCEDURES

The firm has a recall procedure and can recall products by the lot number of the raw ingredient. The firm's corporate office would be involved in any recall since most of the firm's products go to Blue Bell distribution centers, but the local firm has responsibilities in case of a recall.

REFUSALS

There were no refusals.

GENERAL DISCUSSION WITH MANAGEMENT

At the conclusion of the inspection, FDA 483, Inspectional Observations, was not issued. The only objectionable condition observed during the inspection was no soap at the hand sink in the (b) (4) area of the firm. Management promised to correct this observation. The product in the (b) (4) area of the firm is enclosed. During the inspection, I gave Mr. Kilgore a copy of the "Reportable Food Registry (RFR): At a Glance" information sheet.

SAMPLES COLLECTED

No samples were collected.

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EXHIBITS COLLECTED

Exhibit 1 Labels (7 pages)



Janice M. Hickok, Investigator