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厚生労働科学研究費補助金
(食品の安心・安全確保推進研究事業)

総括研究報告書

主任研究者 品川邦汎 岩手大学

食品製造の高度衛生管理に関する研究

2. 食品製造の高度衛生管理に関する実験的研究

近年、各種食品製造施設において、食品の安全確保についてより一層の向上を図るため、危害分析・重要管理点方式（HACCP）を導入した衛生管理システムの構築が進められている。HACCP 導入にあたっては、対象食品について発生しうる危害を科学的データに基づいて評価し、原料の搬入から製品となる製造の各段階で発生する危害を分析し、その管理手法を確立することが重要である。

本研究では、食肉生産における牛・豚等の解体処理時における微生物危害、未殺菌生乳を原料とするナチュラルチーズ製造、および冷凍食品製造過程での微生物汚染・危害について、HACCP 構築のためのデータベース化を目的とし、国内外の文献調査による基礎的データの収集と整理を行った。さらに、これらの食品を原因とする食品媒介細菌感染症を防止するために、各食品と密接に関連する病原細菌の汚染実態調査並びに危害分析を行った。

食肉製造においては、と畜場への搬入牛について腸管出血性大腸菌（STEC）0157、026 およびサルモネラの保菌状況と枝肉汚染状況に関して全国規模の実態調査を行った。直腸内容物並びに枝肉において、腸管出血性大腸菌 0157 の陽性頻度が高い（それぞれ 12.3%および 3.8%）ことを明らかにした。冷凍食品製造については、凍結前未加熱・未加熱摂取されるイカのさしみ製造工程における危害分析を行うため、各工程において一般生菌数、大腸菌群、*E. coli*、および腸炎ピブリオの動態を調査した結果、原料の国内産および輸入イの汚染菌は比較的少なく、また製造工程中のベルトコンベアおよび裁断工程等で汚染（細菌