

## Yama-ei agricultural products processing plants

### New Standard of Safety and Security

In order to fulfill necessary safety standard for edible tea, Yama-ei established original sanitation management system and constructed agricultural products processing plants.

We proceed consist process from producing to bagging / shipping process.

Yama-ei was entrusted as the first HACCP Universal Promotion Office in tea industry by Shizuoka prefecture in 1998.

In 2002, we were also recognized as Mini-HACCP plant by Shizuoka Japan food hygiene Association.



### Yama-ei agricultural products processing plants approved by Mini-HACCP

Tea leaves that were picked by contracted tea farmers are processed to dried tea leaves within that day and brought to proceeding plants.

Processes here are sorting, firing, component combining and so on to make finishing tea and bagging process.

Yama-ei designed the agricultural products processing plants under the presupposition to produce “edible tea”.

Therefore, the safety standard was set up at much higher level compared with general tea factories' standard.

For instance, the total system of the factory was made into Clean Room, and installed Bacteria Inspection Room to guarantee safety and quality.

For our endeavor to attain safety, Yama-ei was entrusted as the first HACCP Universal promotion

office in tea industry by Shizuoka prefecture in 1998,  
And also recognized as Mini-HACCP plant by Shizuoka Japan food hygiene Association in 2002.  
Besides the sanitation quality management system of HACCP from raw material to final product,  
inner auditors of ISO14000 are continuously present in the factory to make sure to observe  
product standard and to manufacture safe and secure products.  
Processes from dried tea leaves to finishing tea is as follows.  
We will introduce the flow of materials from carry-in of dried tea leaves to shipping of finishing  
tea together with the attempt to make safe and secure product in the factory.

## What is HACCP

HACCP or Hazard Analysis and Critical Control Points is originated by NASA (National Aeronautics and Space Administration) in 1960's as a part of space development.  
The work is to make a “Manual” by analyzing manufacture processes in the detail and presupposing possible hazard in advance.  
In every step, work should be recorded about-When, Where, Who, Why With which standard and How the work was done.  
These records must be kept as 'Document'.  
By these documents you can easily confirm the product history and process control.  
In case of some accidents, research of the causes and corrective actions can be done quickly.  
So, this system is gradually established as Food Inspection System for all production processes.  
Yama-ei aims the biggest target that products of no food poisoning or no incorporation of foreign materials or coliforms or agricultural residues.

## Total system of the factory was made into Clean Room

All the rooms such as processing, work in process refrigerator and bagging operation room were made into Clean Room by installing clean room panels.  
Triple filters of moth- proofing nets, pre-filters and HEPA (high efficiency particulate air filter) were applied for intake to introduce only clean air.  
Positive pressure structure (convection system/ duct method) was adopted in order to prevent

from dust and insects invading.

Sanitary management such as measures for bacteria

Every step from tea process to bagging/wrapping process is on-line automatic controlled and realized hygienical environment.

In the tea produce process, tea leaves are treated by microwave for sterilization.

General active bacteria and coliform group bacteria are checked in the inspection room.

Especially for active bacteria check, we set strict self-regulatory value of 1/10 of general standard.

Good equipment, good tea leaves and experienced technology,

To make good tea

Good tea is well-balanced of three elements “taste, flavor and color”

In order to make good tea, good tea-leaves as raw material, good equipment, and more important than else experience and technology of the staffs are all important.

This tea manufacturing work is to blend dried tea leaves and firing according to customer's taste.

So, the work can be liken to the work of piano tuner, tuner of “taste, flavor and color” melody.

In Yama-ei company, so Japanese tea instructor; sommelier of green tea and specialists at Tocha-kai; Technical competition Committee are endeavoring to make delicious tea.

## Overview of agricultural products processing plants

* Name	: Yama-ei agricultural products processing plants	
*Location	: Ono-175-3 Kakegawa-city, Shizuoka, Japan	
*Site area	: 1,950.00 sq. meters	
*Construction area	: 1,273.56 sq. meters	
*Floor area	: Basement 1st floor	516.72 sq. meters
	First floor	1,189.80 sq. meters
	Second floor	135.76 sq. meters
	(Total)	1,842.28 sq. meters

\*Profile of main chambers :

Basement 1st floor

- + Raw material refrigerator 320 square meters (ceiling height 4.1m) max. 100.000kgs
- + Desiccant chamber 20 square meters

First floor

- + Tea proceeding room 320 square meters (ceiling height 6.9-8.7m)
- +Work in process refrigerator 176 square meters (ceiling height 8.3m)
- +Material room 70 square meters (ceiling height 3.3m)
- +Bagging operation room 280square meters (ceiling height 3.3m)

\*Production capacity

- +Green tea proceeding line 2,000kgs/ Day
- +Bagging-Packaging line 10,000pieces/Day

\*Profile of Work in process refrigerator

- +Rack warehouse 896 buckets
- +Space for placed flat 30 containers max. 45.000 kg



Green tea processing room



work in process refrigerator



Bagging operation room



Bacterial inspection room

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Main business : Manufacture and sales of green tea, processing of foods blended with green tea.

Yama-ei started the business of manure as Yamasaki Ei-ichi Shouten in 1927 (Shouwa 2-nen)  
In Shouwa 20's, started investigation of organic manure.

Then, began to sell green tea that was grown by original animal organic manure.

Now we produce and sell not only green tea to drink but edible tea and pet foods and so on.

And also we aim to promote seedling method of tea-trees, to introduce mini-HACCP to processing factories to make safe merchandise.