



**FIRM INFORMATION AND FIRM HISTORY:**

This firm is a MN based corporation established in 1899 and incorporated in: MN

Officers are as follows:

President Ernie Norton

Vice President Mike Chamberlain

Secretary Art Hoffman

Treasurer Art Hoffman

This firm is not a Corporation but is a sole proprietorship or partnership and the owner(s) are: NA

The seasons and hours of operation of this firm are: Continuous

**INDIVIDUALS RESPONSIBLE FOR SPECIFIC AREAS ARE AS FOLLOWS:**

Sanitation: Neil Grummons

Formulation: According to Customer Specifications

Labeling: Donny Schreiber

Quality Control: Neil Grummons

Capital Improvements: Dallas Moe

**MOST RESPONSIBLE PERSON (POINT OF CONTACT PERSON) for this firm at this site:**

Name Dallas Moe

Title Manager

Telephone Number 507-534-3872

Fax Number 507-534-3992

Email address dmoe@plainviewmilk.com

**INTERSTATE COMMERCE:**

This firm produces cream and sells it to (b) (4)

This firm purchases non-fat dry milk from (b) (4)

This firm purchases lactose from (b) (4)

The percent of sales that are interstate are (b) (4) %

The percent of sales that are wholesale are (b) (4) %

This firm employs (b) (4) employees at this site.

This firm operates under the following ALIAS NAMES or DBA Names. None

GROSS SALES of this firm are (b) (4)

**CURRENT INSPECTION RESULTS FROM THIS INSPECTION:**

Provide a description of the firm's process for the product being inspected, include a flow chart. See attachment.

Provide a complete breakdown of the firm's coding system for food products. See attachment.

Is this firm required to have HACCP plan and/or a HACCP trained individual? NO

Does this firm have a HACCP Plan? YES

CCP's for the HACCP plan are as follows: See attachment

HACCP plan monitoring records were reviewed for the following CCP's: pasteurization charts

In accordance with the BT Act, does this firm have a recall procedure in place? YES

If yes, when was the last mock recall conducted? 5-2-08

**NLEA STATUS AND LABEL REVIEW**

This firm's labels that were examined appear to be in compliance with the NLEA. Butter label is in compliance

Are this firm's labels exempt from NLEA? no.

Were any label violations noted during the inspection and if so, what were they No

**QA SYSTEM EVALUATION should include but be not be limited to the review of the following:**

Does this firm require certificates of purity from suppliers? YES

Does this firm conduct in line testing such as swabs? YES

Water source for this firm: Private Well

List the date of the last well water sample if water source(s) is a private well or non-community well. 3-11-09

If the firm conducts finished product testing, what do they test for? (b) (4)

(b) (4)

Does the firm have a boiler that produces steam that will contact food? YES

If yes, are the boiler water additives approved for food contact per CFR 173.310? YES

**EMPLOYEE HEALTH:**

How does firm ensure that any food employee displaying symptoms or is diagnosed with a food borne illness, or has open lesions, is excluded from working with exposed food or clean equipment and utensils? Employees do not work if they are ill.

What training is provided to personnel to ensure that employees are instructed to report such health conditions to their supervisors? GMP and food-safety training, at least annually

**IMPORTED FOODS ADDENDUM**

The Imported Foods Addendum was completed and is attached.

**FOOD ADDITIVES AND COLORINGS:**

The use of food additives and colorings were reviewed the following results None used

**DISCUSSION WITH MANAGEMENT:**

The results of this inspection were discussed with Donny Schreiber and Dallas Moe. Minor objectional conditions noted: 1. Empty bags need to be covered. 2. The socks, gaskets, inspection plugs and leaking agitator seal that need replacing, will be corrected immediately. The areas of the plant that need floor repair will be addressed as per routine maintenance schedule. The areas of plant that need cleaning will be addressed during weekly and monthly scheduled cleaning. The old evaporator has not been run since installing the new divert valves and the leak detect valve will be installed correctly before running product through this unit. Toilet room repairs and other maintenance items will be scheduled for repair. Please refer to the attached MDA plant inspection report for detail on the violations. All violations found will be corrected as per schedule listed and/or before the next regular quarterly inspection of the facility.

**This inspection identified only minor objectional conditions and all repairs, cleaning, and corrections will be made immediately or as soon as possible. (b) (5)**

**ATTACHMENTS:** MDA Inspection Report, Flow Chart, CCP's and Coding System

## FDA Contract Information 2008

FDA 2005 Inspection/Investigation Manual: [http://www.fda.gov/ora/inspect\\_ref/iom/Contents/ch5\\_TOC.html](http://www.fda.gov/ora/inspect_ref/iom/Contents/ch5_TOC.html)

Nutritional Labeling Information: [http://www.fda.gov/ora/inspect\\_ref/igs/nleatxt.html](http://www.fda.gov/ora/inspect_ref/igs/nleatxt.html)

FDA Labeling Exemption Form/Instructions: <http://vm.cfsan.fda.gov/~dms/sbelform.html>

Food Facility Registration/Instructions: <http://www.cfsan.fda.gov/~furl/ovffreg.html>

The Bioterrorism Act of 2002: <http://www.fda.gov/oc/bioterrorism/bioact.html>

Food Defense and Terrorism-ALERT: The Basics: <http://www.cfsan.fda.gov/~dms/alert.html>

Control of *Listeria monocytogenes* in Refrigerated or Frozen Ready-To-Eat Foods:

<http://www.cfsan.fda.gov/~dms/lmrtegui.html>

Code Builder: <http://www.accessdata.fda.gov/scripts/ora/pcb/pch.cfm>



**MINNESOTA DEPARTMENT OF AGRICULTURE**  
DAIRY AND FOOD INSPECTION

**MILK PLANT INSPECTION REPORT**

(Includes Dry Milk/Condensing Plants, Receiving Stations, Transfer Stations, and Milk Tank Truck Cleaning Facilities)

INSPECTING AGENCY:

Minnesota Department of Agriculture  
Dairy & Food Inspection Division  
625 Robert Street N.  
St. Paul, MN 55155 651-201-6027

NAME AND LOCATION OF PLANT

**Plainview Milk Products 130 2<sup>nd</sup> St. SW Plainview, MN 55964**

POUNDS SOLD DAILY

Milk \_\_\_\_\_  
Other Milk Products \_\_\_\_\_  
Total \_\_\_\_\_  
**27-556-C**  
Permit No. **Grade A Cream**

Inspection of your plant today showed violations existing in the items checked below. You are further notified that this inspection report serves as notification of the intent to suspend your permit if the violations noted are not in compliance at the time of the next inspection. (Refer to Sections 3 and 5 of the *Grade "A" Pasteurized Milk Ordinance*.)

**1. FLOORS:**

Smooth; impervious; no pools; good repair; trapped drains.....(a)

**2. WALLS AND CEILINGS:**

Smooth; washable; light-colored; good repair.....(a)

**3. DOORS AND WINDOWS:**

All outer openings effectively protected against entry of flies and rodents.....(a)

Outer doors self-closing; screen doors open outward.....(b)

**4. LIGHTING AND VENTILATION:**

Adequate light in all rooms.....(a)

Well ventilated to preclude odors and condensation; filtered air with pressure systems.....(b)

**5. SEPARATE ROOMS:**

Separate rooms as required; adequate size.....(a)

No direct opening to barn or living quarters.....(b)

Storage tanks properly vented.....(c)

**6. TOILET FACILITIES:**

Complies with local Ordinances.....(a)

No direct opening to processing rooms; self-closing doors.....(b)

Clean; well-lighted and ventilated; proper facilities.....(c)

Sewage and other liquid wastes disposed of in sanitary manner.....(d)

**7. WATER SUPPLY:**

Constructed and operated in accordance with Ordinance.....(a)

No direct or indirect connection between safe and unsafe water.....(b)

Condensing water and vacuum water in compliance with Ordinance requirements.....(c)

Reclaim water complies with Ordinance.....(d)

Complies with bacteriological standards.....(e)

**8. HANDWASHING FACILITIES:**

Located and equipped as required; clean and in good repair; improper facilities not used.....(a)

**9. MILK PLANT CLEANLINESS:**

Neat; clean; no evidence of insects or rodents; trash properly handled.....(a)

No unnecessary equipment.....(b)

No excessive product dust.....(c)

**10. SANITARY PIPING:**

Smooth; impervious, corrosion-resistant, non-toxic, easily cleanable materials; good repair; accessible for inspection.....(a)

CIP cleaned lines meet Ordinance specifications.....(b)

Pasteurized products conducted in sanitary piping, except as permitted by Ordinance.....(c)

**11. CONSTRUCTION AND REPAIR OF CONTAINERS AND EQUIPMENT:**

Smooth, impervious, corrosion-resistant, non-toxic, easily cleanable materials; good repair, accessible for inspection.....(a)

Self-draining; strainers and sifters of approved design.....(b)

Approved single-service articles; not reused.....(c)

**12. CLEANING AND SANITIZING OF CONTAINERS AND EQUIPMENT:**

Containers, utensils, and equipment effectively cleaned.....(a)

CIP cleaning requirements of Ordinance in compliance; records complete; milk tank trucks cleaned at permitted location.....(b)

Approved sanitization process applied prior to use of product-contact surfaces.....(c)

Required efficiency tests in compliance.....(d)

Multi-use plastic containers in compliance.....(e)

Aseptic system sterilized.....(f)

**13. STORAGE OF CLEANED CONTAINERS AND EQUIPMENT:**

Stored to assure drainage and protected from contamination... (a)

**14. STORAGE OF SINGLE-SERVICE ARTICLES:**

Received, stored and handled in a sanitary manner; paperboard containers not reused, except as permitted by the Ordinance (a)

**15a. PROTECTION FROM CONTAMINATION:**

Operations conducted and located so as to preclude contamination of milk, milk products, ingredients, containers, equipment, and utensils.....(a)

Air and steam used to process products in compliance with Ordinance.....(b)

Approved pesticides, safely used.....(c)

**15b. CROSS CONNECTIONS:**

No direct connections between pasteurized and raw milk or milk products.....(a)

Overflow, spilled and leaked products or ingredients discarded.....(b)

No direct connections between milk or milk products and cleaning and/or sanitizing solutions.....(c)

**16a. PASTEURIZATION-BATCH:**

(1) INDICATING AND RECORDING THERMOMETERS: Comply with Ordinance specifications.....(a)

(2) TIME AND TEMPERATURE CONTROLS: Adequate agitation throughout holding; agitator sufficiently submerged.....(a)

Each pasteurizer equipped with indicating and recording thermometer; bulb submerged.....(b)

Recording thermometer reads no higher than indicating thermometer.....(c)

Product held minimum pasteurization temperature continuously for 30 minutes, plus filling time if product preheated before entering vat, plus emptying time, if cooling is begun after opening outlet.....(d)

No product added after holding begun.....(e)

Airspace above product maintained at not less than 5°F (3°C) higher than minimum required pasteurization temperature during holding.....(f)

Approved airspace thermometer; bulb not less than 1 inch (25 mm) above product level.....(g)

Inlet and outlet valves and connections in compliance with Ordinance.....(h)

**16b. PASTEURIZATION-HIGH TEMPERATURE:**

(1) INDICATING AND RECORDING THERMOMETERS: Comply with Ordinance specifications.....(a)

(2) TIME AND TEMPERATURE CONTROLS: Flow-diversion device complies with Ordinance requirements.....(a)

Recorder controller complies with Ordinance requirements.....(b)

Holding tube complies with Ordinance requirements.....(c)

Flow promoting devices comply with Ordinance requirements.....(d)

Product held minimum pasteurization time and temperature.....(e)

(3) ADULTERATION CONTROLS: Satisfactory means to prevent adulteration with added water.....(a)

**16c. ASEPTIC PROCESSING SYSTEMS:**

(1) INDICATING AND RECORDING THERMOMETERS: Comply with Ordinance specifications.....(a)

(2) TIME AND TEMPERATURE CONTROLS: Flow-diversion device complies with Ordinance requirements.....(a)

Recorder controller complies with Ordinance requirements.....(b)

Holding tube complies with Ordinance requirements.....(c)

Flow promoting devices comply with Ordinance requirements.....(d)

**(3) ADULTERATION CONTROLS:**

Satisfactory means to prevent adulteration with added water... (a)

**16d. REGENERATIVE HEATING:**

Pasteurized or aseptic product in regenerator automatically under greater pressure than raw product in regenerator at all times.....(a)

Accurate pressure gauges installed as required; booster pump properly identified, when required, and installed.....(b)

Regenerator pressures meet Ordinance requirements.....(c)

**16e. RECORDING CHARTS:**

Batch pasteurizer charts comply with applicable Ordinance requirements.....(a)

HTST and HST pasteurizer charts comply with applicable Ordinance requirements.....(b)

Aseptic charts comply with applicable Ordinance requirements.....(c)

**17. COOLING OF MILK AND MILK PRODUCTS:**

Raw milk maintained at 45°F (7°C) or less until processed or as provided for in the Ordinance.....(a)

Pasteurized milk and milk products, except those to be cultured, or as provided for in the Ordinance, cooled immediately to 45°F (7°C) or less in approved equipment; all milk and milk products stored thereat until delivered.....(b)

Approved thermometer properly located in all refrigeration rooms and storage tanks as required.....(c)

Recirculated cooling water from a safe source and properly protected; complies with bacteriological standards.....(d)

**18. BOTTLING, PACKAGING AND CONTAINER FILLING:**

Performed in a plant where contents finally pasteurized, except for dry milk and whey products.....(a)

Performed in a sanitary manner by approved mechanical equipment.....(b)

Aseptic filling in compliance.....(c)

Dry milk and whey products packaged in new containers; stored and transported in a sanitary manner.....(d)

**19. CAPPING, CONTAINER CLOSURE AND SEALING:**

Capping and/or closing/sealing performed in a sanitary manner by approved mechanical equipment.....(a)

Imperfectly capped/closed products properly handled.....(b)

Caps and/or closures comply with Ordinance.....(c)

**20. PERSONNEL CLEANLINESS:**

Hands thoroughly washed before performing plant functions; rewashed when contaminated.....(a)

Clean outer garments and hair covering worn.....(b)

No use of tobacco in processing areas.....(c)

Clean boot covers, caps and coveralls worn when entering dryer.....(d)

**21. VEHICLES:**

Vehicles clean; constructed to protect milk.....(a)

No contaminating substances transported.....(b)

**22. SURROUNDINGS:**

Neat and clean; free of pooled water, harborages, and breeding areas.....(a)

Tank unloading areas properly constructed.....(b)

Approved pesticides, used properly.....(c)

REMARKS

See attached report

DATE:  
4/20/2009

POC SIGNATURE:

POINT OF CONTACT (PRINT): Dallas Moe

SIGNATURE:

SANITARIAN (PRINT): Sarah Mellgren

1. A receiving station shall comply with items 1 to 15, inclusive, and 17, 20, and 22. Separation requirements of item 5 do not apply.
2. A transfer station shall comply with items 1, 4, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 20, 22 and as climatic and operating conditions require, applicable provisions of items 2 and 3. In every case, overhead protection shall be required.
3. Facilities for the cleaning and sanitizing of milk tank trucks shall comply with the same requirements for transfer stations.



**MINNESOTA DEPARTMENT OF AGRICULTURE**  
DAIRY AND FOOD INSPECTION

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625 Robert Street N.  
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NAME AND LOCATION OF PLANT

Plainview Milk Products 130 2<sup>nd</sup> St. SW Plainview MN 55964

POUNDS SOLD DAILY

Milk \_\_\_\_\_

Other Milk Products \_\_\_\_\_

Total \_\_\_\_\_

Permit No. 27-556 Grade A DMO

Inspection of your plant today showed violations existing in the items checked below. You are further notified that this inspection report serves as notification of the intent to suspend your permit if the violations noted are not in compliance at the time of the next inspection. (Refer to Sections 3 and 5 of the Grade "A" Pasteurized Milk Ordinance.)

**1. FLOORS:**

Smooth, impervious; no pools; good repair; trapped drains.....(a)

**2. WALLS AND CEILINGS:**

Smooth; washable; light-colored; good repair.....(a)

**3. DOORS AND WINDOWS:**

All outer openings effectively protected against entry of flies and rodents.....(a)

Outer doors self-closing; screen doors open outward.....(b)

**4. LIGHTING AND VENTILATION:**

Adequate light in all rooms.....(a)

Well ventilated to preclude odors and condensation; filtered air with pressure systems.....(b)

**5. SEPARATE ROOMS:**

Separate rooms as required; adequate size.....(a)

No direct opening to barn or living quarters.....(b)

Storage tanks properly vented.....(c)

**6. TOILET FACILITIES:**

Complies with local Ordinances.....(a)

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Clean; well-lighted and ventilated; proper facilities.....(c)

Sewage and other liquid wastes disposed of in sanitary manner.....(d)

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No unnecessary equipment.....(b)

No excessive product dust.....(c)

**10. SANITARY PIPING:**

Smooth; impervious, corrosion-resistant, non-toxic, easily cleanable materials; good repair; accessible for inspection.....(a)

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Pasteurized products conducted in sanitary piping, except as permitted by Ordinance.....(c)

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Recorder controller complies with Ordinance requirements.....(b)

Holding tube complies with Ordinance requirements.....(c)

Flow promoting devices comply with Ordinance requirements.....(d)

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**REMARKS**

See attachment

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4/20/2009

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POINT OF CONTACT (PRINT): Dallas Moe

SIGNATURE:

SANITARIAN (PRINT): Sarah Mellgren

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3. Facilities for the cleaning and sanitizing of milk tank trucks shall comply with the same requirements for transfer stations.

NOTE - Item numbers correspond to required sanitation items for Grade "A" pasteurized milk in the Grade "A" Pasteurized Milk Ordinance.

# Inspection Report

Page 1 of 1



MINNESOTA DEPARTMENT  
OF AGRICULTURE  
DAIRY AND FOOD INSPECTION  
(651)201-6027

DATE: 4/20/09

FIRM NAME: Plainview Milk Products

MANAGER/OWNER: Dallas Moe

ADDRESS: 130 2<sup>nd</sup> St. SW Plainview, MN 55964

COUNTY: Wabasha

TYPE OF ESTABLISHMENT INSPECTED: Cream

License Verified: yes

## COMMENTS AND ORDERS:

### 2A: Walls

1. Clean and paint ceiling in seperator room. Black mold on ceiling.

### 5A: Separate Rooms

1. Louver is missing on the exhaust fan in the seperator room.

### 6C: Toilet Facilities

1. Repair the floor and vanity in the men's lockerroom by the urinals.

### 9A: Milk Plant Cleanliness

1. Clean tops of piping and control boxes in the seperator room

### 11A: Construction of Equipment

1. Repair leaking agitator seal on Silo 11 agitator.

### Remarks:

1. Install a window in the electrical control box for the timing pump. This will enable the box to be properly sealed and still allow employees to view the digital readout.

DATE: 4/20/09

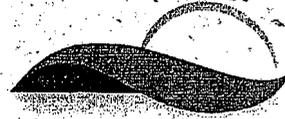
COPY OF THIS REPORT RECEIVED BY AND EXPLAINED TO:

\_\_\_\_\_  
SIGNATURE, TITLE Dallas Moe

\_\_\_\_\_  
INSPECTOR: Sarah Mellgren

# Inspection Report

Page 1 of 2



MINNESOTA DEPARTMENT  
OF AGRICULTURE  
DAIRY AND FOOD INSPECTION  
(651)201-6027

DATE: 4/20/09

FIRM NAME: Plainview Milk Products

MANAGER/OWNER: Dallas Moe

ADDRESS: 130 2<sup>nd</sup> St SW Plainview MN 55964

COUNTY: Wabasha

TYPE OF ESTABLISHMENT INSPECTED: DMO

License Verified: yes

## COMMENTS AND ORDERS:

### 1A: Floors

1. Patch the pitted floor in the downstairs instantizer room.
2. Floor repair and grouting needed on the floor between the new evaporator room and the box dryer.

### 6C: Toilet Facilities

1. Repair the floor and vanity in the men's lockerroom near the urinals.

### 9A: Milk Plant Cleanliness

1. Continue to scrape peeling paint from beams and railings around dryer and instantizer.
2. Clean dried on powder from fan motor on instantizer and also from beams.
3. Clean and organize electrical control room/parts room adjacent to old evaporator.
4. Sweep down powder from top of dryer and control boxes in between wet washes.
5. Clean decking by cyclone above dryer bagger. Peeling paint and powder noted here and by box dryer.
6. Clean exhaust fan in room at the top of the new evaporator.
7. Clean exterior of holding tube and divert lines on new evaporator. Leaked product on piping.

### 11A: Construction and Repair of Equipment

1. Replace the socks on top of the bagger and sifter in the blending area. Socks had holes.
2. Replace the torn gaskets on the piping in heater room downstairs on instantizer.
3. Replace the old and cracked inspection plugs on sight glasses on dryer.

### 12A: Cleaning of Equipment

1. Remove and clean exhaust pipe on blending bag dump hopper.

### 15A: Protection from Contamination

1. Cover pallets of empty bags in the warehouse areas.

# Inspection Report

Page 2 of 2



MINNESOTA DEPARTMENT  
OF AGRICULTURE  
DAIRY AND FOOD INSPECTION  
(651)201-6027

## 16b(2)a: Time and Temperature Controls

1. Leak detect valve on old evaporator HTST is not installed properly. Please install correctly prior to running product on this unit.

## Remarks:

1. All bags of animal feed must be labeled. Place label on bags prior to filling.
2. Fill hand sanitizer in blending bag dump area.
3. Remove tape from Y spout in blending area.
4. Ceiling in hallway by dryer bagger needs repair in one area.
5. Cap tubes of petro gel and CIP lube.

Thank you for your assistance and continued cooperation.

**DATE: 4/20/09**

**COPY OF THIS REPORT RECEIVED BY AND EXPLAINED TO:**

\_\_\_\_\_  
SIGNATURE, TITLE Dallas Moe

A handwritten signature in cursive script that reads "Sarah Mellgren".

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INSPECTOR: Sarah Mellgren