

**Establishment Inspection Report**

Plainview Milk Prod Assn  
Plainview, MN 55964-1314

FEI: **2117605**  
EI Start: 06/02/2004  
EI End: 06/04/2004

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**SUMMARY**

The inspection of this dairy plant was conducted under Minneapolis District Office FY'04 workplans. The firm manufactures both Grade A and non-Grade A dairy products. The Grade A product manufactured is instantized non-fat dry milk. The non-grade A products manufactured by the firm are cream, condensed skim milk, buttermilk, butter and non-fat dry milk, buttermilk powder, and agglomerated whey protein concentrate.

The previous inspection conducted by FDA in conjunction with an IMS for check rating also covered a non-Grade portion of the plant. That inspection conducted on 3/26/02 was classified VAI. A four item FDA-483, Inspectional observation was issued for faulty design of cream High Temperature Short Time (HTST) pasteurizer and disrepair of a window screen in a processing room. All of those items were verified to be corrected at this time.

Current inspection covered the receiving of raw material (raw milk), processing and storage and distribution of finished products. No FDA-483, Inspectional Observation was issued as result of this inspection. However the following the sanitation deficiencies were verbally discussed with the management at the close of the inspection.

1. Chipping paint on the ceiling on the west corner of the ceiling in the separator room.
2. Minor rodent activity was reported on the [REDACTED] pest control log in the last three months.
3. Creamer HTST Pasteurization chart was blotted with red ink, it was difficult to read.

The firm's management promised to correct the problems.

The sample of non-fat buttermilk powder, **Sample # 276413**, was collected and sent to ARL lab to be analyzed for micro.

**ADMINISTRATIVE DATA**

Inspected firm: Plainview Milk Prod Assn  
Location: 130 2nd St Sw  
Plainview, MN 55964-1314  
Phone: 507534-2328  
FAX:  
Mailing address: 130 2nd St Sw  
Plainview, MN 55964-1314

Dates of inspection: 6/2/2004, 6/3/2004, 6/4/2004

Days in the facility: 3

Participants: Mohammed H Adam, Investigator

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### HISTORY

Plainview Milk Producers Association is a cooperative with dairy producers as members. It is a Minnesota Cooperative incorporated in 1899. The Cooperative is managed by seven members of the board. There is no other cooperative related to this firm.

The chairman of the board is Mr. Marlain Timm.

Key Management personnel are:

Dallas Moe, General Manager

Donny Schreiber, Plant Manager

Departmental Supervisors: Neil Grummonz; Brain Boland; and Robert Hofer

Jenna Van Roughen, Office manager

██████████, Secretary

### INTERSTATE COMMERCE:

Some of firm's interstate customers include ██████████

██████████.

### INDIVIDUAL RESPONSIBILITY & PERSONS INTERVIEWED

Upon arriving to the firm, I displayed my credentials and issued a notice of inspection to Dallas V. Moe, General Manager. Mr. Moe is the most responsible person at the firm on a daily basis. Donny Schreiber, Plant Manager joined us with the request of Mr. Moe. Both Messrs Moe and Schreiber provided the information and documents contained in this report. Mr. Schreiber accompanied me during the physical inspection of the plant.

### OPERATIONS, PERSONNEL, AND EQUIPMENT

#### Summary of products produced/products handled and usual production season(s)

(mark products inspected):

The firm manufactures one Grade A dairy product and several non-Grade A products. Three different varieties of dried milk currently produced by the firm are: low-heat, non fat dry milk; High-heat, non-fat dry milk and Grade Instant non-fat dry milk. The facility spray dries non-fat dry milk and produces a limited amount of butter to be sold to its patrons. The schematic diagram of instantizer area and the dryer operation is attached to this report as **Exhibit # 1**.

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**CONSUMER COMPLAINTS & RECALL PROCEDURE**

No consumer complaint was reported to the firm or found in MIN-DO file jacket. The firm does not have consumer complaint file. The plant manager said that no illness or injury was reported regarding firm's product.

**QA System Evaluation:**

Raw Milk Testing ( [REDACTED] etc.):

Each load of raw milk is tested for [REDACTED] by an in-house lab [REDACTED] is also done by the firm's lab. The firm uses [REDACTED] for [REDACTED] testing of raw material.

In-Line Testing (swabs, environmentals, etc):

Firm does an environmental swab of food contact surfaces of major equipment, drums, under pumps & drains in the production area. About [REDACTED] samples of swabs are collected from these areas and sent to [REDACTED]. The samples are tested for [REDACTED]. No positive results were found since last inspection.

Finished Product Testing ( [REDACTED], etc):

Finished products are tested for [REDACTED] by the in-house Lab. Samples of finished products are collected by MN Department of Agriculture on a regular basis.

Pest. Control:

The firm is contracted with [REDACTED] for pest control. [REDACTED] monitors the facility every two weeks. The review of the pest control log filled by [REDACTED] representative indicated that the facility had light rodent activity around the break room and the gate next to the dumpster, particularly in trap # 9 and 6.

Water Tests: (Last test?)(All wells used tested?)

Firm uses its own well as source of water for processing and cleaning. MN. Department of Agriculture samples the well water on annual basis. The copy of the current water sample test result is attached to this report as **Exhibit # 2.**

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**Boiler Water Additives? (What/Live Steam?/FDA approved?)**

The firm receives boiler additives from (b) (4). The firm has a letter on file that indicates all chemicals used by the firm, including boiler additives are approved for food manufacturing facilities per CFR.

**HTST Timing/Sealing:**

Date:	Seals Intact?	In- Temp.	Out- Temp.	FF:(Time)	DF: (Time)
12/10/03 Pasteur. # 1	YES	██████ ° F	██████ ° F	██████	-----

**Daily Past. Record recordings:**

- Type/Amt. Product Past: -----Ok ( x) Deficient ( ) (Explain below :)
- Duration/temp. Of Past. Run: -----Ok (x) Deficient ( ) (Explain below :)
- Lot codes indent. /each past. Run: -----Ok (x) Deficient ( ) (Explain below :)
- Name/Individual Resp.:-----Ok (x) Deficient ( ) (Explain below :)
- Temp.Rec.Chart w/in 1/2 deg. /Indic. Therm: ----Ok (x) Deficient ( ) (Explain below :)
- Cut-In/Cut out Temps. Recorded: -----Ok (x) Deficient ( ) (Explain below :)

**Explanations:**

Several pasteurization charts were blotted with red ink and was difficult to read.

**Operations/Improvements**

**Milk Receiving:**

Milk is received from approx. █████ patrons located within █████ miles radius of Plainview, MN.  
About █████ % of the milk volume is received in Grade A.

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**Raw Product Storage:**

Milk is received in an enclosed receiving bay and stored in one of (b) (4) vertical silos. Capacity of the silos range from (b) (4) gallons.

Starter Procedure (frozen/own make-up): N/A

Filters (Raw Product/in-line, change interval, etc.): The facility has (b) (4) filter before the separator. The filter is changed every before the runs.

**Temperatures Observed:**

Raw Milk Storage	Whey Cream	Brining/Curing	Finished Product	Other:
Silo # 8 = (b) (4) ° F	N/A	N/A	(b) (4) ° F	
Silo # 6 = (b) (4) ° F				
Silo #9 = (b) (4) ° F				
Silo #7 = (b) (4) °				
Silo #11 = (b) (4) °				
Silo #12				
Skim milk silo				
Empty				

**Comparison of Indicating Therm. vs. Recorder Charts:**

Indicating Therm.		Recording Chart.	Was not running
Indicating Therm.		Recording Chart.	

**Packaging/Labeling Operations:**

The firm uses preprinted 50 lb paper bags with flexible plastic liner for packing spray dried non-fat milk. The packages are sewed with the machine after filling the bags. The paper bags are stamped with the lot # and manufacturing date.

**Finished Product Storage (facilities):**

The firm has non-refrigerated rooms for storage of finished products. A new storage area was added within the last two years. The storage condition of the finished product was adequate.



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**Samples Collected:**

Sample of Non Grade-A butter milk powder, Spl. # 276413 was collected and sent to Arkansas Lab For microbiological analysis.

**Detailed report of discussion with management :**( explanation of FDA 483 items/verbal recommendations & responses) (include names of people involved in exit interview):

At the end of the inspection, I had a brief exit meeting with Mr. Dallas V. Moe, General Manager of the firm. Mr. Donny Schreiber, Plant Manager was present during this meeting.

No FDA-483, Inspectional Observation was issued as result of this inspection. However the following the sanitation deficiencies were verbally discussed with the management at the close of the inspection.

1. Chipping paint on the ceiling on the west corner of the ceiling in the separator room.
2. Minor rodent activity was reported on the [REDACTED] pest control log in the last three months. However I did not any rodent problem during the walk through the facility.
3. Creamer HTST Pasteurization chart was blotted with red ink, it was sort of messy and hard to read.

The firm's management promised to correct the problems.

The sample of non-fat buttermilk powder, Sample # 276413, was collected and sent to Arkansas lab to be analyzed for micro.

**EXHIBITS:**

1. Copy of schematic diagram of instantizer area, 2 pages.
2. Copy of the record of water and cooling medium sample test result, one page.
3. Copy of Interstate shipping record (B/L), 3 pages.

**ATTACHMENTS:**

1. Form FDA-484, Receipt for Samples.
2. Form FDA-482, Notice for Inspection

  
Mohammed H. Adam

Investigator

Minneapolis District Office

HFR-CE850: 6/18/04: MHA