

QUALITY-ASSURED HACCP RECIPE PROCEDURES

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Recipe Name: Sushi Rice	Portion size (vol.):	Number of casings:
Recipe #:	Number of portions:	Preparation time:
Production style:	Final yield (AS):	To be prepared by:
	Final Yield:	Supervisor:
Written by:	Date:2/99	SA/QA by: P. Snyder
		Date:3/99

Gp. #	Ingred. #	Ingredients and Specifications	Weight %	Weight	
I	1	Rice, short grain 3 1/2 cups	38.14	682.5 g.	24.1 oz.
	2	Water, 4 cups	52.53	940.0 g.	33.2 oz.
II	2	Rice vinegar*, 5 tablespoons plus 1	4.47	80.0 g.	2.8 oz.
	3	teaspoon	3.63	65.0 g.	2.3 oz.
	4	Sugar, 5 tablespoons	1.23	22.0 g.	0.8 oz.
		Salt, 4 teaspoons			
		Total weight	100.00	1789.5 g.	63.2 oz.

* Nakano Rice Vinegar (4.2% acetic acid)

Pre-preparation

1. Assemble all ingredients and equipment.
2. Wash rice in colander until water runs clear. Drain thoroughly. (If enriched rice is used, do not wash the rice because washing removes enrichment B-vitamin and mineral mixture.) Remove physical hazards.

Preparation

3. Place drained rice in pan or rice cooker. Add water. Cover container with close fitting lid and bring the water containing the rice to boil (212°F).
4. Reduce heat to a simmering temperature (>190°F) and continue to cook for 15 to 20 minutes until all the water has been absorbed. The rice is now pasteurized, and all vegetative pathogens are reduced to a safe level. Spores survive.
5. While the rice is cooking, combine the vinegar, sugar and salt in a small stainless steel bowl or pan. Heat the mixture until the sugar has dissolved (150°F), stirring constantly. Remove from heat. Set aside.
6. Remove the rice from the stove. Empty the rice into a stainless steel or plastic pan, <2 1/2 inches thick, and spread the rice evenly over the bottom with a stainless steel spoon.
CCP Run a spatula through the rice (~80°F) using right and left slicing motions to separate the grains. At the same time, slowly add the vinegar mixture (~80°F). Let cool at room temperature. (As an alternative, the rice can be spread on a stainless steel pan and cooled to 80°F in about 30 minutes.)
7. Check the pH of the rice mixture. The pH must be 4.2 or less to prevent the growth of *Bacillus cereus*. The rice does not need to be refrigerated, because it is at a safe pH and is no longer a potentially hazardous food. Keep it covered to prevent drying. Sushi quality lasts just one day. It should not be used as a leftover for quality reasons.

SUSHI RICE INGREDIENT LIST AND FLOW DIAGRAM

Ingredients
Rice, short grain
Water
Rice vinegar
Sugar
Salt

Pre-preparation

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SUSHI RICE HACCP PLAN

Process Step(s) and Controls: GMPs and prerequisites are in place	B,C,P Potential Hazards & Risk Analysis	Control(s) Critical Limit (CL) for Each Hazard Control	Monitoring & Record (What, How, Frequency, Who)	Corrective Action & Record	Verification & Record (Procedures and Frequency)
1. Assemble all ingredients and equipment.	B No significant risk C No significant risk P No significant risk				
2. Wash rice in colander until water runs clear. Drain thoroughly. (If enriched rice is used, do not wash the rice because washing removes enrichment B-vitamin and mineral mixture.) Remove physical hazards.	B No significant risk C No significant risk P No significant risk				
3. Place drained rice in pan or rice cooker. Add water. Cover container with close fitting lid and bring the water containing the rice to boil (212°F).	B No significant risk C No significant risk P No significant risk				
4. Reduce heat to a simmering temperature (>190°F) and continue to cook for 15 to 20 minutes until all the water has been absorbed. The rice is now pasteurized, and all vegetative pathogens are reduced to a safe level. Spores survive.	B No significant risk C No significant risk P No significant risk				
5. While the rice is cooking, combine the vinegar, sugar and salt in a small stainless steel bowl or pan. Heat the mixture until the sugar has dissolved (150°F), stirring constantly. Remove from heat. Set aside.	B No significant risk C No significant risk P No significant risk				
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