

CONTENTS

	Page no.
INTRODUCTION	1
PART A: EFFECTIVE CONTROL AND PREVENTION OF FOREIGN BODIES IN FOODS	3
SECTION 1. DEFINITIONS	5
1.1 Foreign bodies	5
1.2 Intrinsic foreign bodies	5
1.3 Extrinsic foreign bodies	5
SECTION 2. SCALE OF THE PROBLEM	6
2.1 Typical sources of foreign bodies in foods	6
2.2 Hazards and risks from foreign bodies in foods	7
2.3 Surveillance and monitoring of foreign body incidents	7
SECTION 3. REASONABLE PRECAUTIONS AND DUE DILIGENCE	8
3.1 The legal position	8
3.2 The 6-point plan for due diligence	9
SECTION 4. SUGGESTED PROCEDURES FOR INVESTIGATING A FOREIGN BODY INCIDENT	11
4.1 General guidance	11
4.2 A flow chart for investigating foreign body incidents	12
4.3 What to do when a foreign body incident has occurred	13

SECTION 5. CONTROL FACTORS	15
5.1 Introduction	15
5.2 Good Manufacturing Practice (GMP)	15
5.3 Hazard Analysis and Critical Control Point (HACCP)	15
PART B: FOREIGN BODY DETECTION AND REMOVAL METHODS	19
SECTION 6. SELECTION OF DETECTION AND REJECTION SYSTEMS	21
6.1 System selection and location	21
6.2 Rejection systems for foreign bodies	22
6.3 Routine maintenance and testing	23
6.4 Replacement of foreign body inspection systems	27
SECTION 7. METAL DETECTION SYSTEMS	28
7.1 Introduction	28
7.2 Detection of different metals	28
7.3 Limitations on sensitivity and resolution	28
7.4 Future developments	30
SECTION 8. X-RAY DETECTION SYSTEMS	31
8.1 Introduction	31
8.2 Which foreign bodies are detectable with X-ray systems?	31
8.3 Factors affecting accurate and reliable foreign body detection	32
8.4 X-ray system detection accuracy, sensitivity and false rejects	33
8.5 Performance testing regimes	34
8.6 Additional considerations	35
8.7 Safety and legal requirements	36
8.8 Future developments	36
SECTION 9. VISION AND OPTICAL DETECTION SYSTEMS	37
9.1 Introduction	37
9.2 Principles of operation	37
9.3 Limitations of vision and optical systems	40
9.4 User considerations	42
9.5 Future developments	43

SECTION 10. PHYSICAL SEPARATION SYSTEMS	44
10.1 Introduction	44
10.2 Air aspiration systems	45
10.3 Air abraders and grinders	46
10.4 Gravity separators	47
10.5 Liquid washers and sprayers	47
10.6 Liquid settlers and flumes	48
10.7 Liquid and centrifuge cleaning	48
10.8 Magnetic grids and permanent magnets	50
10.9 Sieves and filtration	52
SECTION 11. MANUAL SORTING	56
11.1 Introduction	56
11.2 Design factors relating to equipment and working arrangements	56
11.3 Rejection of foreign bodies and food product	57
11.4 Limitations and effectiveness of manual sorting	57
SECTION 12. NEW AND EMERGING FOREIGN BODY DETECTION TECHNOLOGIES	58
12.1 Introduction	58
12.2 Data analysis	58
12.3 New and emerging foreign body detection systems	58
12.3.1 Optical systems	58
12.3.2 Electromagnetic techniques	59
12.3.3 Imaging techniques	61
SECTION 13. REFERENCES	64