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PLANT NAME:	The Greater Knead	ISSUE DATE	12/01/19
ADDRESS:	1690 Winchester Rd, Bensalem, PA 19020	SUPERSEDES	05/17/19

Food Safety Plan for Brownies and Blondies

Developed by: Mengyi Hu PCQI

Created Date: 09/12/18

Approved by: Michelle Carfagno

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Company Overview

The Greater Knead is a top 8 allergen free and gluten-free baked products manufacturer.

[Site Map](#)

Our food safety team consists of:

Michelle Carfagno - CEO - Team Lead

Mengyi Hu - Food Technologist - PCQI

Maxie Walsh - Account Manager

Bailey Brady - Quality Assurance Assistant

[Organizational Chart](#)

Product Description

Product Name

Brownies and Blondies

Product Description

The Brownies and Blondies currently have 4 flavor variations (Deep Chocolate Brownies, Chocolate Chunk Blondies, Birthday Cake Blondies and P’Nutter Chocolate Chip Blondies). They are manufactured by The Greater Knead for Rule Breaker Snacks. They are gluten-free and free from the top 8 common allergens, wheat, dairy, soy, egg, peanut, tree nut, fish, and shellfish. They are made with ingredients that are non-GMO and are all Kosher Parve, certified by Kof K Supervision.

The Brownies and Blondies are single serving snacks, round in shape, about 3” in diameter and 1” in height. Soft and moist texture, with chocolate / caramel / vanilla / peanut butter aroma and flavor depending on the flavor variation. There is another size variation that is 1” in diameter and ¼’ in height. The sensory elements remain the same.

Ingredients

- Deep Chocolate Brownie - Chickpea Flour, Palm Shortening, Chocolate (Unsweetened Chocolate; Organic Cane Sugar; Non-Dairy Cocoa Butter), Date Paste, Tapioca Syrup, Brown Rice Syrup, Arrowroot Flour, Unsweetened Cocoa, Tapioca Flour, Prebiotic Fiber, Vegetable Glycerin, Natural Flavor, Sea Salt, Baking Powder
- Chocolate Chunk Blondie - Chickpea Flour, Palm Shortening, Chocolate (Unsweetened Chocolate; Organic Cane Sugar; Non-Dairy Cocoa Butter), Date

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Paste, Tapioca Syrup, Brown Rice Syrup, Arrowroot Flour, Tapioca Flour, Prebiotic Fiber, Vegetable Glycerin, Natural Flavor, Sea Salt, Baking Powder

- Birthday Cake Blondie - Chickpea Flour, Palm Shortening, , White Chocolate (Sugar, Palm Kernel Oil, Natural Flavor, Sunflower Lecithin, Salt), Date Paste, Tapioca Syrup, Brown Rice Syrup, Arrowroot Flour, Tapioca Flour, Sprinkles (Sugar, Corn Starch, Palm Oil, Palm Kernel Oil, Sunflower Lecithin, Natural Vanilla Flavor, Spirulina for Color, Riboflavin for Color, Vegetable Juices for Color, Annatto for Color, Carnauba Wax), Prebiotic Fiber, Vegetable Glycerin, Natural Flavor, Sea Salt, Baking Powder
- P'Nutter Chocolate Chip Blondie - Chickpea Flour Blend (chickpeas, yellow peas), Palm Shortening, Date Paste, Tapioca Syrup, Brown Rice Syrup, Arrowroot Flour, Tapioca Flour, Chocolate (Unsweetened Chocolate; Organic Cane Sugar; Non-Dairy Cocoa Butter), Sunflower Seed Butter, White Chocolate (Sugar, Palm Kernel Oil, Natural Flavor, Sunflower Lecithin, Salt), Prebiotic Fiber, Vegetable Glycerin, Natural Flavor, Sea Salt, Baking Powder

Allergens

None

Packaging Used

Pre-printed plastic flow wrap films

Intended Use and Consumers

Consume direct from packaging. Consumer include general consumers and people who have dietary restrictions of the top 8 allergens.

Shelf Life

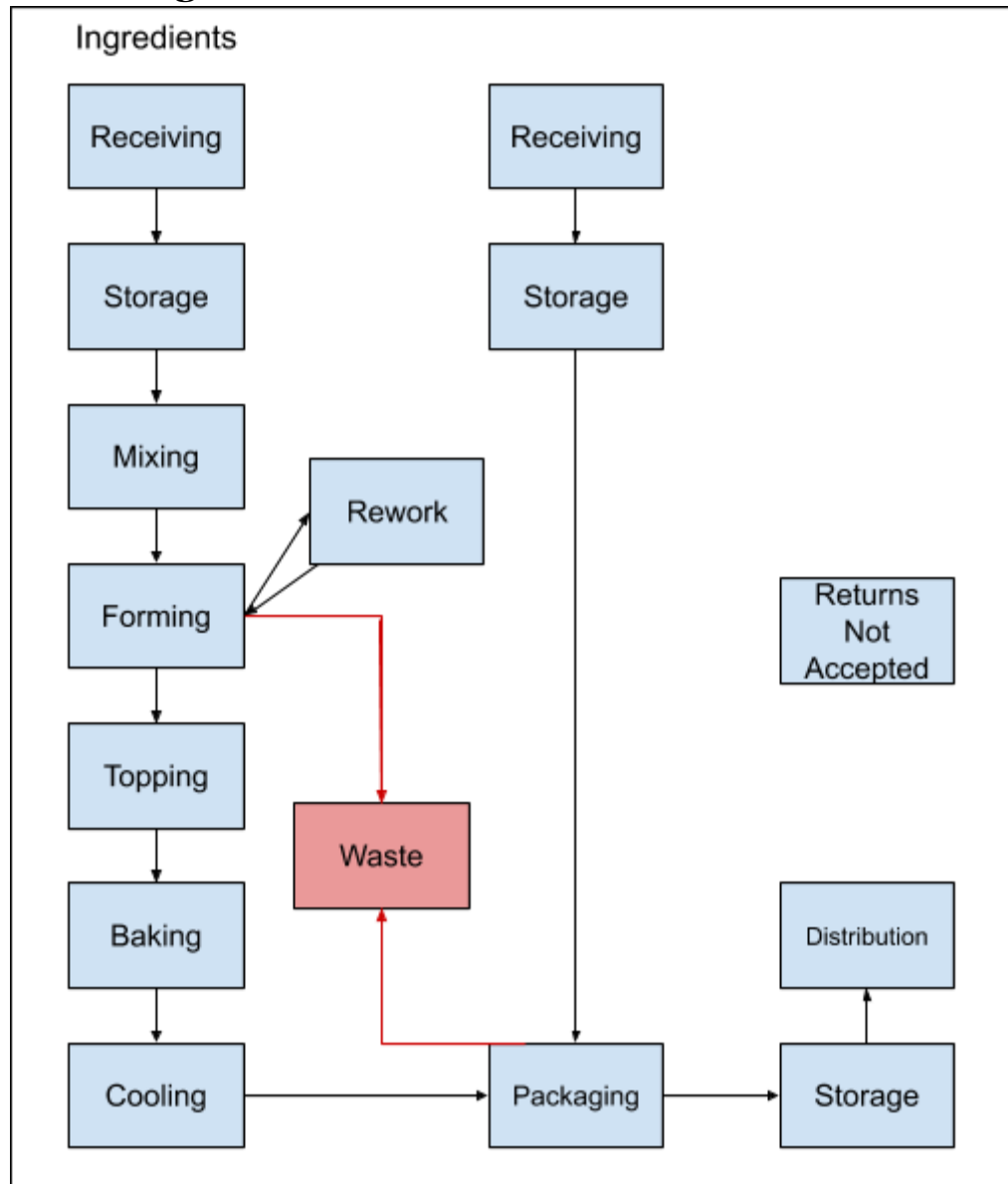
12 months in ambient storage

Storage and Distribution

The brownies and blondies are stored at room temperature, avoiding direct sunlight and heat.

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Flow Diagram



Outgoing

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Process Narrative

Receiving - Ingredients and packaging materials are received according to the [Receiving Policy](#) and recorded in the Receiving Log at the front desk.

Storage - Ingredients and packaging materials are stored according to recommendations in designated and labeled areas.

Mixing - Ingredients are weighed out individually and mixed in the mixer.

Forming - Dough is transferred to the Formatic and divided into chunks weighing from 58g to 62g. Chunks are put in trays lined with parchment paper. Waste is generated at this step and is discarded.

Rework - Dough that is collected but does not become waste is reworked into dough being formed.

Topping - This step is only applicable to Birthday Cake flavor. The chunks are manually dipped in sprinkles before being put on trays lined with parchment paper.

Baking - The pucks are baked at 350 °F for 12-13 minutes. The bites are baked at 275 °F for 11-12 minutes.

Cooling - Baked Brownies and Blondies are left to cool until they are hardened on the surface and cool enough for packaging.

Packaging - Brownies and Blondies are packaged into single serving pouches using a flow wrap machine. Waste is generated at this step and is discarded.

Room Temperature Storage - Finished products are boxed and stored at room temperature.

Returns - Returns are not accepted. We do not re-store returned product.

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Hazard Analysis

Hazard identification (column 2) considers known or reasonably foreseeable hazards (i.e., potential hazards) that may be present in the food because the hazard occurs naturally, the hazard may be unintentionally introduced, or the hazard may be intentionally introduced for economic gain.

B = Biological hazards including bacteria, viruses, parasites, and environmental pathogens

C = Chemical hazards, including radiological hazards, food allergens, substances such as pesticides and drug residues, natural toxins, decomposition, and unapproved food or color additives

P = Physical hazards include potentially harmful extraneous matter that may cause choking, injury or other adverse health effects

(1) Ingredient/ Processing Step	(2) Identify <u>potential</u> food safety hazards introduced, controlled or enhanced at this step	(3) Do any <u>potential</u> food safety hazards require a preventive control?		(4) Justify your decision for column 3	(5) What preventive control measure(s) can be applied to significantly minimize or prevent the food safety hazard? <i>Process including CCPs, Allergen, Sanitation, Supply-chain, other preventive control</i>	(6) Is the preventiv e control applied at this step?	
		Yes	No			Yes	No
Receiving shelf-stable ingredient: Chickpea Flour	B Salmonella, E.coli, Pests	X		Flour mixes are linked with potential E.coli and Salmonella contamination. There is the potential for pests to come into contact with the product.	Process Control - subsequent cook step. Visual checks and pest control.		X
	C Allergen Cross Contact. Undeclared allergens	X		Ingredient manufactured on shared equipment with soy. There is potential for undeclared allergens.	Supplier Chain Control and approval process		X
	P Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		x
Receiving shelf-stable ingredient: Toasted Pea Flour	B Salmonella, E.coli, Pests	X		Flour mixes are linked with potential E.coli and Salmonella contamination. There is the potential for pests to come into contact with the product.	Process Control - subsequent cook step. Visual checks and pest control.		X
	C -Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process		x
	P Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		x
Receiving shelf-stable ingredient: Palm Shortening	B E.coli, Salmonella, Listeria, Pest	X		Vegetable shortenings are linked with potential E.coli, Salmonella and Listeria contamination. There is the potential for pests to come into contact with the product.	Process Control - subsequent cook step. Visual checks and pest control.		X
	C -Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process		X

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	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient: Date Paste	B	Listeria, Pest	X		Shelf-stable processed fruits are linked with potential Listeria contamination. There is the potential for pests to come into contact with the product.	Process Control - subsequent cook step. Visual checks and pest control.		X
	C	-Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process		X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient: Tapioca Syrup	B	-Pests	X		There is the potential for pests to come into contact with the product.	Visual checks and pest control.		X
	C	-Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process		X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient: Brown Rice Syrup	B	-Pests	v		There is the potential for pests to come into contact with the product.	Visual checks and pest control.		X
	C	-Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process		X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient: Arrowroot Flour	B	Salmonella, E.coli, Pests	X		Flour mixes are linked with potential E.coli and Salmonella contamination. There is the potential for pests to come into contact with the product.	Process Control - subsequent cook step. Visual checks and pest control.		X
	C	-Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process		X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient: Tapioca Flour	B	Salmonella, E.coli, Pests	X		Flour mixes are linked with potential E.coli and Salmonella contamination. There is the potential for pests to come into contact with the product.	Process Control - subsequent cook step. Visual checks and pest control.		X
	C	-Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process		X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient:	B	Salmonella, Pests	X		Chocolate products are linked to potential Salmonella contamination. There is the	Process Control - subsequent kill step. Visual		X

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Chocolate Chips				potential for pests to come into contact with the product.	checks and pest control.		
	C	-Undeclared allergens	X	There is potential for undeclared allergens.	Supplier approval process		X
	P	-Extraneous matter	X	There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient: White Chocolate Chips	B	Salmonella, Pests	X	Chocolate products are linked to potential Salmonella contamination. There is the potential for pests to come into contact with the product.	Process Control - subsequent kill step. Visual checks and pest control.		X
	C	-Undeclared allergens	X	There is potential for undeclared allergens.	Supplier approval process		X
	P	Extraneous matter	X	There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient: Prebiotic Fiber (VitaFiber Syrup)	B	-Pests	X	There is the potential for pests to come into contact with the product.	Visual checks and pest control.		X
	C	-Undeclared allergens	X	There is potential for undeclared allergens.	Supplier approval process		X
	P	Extraneous matter	X	There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient: Glycerine	B	-Pests	X	There is the potential for pests to come into contact with the product.	Visual checks and pest control.		X
	C	-Undeclared allergens	X	There is potential for undeclared allergens.	Supplier approval process		X
	P	Extraneous matter	X	There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient: Cocoa	B	Salmonella, Pests	X	Chocolate products are linked to potential Salmonella contamination. There is the potential for pests to come into contact with the product.	Process Control - subsequent kill step. Visual checks and pest control.		X
	C	-Undeclared allergens	X	There is potential for undeclared allergens.	Supplier approval process		X
	P	Extraneous matter	X	There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Receiving shelf-stable ingredient: Natural Flavors (Liquid and Powder)	B	Salmonella, Pests	X	Natural Flavors are linked to potential Salmonella contamination. There is the potential for pests to come into contact with the product.	Process Control - subsequent kill step. Visual checks and pest control.		X
	C	Unapproved additives, Undeclared allergens	X	Natural Flavors are linked to unapproved additives. There is potential for undeclared allergens.	Supply-chain control: Approved		X

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					supplier 3rd party audit		
	C	Allergen Cross Contact	X		Ingredients are manufactured on shared equipment with allergens	Supply Chain Control: Allergen control program and 3rd party audit	X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process	X
Receiving shelf-stable ingredient: Sprinkles	B	-Pests	X		There is the potential for pests to come into contact with the product.	Visual checks and pest control.	X
	C	-Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process	X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process	X
Receiving shelf-stable ingredient: Sea Salt	B	-Pests	X		There is the potential for pests to come into contact with the product.	Visual checks and pest control.	X
	C	-Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process	X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process	X
Receiving shelf-stable ingredient: Baking Powder	B	-Pests	X		There is the potential for pests to come into contact with the product.	Visual checks and pest control.	X
	C	-Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process	X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process	X
Receiving shelf-stable packagings	B	-Pests	X		There is the potential for pests to come into contact with the product.	Visual checks and pest control.	X
	C	-Undeclared allergens	X		There is potential for undeclared allergens.	Supplier approval process	X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process	X
Storing shelf-stable ingredients and packagings	B	-Pests	X		There is the potential for pests to come into contact with the product.	Visual checks and pest control.	X
	C	-Undeclared allergens	X		There is potential for undeclared allergens.	Visual checks and our supplier approval and brand list	X

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	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Check and supplier approval process		X
Mixing	B	-Pests	X		There is the potential for pests to come into contact with the product.	Visual checks and pest control.		X
	C	Undeclared allergen contamination from employee clothing		X	Risk Analysis - Clothing, Hair and PPE Policy			X
	P	Pieces of broken gloves and arm guards could fall into the dough. Extraneous matter		X	Gloves and arm guards are blue, broken pieces are easily identifiable if fall into the dough	Visual Checks		
Forming	B	-Pests	X		There is the potential for pests to come into contact with the product.	Visual checks and pest control.		X
	C	Undeclared allergen contamination from employee clothing		X	Risk Analysis - Clothing, Hair and PPE Policy			X
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Checks		X
Baking	B	Survival of vegetative pathogens, Pests	X		Thorough cooking is required to kill vegetative pathogens. There is the potential for pests to come into contact with the product.	Process Control: Cooking to achieve lethal temperature. Visual checks and pest control.	X	X
	C	-						
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Checks		X
Cooling	B	Environmental pathogen contamination, Pests	X		Re-contamination of environmental pathogens might occur if sanitation controls are not in place. There is the potential for pests to come into contact with the product.	Sanitation Control - prevent recontamination		X
	C	-						
	P	Extraneous matter	X		There is potential for extraneous matter to come in contact.	Visual Checks		X
Packaging	B	Environmental pathogen contamination, Pests	X		Re-contamination of environmental pathogens might occur if sanitation controls are not in place. There	Sanitation Control - prevent recontamination.		X

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				is the potential for pests to come into contact with the product.	Visual checks and pest control.		
	C	Undeclared allergen contamination from employee clothing		X	Risk Analysis - Clothing, Hair and PPE Policy		
	P	Extraneous matter			There is potential for extraneous matter to come in contact.	Visual Checks	
Ambient Storage	B	-Pests			There is the potential for pests to come into contact with the product.	Visual checks and pest control.	
	C	-					
	P	Extraneous matter			There is potential for extraneous matter to come in contact.	Visual Checks	
Distribution	B	-Pests			There is the potential for pests to come into contact with the product.	Visual checks and pest control.	
	C	-					
	P	Extraneous matter			There is potential for extraneous matter to come in contact.	Visual Checks	
Returns					No returns are accepted. Discard any returns.		
Radiological					The company does not source product from areas or suppliers known to have radiological risks.		

Process Preventive Controls - Baking

Process Control	Hazard	Critical Limits	Monitoring		Corrective Action	Verification	Records
			How	Frequency			
Baking	Vegetative pathogens	175 °F	Check temperature of one brownie/ blondie from center of the rack right after baking	Daily	Hold and test another product and evaluate - rework, discard Determine root cause - retrain or adjust as needed	Quarterly calibration of thermometer	Temp Log Calibration Log

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Food Allergen Preventive Controls

This facility does not handle or store allergens. See [Allergen Control Plan](#)

Sanitation Preventive Controls

Cleaning and Sanitizing Procedure

Location	Production Room - Mixer, dishes, Vemag, Formatic, Former, Work tables, Floor, Drains Packaging Station - Slicer, Bins, Flow Wrap, Bagelator, Packaging tables, Floor
Purpose	To ensure cleanliness of food contact surfaces and preventing products from being re-contaminated by environmental pathogens and spoilage microorganisms.
Frequency	Daily
Procedure	Clean and sanitize as specified in Cleaning Checklist
Monitoring	Opening and pre-operation inspections; Review Cleaning Checklist daily
Corrections	Re-clean before using; Determine root cause - retrain or adjust as needed
Records	Cleaning Checklists, Environmental Testing results, Titration and ppm test log
Verification activities	Titration of cleaner and PPM testing of sanitizers, Quarterly review of ATP swab results, Environmental Monitoring Program

Hygienic Zoning

See [Environmental Monitoring Program](#)

Environmental Monitoring for Sanitation Control Verification

See [Environmental Monitoring Program](#)

Supply-chain-applied Preventive Controls Program

Ingredient	Approved Supplier	Hazard(s) requiring supply-chain applied control	Date of approval	Verification methods	Verification records
Complete Flour	Natural Products Inc	Allergen cross contact	11/27/17	Validated Allergen Clean Out Program and copy of 3rd party audit obtained from supplier	Allergen Control Program and COAs saved on file
Natural	Mother	Allergen Cross	11/27/17	Validated Allergen Clean	COAs and

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Flavors	Murphy's; David Michael Co.; Ungerer	Contact		Out Program and copy of 3rd party audit obtained from supplier	certificates saved on file
		Unapproved additives		Copy of 3rd party audit obtained from supplier	

Receiving Procedure for Ingredients Requiring a Supply-chain-applied Control

[Receiving Policy](#) and receiving log can be found at the front receiving desk and is applied to all ingredients and materials.