

1 Scope

2
3 This standard applies to fresh-chilled and fresh-frozen tuna intended for direct consumption as
4 *sashimi*.

6 2 References

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8 The titles of the standards and publications referred to in this standard are listed on the back
9 cover.

11 3 Definition of terms

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13 For the purpose of the standard, the following terms shall mean:

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15 **3.1 Chilling** refers to the process of cooling fish to a temperature approaching that of
16 melting ice.

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18 **3.2 Clean seawater** refers to seawater which meets the same microbiological standards as
19 potable water, and is free from objectionable odor and substances.

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21 **3.3 Contaminant** refers to any biological or chemical agent, foreign matter, or other
22 substances not intentionally added to the food, which may compromise food safety or its
23 suitability.

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25 **3.4 Dressed tuna** refers to the portion of fish remaining after be-heading, gutting and fins
26 trimmed. Also referred to as Headless, Gutted and Tailless (HGT).

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28 **3.5 Fresh fish** refers to fish or fishery products that have received no preserving treatment
29 other than chilling.

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31 **3.6 Frozen fish** refers to fish that have been subjected to a freezing process sufficient to
32 reduce the temperature of the whole product to a level low enough to preserve the inherent
33 quality of the fish, and that have been maintained at this low temperature.

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35 **3.7 Glazing** refers to the application of a protective layer of ice formed at the surface of a
36 frozen product by spraying it with, or dipping it into, clean seawater, potable water or potable
37 water with approved additives, as appropriate

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39 **3.8 Tuna loin** refers to longitudinal quarter of the great lateral muscle freed from skin,
40 scales, visible blood clots, bones, gills, viscera and from the non-striated part of such muscle,
41 which part (known automatically as the median superficial muscle) is highly vascular in
42 structure, dark in color because of retained blood, and granular in form.

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44 **3.9 Potable water** refers to water suitable (both health and acceptability considerations)
45 for drinking and cooking purposes.

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47 **3.10 Saku bar** is a Japanese term referring to a rectangular block derived from tuna loins.

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49 **3.11 Sashimi tuna** is a Japanese term referring to bite size tuna slices, generally eaten as
50 raw, served as a delicacy.

4 Description

4.1 Product description

The product is of prime quality tuna prepared for *sashimi* and presented either in these following forms:

- a) whole round;
- b) whole gilled and gutted (GG);
- c) dressed;
- d) loins; and
- e) *saku* bars.

4.2 Process description

Properly caught and killed tuna are bled; prepared into forms as defined in Section 4.1; and subjected to any of the processing methods described below:

4.2.1 Fresh-chilled

Rapid cooling and chilling should be applied to fish throughout the handling process.

- a) The whole round; whole gilled and gutted (GG); and dressed tuna are chilled in clean seawater ice-slurry, and stored in ice maintained at 0°C to 4°C.
- b) Other tuna product forms are subjected to immediate chilling temperature of 0°C to 4°C using other appropriate methods (e.g. direct icing and other forms of refrigeration).

4.2.2 Fresh-frozen

All tuna product forms are immediately frozen to a core temperature of -30°C or lower using appropriate freezing methods, and followed by storage at -18°C or lower.

5. Essential composition and quality factors

5.1 Basic ingredients

5.1.1 Raw material (Tuna)

The product shall be prepared from fresh quality tuna weighing 35 kg and above.

5.1.2 Water

Water for washing, cleaning, glazing and cooling shall be potable as defined in Section 3.9.

5.2 Final product

5.2.1 The final product shall meet the requirements of this standard when lots examined in accordance with Section 12 and comply with the provisions set out in Section 11. Products shall be examined by the methods given in Section 10.

5.2.2 The final product shall not have more than 20 ppm of histamine, based on the average of the sample unit tested.

5.2.3 The final product shall have meat color and condition scores of 50 to 40 as described in Annex A.

5.2.4 The final product shall conform to the following microbiological quality requirements in Table 1:

Table 1 – Microbiological quality requirements

Test/Microorganism	n	c	m	M
1. APC/SPC, cfu/g	5	3	5×10^5	10^7
2. <i>E. coli</i> , MPN/g	5	2	11	500
3. <i>Salmonella</i> /25g	5	0	0	-
4. <i>Shigella</i>	5	0	0	-
5. <i>Staphylococcus aureus</i> (coagulase +), cfu/g	5	2	10^3	10^4
6. <i>Vibrio cholera</i>	5	0	0	-
7. <i>V. parahaemolyticus</i> , cfu/g	5	2	10^2	10^3
8. <i>Listeria monocytogenes</i>	5	0	0	-

Legend:

n -number of sample units selected from a lot of food to be examined

m -acceptable level of microorganism determined by a specified method; the values are generally based on levels that are achievable under GMP

M -level which when exceeded in one or more samples would cause the lot to be rejected as this indicates potential health hazard or imminent spoilage

c -maximum allowable number of defective or marginally acceptable units

6 Food additives

No food additives permitted.

7 Contaminants

The products shall comply with the maximum level of contaminants as specified in Annex B.

8 Hygiene and handling

The products shall be prepared and processed under hygienic conditions in accordance with the Revised Guidelines on Current Good Manufacturing Practice in Manufacturing, Packing, Repacking, or Holding Food (DOH AO No. 153 s. 2004) and its future amendments, the ASEAN-CANADA Fisheries Post-Harvest Technology Project – Phase II: Improved Quality Control for Handling and Processing of Fresh and Frozen Tuna At Sea and On Shore, and the following Codex Recommended Codes of Practice (CAC/RCP):

- a) General Principles of Food Hygiene (CAC/RCP 1-1969); and
- b) Code of Practice for Fish and Fishery Products (CAC/RCP 52-2003).

9 Packaging and labeling

9.1 Packaging

The products shall be packaged in appropriate food grade containers. Packaging can be done individually or in bulk.

All cartons for the shipping of either fresh or frozen tuna must be new, clean, and sound.

9.2 Labeling

The product shall be labeled according to the provisions of the Codex General Standard for the Labeling of Prepackaged Foods (CODEX STAN 1-1985), the Rules and Regulations Governing the Labeling of Prepackaged Food Products Distributed in the Philippines (DOH-BFAD/FDA Administrative Order No. 88-B series of 1984) and its future amendments.

9.2.1 Retail package/container (for loins and saku bars)

Each retail product package shall be labeled and marked with the following information:

- a) The name of the product shall be “Fresh-chilled” or “Fresh-frozen” and the corresponding English or common/local name with its scientific name in parenthesis, e.g. Fresh-chilled Yellowfin Tuna (*Thunnus albacares*) or Fresh-frozen “Bariles” (*Thunnus albacares*). The products may be labeled with the following forms as presented in Section 4.1. The products may be called by other common/local names provided that such names are accepted in the country of distribution;
- b) The net content by weight in the metric system (grams or kilograms) and/or number of pieces. The net weight based on other systems of measurement required by importing countries shall appear in parenthesis after the metric net weight. Where the product has been glazed, the declaration of net contents of the product shall be exclusive of the glaze;
- c) The label shall state that the product must be stored under conditions to maintain the best quality during transport, storage and distribution (e.g. keep frozen, keep chilled, store at temperature not exceeding 4⁰C if chilled or -18⁰C if frozen);
- d) The name and address of either of the following: manufacturer, packer, distributor, importer, exporter or vendor;

- 1 e) The lot identification code/number;
- 2 f) The words “Product of the Philippines” or the country of origin if imported; and
- 3 g) The pictorial presentation (optional). Pictorial presentation of the product on the label
- 4 should not mislead the consumer with respect to the product so illustrated.
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6 9.2.2 Non-retail container (for whole round; whole gilled and gutted; dressed and loins)

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8 Information on the above provisions shall be given either on the container or in accompanying

9 documents, except that the name of the product, lot identification, and the name and address of

10 the manufacturer or packer as well as storage instructions, shall appear on the container.

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12 However, the lot identification and the name and address of the manufacturer or packer may

13 be replaced by an identification mark, provided that such mark is clearly identifiable with the

14 accompanying documents.

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16 10 Methods of sampling, examination and analysis

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18 10.1 Method of sampling

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20 Sampling of lots for examination of the final product shall be in accordance with the General

21 Guidelines on Sampling (CAC/GL 50-2004). A sample unit is the individually packed product

22 or a 1kg portion from bulk containers.

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24 10.2 Method of sensory and physical examinations

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26 Samples taken for sensory and physical examination shall be assessed by persons trained in

27 such examination using the Guidelines for the Sensory Evaluation of Fish and Shellfish in

28 Laboratories (CAC/GL 31-1999).

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30 10.3 Methods of analysis

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32 10.3.1 Determination of histamine

33 According to the AOAC 977.13.

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35 10.3.2 Determination of heavy metals

36 According to the Codex Recommended Methods of Analysis and Sampling (CODEX STAN

37 234-1999) or an equivalent analysis method.

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39 10.3.3 Determination of microorganisms in Table 1

40 According to the procedure described by FDA Bacteriological Analytical Manual (BAM),

41 published by AOAC, 2001, 12th Edition or the latest edition or an equivalent analysis method.

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43 10.3.4 Determination of net weight

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45 10.3.4.1 Determination of net weight of products not covered by glaze

46 The net weight (exclusive of packaging material) of each sample unit representing a lot shall

47 be determined in the frozen state.

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10.3.4.2 Determination of net weight of products covered by glaze

As soon as the package is removed from low temperature storage, open immediately and place the contents under a gentle spray of cold water. Agitate carefully so that the product is not broken. Spray until all ice-glaze that can be seen or felt is removed. Remove adhering water by the use of paper towel and weigh the product in a tare pan.

10.3.5 Procedure for the detection of parasites (Type 1 method)

The entire sample unit is examined non-destructively by placing appropriate portions of the thawed sample unit on a 5 mm thick acryl sheet with 45% translucency and candled with a light source giving 1500 lux 30 cm above the sheet.

10.3.6 Thawing**10.3.6.1 Air thaw method**

Frozen fish are removed from the packaging. The frozen fish are individually placed into snug fitting impermeable plastic bags or a humidity controlled environment with a relative humidity of at least 80%. Remove as much air as possible from the bags and seal. The frozen fish sealed in plastic bags are placed on individual trays and thawed at air temperature of 25⁰C or lower. Thawing is completed when the product can be readily separated without tearing. Internal fish temperature should not exceed 7⁰C.

10.3.6.2 Water immersion method

Frozen fish are removed from the packaging. The frozen fish are sealed in plastic bags. Remove as much air as possible from the bags and seal. The frozen fish are placed into a circulating water bath with temperatures maintained at 21⁰C + 1.5⁰C. Thawing is completed when the product can be easily separated without tearing. Internal fish temperature should not exceed 7⁰C.

10.3.6.3 Other methods as appropriate.**11 Definition of defectives**

The sample unit shall be considered as defective when it exhibits any of the properties defined below.

11.1 Freezer burn

More than 10% of the declared weight of the frozen whole or choice cut tuna is affected by dehydration evident in more than 10% of the surface area.

11.2 Foreign matter

The presence in the sample unit of any matter which has not been derived from tuna (excluding packing material), does not pose a threat to human health, and is readily recognized without magnification or is present at a level determined by any method including magnification that indicates non-compliance with good manufacturing and sanitation practices.

11.3 Odor

Presence of distinct objectionable odor indicative of decomposition.

11.4 Color

Discoloration characterized by fading, greening or darkening of the characteristic color of the product.

11.5 Texture

Textural breakdown of the flesh, characterized by softening muscle structure.

11.6 Parasites

Presence of parasites or parasitic infestation (pinholes) in the tuna meat.

12 Lot of acceptance

A lot shall be considered as meeting the requirements of this standard when:

- a) the total number of defective sample units as classified according to Section 11 does not exceed the acceptance number (c) of the appropriate sampling plan (AQL-6.5);
- b) the average net weight of all sample units is not less than the declared weight, provided there is no unreasonable shortage in any individual container; and
- c) the essential composition and quality factors, food additives, contaminants, hygiene and handling, and labeling requirements of Sections 5, 6, 7,8 and 9, respectively, are met.

Annex A

Table 2 – Point score system for grading tuna

I. Color scores
<p>1. Very good (50)</p> <p>a. Meat is translucent, glossy.</p> <p>b. Colors are bright red (reddish).</p> <p>c. Fat is clearly visible.</p>
<p>2. Good (40)</p> <p>a. Meat is little translucent, and less glossy.</p> <p>b. Colors are less bright red (reddish).</p> <p>c. Fat just visible in outer layers.</p>
<p>3. Medium (30)</p> <p>a. Meat is translucent, and has lost its gloss.</p> <p>b. Colors are a little dull, may appear a little brownish.</p> <p>c. No fat visible in outer layers.</p>
<p>NOTE: The natural color of tuna is affected by many factors. The most important one being the freshness, fat content, and time of exposure to the air. Freshly cut surface of tuna meat are dark, and become bright red as the tissues take up oxygen. It is important to remember this factor when grading, you must wait 30 minutes after the notches are cut.</p>
II. Condition scores
<p>1. Very Good (50)</p> <p>a. No apparent defects/damage (no rips, tears, cuts and abrasions).</p> <p>b. Scales intact.</p> <p>c. Fish looks as though it has just been lifted from the water, natural body colors bright.</p> <p>d. Flesh at notch very firm, springs back quickly on pressing lightly with fingertips. No soft spots present on carcass surface.</p>
<p>2. Good (40)</p> <p>a. Slight defects/damage; there are a few minor rips, tears, cuts, and abrasions.</p> <p>b. Some scales loss.</p> <p>c. Body colors are little dull.</p> <p>d. Flesh at notch springs back slowly on pressing lightly with fingertips. One or two very small soft spots present on carcass surface.</p>
<p>3. Medium (30)</p> <p>a. Noticeable defects/damage; a maximum of two rips, tears, cuts, abrasions which could affect the meat yield.</p> <p>b. Small patches of scales lost.</p> <p>c. Body colors dull/dark.</p> <p>d. Flesh at notch less firm, does not spring back fully on pressing lightly with fingertips. Several small spots present on carcass surface.</p>
<p>NOTE: Condition has two aspects: carcass and flesh condition. Carcass condition is assessed in terms of damage of the exterior damage to the skin; for example rips, cuts and tears. Flesh condition is done by assessing the meat at the tail cut to see if there is gaping, parasites and disease, and also along the exterior surface of the carcass damage which can be felt with the fingers. Bruising is one example.</p>

Source:

Wiryanti J., Glynn G. and Limpus L., 1997. *Improved Quality Control for Handling and Processing of Fresh and Frozen Tuna At Sea and On Shore. ASEAN-CANADA Fisheries Post-Harvest Technology Project – Phase II, p.134-137*

Annex B

Table 3 – Acceptable levels of heavy metals in fish

Heavy metal	Maximum level
Lead	0.3 ppm (0.3 mg/kg) ¹
Cadmium	0.1 ppm (0.1 mg/kg) ²
Mercury	1 ppm (1 mg/kg) ¹

Sources:

1 *CODEX STAN 193-1995 (Codex General Standard for Contaminants and Toxins in Food and Feed)*

2 *COMMISSION REGULATION (EC) No 1881/2006 (Maximum levels for certain contaminants in foodstuffs)*

Fresh-chilled and fresh-frozen tuna for sashimi

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References

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

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Blanc, Michel et al. Onboard Handling of Sashimi-Grade Tuna : A Practical Guide for Crew Members / Michel Blanc ; Aymeric Desurmont ; Steve Beverly – Revised Edition – Noumea, New Caledonia: Secretariat of the Pacific Community, 2005.

Title 21 – Food and Drugs, Code of Federal Regulation. Food and Drug Administration. Department of Health and Human Services. USA. 2012

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