



Wiskerchen Cheese Inc. SOP

Title: Cheese Making

2.014

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| Issue Date: 4/5/11 | Written By: Jesse Norton | Approved By: John Wiskerchen | Revision # New | Revision Date: | Revised By: | Supersedes: | Page 1 of 2 |
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Responsible Party: Trained Pasteurizer Operators, Blue production employees and Feta production employees

I. Homogenization

The pasteurizer operator shall record the homogenizer pressure reading next to vats of cheese that receive homogenized milk on the pasteurizer chart. Milk shall be homogenized for all blue veined cheeses at a pressure between 1350 and 1750 psi.

If homogenization does not occur at the required pressure make a note on the chart and inform plant management and quality assurance for investigation.

II. Make Record Ingredient Use

When filling out the ingredient portion of the make record operators shall record the lot numbers of ingredient used for each vat of production as well as how much of that ingredient was used. Operators should refer to posted ingredient use rate documents to find how much they should use of each ingredient.

III. Make Process Records

A. Blue

1. Curd Setting Check

At the end of the automated setting period the operator shall perform a curd set check to ensure that the coagulum is properly set before moving to the cutting stage.

- i. Determine the readiness of the coagulum by making a very thin vertical slit, about 3-5 cm long, in the surface of the gelled milk.
- ii. Insert the knife blade at a shallow angle under the length of the slit. Gently tilt the knife tip upward to break the coagulum.
- iii. A ready-to-cut curd will break along the slit, forming a deep wound with uniformly curved side walls and with only a little whey at the bottom.
- iv. If the wound tends to collapse, it is not yet ready. If there is much whey, it should have been cut earlier.

The operator shall initial in the curd check – operator / ack time box after performing the curd check. If the cheese needs to be held because the coagulum is not ready then the operator should note this on the make record. When the operator has determined the curd is ready they should acknowledge the check on the automation panel. Record the time of acknowledgement in the curd check – operator / ack time box.

2. Hooping End

When operators are finished hooping a vat they must record the time on the make record. Hooping cheese should take between 30 – 50 minutes.

3. Draining End



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Operators removing cheese from forms and dumping cheese into brine, they must record the time on the make record. Cheese should drain for 12 -20 hours.

B. Feta

1. Time of Setting

Operators shall record the time of setting for each vat of feta cheese on the make record.

2. Curd Setting Check

At the end of the setting period the operator shall perform a curd set check to ensure that the coagulum is properly set before moving to the cutting stage.

- v. Determine the readiness of the coagulum by making a very thin vertical slit, about 3-5 cm long, in the surface of the gelled milk.
- vi. Insert the knife blade at a shallow angle under the length of the slit. Gently tilt the knife tip upward to break the coagulum.
- vii. A ready-to-cut curd will break along the slit, forming a deep wound with uniformly curved side walls and with only a little whey at the bottom.
- viii. If the wound tends to collapse, it is not yet ready. If there is much whey, it should have been cut earlier.

The operator shall initial in the curd check – operator / time box after performing the curd check. If the cheese needs to be held because the coagulum is not ready then the operator should note this on the make record. When the operator has determined the curd is ready they should move to the cutting stage. Record time of the final curd check in the curd check – operator / time box.

3. Agitation Passes

During the agitation stage the operator shall record the number of passes the cheese receives from the paddles. For the purposes of this check a pass is defined as one length of the vat. Feta cheese shall receive 2 passes with the paddles and reduced fat feta shall receive 4 passes with the paddles.

4. Hooping End

When operators are finished hooping a vat they must record the time on the make record. Hooping cheese should take between 40 – 60 minutes.

5. Operators removing cheese from forms must record the time on the make record. Cheese should drain for 16 -20 hours.

Approved By: _____

Date: _____