**Section 743.20 Food, Consumer Containers, Equipment Maintenance and Operations**

a) Food Sources. All food offered for sale through vending machines shall be manufactured, processed and prepared in commissaries or establishments which comply with all applicable State laws and rules.

b) Food Packaging. All food shall be stored or packaged in clean protective containers, and shall be handled, transported and vended in a sanitary manner.

c) Condiments. Condiments provided for service in conjunction with food dispensed by a vending machine, shall be packaged in individual portions in single service containers or shall be dispensed from approved sanitary dispensers which are washed, sanitized and filled at the commissary.

d) Fresh Fruits. Fresh fruits which may be eaten raw without peeling, may be dispensed unpackaged but must have been thoroughly washed in potable water at the original packing plant or immediately before being placed in the vending machine.

e) Wet Storage. Storage of cartoned, bottled, canned or packaged food by placing or submerging it in a liquid is prohibited. Submerging such containers of food in ice is prohibited.

f) Potentially Hazardous Food Dispensing. Potentially hazardous food offered for sale through vending machines shall be dispensed to the consumer in the individual original container or wrapper into which it was placed at the commissary or at the manufacturer's or processor's plant, or such products shall be dispensed into single-service containers from bulk containers which were filled at the commissary or at the manufacturer's or processor's plant. In those vending machines which dispense potentially hazardous food from bulk, the bulk supplies of such food shall be transferred only bulk vending machine containers and appurtenances which have been cleaned and sanitized.

g) Potentially Hazardous Food Temperatures.

1) Potentially hazardous food within the vending machine shall be maintained at a temperature at 45°F. or below, or 140°F. or above, whichever is applicable: Provided, that exceptions may be made for

A) the actual time required to load or otherwise service the machine and for maximum recovery period of 30 minutes, following completion of loading or servicing operation; and

B) in the case of hot food vending machines, a maximum of 120 minutes to heat food through the 45°F. to 140°F. temperature zone.

2) In hot food vending machines which are not equipped with refrigerated storage, there shall be no time delay to preclude heat from being applied to potentially hazardous food immediately after it is loaded or placed in the machine. Potentially hazardous food once heated to, or held at, a temperature of 140°F. or above, shall be maintained at such temperature until served or discarded.

h) Vending Machine Controls.

1) Vending machines dispensing potentially hazardous food shall be provided with adequate refrigerating or heating units, or both, and thermostatic controls which insure the maintenance of applicable temperatures at all times. Such vending machines shall also have controls which prevent the machine from vending potentially hazardous food until serviced by the operator, in the event of power failure or other condition which results in noncompliance with temperature requirements in the food storage compartment.

2) Hot food vending machines designed to heat food through the 45°F. to 140°F. temperature range, shall also be equipped with automatic controls which render the machine incapable of vending potentially hazardous food until serviced by the operator in the event that heating through this temperature range is not accomplished in 120 minutes or less.

i) Thermometers. Vending machines dispensing potentially hazardous food shall be provided with one or more thermometers which, to any accuracy of ±2°F., indicated the air temperature of the warmest part of the refrigerated food storage compartment, or the coldest part of the heated food storage compartment, whichever is applicable.

j) Vending of Mild & Fluid Milk Products. Mild and fluid milk products offered for sale through vending machines shall be pasteurized and shall be dispensed only in individual, original containers or from bulk containers into which such product was placed at the milk plant: Provided, that such products may be reconstituted automatically within the vending machine when

1) the powder or concentrate is made from a pasteurized milk or mild product and is from an approved source;

2) the mixing chambers or bowls and any food-contact surface downstream from such mixing units are maintained at safe temperatures; and

3) the product is reconstituted for immediate dispensing in individual unit servings.

k) Cleaning & Sanitizing of Canisters. Vending machine canisters and appurtenances used for the transfer of milk products shall be effectively cleaned and sanitized at approved, fixed facilities at the commissary by methods approved by the health authority. After sanitization, the canister and appurtenances shall be fully wrapped in a single-service bag or cover which shall not be opened until the canister unit is installed in the refrigerated compartment of the vending machine. Canisters and appurtenances shall be so designed and constructed that the handling of product contact surfaces at the machine location is unnecessary; and, such surfaces shall not be handled during canister installation, tube insertion, or product transfer.

l) Cleaning & Sanitizing Bulk Milk Vending Machines. All parts of any bulk milk vending machine which come into direct contact with the milk or milk product shall be effectively cleaned and sanitized at the milk plant. Provided, that single-service dispensing tubes which receive sanitizing treatment at the fabricating plant and which are individually packaged in such manner as to preclude contamination, may be exempted from this provision. The can or other bulk milk container shall be filled only at the milk plant and shall be sealed in such manner as to make it impractical to withdraw any part of its contents or to introduce any substance without breaking the seal or seals. The delivery tube and any milk-contact parts of the dispensing device shall be attached at the milk plant, and shall be protected by a moisture-proof covering, or housed in a compartment with a moisture-tight closure which shall not be removed until after the container is placed in the refrigerated compartment of the vending machine.

m) Cleaning & Sanitizing of Multiuse Containers and Potentially Hazardous Food Contact Surfaces. With the exception of food-contact surfaces of bulk milk vending machines for which separate provisions for cleaning and sanitizing are specified in subsection (l) above, all multiuse containers or parts of vending machines which come into direct contact with potentially hazardous food shall be removed from the machine daily and shall be thoroughly cleaned and effectively sanitized at the commissary or other approved facility: Provided, that the requirement for daily cleaning and sanitizing may be waived from those food-contact surfaces which are maintained at all times at a temperature of 45°F. or below, or 140°F. or above, whichever is applicable, and an approved cleaning frequency is followed. Such parts shall, after sanitizing, be protected from contamination.

n) Cleaning Nonpotentially Hazardous Food Contact Surfaces. All parts of vending machines which come into direct contact with other than potentially hazardous food shall be thoroughly cleaned by approved methods. The frequency of such cleaning shall be established by the health authority based upon the type of product being dispensed. A record of such cleaning operations shall be maintained by the operator in each machine or shall be made available at the time of inspection and shall be current for at least the past 30 days.

o) Care & Handling of Single Service Articles. All single-service articles shall be purchased in sanitary cartons or packages which protect the articles from contamination, shall be stored in a clean, dry place until used, and shall be handled in a sanitary manner. Such articles shall be stored in the original carton or package in which they were placed at the point of manufacture until introduced into the magazine or dispenser of the vending machine. Single-service articles stored with-in the vending machine shall be protected form manual contact, dust, insects, rodents and other contamination.