

**1550.1800 FILLING BOTTLES.**

Subpart 1. **General.** Beverage containers shall be filled and sealed in a sanitary manner. The operator or the operator's clothes shall not come in contact with any portion of the container or machinery which might result in contamination of the product.

Subp. 2. **Sealing of bottles; closures.** Closures, (caps, crowns, seals, etc.) must be new; not previously used. New closures are to be properly protected in storage and use from contamination and stored until used in a sanitary manner which protects them from airborne contamination. Sealed bottles containing noncarbonated water must have a tamper-proof tight closure which will show evidence of tampering or opening prior to use.

Subp. 3. **Satisfactory compliance.** This part is deemed to be satisfied when:

A. Syrup, base, water, and carbonated or noncarbonated (still) beverages are introduced into returnable bottles and similar one-trip containers and sealed by means of automatic machinery.

B. Crowns, caps, or lids which have been touched on the inner side by the operator as may occur while adjusting the machinery or are contaminated in any other way are to be discarded.

C. If the filling and sealing devices are not integral parts of one machine, but are performed by separate units of equipment, they are to be arranged to exclude manual contact with necks or tops of the container between filling and sealing.

D. The equipment is maintained in good repair and in a clean and sanitary condition at all times.

E. All sealed bottles containing noncarbonated water shall be sealed with closures, caps, crowns, or seals which shall be constructed and designed to show evidence of tampering or prior opening.

**Statutory Authority:** *MS s 31.10; 31.101*

**History:** *17 SR 1279*

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