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## 1.0 SCOPE

To ensure 100% foreign material audit is done for every load packed.

## 2.0 REFERENCE DOCUMENTS

Hold tag SOP  
Grading Shelled Almonds SOP  
F/M charts  
Allergens List

## 2.0 GLOSSARY

**F/M:** short for Foreign Material

**Foreign Material:** Anything found in the product that is not an almond. i.e. pieces of hull, shell, or any other foreign matter unrelated to almonds.

**Hazardous Foreign Material:** Metal, Glass, Rock, Hard Plastic, or anything on the Allergen list is considered hazardous. If found, the pallet will be placed on HOLD and re-sorted.

**Confectionary Grade:** This allows only almond related F/M to be present in the product. i.e. pieces of hull, shell, or gum from the almond tree. Obvious embedded shell is included in the foreign material piece count as well.

## 4.0 RESPONSIBILITIES

It is the responsibility of the Quality department to ensure the F/M chart is kept, controlled and the information is relayed to production on whether the load has acceptable levels of F/M. The Online tester will track the findings of the final belt sorters and notify the floor person and QA Manager/Supervisor of any Holds. The QA Manager/Supervisor is responsible for approving product disposition.

## 5.0 PROCEDURE

- Four final belt sorters per line (two per side) will look at 100% of the product as it is passed on the final belt.

Title: Foreign Material Testing

- F/M is picked and placed in container attached to sorting table.
- At the end of each pallet, the grader will collect the F/M found and sort it into categories listed on the F/M charts provided by the Quality department.
- The charts are based per customer specification, found in the customer spec binder.
- Any non-conformance F/M is circled in red and placed on HOLD and the Quality dept. is notified.

Exit Exam

Employee Name:

Date:

- 1) Which can be called FM?
  - a. Insect damage
  - b. A gummy almond
  - c. Anything that isn't an Almond
- 2) Which can be called Hazardous FM?
  - a. Metal, Glass, Rock or Hard Plastic
  - b. Hulls
  - c. Obvious embedded Shell
- 3) Who is responsible for collecting, and documenting the FM from the final belt?
  - a. Floor Person
  - b. Grader
  - c. QA Manager or Supervisor
- 4) Who is responsible for approving product disposition?
  - a. Grader
  - b. QA Manager or Supervisor
  - c. Floor Person

Management Review: