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Cleaning-in-Place

Dairy, Food and Beverage Operations

Third Edition

Edited by

Dr Adnan Tamime
Dairy Science and Technology Consultant
Ayr, UK



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Contents

<i>Preface to Technical Series</i>	xvi
<i>Preface to Third Edition</i>	xvii
<i>Preface to Second Edition</i>	xviii
<i>Preface to First Edition</i>	xix
<i>Contributors</i>	xx
1 Principles of Cleaning-in-Place (CIP)	1
M. WALTON	
1.1 Introduction	1
1.2 Cleaning-in-place (CIP): definition	1
1.3 CIP systems: hardware	2
1.4 The processes of cleaning	2
1.4.1 Removal of gross debris (product recovery)	2
1.4.2 Pre-rinse	3
1.4.3 Detergent circulation	3
1.4.4 Intermediate rinse	4
1.4.5 Second detergent circulation (optional)	4
1.4.6 Second intermediate rinse	4
1.4.7 Disinfection	4
1.4.8 Final rinse	5
1.5 Planning a cleaning project	5
1.5.1 What is the physical nature of the plant or equipment to be cleaned?	5
1.5.2 What standards of cleaning are required?	6
1.5.3 What is the nature of the soil to be removed?	6
1.5.4 When is the cleaning to be undertaken?	7
1.5.5 The selection of detergents	7
The attributes of detergents	7
The mechanisms of soil removal	8
1.6 Conclusions	8
References	9
2 Fluid Flow Dynamics	10
M.J. LEWIS	
2.1 Introduction	10

2.2	Some background principles	10
2.3	Some background information	11
2.3.1	Temperature	13
2.3.2	Volumetric flowrate	13
2.3.3	Density	13
2.3.4	Specific gravity	14
2.3.5	Viscosity (η) and rheology	14
2.3.6	Continuity equations and energy balances	15
2.4	Streamline and turbulent flow	17
2.5	Calculation of frictional loss in a straight pipe	19
2.6	Pump characteristics	23
2.7	Tank cleaning heads and falling films	25
2.8	Some concluding remarks	26
2.9	Appendix: definitions and equations	27
2.9.1	Pressure	27
2.9.2	Volume and volumetric flowrate	27
2.9.3	Temperature conversions	28
2.9.4	Temperature difference	29
2.9.5	Fixed points	29
2.9.6	Energy units	29
2.9.7	Some conversion factors	29
2.9.8	Specific heat	30
2.9.9	Density of milk	30
2.9.10	Viscosity	30
	References	30
	Further reading	31
3	Water Supplies in the Food Industry	32
	S.I. WALKER	
3.1	Introduction	32
3.2	Sources of water	32
3.2.1	Natural water and rainwater	33
3.2.2	Authority-provided water	35
3.2.3	Water from products	36
3.2.4	Water from recycling	36
3.3	Improving water quality	37
3.4	Equipment for improving water quality (coarse removal)	37
3.4.1	Screens and strainers	39
3.4.2	Bag and cartridge filters	40
3.4.3	Sand-type filters	40
3.4.4	Separators	40
3.5	Equipment for improving water quality (fine removal)	41
3.5.1	Softeners	41

3.5.2	Reverse osmosis	41
3.5.3	Electro deionisation (EDI)	41
3.6	Applications of water in the dairy	41
3.6.1	Water as an ingredient	41
3.6.2	Water as a cooling agent	42
3.6.3	Water in heating applications	43
	Water for boilers	43
	Water as condensate return	45
3.6.4	Water for general use	45
3.6.5	Water for cleaning purposes	47
3.7	Water leaving the dairy	47
3.7.1	Minimum treatment	47
3.7.2	Buffering of wastewater	48
3.7.3	Effluent treatment	48
	Initial screen	48
	Balancing tanks	49
	Phase separator	49
3.7.4	Wastewater treatment	51
	Discharge from site	51
	Recycle to the factory	51
	Recycle as 'grey water' to effluent plant	51
	Further treatment	52
3.7.5	Problems associated with biological treatment plants	53
	Micro-organisms	53
	Microbial nutrient deficiency	54
	Low organic loading	54
	Low oxygen level	54
References		54
4	Chemistry of Detergents and Disinfectants	56
	W.J. WATKINSON	
4.1	Introduction	56
4.2	Why do we clean?	56
4.2.1	Appearance	56
4.2.2	Micro-organism contamination	56
4.2.3	Plant efficiency	57
4.2.4	Safety	57
4.3	Soil to be removed	57
4.4	Chemistry of water	58
4.5	Water attributes important to dairy and beverage cleaning and disinfection	58
4.6	Basic detergency: how does a detergent work?	59
4.6.1	Chemical reaction	60
4.6.2	Solvent cleaning	60

4.6.3	Abrasive cleaning	60
4.6.4	Dispersion–suspension cleaning	60
4.7	What materials make up a detergent?	62
4.7.1	Surfactants: synthetic surface-active agents	62
4.7.2	Inorganic components of detergents, or builders	63
	Caustic soda (sodium hydroxide)	63
	Soda ash (sodium carbonate)	63
	Silicates	64
	Phosphates	64
4.7.3	Sequestrants	65
4.7.4	Acids	65
4.8	Factors affecting detergent performance	65
4.9	Methods of application	66
4.9.1	Manual cleaning	66
4.9.2	Circulation cleaning (CIP, spray cleaning)	67
4.9.3	Soak-cleaning	67
4.9.4	Spray-washing	67
4.9.5	Long-contact vertical surface cleaning using foams or gels	67
4.10	The science of disinfection	68
4.10.1	Background	68
4.10.2	Objectives of effective disinfection	68
4.10.3	Factors affecting the performance of disinfectants	68
	Time	68
	Temperature	68
	Concentration	69
	Surface tension	69
	pH	69
	Number and location of organisms	70
	Organic matter	70
	Metal ions	70
	Type of organisms	70
4.10.4	Choosing the most appropriate disinfectant	71
	Heat	71
	Oxidising disinfectants	71
	Non-oxidising surfactant-based disinfectants	74
4.11	Construction materials and their corrosion: influence on choice of detergents and disinfectants	77
4.11.1	Aluminium and its alloys	77
4.11.2	Mild steel	79
4.11.3	Stainless steel	79
4.11.4	Copper	79
4.11.5	Galvanising	79
4.12	Conclusions	79
	Bibliography	80

5 Designing for Cleanability	81
A.P.M. HASTING	
5.1 Background	81
5.2 Equipment design and installation	82
5.2.1 European Union (EU) regulatory requirements	82
5.2.2 The European Hygienic Engineering and Design Group (EHEDG)	82
5.3 Hygienic design principles	83
5.4 Hygienic design requirements	85
5.4.1 Materials of construction	85
Stainless steel	85
Plastics	86
Elastomers	86
5.4.2 Surface finish	87
5.4.3 Joints	88
5.4.4 Other constructional features	90
Fasteners	90
Drainage	91
Internal angles, corners and dead spaces	92
Bearings and shaft seals	93
Instrumentation	93
5.5 Cleaning process equipment	94
5.5.1 Effect of fluid flow on cleaning	94
5.5.2 Pipelines	96
5.5.3 Pumps	97
5.5.4 Valves	98
5.5.5 Heat exchangers	100
Plate heat exchangers (PHE)	100
Tubular heat exchangers (THE)	101
Scraped surface heat exchangers (SSHE)	103
5.5.6 Tanks	103
5.6 Conclusions	105
References	106
 6 Perspectives in Tank Cleaning: Hygiene Requirements, Device Selection, Risk Evaluation and Management Responsibility	 108
R. PACKMAN, B. KNUDSEN AND I. HANSEN	
6.1 Introduction	108
6.2 Background	108
6.2.1 More than just equipment	108
6.2.2 Many aspects of tank cleaning	109
6.2.3 Ways to tackle tank hygiene	109
Cleaning-out-of-place (COP)	109
Cleaning-in-place (CIP)	109
6.3 Two basic approaches to tank cleaning	110

6.3.1	High volume/low pressure	110
6.3.2	Low volume/high pressure	111
6.4	Key parameters in determining tank-cleaning effectiveness	112
6.4.1	The Sinner circle	112
6.4.2	Mechanical forces: hydraulic energy and coverage	113
6.4.3	System parameters	114
6.4.4	Operating parameters	114
6.4.5	Distribution device parameters affecting cleaning performance	116
6.4.6	Nozzle design	116
6.4.7	Difference in mechanical energy applied by static spray balls and rotary jet heads	117
6.5	Tank-cleaning technologies	117
6.5.1	Static spray balls	118
	Description	118
	How they work	119
	Mounting	119
	Applications	119
	Advantages	121
	Disadvantages	121
6.5.2	Rotary spray heads	121
	Description	121
	How they work	123
	Mounting	123
	Applications	123
	Advantages	123
	Disadvantages	123
6.5.3	Rotary jet heads	125
	Description	125
	How they work	126
	Mounting	126
	Applications	126
	Advantages	127
	Disadvantages	129
6.5.4	Cleaning tanks that include internal fittings and other equipment	129
6.5.5	Selection and sizing of tank-cleaning equipment	130
	Flowrate	130
	Effective cleaning distance	131
	Simulation software	136
6.5.6	Upgrading tank-cleaning systems: total cost of ownership (TCO) and risk assessment approach	136
6.5.7	Risk assessment example	137
	Residue type	137
	Tank design	137
	Methodology	138
	Monitorability	138

Repeatability	138
Cleaning materials	138
Testing	139
6.5.8 Perspectives associated with CIP tank cleaning	139
6.5.9 Tank-cleaning devices	140
6.5.10 Cleaning validation	142
6.5.11 Case study	143
6.6 Conclusions	144
References	145
7 Design and Control of CIP Systems	146
D. LLOYD	
7.1 Introduction	146
7.1.1 Full recovery system: three tanks CIP	146
7.1.2 How much CIP?	147
7.1.3 Size of the CIP equipment	147
7.1.4 Hot or cold pre-rinse?	147
7.1.5 Choice of scavenge pump	147
7.1.6 Choice of spray head	149
7.1.7 Control units	149
7.1.8 Supermarkets	150
7.2 Principles of chemical cleaning	150
7.2.1 Soil removal	150
7.2.2 Soil removal parameters	150
7.2.3 Chemical soil removal and disinfectants	150
7.3 Application of CIP	152
7.3.1 Pipeline cleaning	152
7.3.2 Vessel cleaning	153
CIP application	153
CIP return or scavenge	153
7.4 Types of CIP system	154
7.4.1 Single-use system	154
7.4.2 Partial recovery system	154
7.4.3 Full recovery system with heated rinse tank (optional)	154
7.5 Verification	155
7.6 Control systems	155
7.6.1 Schematic illustration	155
7.6.2 Instrumentation	156
7.6.3 Mechanical components	156
7.7 Design information	157
7.7.1 Pipeline capacities	157
7.7.2 Detergent tank capacities	157
7.7.3 Cleaning velocity	158
7.7.4 Pressure drop	159
Bibliography	163

8	Assessment of Cleaning Efficiency	164
	K. ASTERIADOU AND P. FRYER	
8.1	Introduction	164
8.2	Validation	164
8.2.1	Preliminary examination	166
8.2.2	Visual examination	166
8.2.3	Action following an unsatisfactory preliminary examination	168
8.3	Verification	168
8.3.1	Surfaces	168
8.3.2	Flush/rinse material	169
8.3.3	Water quality	169
8.3.4	In-process material	169
8.4	Frequency of assessment/sampling	170
8.4.1	Equipment/surfaces	170
8.4.2	Product	171
	Method of sampling	171
	Heat-treated product	171
	Packed product	171
	Swabbing and rinsing methods	172
8.5	Monitoring	172
8.5.1	Results from system monitoring	173
8.5.2	Interpreting results and taking action	174
8.6	The commercial benefits of assessment	176
8.7	Conclusions	176
	References	176
9	Management of CIP Operations	178
	K.J. BURGESS	
9.1	Background to cleaning-in-place (CIP)	178
9.2	Some CIP operation basics	179
9.2.1	CIP parameters	179
9.2.2	People involved	179
9.2.3	Key steps in CIP implementation	179
9.2.4	A typical CIP sequence	180
9.2.5	Cleaning the CIP system	181
9.3	Chemicals and chemical suppliers	181
9.4	Troubleshooting CIP	182
9.4.1	Positive factors	182
9.4.2	Negative factors	182
9.5	CIP and operational goals	183
9.6	CIP management and quality	183
9.6.1	Quality management system issues	183
9.6.2	CIP and due diligence	183
9.6.3	CIP and hazard analysis and critical control point (HACCP) system	184

9.6.4	Some aspects of good practice	185
9.7	CIP management and safety	185
9.7.1	Health and safety issues with CIP	185
	Exposure to cleaning chemicals	186
	Slips and trips	187
	Falls	188
	Machinery	188
	Handling	188
	Transport	188
9.7.2	Safe CIP	189
9.8	CIP management and productivity	189
9.8.1	CIP cost inputs	189
9.8.2	Product recovery	190
	Product reclaim	190
	Product purging	191
	Product scheduling	191
9.9	CIP management review and improvement	191
9.9.1	CIP review	191
	CIP change review	192
	CIP verification	192
9.9.2	CIP improvement	193
9.10	Conclusions	193
	References	194
10	Membrane Filtration	195
	C.E. ASKEW, S. te POELE AND F. SKOU	
10.1	Introduction	195
10.2	Membrane filtration processes	195
10.3	Membrane process design	196
10.3.1	Membrane material	198
10.3.2	Membrane module design	198
10.3.3	Methods of operation	200
10.4	Membrane filtration in dairies	202
10.4.1	Microfiltration (MF)	202
10.4.2	Ultrafiltration (UF)	203
10.4.3	Diafiltration (DF)	203
10.4.4	Nanofiltration (NF)	203
10.4.5	Reverse osmosis (RO)	204
10.5	Damage that can occur to membranes	204
10.6	How do membranes become fouled or soiled?	206
10.6.1	Concentration polarisation and membrane fouling	206
10.6.2	Membrane fouling in dairy processing	207
10.6.3	Fouling control	208
10.7	Cleaning membrane filtration installations	209

10.7.1	Background	209
10.7.2	Cleaning fouled membranes	210
	Product processed and soil type	211
	Membrane installation and type	211
	Level of membrane fouling	213
	pH and temperature sensitivity	213
	Chlorine sensitivity	214
	Equipment and membrane manufacturer's endorsements	214
	Customer preferences	215
	Local legislation	215
	Environmental issues	215
10.7.3	Cleaning agents	216
10.7.4	Cleaning regime	217
10.8	Monitoring and recording	218
10.9	Recent developments	219
10.9.1	Ultrasonic cleaning	219
10.9.2	Microsieves	220
10.9.3	High tolerant membranes	220
10.10	Conclusions	220
	References	221
11	Laboratory Test Methods	223
	W.J. WATKINSON	
11.1	Introduction	223
11.2	Test methods for in-use solutions	223
11.2.1	Alkalinity	223
11.2.2	Acidity	224
11.2.3	Ethylenediaminetetra-acetic acid (EDTA)	225
11.2.4	Total EDTA	225
11.2.5	Total water hardness	226
11.2.6	Disinfectants	226
	Available chlorine	226
	Available iodine	226
	Available oxygen	227
	Peracetic acid content	227
	Quaternary ammonium compounds (QACs)	227
	Miscellaneous tests	227
11.3	Qualitative test methods for neat detergents	229
11.3.1	Alkalinity	229
	Silicates	229
	Phosphates	229
	Carbonates	229
11.3.2	Acids	229
	Nitric acid	230

	Phosphoric acid	230
	Hydrochloric acid	230
	Sulphuric acid	230
11.3.3	Water-conditioning agents	230
	Reducing agents	230
	Oxidising agents	231
	Surfactants	231
	Miscellaneous	232
11.4	Quantitative tests for neat detergents	233
11.4.1	Alkalinity	233
	Free and total alkalinity	233
11.4.2	Inorganic silicate	233
11.4.3	Inorganic phosphate	234
11.4.4	Carbonates	235
11.4.5	Acidity	235
11.4.6	Water-conditioning agents	236
	Ethylenediaminetetra-acetic acid (EDTA)	236
	Sodium gluconate/heptonate by dimedone complex	236
11.4.7	Oxidising agents	237
	Available chlorine	237
	Available iodine	237
	Available oxygen	237
	Hydrogen peroxide and peracetic acid (PAA) in peracetic acid products	237
11.4.8	Surfactants	238
	Determination of anionic surfactants	238
	Determination of cationic surfactants	239
11.4.9	Miscellaneous	239
	Determination of chloride	239
	Determination of sulphate	240
	Preparation of reagents	240
	Preparation of indicators	242
	References	242
	<i>Index</i>	243

The colour plate section can be found between pages 138 and 139

Preface to Technical Series

For more than 60 years, the Society of Dairy Technology (SDT) has sought to provide education and training in the dairy field, disseminating knowledge and fostering personal development through symposia, conferences, residential courses, publications, and its journal, the *International Journal of Dairy Technology* (previously known as the *Journal of the Society of Dairy Technology*).

In recent years there have been significant advances in our understanding of milk systems, probably the most complex natural food available to man. Improvements in process technology have been accompanied by massive changes in the scale of many milk-processing operations, and the manufacture of a wide range of dairy and other related products.

The Society has now embarked on a project with Wiley-Blackwell to produce a Technical Series of dairy-related books to provide an invaluable source of information for practising dairy scientists and technologists, covering the range from small enterprises to modern large-scale operation. This fifth volume in the series, the third edition of *Cleaning-in-Place: Dairy, Food and Beverage Operations*, now under the editorship of Dr Adnan Tamime, provides a timely and comprehensive update on the principles and practice of the cleaning-in-place of process equipment. Thanks to the perishability of milk and many milk products, the dairy industry has been in the vanguard of the development of cleaning techniques and associated hygiene requirements. These are equally valid for other sectors of the food and bioprocessing industries, and this book will provide a valuable resource for food and dairy technologists.

Andrew Wilbey
Chairman of the Publications Committee, SDT

Preface to Third Edition

The first edition of this book was published in 1959 by the Society of Dairy Technology (SDT), and was entitled *Cleaning-In-Place (CIP) of Dairy Equipment*. An updated second edition, edited by A.J.D. Romney, was published in 1990.

Although the original title of the publication was orientated towards the dairy industry, the technical aspects of cleaning-in-place allow a broadening of the target audience towards readers concerned with food and beverage operations. The processed food industry has seen a major shift towards CIP over the past 10–15 years, and the beverage industry, which has been broadly in line with dairy industry technology, has seen increased demands from customers with regard to CIP verification and validation, and the attendant improvements in plant hygiene and related efficiency.

The book has been extensively revised and updated in this new edition. The two chapters on Chemistry of Detergents and Chemistry of Disinfectants have been combined into one chapter, and sections on Fluid Flow Dynamics and Laboratory Test Methods now appear as separate chapters. One new chapter on the subject of Membrane Cleaning has been added. This is a relatively new area and requires specialised cleaning products and procedures.

Authors have been selected from within the industry, allied suppliers and academia to provide a balanced and leading-edge assessment of the subject matter. Whilst the second edition has been a very popular publication, it is now rather outdated, and this revision is timely. The book will be a valuable addition to the SDT's Technical Series, offering the latest information on CIP to readers within the dairy, food and beverage processing industries internationally.

A.Y. Tamime

Preface to Second Edition

Following the highly successful rewriting of the Society's *Pasteurizing Plant Manual* in 1983, a need was identified to update the manual on *In-Place-Cleaning of Dairy Equipment*, published in 1959 and out of print for some years.

To this end, a decision was taken by the Council to reconstitute the Dairy Equipment and Standardisation Committee disbanded in 1974; this committee was re-formed in 1985 under the new title of the Dairy Equipment Advisory Committee (DEAC), part of its brief to progress this task.

A listing of the proposed chapter headings and possible authors was drawn up, and I was invited to take on the role of both coordinating and editing the new work.

To all those who have contributed to the text and provided the illustrations for this project I extend most hearty thanks, both on my own behalf and on that of the Society. My gratitude goes also to my good friend and mentor, Tom Ashton, both for the Foreword to this edition and for his guidance and support in the past.

It is the hope of the Council, of all the members of the DEAC and of myself that this work will prove of value, to dairy managers and quality assurance staff as well as to students entering our industry.

A.J.D. Romney
1990

Preface to First Edition

In 1953, the Society of Dairy Technology published the *Pasteurizing Plant Manual*. The success of that venture encouraged the Dairy Equipment and Standardisation Committee to consider what could be done further in this new field of the Society's activities. Once again the inspiration, and much of the preliminary work, came from the late J.R. Cuttell. In producing this book, the Drafting Committee has been guided by the inspiration and has endeavoured to achieve a result worthy of the original conception.

The text has been written by Dr T.R. Ashton, Mr G.H. Botham, Dr L.F.L. Clegg, Mr H.C. Cooper, the late Mr J.R. Cuttell, Mr H.S. Hall, Mr H.C. Hillman, Mr P.A. Lincoln, Dr R.J. MacWalter and Mr W.W. Ritchie assisted by their colleagues on the Drafting Committee, Mr T.A. Hole, Mr E.L. Jarvis, Mr J.R. Rowling, Mr W. Rushton and Mr G.E. Taylor. The task of editing has again been taken by Dr J.G. Davis.

The Drafting Committee wishes to acknowledge gratefully the substantial contributions to its work by Mr P. O'Niell, who has acted as Secretary, and Miss E.G. Dunworth, who has undertaken the typing and duplicating work. The Committee greatly appreciates the facilities provided by the National Dairymen's Association, in whose offices all the meetings have been held.

Illustration material has kindly been provided by the APV Co. Ltd, Clarke-Built Ltd, CP Equipment Ltd, Dairy Pipe Lines Ltd and Talbot Stead Tube Co. Ltd. Mr H.C. Cooper has designed the cleaning circuit illustrations.

It is the hope of the Drafting Committee that this book will serve as an introduction to what is a comparatively new subject and so pave the way to the wider use of modern techniques.

H.S. Hall
1959

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1 Principles of Cleaning-in-Place (CIP)

M. Walton

1.1 Introduction

Cleaning-in-place (CIP) is now a commonplace activity in almost all dairy, beverage and processed-food production plants. The processed food industry has seen a major shift towards CIP over the past 10–15 years, and the beverage industry, which has been broadly in line with the dairy industry technology, has seen increased demands from customers in terms of CIP verification and validation to provide improvements in plant hygiene, finished product quality, and related shelf-life and microbiological considerations.

The highest standards of plant hygiene are an essential prerequisite for the production of any high-quality product being produced for human consumption. The cleaning and subsequent disinfection or sterilisation of any item of processing plant or equipment must be carried out with the utmost care and attention if the final product quality is to be fully assured. In earlier days, cleaning tended to be a manual process; indeed, it still is today in many small-scale operations, especially in the processed food sector, where a combination of manual strip-down clean and rebuild is common. Where manual cleaning is still practised, it is vital that there is meticulous attention to detail, because – for reasons of the health and safety of the operative – only mild and comparatively cool chemical solutions, detergents and disinfectants can be used, and strict adherence to cleaning procedures is critical. In larger-scale operations, and where more complex plant and equipment may be involved, the most usual approach today is to employ CIP, and it is to this aspect of cleaning technology that this book is primarily devoted, with a view to providing an understanding of the concepts and application of CIP in the processed food, pharmaceutical, dairy and beverage sectors.

1.2 Cleaning-in-place (CIP): definition

In the 1990 edition of the Society of Dairy Technology manual *CIP: Cleaning in Place*, CIP was defined as:

The cleaning of complete items of plant or pipeline circuits without dismantling or opening of the equipment and with little or no manual involvement on the part of the operator. The process involves the jetting or spraying of surfaces or circulation of cleaning solutions through the plant under conditions of increased turbulence and flow velocity.

This was taken from the National Dairyman's Association (NDA) Chemical Safety Code, which was published in 1985; although the NDA has been superseded, their definition of CIP is still felt to be quite appropriate.

1.3 CIP systems: hardware

CIP units comprise vessels for storage and recovery of cleaning solutions, along with valves, pumps, pipelines and field instrumentation to allow cleaning to take place, usually automatically. They vary in complexity and degree of automation, and hence their efficiency and cost-effectiveness are also variable. For example, the single-use CIP units tend to be very expensive to operate (detergent, water and energy requirements are high), but can be much more hygienic as the chance of cross-contamination and potential spore formation is greatly reduced. Full recovery systems with large detergent storage tanks are usually multifunctional and tend to be relatively economic in operation, but need to be closely monitored to prevent the build-up of soil residues in the dilute detergent or recovered rinse tanks due either to the inherent recovery efficiency of the set or perhaps to poor pre-rinsing. It is therefore very important to refresh cleaning solutions on a regular basis.

1.4 The processes of cleaning

The cleaning processes, whether manual or automated and throughout all industry sectors, tend to follow similar principles, and will usually consist of a series of discrete stages or cycles, generally including:

- removal of gross debris (product recovery)
- pre-rinse
- detergent recirculation
- intermediate rinse
- second detergent recirculation (optional)
- intermediate rinse
- disinfection
- final rinse

1.4.1 *Removal of gross debris (product recovery)*

In manual cleaning operations, this tends to refer to removal of any residual product by mechanical means prior to introduction of a water rinse. In CIP applications, removal of gross debris generally involves draining product from the system to be cleaned under gravity, or physically displacing the product using various media, such as compressed air, water or a mechanical pigging device. This stage is often incorporated into the pre-rinse cycle of the cleaning programme with the addition of a divert valve system to facilitate product recovery into a suitable vessel or direct routing to drain. Control of this feature is quite often via automated valve and timer, but it is also possible to use more sophisticated methods, such

as turbidity or conductivity sensors in the return line. It is important to include an override timer into these systems as a 'failsafe' in order to avoid filling a product recovery tank with pre-rinse water if the system fails to activate the divert valve: this is not an uncommon situation, with probe and controller maintenance being a critical aspect of successful operation. Product recovery systems are becoming more sophisticated with the introduction of membrane plants that are designed to remove high levels of water from the effluent stream – often termed 'white water' in the dairy sector – to allow the recovered solids to be sold on for re-processing: these plants are effective at reducing effluent loading, and can form part of site pollution prevention and control (PPC) systems (e.g. The Environmental Protection Act; Anonymous, 1990).

1.4.2 *Pre-rinse*

Pre-rinse cycles often utilise recovered 'water' from the intermediate rinse stage (see Section 1.4.4). This serves two purposes: first, to reduce total water consumption (and effluent generation); and second, to utilise any heat energy and possible residual detergent solution carried into the recovered rinse tank during the rinse recovery stage. It is not uncommon to find heated pre-rinse systems in certain applications, such as cream production, where the hot pre-rinse solution provides a greatly enhanced method of product residue removal. The pre-rinse stage is important because it is not desirable to introduce excessive soiling into the dilute detergent tank. This stage is generally controlled via a timer, sometimes split between product recovery and drain, and these timers are often set at excessive levels to ensure maximum product removal. However, this may not be cost-effective in circumstances where water and effluent costs are high. In general, the pre-rinse cycle for tanks, silos or vessels consists of several 'burst' or 'pulsed' rinses, as this both improves rinsing efficiency and can reduce water consumption significantly.

1.4.3 *Detergent circulation*

This is where the main task of cleaning takes place, resulting in the soil being lifted from the plant surface and held suspended or dissolved in the detergent solution; for the selection of suitable detergents see Section 1.5.5, but an important attribute of the detergent should be the ability to prevent any soil from being redeposited during recirculation. Recirculation timings need to be assessed by experimentation and a degree of experience, with timing generally varying from 15 min up to 1 h, where exceptionally large and complex circuits are being cleaned. Contact times can be reduced by offsetting the potentially reduced cleaning effectiveness with higher temperatures, higher concentrations, or the use of more sophisticated (and expensive) detergent formulations. Cycle timers are often set to start counting down once the temperature set point has been reached in the return leg: this can lead to excessive cleaning times if the efficiency of the heating system is inadequate. It is important, for example, to ensure that tanks incorporating a water-cooling jacket have the jacket drained prior to CIP. Depending on detergent formulation, foaming can sometimes be a problem, and it is often associated with product contamination. It can also be caused by many other factors, including air entrainment via leaking pump seals; the use of totally softened water supplies can also be a contributory factor. It is also possible to utilise an acidic detergent for

the main cleaning step: this is quite common in both the dairy and beverage sectors, where milk residues in ‘cold/raw’ milk areas respond well to acidic detergents, and in the brewing sector, where acidic detergents have significant advantages over alkaline detergents in their ability to clean under CO₂ environments without loss of activity. Combined detergent/disinfectant chemical blends may be used in the cleaning cycle itself, though this approach has comparatively limited application, as they can be adversely affected by high soil loading, and the ratio of detergent to disinfectant can become imbalanced.

1.4.4 *Intermediate rinse*

The intermediate rinse serves to remove all traces of detergent and entrained soil from the plant being cleaned and, in a partial recovery situation, to recover as much detergent (and thermal energy) back to the dilute detergent tank as possible; it also may need to be sufficient to cool the plant down ready for disinfection and/or refilling. The intermediate rinse should use potable water, and is normally cold, although – if a warm secondary detergent step is being incorporated – it may be desirable to use hot water (if available from sources such as recovered and suitably treated condensate). The intermediate rinse is often recovered and reused as the pre-rinse for the next cleaning cycle.

1.4.5 *Second detergent circulation (optional)*

Some systems utilise a secondary detergent cycle, often an acidic detergent to follow an alkaline product in the first detergent stage. This is common practice where built detergents are not being used (sodium hydroxide liquor followed by nitric acid was once very common), and also where there are high levels of process-generated soils, such as in heat exchangers and cheese vats.

1.4.6 *Second intermediate rinse*

This second intermediate rinse will almost always use cold potable water. The quality of this water is critical, if there is to be no disinfection stage. Some sites that do not use a discrete disinfection stage in the CIP cycle ensure the quality of their potable water by treating it with chlorine dioxide.

1.4.7 *Disinfection*

The disinfection cycle is usually undertaken cold, and often uses an oxidising biocide, such as sodium hypochlorite or peracetic acid solution (equilibrium mixture of acetic acid and hydrogen peroxide). Some non-oxidising biocides are also available, but they must be low foaming and fast acting in cold water in order to be effective for CIP. It is also possible to use hot water at the disinfection stage rather than a chemical agent; this is also very effective, but requires a high thermal energy input, which can prove costly.

1.4.8 Final rinse

The final rinse stage should be undertaken using cold potable water. Again, the quality of this water is critical, as it can lead to post-disinfection contamination and product spoilage.

1.5 Planning a cleaning project

Above all else, the paramount consideration in the planning of any cleaning project must be safety – not only of the plant and personnel involved, but of the product which that plant is required to process. The mid-1980s saw a dramatic reappraisal of many of the standards and practices previously regarded as acceptable within the dairy industry, following incidents – both at home and overseas – of contamination of products by micro-organisms rarely ever encountered as presenting problems of any significance, other than in raw milk supplies, to the average United Kingdom dairyman. Problems of *Salmonella* spp., *Listeria* spp. and *Yersinia* spp. contamination in finished product have all played their part in accentuating the need for stringent food hazard assessment in every field of activity; cleaning technology is not least among these. The interconnection of ‘raw’ and ‘processed’ side plant and pipelines into a single cleaning circuit, or the separate cleaning of ‘raw’ and ‘processed’ side equipment from a common CIP set – frequently encountered in the days when the fashion was for large, multi-purpose, centralised cleaning systems – is now generally considered to present unacceptable product risks. The trend is now strongly towards the use of smaller units, specifically dedicated to either raw or finished products, or to the cleaning requirements of individual circuits and plant equipment items. The total separation of the ‘raw’ and ‘processed’ sides of a factory – the only point at which the two ever come together being the flow diversion valve of the processing plant – should be the basic design objective of every process engineer. This approach may, in some installations, carry a capital cost penalty, but the advantages in quality assurance and generally lower revenue operating costs weigh heavily on the benefit side. Such an approach need not, of course, preclude the use of a common centralised control system; the need for programme safety interlocks between the individual systems is vital to such an approach.

Before embarking on any cleaning project, however, a considerable number of questions have to be answered regarding the actual equipment to be cleaned and the standards of cleanliness to be achieved.

1.5.1 What is the physical nature of the plant or equipment to be cleaned?

Any food manufacturing or processing plant will comprise many different items of equipment: for example, dairies and breweries will have plate heat exchangers, storage tanks, vats, pumps, valves, and interconnecting pipework, as well as specialised items, such as bottle and carton fillers or – on the manufacturing side – cheese plant, evaporators, spray dryers and continuous butter-makers. Each of these will have its own cleaning requirements, and pose its own individual cleaning problems. Food processing plants are probably the most diverse sector in terms of equipment design and cleaning requirements, and full consideration needs to be given to the design of this equipment with respect to CIP. Materials of

construction must be considered, not only regarding any metal parts, but also items such as gaskets and similar rubber components, and plastic mouldings, to ensure their compatibility with the cleaning chemicals proposed regarding corrosion or degradation. Questions as to temperature and pressure or vacuum limitations of the equipment must be considered, all aimed at answering the overriding question: 'Can the plant be cleaned safely and effectively by in-place methods, achieving acceptable standards of cleanliness without damage to the plant itself?'

1.5.2 *What standards of cleaning are required?*

It is important to understand that various degrees of cleanliness may be appropriate in different circumstances. It is vital that this is clearly recognised, and the target level of cleanliness defined when considering any cleaning project. Levels of cleaning that might be considered are as follows.

- *Physically clean*: This primarily addresses the aesthetic aspect. The surface appears clean, but chemical residues, often deliberately left to achieve a particular desired effect, may have been allowed to remain. Disinfection of the surface has not been considered.
- *Chemically clean*: The surface is rendered totally free from any trace of chemical residues.
- *Microbiologically clean*: This addresses the degree of microbiological contamination remaining on the surface, and may range from plant that has been 'disinfected' – that is, the number of bacteria on the surface of the equipment has been reduced to a level consistent with acceptable quality control and hygienic standards – to surfaces rendered totally sterile, as is essential in ultra-high-temperature (UHT) and similar aseptic operations.

One can thus reach a situation where the surface involved has been physically cleaned and has, perhaps, been rendered microbiologically clean by chemical disinfection, but traces of substantive disinfectant chemical have been deliberately left on the surface to reduce the risk of subsequent microbiological contamination, and the surface is therefore still chemically 'contaminated'.

1.5.3 *What is the nature of the soil to be removed?*

Soil can be considered as the product residues, scale and any other unwanted deposits of foreign matter that have to be removed from the plant surfaces during the cleaning process. Within the manufacturing or processing dairy, such soil may include fat, protein (both denatured and un-denatured: see IDF, 1997), sugar (possibly caramelised), minerals (both from product and from the water supply), fruit cells and various manufacturing ingredients including gums, starches, stabilisers and emulsifiers – all of which will present different and often complex cleaning problems to the detergent chemist. In the dairy context, soil can be divided into two broad general headings: organic soil, which is mainly of plant or animal origin, and is generally most susceptible to attack by alkaline detergents; and inor-