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# RFID from Farm to Fork: Traceability along the Complete Food Chain

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**Abstract**— The project “RFID from Farm to Fork” looks for the extension of RFID technologies along the complete food chain: from the farms where cows, fishes, sheep, grapes, etc. grow; to the final consumer at the supermarkets, including all intermediate stages: transports, factory processes, storage. The paper is intended to show the project objectives and concerns, as well as it highlights the main radio propagation problems detected within a RFID system installed in a food factory. The paper also shows a proposal of using RFID traceability in different study cases.

## 1. INTRODUCTION

People need to eat! For this reason, the production and distribution of food is the largest and the most important activity in each country all over the world. Because of this extension of food economy, different new proposals appear to improve the quality of the products and the information received by the consumers.

This paper has the aim to present the works developed along the project “RFID from Farm to Fork”, a CIP-Pilot action involved within the 7th Frame Work of the European Union. Our proposal looks for the extension of RFID technologies [1] along the complete food chain: from the farms where cows, fishes, sheep, grapes, etc. grow; to the final consumer at the supermarkets, including all intermediate stages: transports, factory processes, storage. The main objective is the use of only one system to perform the complete traceability, recording data at each stage. These data could be useful to determine the perfect condition of the final product, but also to control the process during the elaboration. Thus, both final consumers and producers would take advantage of such systems.

The final consumers could obtain different data above the whole process suffered by the product they are buying, just by moving the object (labeled with a RFID tag) in the surroundings of a RFID reader, which can be installed in the supermarket or even as an application at each personal smart phone. The individual identification of the product allows the software to obtain a complete traceability report from a central database, and to bring the consumer this information. Each of the producers along the chain could use the identification by radio frequency to control his production and storage, and to know some previous information of his ingredient matters. The project involved both the design of the complete system and its tests at different stages of the chain: fishing companies, wine producers, food transporters, and final users, in order to define the actual interest of the system, its performance, and its advantages and disadvantages.

The following sections show the proposal of the project, the radio propagation difficulties in factory ambient, as well as an introduction to some of the pilot tests.

## 2. THE RFID F2F PROPOSAL

The project will showcase the ability of RFID technologies to make a return on investment for SMEs in the food industry, as well to provide large information to the consumers [2]. The opportunities for such a return on investment arise from the following:

- Opportunities to create markets for premium products (organic, etc.) if technology can address authentication, condition monitoring and quality control.
- New opportunities are created to increase quality, reduce wastage, reduce energy used for refrigeration, reduce chemical usage for preservatives, optimize carbon use, etc.
- Impact on competitiveness and productivity gains.
- Potential for new markets for food producers in the regions.
- Increased productivity through reduced wastage.

- Authentication of origin, process and transport of products.

These advantages have been realized in large concerns, which have control over most or all of the value chain and are in a position to make an end-to-end investment. However, they are not available to independent SMEs, which only participate in one stage of the value chain. By linking RFID and sensor network technologies with a Europe wide database, which can store the exact history of any food product, SMEs will be given the opportunity to optimize their own business process to maximize return. In addition, a pan-union resource will be created which will allow producers to demonstrate unequivocally the quality and freshness of their product, which will have the effect both of increasing consumer confidence, and increasing producer margins.

The emphasis of the current project is somehow advanced from previous projects, in that it proposes:

- Integration of RFID and sensor networks to provide end to end monitoring.
- Demonstration of end-to-end traceability for the whole value chain in a number of different product areas.
- Integration with an international database of food ingredients.

### 3. RADIO WAVE PROPAGATION IN FOOD FACTORY AMBIENTS

The use of RFID and/or sensor networks in the food chain has been previously tested, and it could obviously provide a competitive advantage to the involved companies. However, the radio propagation within a factory presents important differences compared to other more friendly environments: there are lots of metallic elements: machinery, store installations, transports, and even walls and ceiling, which limits the performance of the radio systems. When the factory belongs to the food sector, the situation becomes more and more complicated, as most of the food products present a large content in water, which is not the best friend of the radio waves. Even more, some of the packages are metallic (cans or metallic sheets), which are also limitative for the good performance of a radio system.

#### 3.1. Fish Factories

The fish factories, both for freezing or for canning processing, resulted to be problematic for radio electric propagation due to the presence of large amounts of water and ice within the tags and the readers. The fresh fish is commonly transported inside plastic boxes containing the fish and a lot of ice around. This ice content makes really difficult to establish a radio link if the RFID tag is glued directly to the plastic: a solution consists of separating the tag away from the box (i.e., from the ice) to improve the propagation conditions.

Some tests have been performed using plastic boxes with frozen fish, or just fish with water, or even a simple wet box. When the box is dry, the tag can be read from several meters, but in wet conditions the coverage distance is reduced to several centimeters. Once the fish is frozen and packed, the installation of the tag is again a problem: if it is too close to the ice, the performance of the radio link could be reduced. And it is not easy to install a tag far from the ice inside a freezer!

When the final product is the canned fish, the metallic surfaces of the cans act as isolators for the radio links. The installation of the individual tags in a separate section of the carton package could be enough to solve the situation in a supermarket. But it is almost impossible to manage a store of cans, by means of individual RFID tags. Thus, a separate tagging (individual can vs. lots of cans in larger batches) would be needed to control the storage. This solution could also present some problems depending on the side of the box the tag is glued: if the tags fall in the middle of a package island, perhaps the RFID reader is unable to detect the tag information.

#### 3.2. Wineries

When dealing with wine factories, there are different limitations to the propagation along the process from the vineyards to the bottled wine. The grapes are commonly carried from the vineyards to the winery in plastic boxes of around 20 kg. Again, the water contents could be a difficulty, although less important than in fishery.

Part of the process of manufacturing the wine is performed in steel barrels. The building where these recipients are placed does not present good propagation conditions, as a lot of reflectors and scatters are present in such indoor environment. In this situation, the performance of the physical layer of a RFID system could be affected, as various fading events could appear due to the multipath phenomena.

Once the wine is bottled, the location of the tags on the bottle surface is also problematic: the liquid content becomes a good conductor, and so the transmission capabilities of the tag are reduced. A good selection of the type of tags, as well as its location in the body of the bottle, is a key factor to achieve valid performances.

#### 4. CASE I: WINE PRODUCTION

The quality and the taste of a wine depend on many factors: type of grape, soil, percentage of precipitation and temperature during grapes growing, eventual use of pesticides, types of harvest (day or night), storage conditions of grape before of wine making, and so on.

Experts wine consumers, therefore, are becoming more discerning and pretend to know as much data as possible in order to enlarge their knowledge, be sure of the authenticity of a wine and spend consciously.

One of the several pilots related to the wine supply chain is a small winery named “Vigne Mastrodomenico” located in Basilicata, a Region of Southern Italy, and producing no more than 10000 bottles per year of “Aglanico del Vulture”. The vines grow on a hilly volcanic soil as large as eight ectars with different degrees of sun exposure depending on the vineyard zone. In some cases, hence, it could be necessary a selective forced irrigation. Once the harvest is done, the grapes are processed in a small winery carved into the rock, creating a natural habitat (for instance, a constant temperature of almost 15°C is naturally achieved) for this kind of wine. The presence of the wine and of steel drums, though, complicates the scenario from an EM point of view.

Two aspects have been considered so far. The first one regards the wireless sensor network (WSN) at the vineyard site, useful to collect both meteorological and soil status data to be associated with the single wine bottle and to automatically activate the forced irrigation. The second one, more critical, regards the RFID-related hardware investigation to be used in the winery. As previously stated, in fact, the presence of electromagnetically hostile materials, such as liquids and metals, makes challenging the single bottle traceability in the different steps of the wine supply chain.

For such a purpose, a very complex RFID-based test bed environment has been assembled. The test bed is capable to evaluate the tag performance in realistic situations and in each step of the wine supply chain. Results in terms of successful read rate as well as of RSSI (Received Strength Signal Indication) have been obtained. These results demonstrate that, among the possible RFID frequency bands, UHF has to be preferred to HF for several reasons. For instance, HF tags do not work properly in Far Field conditions, thus implying the impossibility to be used in some critical steps of the supply chain requiring a far field interrogation. Moreover, they are not EPCGlobal compliant, with relevant consequences in terms of multiple readings, generality of the implemented solution and many others. Consequently, two different UHF readers, three different reader antennas, two different Near Field UHF tags and six different Far Field UHF tags have been tested. With each tag attached to a wine bottle, the reading range has been firstly measured both with and without wine inside, so to characterize each tag on the bases of its tolerance to the liquid presence. Then, the problem of the tag performance degradation when the traceability system is implemented at items level in case of presence of liquid has been investigated. Results in terms of successful read rate have been obtained by varying the mutual orientation between tag antenna and reader antenna (i.e., 0° and ±90°). In Figure 1, for instance, the successful read rate of two near field tags (Cube 2 and Paper Clip) and of a far field one (Jumping Jack) are reported. It is quite evident that in critical conditions far field tags perform better than near field ones. Nevertheless, when different supply chain steps based on longer interrogation distances are considered, the effect of the performance degradation is more marked. The individuation of the best tag positioning on the wine bottle is the next step.

#### 5. CASE II: FISH MANUFACTURING

A fish pilot in Slovenia deals with traceability of seabass grown in northern part of Adriatic sea. At farm, a young fish brought from hatchery is breeding for four years in cages under similar conditions as other fish. On the day of catch, fish is transferred to the processing factory, sorted by weight category and packed into styrofoam boxes depending on orders. In some cases fish is also cleaned or filleted. After that, boxes are covered with ice and transported to cold store. The next day, fish is delivered to retailers, restaurants, fish market and even private consumers.

In the supply chain is very important to secure required temperatures of fish between 0°C and 4°C. This can be easily done by using active RFID data logging device with temperature sensor.

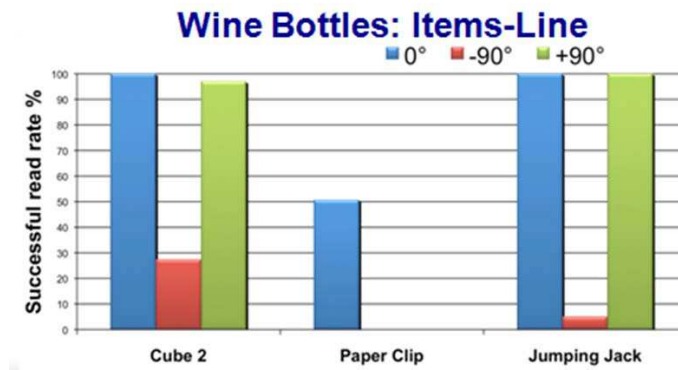


Figure 1: Successful read rate of three commercial tags in the wine items line.

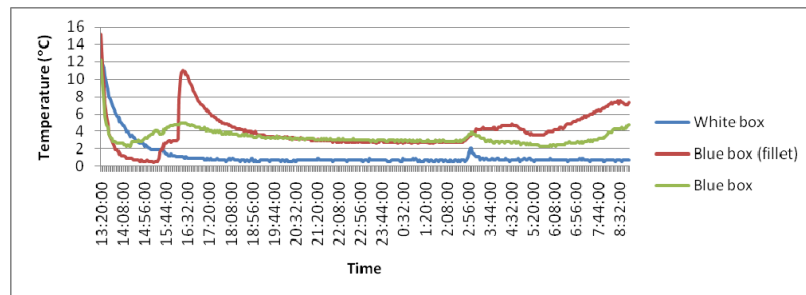


Figure 2: Temperatures measured inside three boxes of fish.

To perform tests in real environment we used two RFID development kits [3], one with IDS-SL900A chip working in UHF frequency bands and the other one with IDS-SL13A in HF frequency bands. Temperatures are automatically measured and recorded, and can be used in a system to automatically notify users about an event.

For the pilot implementation, RFID data loggers will be used to measure the temperature of fish which means that they are placed in the middle of box under the ice before they leave a processing room. By this kind of a solution we start measuring temperatures when fish is packed and read temperatures only at the delivery place. To show a temperature graph during complete supply chain a mobile RFID reader will be used when RFID data loggers are removed from the box.

An example of measured temperatures can give the consumer a clear picture what happened with fish he ordered. Figure 2 shows a temperature graph of three different packages of fish: a) White box — temperatures inside a box where fish was covered by ice; b) Blue box (Fillet) — the process of filleting took place after the sorting process and fish was stored to the blue box and covered by ice packing sheets; c) Blue box — fish was stored to blue box and covered by ice packing sheets. At the end, by the delivery only temperatures of fish covered with ice was more or less the same while in blue boxes temperature starts to increase due to the transport environmental conditions.

## 6. CONCLUSIONS

This paper presents the objectives and initial work of the project “RFID from Farm to Fork”, highlighting the radio propagation concerns of a RFID system within an industrial environment. Some advances on the application to winery and fish manufacturing processes have been also commented.

Taking into account the electromagnetically complex propagation scenario of a winery and of a wine supply chain, an exhaustive tag characterization has been carried out and the performance degradation due to the presence of liquid has been confirmed. Once proved that, in the wine production case, UHF tags must be preferred to HF ones. The performance comparison of both near field and far field UHF tags in a practical scenario has been performed and the better suitability of far field tags has been pointed out.

Vice versa, as for the fish manufacturing case, RFID data loggers were used to measure and store

temperatures inside a box of fish covered with ice. This data can be used to control the conditions of perishable food in the supply chain. The proposed implementation is based on radiofrequency identification and does not require the use of any additional sensor networks communication technology. The results were very similar for both systems (HF and UHF) used in the described scenario.

#### **ACKNOWLEDGMENT**

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