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Food Safety Overview In The Production of Roasted Chicken Legs For Ci Airlines AT PT. AFD

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Abstract
The HACCP system is a preventive approach to ensuring food safety implemented by PT AFD in the production of Roasted Chicken Legs for airlines. This study was conducted through observation of the production stages and identification of critical control points (CCPs). There are five main CCPs that are strictly controlled, namely cold/frozen ingredient reception, storage, cooking, blast chilling, and portioning. The results of the observation show that all stages have met HACCP standards, with the support of seven OPRPs to maintain a hygienic environment and work practices. The role of Quality Control is vital, but the collaboration of the entire production team is also key to the success of this system. PT AFD Indonesia has successfully implemented HACCP and OPRP effectively with five main CCP points to maintain the quality and safety of Roasted Chicken Leg. It is recommended to improve consistency in implementation through regular training, digital recording, and production supervision.
Keywords: CCP, food safety, HACCP

1. Introduction

Food is a basic human need that continues to increase with the times. The more advanced a nation is, the greater the attention paid to food quality and safety [1]. In the food service industry, providing safe and high-quality food is an important factor in building customer trust and loyalty. One sector that has experienced an increase in demand is airline catering. Therefore, catering companies are required to produce food that is not only delicious and nutritious, but also safe for consumption [2].

PT. AFD is an international inflight catering service company spread across various regions in Indonesia, including Unit D. This unit has been certified with ISO 9001 and ISO 22000. ISO 9001 sets quality management system requirements to ensure product and service quality, while ISO 22000 requires the implementation of GMP (Good Manufacturing Practice), SSOP (Sanitation Standard Operating Procedure), and HACCP (Hazard Analysis Critical Control Point) [3]. As an airline catering service provider, PT. AFD is required to consistently implement food safety standards to ensure the safety and quality of its products.

Hazard Analysis Critical Control Point (HACCP) is a control system that aims to prevent potential hazards by identifying critical points in the food production process . This system is a form

of prevention-based risk management to ensure overall food safety [4]. In its application, each stage of production has a Critical Control Point (CCP) that must be strictly controlled. PT. AFD implements five CCPs, namely: CCP 1 (receipt of cold and frozen raw materials), CCP 2 (cold and frozen storage), CCP 3 (cooking process), CCP 4 (blast chilling), and CCP 5 (dishing and portioning). In addition to the HACCP system, PT. AFD also implements an Operational Prerequisite Program (OPRP). This system serves to control potential hazards and prevent contamination or the growth of food safety hazards, both in products and in the processing environment.

Roasted Chicken Leg is one of the main courses produced by PT. AFD for CI Airlines economy class. In its processing, this menu has implemented the HACCP and OPRP systems so that it remains safe and does not spoil even when traveling long distances by air. Based on this background, the issues that can be identified in this activity are how HACCP and OPRP are implemented in the processing of Roasted Chicken Leg at PT. AFD, and how the Critical Control Point (CCP) stages are applied to ensure the quality and safety of food served on long-haul flights. The urgency of this research lies in the importance of implementing an effective food safety system in the airline catering industry, given that food for flights has a high risk of microbiological contamination due to the long distribution chain, repeated storage (refrigeration and reheating), and limited processing facilities on board the aircraft.

2. Material and Methods

This research was conducted in the inflight catering department of PT. AFD for 4 months from February to June 2024 using observational and descriptive methods on the production process of the Roasted Chicken Leg menu. The results of the observation were described in narrative and table form. The analysis of CI airline food products was carried out by identifying potential hazards and implementing Hazard Analysis Critical Control Point (HACCP) and Operational Prerequisite Program (OPRP) as determined by PT.AFD.

3. Results and Discussion

3.1 Raw Material Receipt

The acceptance of raw materials for CI airline's Roasted Chicken Leg menu was carried out through stages starting from the submission of a Purchasing Request (PR) by the store and kitchen departments, which was then processed by the purchasing department into a Purchasing Order (PO) and sent to vendors according to the specified quantity and schedule. If there was a shortage of materials, the kitchen would submit a request to the store department for follow-up. Vendors delivering ingredients must comply with hygiene standards, such as wearing hairnets, closed shoes, and special uniforms, as well as ensuring that their vehicles are clean, rust-free, and specifically used for food [5]. Raw materials received are classified into three groups, namely vegetables and fruits, cold and frozen ingredients, and other ingredients, with a predetermined receipt schedule to support management efficiency [6]. The schedule for receiving raw materials can be seen in Table 1.

Table 1
Raw Material Receiving Schedule

No	Item	Waktu
1.	Vegetables and Fruits	08.00-11.00 WITA
2.	Chilled and Frozen Products	11.00-14.00 WITA
3.	Other	14.00-16.00 WITA

Raw materials are placed in baskets categorized by vendor. The color categories for the baskets are shown in Table 2

Table 2
Raw material receiving basket categories

No	Basket Color Product Type	Basket Color Product Type
1	Green	Vegetables and Fruits
2	Yellow	Meat
3	Blue	Ready to eat food
4	Gray	equipment

After raw materials are received and grouped, the next process is checking by the store and Quality Control (QC) team. The vendor and store are responsible for ensuring that the quantity of materials received matches the order. Meanwhile, QC is tasked with evaluating the quality of raw materials and recording the results of the check on the incoming material form. Quality checks include vehicle and ingredient temperature, physical condition, cleanliness, halal logo, size, ripeness and sweetness, and expiration date [7]. Ingredient quality is recorded based on four categories: chill and frozen food, dry goods, vegetables and fruit, and ready-to-eat [8].

3.2 Receipt of Chilled and Frozen Raw Materials

During the receiving process, cold and frozen raw materials are given priority for inspection so that the materials do not thaw easily, which can facilitate microbial growth. Inspections are carried out based on temperature, texture, appearance, and expiration date parameters [9]. Temperature measurements are carried out using a thermometer gun because this tool is able to provide fast, non-destructive, and fairly accurate results for checking the surface temperature of products without having to open the packaging. Several studies have shown that the use of digital infrared thermometers in the food industry is effective in detecting temperature deviations during raw material receipt [10]. Cold products can be accepted at temperatures of 0–5°C, and can still be tolerated at temperatures of 5–8°C provided they are immediately stored in a chiller. Meanwhile, frozen products such as meat must have a hard texture and show no signs of thawing, such as excess liquid due to thawing [11]. If there is a discrepancy between the incoming raw materials and the PO or company specifications, corrective action will be taken through an official report, and the materials will be returned to the vendor. For the CI airline's Roasted Chicken Leg main course menu produced by PT. AFD, frozen or chilled chicken meat raw materials are used, which are included in Critical Control Point 1 (CCP 1). This critical point occurs at the raw material acceptance stage, as listed in Table 3.

Table 3
CCP1 Receipt of Frozen and Chilled Raw Materials

Steps	*Frozen* products: Frozen chicken meat
Hazard	Biological: The growth of microbial pathogens on potentially hazardous food making the product unfit for consumption
Critical Limit	Product is firm and has no signs of *thawing* or wateriness. Product has signs of *thawing* or wateriness
Actual	*Chicken thigh* is frozen, firm and has no signs of *thawing* or watery and the product is accepted
Action	Product accepted Product rejecte

3.3 Receipt of Raw Vegetable and Fruit Materials

The process of receiving vegetable and fruit raw materials at PT. AFD Indonesia begins with a sorting stage to ensure that the quality of the materials received is good and free from worms, caterpillars, dirt, or other foreign objects. Sorting is done by grouping materials based on appearance and size. After that, materials that pass the sorting process are labeled with information on the name of the material, weight, date of receipt, expiration date, and supplier name. Labeled fruits and vegetables are then stored in a chiller to maintain their freshness. According to the FAO (2021), sorting at the reception stage serves to remove materials that are physically or biologically contaminated. 3.2.2 Dry Goods Product Receiving The receipt of dry goods at PT. AFD is not included in Critical Control Point 1 (CCP 1), as there are no critical process stages that require direct control [12], but quality checks are still carried out. The inspection includes the appearance of the goods, expiration date, cleanliness, and ensuring that the goods are free from contamination and physical damage. The dry goods receiving process is generally carried out every day from 2:00 p.m. to 4:00 p.m. WITA and for fresh goods from 9:00 a.m. to 12:00 p.m.

3.3 Storage

After going through the receiving process, the raw materials are then stored in storage rooms that are divided into two types, namely dry storage for dry materials and cold storage for cold and frozen materials. Separation of storage locations is a basic principle in food safety and quality management, as it is directly related to the prevention of cross-contamination and quality stability of materials [13]. Storage in cold storage is included in Critical Control Point 2 (CCP 2), which is divided into two: cold storage (chiller) and frozen storage (freezer) [14]. For chicken meat raw materials used in the Roasted Chicken Leg menu, storage is carried out in a freezer along with other animal-based ingredients such as meat and fish, at a temperature of ≤ -18°C. This temperature is set as the critical limit for CCP 2 because at this step, temperature control can be applied directly and is essential to prevent or reduce microbiological hazards so that the temperature can be controlled [15] and also to maintain the quality and safety of raw materials and prevent microbial growth, so that the materials remain durable and suitable for use in products.

Table 4

CCP 2 Cold and Frozen Storage

Steps	Cold Storage (chilled)
Hazard	Biological: Pathogenic microbial growth (in potentially hazardous food and ready to eat food)
Critical Limit	Chilled food products at refrigerator temperature (Cold storage) and products ≤ 50 C (i.e. potentially hazardous food/chilled food)
Actual	Chiller temperature in accordance with the standard of 2.4°C C
Action	Product is maintained because the temperature is in accordance with the standard
Monitoring	Checking and supervision by the *engineering*..

3.4 Cooking

Cooking is included in Critical Control Point 3 (CCP 3) because it plays an important role in determining the quality and safety of the final product [16]. At this stage, the Quality Control (QC) team checks the final temperature of the product to ensure that each ingredient has reached the critical temperature in accordance with the standard [17]. Each type of ingredient has a different critical temperature limit, and these standards are referenced from the provisions applied by PT. AFD as listed in Table 5.

Tabel 5

Critical cooking temperature limits

Type of Food Ingredient	Critical Cooking Temperature
Meat (beef, mutton), whole shellfish, whole shrimp.	Minimum 65℃
Milk, coconut milk and preparations	Minimum 72℃
Eggs and their products.	Minimum 74℃
Meat cuts, shell fish and Processed.	Minimum 74℃
Poultry and its products.	Minimum 74℃
Beef steak/grill.	Minimum 65℃

The Roasted Chicken Leg cooking process takes approximately 20 minutes at an oven temperature of 150°C. During this process, temperature control is very important and must comply with Critical Control Point 3 (CCP 3) standards set by PT. AFD. For chicken meat cuts and processed products, the minimum critical temperature that must be reached is 74°C. The Roasted Chicken Leg production process has met the standards listed in the table, with the final product temperature reaching 86°C, indicating that the product has been cooked safely and according to procedure. Details of CCP 3 for this process can be seen in Table 6.

Table 6

Cooking Temperature for Roasted Chicken Leg

Steps	Roasted Chicken Cooking
Hazard	Possible biological hazards: bacteria, pathogens, and physical hazards such as hair, stones, or others
Critical Limit	Minimum cooking and final chicken product temperature 74℃
Actual	Suhu produk akhir 86℃
Action	Product is maintained because the final product temperature is in accordance with the standard
Monitoring	Checking and supervision by Quality Control officers .

3.5 Blast Chilling

After the roasted chicken cooking process is complete, the next stage is blast chilling, which is included in Critical Control Point 4 (CCP 4). Blast chilling is a rapid cooling process by placing hot food in a blast chiller, with the aim of lowering the temperature from 60°C to 10°C within a maximum of 4 hours [18]. The main purpose of this process is to prevent food from entering the danger zone for bacterial growth (10°C–60°C), where microorganisms can multiply very quickly and endanger consumer health [19]. With rapid temperature reduction, new bacterial growth can be prevented, food does not spoil quickly, and shelf life is increased [20]. After blast chilling, the product is stored in a chiller at 0°C–5°C and can last up to 72 hours (3 days) [21]. The blast chilling process is classified as a Critical Control Point (CCP) because at this stage, direct control is exercised over significant biological hazards that cannot be eliminated at subsequent stages. If the cooling process is not carried out properly, the risk of microbial growth increases dramatically and can reduce product quality and safety. Therefore, monitoring the temperature and cooling time are critical factors in the application of HACCP principles [22]. Details of CCP 4 are listed in Table 7.

Table 7
Cooking Temperature for Roasted Chicken Leg

Steps	Blast chilling Roasted Chicken
Hazard	Biological: Possible pathogenic microbial growth
Critical Limit	Food temperature must be reduced from 60°C to 10°C for a maximum of 4 hours
Actual	Final product temperature 5.7°C for 3 hours 45 minutes
Action	The product is maintained because the final product temperature is within the standard and the food is put into the *blast chiller* before portioning.
Monitoring	Checking and supervision by quality control (QC) officer)

3.6 Dishing and Potioning

The dishing and portioning process for the Roasted Chicken Leg menu is included in Critical Control Point 5 (CCP 5) and is carried out in two separate areas, namely the hot dishing room for hot food and cold dishing for cold food such as salads and fruit. Before portioning, the Quality Control team sorts the ingredients using a special lamp to ensure there are no defects or foreign object contamination [23]. Products that pass the sorting process are labeled as fit for use [24].

Portioning time is limited to a maximum of 45 minutes with a room temperature between 15–21°C, and food temperature must not exceed 15°C to prevent contamination when food comes out of the blast chiller [25]. Chilling officers are required to use hygienic equipment in accordance with standards, including kitchen clothes, aprons, head and arm covers, and special gloves to avoid cross-contamination [26]. After portioning is complete, the food is placed in baskets labeled according to the day of portioning before being stored in a temperature-controlled room [27]. CCP 5 standards for portioning can be seen in Table 8

Tabel 8
CCP 5 Roasted Chicken Leg Menu Preparation Process

Steps	Hot dishing dan meal tray set up
Hazard	Biological: Possible presence of microbes that are still growing. Physical: The presence of physical hazards such as hair, stones, insects, and others.
Critical Limit	The final curing temperature is a maximum of 15°C with a maximum time of 45 minutes and the room temperature is kept > 15°C and smaller than 21°C.
Aktual	The final temperature after portioning is 15°C and the room temperature is 21°C with a portioning time of 40 minutes.
Tindakan	Verification of the report by the supervisor, as the temperature is not up to standard. If the product temperature is >15°C then the product is discarded
Monitoring	Checking and supervision by the Quality Control (QC) officer)

3.7 Meal Tray Set Up

After the portioning process is complete, the next stage is arranging the food in the Meal Tray Set Up (MTSU) room. In this room, the food is arranged according to the airline's order using two methods, namely manually or with the help of a belt conveyor. The arrangement is carried out based on the food order sheet (FOS) or a complete menu image that has been agreed upon with the airline [28].

For CI airlines, cutlery such as spoons, forks, knives, salt, and pepper are wrapped in special plastic bearing the airline's identity. Trays for economy class are also equipped with mineral water, fruit slices, salad, dessert, butter, sauce, and soft roll bread. The temperature of the MTSU room is maintained between 15–21°C and the maximum working time is 45 minutes, with the food temperature not exceeding 15°C [29]. After all food is arranged according to standards, the trays are placed in a closed trolley and checked for completeness. The complete trolley is then moved to the final holding room or last chiller with a temperature of 0–5°C before being transported to the aircraft [30].

4. Conclusion

Based on observations during research at PT AFD, it can be concluded that this company implements strict quality control through the HACCP and OPRP systems to ensure the safety and quality of the catering products it produces. There are five Critical Control Points (CCPs) that are critical limits in the production process, namely: receipt of cold and frozen raw materials, storage of cold and frozen raw materials, cooking process, blast chilling, and portioning. The implementation of HACCP is overseen by the Quality Control team, which plays an important role in field supervision. However, the success of this system also depends heavily on the cooperation of all staff, especially production staff who interact directly with food. With proper and consistent implementation of the system, the quality of products such as Roasted Chicken Leg, one of the main menu items, will be maintained and meet established food safety standards. To maintain and improve product quality at PT AFD, it is recommended that the implementation of the HACCP and OPRP systems be carried out consistently through regular training for production staff. Monitoring of critical control points (CCP) needs to be strengthened with digital recording and periodic verification. Equipment maintenance and calibration should be carried out on a scheduled basis to ensure the accuracy of quality control. In addition, distribution monitoring must ensure that the cold chain is maintained so that products such as Roasted Chicken Leg remain safe and of high quality.

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