



United States
Department of
Agriculture

Food Safety
and Inspection
Service

Washington, D.C.
20250

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Dr. Mervyn Baker, Director
Food of Animal Origin Division
Canadian Food Inspection Agency
59 Camelot Drive
Nepean, Ontario K1A0Y9, Canada

Dear Dr. Baker:

This letter transmits the Food Safety and Inspection Service's final report of a meat inspection system audit conducted in Canada June 17 through July 31, 2003. Comments from Canada have been included in the final report.

If you have any questions about this audit or need additional information, please contact me at 202-720-3781, by fax at 202-690-4040, or by email at sally.stratmoen@fsis.usda.gov.

Sincerely,

Sally Stratmoen, Director
International Equivalence Staff
Office of International Affairs

Enclosure

cc:

Gary Groves, Minister Counselor, U.S. Embassy, Ottawa
John Masswohl, First Secretary, (Agriculture), Embassy of Canada
Jeanne Bailey, FAS Area Officer
Amy Winton, State Department
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Country File (Canada Audit #2 FY 2003)

FINAL

DEC 16 2003

FINAL REPORT OF AN AUDIT CARRIED OUT IN CANADA
COVERING CANADA'S MEAT, POULTRY AND EGG
PRODUCTS INSPECTION SYSTEM

JUNE 17 THROUGH JULY 31, 2003

Food Safety and Inspection Service
United States Department of Agriculture

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ABBREVIATIONS AND SPECIAL TERMS USED IN THE REPORT

CCA	Central Competent Authority - Canadian Food Inspection Agency (CFIA)
CFIA	Canadian Food Inspection Agency
FSIS	Food Safety and Inspection Service
PR/HACCP	Pathogen Reduction/Hazard Analysis and Critical Control Point Systems
OIA	Office of International Affairs
SSOP	Sanitation Standard Operating Procedures
<i>E. coli</i>	<i>Escherichia coli</i>
<i>Salmonella</i>	<i>Salmonella</i> species

1. INTRODUCTION

The audit took place in Canada from June 17 through July 31, 2003.

An opening meeting was held on June 17, 2003 in Ottawa, Ontario with the Central Competent Authority (CCA). At this meeting, the auditors confirmed the objective and scope of the audit, the auditors' itinerary, and requested additional information needed to complete the audit of Canada's meat, poultry, and egg products inspection system.

The auditors were accompanied during the entire audit by representatives from the CCA, the Canadian Food Inspection Agency (CFIA) and/or representatives from the Area and Regional inspection offices.

2. OBJECTIVE OF THE AUDIT

This audit was a routine annual audit. The objective of the audit was to evaluate the performance of the CCA with respect to controls over the slaughter, processing and egg product establishments certified by the CCA as eligible to export meat, poultry and egg products to the United States.

In pursuit of the objective, the following sites were visited: the Headquarters of the CCA, four Area inspection offices, eight Regional inspection offices, five laboratories performing analytical testing on United States-destined product, six meat slaughter establishments, three poultry slaughter establishments, Twenty Two meat and/or poultry processing establishments, six egg products establishments, one feed mill and one independent inedible rendering facility.

Competent Authority Visits			Comments
Competent Authority	Central	1	
	Area	4	
	Regional	8	
Laboratories		5	
Meat Slaughter Establishments		6	
Poultry Slaughter Establishments		3	
Meat and/or Poultry Processing Establishments		22	
Egg Product Establishments		6	
Independent Inedible Rendering Facility		1	
Feed Mill		1	

3. PROTOCOL

This on-site audit was conducted in four parts. One part involved visits with CCA officials to discuss oversight programs and practices, including enforcement activities. The second part involved an audit of a selection of records in the country's inspection Headquarters, Area and Regional Offices. The third part involved on-site visits to 37 establishments (nine slaughter establishments 28 processing establishments). The fourth part involved visits to three government (CFIA) laboratories located in Dartmouth.

Nova Scotia, St-Hyacinthe, Quebec and Saskatoon, Saskatchewan and to two private laboratories in Laval, Ontario and Sherbrooke, Quebec. The three CFIA laboratories were conducting analysis of field samples for generic *E. coli*, *E. coli* O157:H7, *Staphylococcus*, *Salmonella* species (*Salmonella*), *Listeria monocytogenes* and of non-meat field samples for Canada's national residue control program. The two private laboratories, Bodycote Microbiological Laboratory, Laval, Ontario and Environmental Laboratory SM, Sherbrooke, Quebec were conducting analysis for the presence of generic *E. coli*, *E. coli* O157:H7, *Staphylococcus*, *Salmonella* species and *Listeria monocytogenes*.

Program effectiveness determinations of Canada's inspection system focused on five areas of risk: (1) sanitation controls, including the implementation and operation of Sanitation Standard Operating Procedures, (2) animal disease controls, (3) slaughter/processing controls, including the implementation and operation of HACCP programs and a testing program for generic *E. coli*, (4) residue controls, and (5) enforcement controls, including a testing program for *Salmonella*. Canada's inspection system was assessed by evaluating these five risk areas.

During all on-site establishment visits, the auditor evaluated the nature, extent and degree to which findings impacted on food safety and public health. The auditors also assessed how inspection services are carried out by Canada and determined if establishment and inspection system controls were in place to ensure the production of meat, poultry and egg products that are safe, unadulterated and properly labeled.

At the opening meeting, the auditors explained that Canada's meat, poultry and egg products inspection system would be audited against two standards: (1) FSIS regulatory requirements and (2) any equivalence determinations made for Canada. FSIS requirements include, among other things, daily inspection in all certified establishments, monthly supervisory visits to certified establishments, humane handling and slaughter of animals, ante-mortem inspection of animals and post-mortem inspection of carcasses and parts, the handling and disposal of inedible and condemned materials, sanitation of facilities and equipment, residue testing, species verification, and requirements for HACCP, SSOP, and testing for generic *E. coli* and *Salmonella*.

Equivalence determinations are those that have been made by FSIS for Canada under provisions of the Sanitary/Phytosanitary Agreement. Currently, the *Salmonella* testing procedure is the only equivalence determination that has been made for Canada. The establishment personnel are authorized to take the samples and private laboratories are authorized to analyze the samples.

There are several issues currently under consideration for equivalence determination. These include pre-shipment reviews, monthly supervisory visits, and analytical methods for *E. coli* O157:H7.

4. LEGAL BASIS FOR THE AUDIT

The audit was undertaken under the specific provisions of United States laws and regulations. in particular:

- The Federal Meat Inspection Act (21 U.S.C. 601 et seq.).
- The Federal Meat Inspection Regulations (9 CFR Parts 301 to end), which include the Pathogen Reduction/HACCP regulations.
- The Poultry Products Inspection Act (21 U.S.C. 451 et seq.)
- The Poultry Products Inspection Regulations (9 CFR Part 381)
- The Egg Products Inspection Act (21 U.S.C. 1031 et seq.)
- The Egg Products Inspection Regulations (9 CFR Part 590)

5. SUMMARY OF PREVIOUS AUDITS

Final audit reports are available on FSIS' website at www.fsis.usda.gov/ofotsc.

The following concerns arose as a result of the FSIS audit of Canada's inspection system conducted June 11 through July 15, 2001.

- Three establishments were evaluated as acceptable/re-review.
- The CFIA performed reduced numbers of supervisory reviews, four per year in Alberta and British Columbia, and one to three per year in slaughter establishments in Quebec.
- The carcass selection for testing for *E. coli* and *Salmonella* was not random in two establishments.
- The zero tolerance policy for fecal contamination was not defined in two establishments; the critical limits allowed fecal contamination of carcasses.
- Denaturing of condemned carcasses was not performed in four establishments.
- Several insanitary conditions, such as condensation, were observed.
- Poor sanitary dressing and sanitizing procedures were observed.

Audit findings identified during the audit conducted June 11 through July 15, 2001 were found to be corrected during the audit conducted October 15 through November 15, 2002.

The following concerns arose as a result of the FSIS audit of Canada's inspection system conducted October 15 through November 15, 2002.

- Two establishments were delisted by Canadian officials.
- Two establishments received Notices of Intent to Delist from Canadian officials.

The following was identified during the audit of Canada's accredited laboratories:

- Audit of SGS Laboratory, Vancouver, British Columbia identified the method of analysis for generic *E. coli* in this laboratory was a modified version of an AOAC method that had not been submitted to FSIS for an equivalence determination. This was found to be correct during the current audit.

The following SSOP and sanitary operation issues were identified during the audit and were found to be uncorrected, resulting in repeat occurrences during the current audit.

- In three establishments, SSOP implementation was inadequate.
- In four establishments, condensation was falling from overhead structures that were not cleaned and sanitized daily onto exposed product and/or production equipment.
- Preventive measures were not recorded in the daily pre-operational sanitation documentation in three establishments; preventive measures were not recorded in either in the daily pre-operational or in the daily operational sanitation documentation in ten establishments.
- Documentation of cleaning procedures and corrective actions in pre-operational and operational sanitation records was inadequate in 2 establishments.
- Sanitary operations were inadequate in fourteen establishments. The inadequacies involved, for example, condensation, saw cleanliness, and sanitizing, cartooned and exposed product storage, and equipment cleaning and controls.

The following HACCP implementation issues were identified during the audit and were found to be uncorrected, resulting in repeat occurrences during the current audit.

- The hazard analyses were incomplete in six establishments: there was no record of hazards considered and rejected, or of the justification for their rejection.
- Some critical limits specified in the written HACCP plans, including zero tolerance for visible contamination with feces, ingesta, and milk, were inappropriate in two establishments, so that the zero-tolerance policy was not adequately enforced.
- Preventive measures were not included in the written corrective actions specified in response to deviations from critical limits in five establishments.
- The documentation of corrective actions taken in response to deviations from critical limits was inadequate in two establishments.

- The documentation of preventive measures was not included in the written corrective actions taken in response to deviations from critical limits in three establishments.

6. MAIN FINDINGS

6.1 Government Oversight

Canada is divided into four areas of administration and field operations. The Atlantic, Ontario and Quebec areas are divided into four Regions. The Western Area is divided into six Regional Offices with local offices as needed. The personnel in these areas and regional offices provide program and training support to field operations as well as supervise and oversee all field inspection personnel and in-plant functions.

In the CFIA headquarters in Ottawa, in order to gather more information on oversight, interviews were conducted with the officials responsible for:

- Field operations and inspection services
- Food Safety Enhancement Program and HACCP programs
- National Residue Program
- Microbiological Sample Program
- Bovine spongiform encephalopathy
- Export programs and U. S. Regulations
- Enforcement and prosecution
- Training
- National rendering control program
- National feed manufacturing control program

In the CFIA Area and Regional Offices, interviews were conducted with the officials responsible for:

- Field operations and inspection services
- Area operations
- Regional operations
- Monthly supervisor visits
- Prerequisite programs and monthly supervisor visits
- Enforcement and compliance
- Training

6.1.1 CCA Control Systems

The Chief of Export Programs located in the Central Headquarters Office in Ottawa, Ontario supervises the export activities of the Area Offices. Each Area Office maintains an Import/Export specialist to oversee the maintenance of eligibility of an establishment to export to another country. The Area Supervisors have the authority, under Canadian regulations, to enforce the necessary requirements to export to a country. Their duties also include initiating investigations into failure on the part of an establishment to meet

the standards of the importing country and to delist those who fail in this requirement. The official list is maintained and controlled by the Director of Food of Animal Origin, Ottawa, Ontario through the Chief of Export Programs.

6.1.2 Ultimate Control and Supervision

Control in an establishment is accomplished by the Veterinarian-in-Charge (in a slaughter establishment) and by the Inspector-in-Charge (in a processing establishment). These officials are supervised by Inspection Managers or Processing Supervisors. Regional Veterinary Officers are responsible for program delivery and assuring export requirements are met in slaughter establishments and some processing establishments. Processing Supervisors assure export requirements are met for processing establishments. The Regional Director, in conjunction with Regional Office personnel, oversees and supervises the Inspection Managers and the Regional Veterinary Officers. The central control and supervision is in the Headquarters Office in Ottawa. Establishments are listed or delisted by this office for certification to export to eligible countries.

New export establishments must file a completed Form, Annex I, with the Area Office. The Annex I is the official request to be considered for export certification. The establishment and CFIA must each contribute information for the completion of the form. Initial verification of export compliance is accomplished by establishment audits by the Regional Veterinary Officer, Inspection Manager, or the Complex Processing Supervisor. Quarterly reviews for export compliance are performed by the Regional Veterinary Officer. HACCP Partial Audits are performed by the HACCP audit team. The monthly supervisory reviews are performed by the Regional Veterinary Officer, Inspection Manager, Inspector-in-Charge, Veterinarian-in-Charge or the Complex Processing Supervisor.

New official inspection guidelines are issued by CFIA headquarters in Ottawa, Ontario. These are provided by fax, e-mail, and hard copy to the Directors of the area offices and, through them, to the regional offices and then to the appropriate field personnel. Under the current system, it is the responsibility of regional directors to delegate implementation instructions to the appropriate officials under their supervision, and to ensure their implementation. This is carried out by Regional Veterinary Officers, Inspection Managers and Complex Processing Supervisors.

6.1.3 Assignment of Competent, Qualified Inspectors

The Central Headquarters staff is responsible for maintaining the National Training Program and training modules. Operational Supervisors are responsible to ensure that adequate training has been provided to inspectors before assigning them to a position. Each Area Office maintains a Training Coordinator who tracks the training needs of inspection personnel. HACCP Coordinators located in the regional offices assure only HACCP-trained inspectors are assigned to establishments eligible to export to the United States. It is also the responsibility of the Inspection Manager, as well as the establishment supervisor, to see that all establishments are provide with trained and competent inspectors for direct and continuous official supervision of slaughtering and preparation of product. Direct and continuous official supervision of establishments was provided except as noted later in this section.

No full- or part-time CFIA employees are permitted to perform any private, establishment-paid tasks at an establishment in which they perform official duties. There are provisions for private veterinarians to be hired under contract as part-time CFIA employees. Non-veterinarians are not hired as part-time employees. Full-time employees are hired and receive their basic training by the regional office.

6.1.4 Authority and Responsibility to Enforce the Laws

CFIA has the authority and responsibility to enforce U.S. requirements. Each establishment has copies of the pertinent CFIA and U.S. rules and regulations.

Export requirements for each establishment certified to export to the United States are verified by the Veterinarian-in-Charge or Inspector-in-Charge using the Basic Compliance Checklist. The checklist includes HACCP verification procedures for establishment compliance. The activities of fully recognized HACCP-Food Safety Enhancement Program (FSEP) establishments are completely verified and documented in a one-month cycle.

If public health concerns are identified, the national Food Safety and Recall Committee is the official body to make decisions concerning product dispositions and, if necessary, recall the effected product.

6.1.5 Adequate Administrative and Technical Support

CFIA has adequate administrative and technical support in the central and regional offices and in the field to operate and support its inspection system, including experts, specialists and adequate facilities.

6.2 Headquarters Audit

The auditor conducted a review of inspection system documents at the headquarters in Ottawa, at four Area Offices and eight Regional Offices. The records review focused primarily on food safety hazards and included the following:

- Internal review reports.
- Supervisory visits to establishments that were certified to export to the United States
- Training records for inspectors and laboratory personnel.
- Label approval records such as generic labels and animal raising claims.
- New laws and implementation documents such as regulations, notices, directives and guidelines.
- Sampling and laboratory analyses for residues.
- Sanitation, slaughter and processing inspection procedures and standards.
- Control of products from livestock with conditions such as tuberculosis, cysticercosis, etc., and of inedible and condemned materials.
- Export product inspection and control including export certificates.
- Enforcement records, including examples of criminal prosecution, consumer complaints, recalls, seizure and control of noncompliant product, and

withholding, suspending, withdrawing inspection services from or delisting an establishment that is certified to export product to the United States.

No concerns arose as a result the examination of these documents.

6.3.1 Audit of Regional and Local Inspection Sites

The Area Offices audited were: Atlantic Area Office, Moncton, New Brunswick, Ontario Area Office, Guelph, Ontario; Quebec Area Office, Montreal, Quebec and the Western Area Office, Calgary, Alberta. The Regional Offices audited were: Nova Scotia Regional Office, Dartmouth, Nova Scotia; Prince Edward Island Regional Office, Charlottetown, Prince Edward Island; Central Regional Office, Guelph, Ontario; Toronto Regional Office, Downsview, Ontario; Quebec Regional Office, Quebec, Quebec; St-Hyacinthe Regional Office, St-Hyacinthe, Quebec; Alberta North Regional Office, Edmonton, Alberta; Saskatchewan Regional Office, (Local Office) Saskatoon, Saskatchewan.

During the audit of the Quebec Regional Office staffing of establishments certified to export to the United States was discussed. The Regional Inspection Manager for processing conveyed CFIA's Manual of Procedures Chapter 1, Section 1.13 Requirements for Staffing. Low risk and low complexity processing establishments are classified as Category A establishments. Establishments falling into Category A are not considered to normally require daily visits of CFIA inspection, and scheduling should be based on the weekly requirement, with the allotted inspection provided on one or more days each week. The Regional Inspection Manager confirmed that inspection was conducted daily in all slaughter establishments, but daily inspection coverage for processing establishments was not always provided as required by FSIS import regulatory requirements. Processing establishments eligible to export product to the United States were staffed the same as domestic establishments, i.e., less than daily staffing. This does not meet FSIS regulatory requirements [9 CFR 327.2 (a) (2) (ii) (D)] for "Direct and continuous official supervision of slaughtering and preparation of product, by the assignment of inspectors to establishments certified under (a) (3) of this section, to assure that adulterated or misbranded product is not prepared for export to the United States".

7. ESTABLISHMENT AUDITS

The FSIS auditors visited a total of 37 establishments, of which nine were slaughter establishments and 28 were processing establishments. Two establishments were delisted by Canada. One establishment was delisted for failure to implement their SSOPs and poor sanitary conditions in production areas. Another establishment was delisted for failure to meet United States regulatory requirements. Six establishments received a Notice of Intent to Delist (NOID) at the time of the audit from Canada and one establishment received a NOID at the time of the exit meeting for not properly implementing the SSOPs, for an inadequate HACCP system and for not maintaining sanitary conditions in production areas.

These establishments may retain their certification for export to the United States provided that they correct all of the problems noted during the audit within 30 days of the date the establishment was reviewed.

Specific issues are noted in the attached individual establishment review forms.

8. RESIDUE AND MICROBIOLOGY LABORATORY AUDITS

During laboratory audits, emphasis was placed on the application of procedures and standards that are equivalent to United States requirements.

Residue laboratory audits focus on sample handling, sampling frequency, timely analysis data reporting, analytical methodologies, tissue matrices, equipment operation and printouts, detection levels, recovery frequency, percent recoveries, intra-laboratory check samples, and quality assurance programs, including standards books and corrective actions.

Microbiology laboratory audits focus on analyst qualifications, sample receipt, timely analysis, analytical methodologies, analytical controls, recording and reporting of results, and check samples. If private laboratories are used to test United States samples, the auditor evaluates compliance with the criteria established for the use of private laboratories under the FSIS Pathogen Reduction/HACCP requirements.

The following five laboratories were audited:

Three government (CFIA) laboratories located in Dartmouth, Nova Scotia, St-Hyacinthe, Quebec, and Saskatoon, Saskatchewan were audited. Two private laboratories, Bodycote Microbiological Laboratory, Laval, Ontario and Environmental Laboratory SM, Sherbrooke, Quebec were audited.

No concerns arose from the audit of the five laboratories.

9. SANITATION CONTROLS

As stated earlier, the FSIS auditors focused on five areas of risk to assess Canada's meat, poultry and egg inspection system. The first of these risk areas that the FSIS auditor reviewed was Sanitation Controls.

Based on the on-site audits of establishments, and except as noted below, Canada's inspection system had controls in place for SSOP programs, all aspects of facility and equipment sanitation, the prevention of actual or potential instances of product cross-contamination, good personal hygiene practices, and good product handling and storage practices.

In addition, and except as noted below, Canada's inspection system had controls in place for water potability records, chlorination procedures, back-siphonage prevention, temperature control, work space, ventilation, ante-mortem facilities, welfare facilities, and outside premises.

All products that are produced in establishments certified to export to the United States are considered eligible for exportation to the United States; therefore separation of product is not an issue for Canada.

9.1 SSOP

Each establishment was evaluated to determine if the basic FSIS regulatory requirements for SSOP were met. According to the criteria employed in the United States domestic inspection program, SSOP regulations do not apply to egg product establishments; therefore in the 31 of the 37 egg product establishment audited findings will be reported under Sanitary Operations. The SSOP in 30 of the 31 establishments audited were found to meet the basic FSIS regulatory requirements.

- Basic SSOP requirements were not met in one of the 31 establishments audited.

On-going SSOP requirements were not met in some establishments.

- In 11 of the 31 establishments audited, Sanitation Standard Operation Procedures (SSOP) were not effectively implemented.
- In nine of the 31 establishments audited, corrective actions written in the Sanitation Standard Operation Procedures (SSOP) were ineffective or failed to prevent direct product contamination.
- In 19 of the 31 establishments audited, records documenting implementation, maintenance and effectiveness, and corrective actions of the Sanitation Standard Operation Procedures (SSOP) were incomplete or missing.
- In 19 of the 31 establishments audited, preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records for each occurrence. This is a repeat finding identified in the previous audit report

9.2 Sanitation

The following sanitation problems were noted (further details may be found in the individual Foreign Establishment Audit Checklists, which are attached to this report):

Sanitary Operations

- In one of the 37 establishments audited, pest controls were not effective.
- In seven of the 37 establishments audited, construction and maintenance controls were not effective.
- In 13 of the 37 establishments audited, ventilation problems resulted in over product condensation.
- In one of the 37 establishments audited, dressing rooms were not adequately maintained.

- In six of the 37 establishments audited, sanitation controls for equipment and utensils were not effective.
- In 14 of the 37 establishments audited, sanitation controls for sanitary operations were not effective.
- In two of the 37 establishments audited, employee hygiene controls were not effective.

10. ANIMAL DISEASE CONTROLS

The second of the five risk areas that the FSIS auditors reviewed was Animal Disease Controls. These controls include ensuring adequate animal identification, humane handling and humane slaughter, control over condemned and restricted product, and procedures for sanitary handling of returned and reconditioned product. The auditors determined that Canada's inspection system had adequate controls in place in 35 of the 37 establishments audited. The following was noted:

- In two of the 37 establishments audited, control over condemned and inedible product was not effective.

One off-site rendering facility and one feed mill were audited to observe the implementation of control measures of the two facilities and the audit procedures used by CFIA to verify compliance. No concerns arose from the audit of these two facilities.

Canada is currently under restriction for importation into the United States of ruminant meat and meat products (beef, veal, sheep and goat) due to risk of Bovine Spongiform Encephalopathy (BSE).

11. SLAUGHTER/PROCESSING CONTROLS

The third of the five risk areas that the FSIS auditors reviewed was Slaughter/Processing Controls. The controls include the following areas: ante-mortem inspection procedures; ante-mortem disposition; post-mortem inspection procedures; post-mortem disposition; ingredients identification; control of restricted ingredients; formulations; processing schedules; equipment and records; and processing controls of cured, dried, and cooked products.

The controls also include the implementation of HACCP systems in all meat and poultry establishments and implementation of a generic *E. coli* testing program in slaughter establishments. HACCP requirements do not apply to egg product establishments.

11.1 Humane Handling and Slaughter

No problems were observed.

11.2 HACCP Implementation.

All establishments approved to export meat and poultry products to the United States are required to have developed and adequately implemented a HACCP program. Each of these programs was evaluated according to the criteria employed in the United States' domestic inspection program. HACCP regulations do not apply to egg product establishments; therefore the egg product establishment findings have been reported under section 9.2 Sanitation of this report.

The HACCP programs were reviewed during the on-site audits of the 31 establishments. Basic HACCP requirements were not met in the following establishments:

- In 20 of the 31 establishments audited, contents of HACCP plans did not contain all required components.

On-going HACCP requirements were not met in the following establishments:

- In 19 of the 31 establishments audited, verification and/or validation documentation was missing.
- In 13 of the 31 establishments audited, corrective actions for a deviation from a critical limit did not contain all four regulatory components of corrective action.
- In eight of the 31 establishments audited, HACCP plans were not adequately reassessed.
- In three of the 31 establishments audited, records for documentation of the written HACCP plan were not properly completed.
- In three of the 31 establishments audited, pre-shipment review records were lacking. This is a repeat finding identified in the previous audit report.

11.3 Testing for Generic *E. coli*

Canada has adopted the FSIS regulatory requirements for generic *E. coli* testing.

The nine slaughter establishments audited were required to meet the basic FSIS regulatory requirements for generic *E. coli* testing and were evaluated according to the criteria employed in the United States' domestic inspection program.

Testing for generic *E. coli* was properly conducted in seven of the nine slaughter establishments. In two of the establishments audited, *E. coli* testing results were not evaluated properly.

- In the two establishments, statistical process control procedures had not been developed, as required, to evaluate the results of the testing. The two establishments were using the incision data in evaluating sponge sampling results.

11.4 Testing for *Listeria monocytogenes*

Fourteen of the 31 meat and poultry establishments audited were producing ready-to-eat products for export to the United States. In accordance with United States requirements, the HACCP plans in 11 meat and poultry establishments had been reassessed to include *Listeria monocytogenes* as a hazard reasonably likely to occur.

- In three of the 14 establishments producing ready-to-eat product, *Listeria monocytogenes* was not considered as a hazard reasonably likely to occur in their ready-to-eat process.

12. RESIDUE CONTROLS

The fourth of the five risk areas that the FSIS auditors reviewed was Residue Controls. These controls include sample handling and frequency, timely analysis, data reporting, tissue matrices for analysis, equipment operation and printouts, minimum detection levels, recovery frequency, percent recoveries, and corrective actions. The three CFIA residue laboratories audited were located in Dartmouth; Nova Scotia, St-Hyacinthe; Quebec, and Saskatoon; Saskatchewan. The CFIA residue laboratory, located in Saskatoon, Saskatchewan, performed all sample analysis for Canada's National Residue Program.

No problems were observed.

Canada's National Residue Testing Plan for fiscal year April 1, 2003 through March 31, 2004, was being followed and was on schedule.

13. ENFORCEMENT CONTROLS

The fifth of the five risk areas that the FSIS auditors reviewed was Enforcement Controls. These controls include the enforcement of inspection requirements and the testing program for *Salmonella*.

13.1 Daily Inspection in Establishments

Inspection was being conducted daily in all slaughter establishments. Daily inspection coverage for processing activities in 10 of the 28 processing establishments audited was not always provided as required by FSIS import regulatory requirements. All processed product produced in establishments eligible for export to the United States is eligible for export to the United States.

13.2 Testing for *Salmonella*

Canada has adopted the FSIS requirements for testing for *Salmonella* with the exception of the following equivalent measures. Establishments are authorized to take test samples for *Salmonella* and private laboratories are authorized to analyze the samples.

Seventeen of the 37 establishments audited were required to meet the basic FSIS regulatory requirements for *Salmonella* testing and were evaluated according to the criteria employed in the United State's domestic inspection program.

Testing for *Salmonella* was properly conducted in 16 of the 17 establishments. The following was observed in the remaining establishment:

- In one establishment, aseptic sampling procedures were not used to sample product.

13.3 Species Verification

Species verification was being conducted in those establishments in which it was required.

13.4 Monthly Reviews

Monthly supervisory reviews of certified establishments were being performed and documented as required in 31 of the 37 establishments audited.

- In the other six establishments, monthly reviews were not performed for each month as required.

13.5 Inspection System Controls

The CCA had controls in place for ante-mortem and post-mortem inspection procedures and dispositions; restricted product and inspection samples; disposition of dead, dying, diseased or disabled animals; shipment security, including shipment between establishments; and prevention of commingling of product intended for export to the United States with product intended for the domestic market. The following inspection controls that were not effective were identified:

- In one of the nine slaughter establishments audited, ante-mortem inspection procedures were not performed according to FSIS regulatory requirements for cows.
- In three of the nine slaughter establishments audited, an alternative high-speed post-mortem inspection procedure was used. This procedure had not been submitted for equivalence.
- In five of the nine slaughter establishments audited, post-mortem inspection procedures were not performed according to FSIS regulatory requirements. The three establishments using an alternative high-speed post-mortem inspection procedure is included in the five establishments under this bullet.
- In eight of the 37 establishments audited, CFIA local inspectors did not maintain records for monitoring or frequency for hands on pre-operational sanitation verification procedures.

- In 32 of the 37 establishments audited, FSIS regulatory requirements were not enforced. SSOP and HACCP requirements, as identified in the individual establishment reports, were not identified by CFIA in SSOP and HACCP verification activities as non compliances to be corrected by the establishment.
- In 10 of the 37 establishments audited, daily inspection coverage for processing activities was not always provided as required by FSIS import regulatory requirements.
- In one of the nine slaughter establishments audited adequate staffing was not provided for postmortem inspection.

Controls were in place for the importation of only eligible livestock from other countries, i.e., only from eligible third countries and certified establishments within those countries, and the importation of only eligible meat products from other countries for further processing.

Lastly, adequate controls were found to be in place for security items, shipment security, and products entering the establishments from outside sources.

14. CLOSING MEETING

A closing meeting was held on July 31, 2003 in Ottawa, Ontario, Canada with the CCA. At this meeting, the primary findings and conclusions from the audit were presented by the auditor.

The CCA understood the findings.

Dr. Don Carlson
International Audit Staff Officer

A handwritten signature in black ink that reads "Dr. Don Carlson". The signature is written in a cursive style and is positioned above a horizontal line.

15. ATTACHMENTS

Individual Foreign Establishment Audit Forms

Individual Foreign Laboratory Reports

Foreign Country Response to Draft Final Audit Report

07-15-2003

Center for Veterinary Drug Residues

FOREIGN COUNTRY LABORATORY REVIEW

FOREIGN GOV'T AGENCY: Canadian Food Inspection Agency
 CITY & COUNTRY: SASKATOON, CANADA
 ADDRESS OF LABORATORY: 116, Veterinary road Sk S7n2r3

NAME OF REVIEWER: Dr. S. P. Singh
 NAME OF FOREIGN OFFICIAL: Dr. James d. Macneal, Head

Residue Code/Name			100	200	300	400	500	800	900				
SAMPLING PROCEDURES	REVIEW ITEMS	ITEM #											
	Sample Handling	01	A	A	A	A	A	A	A				
	Sampling Frequency	02	A	A	A	A	A	A	A				
	Timely Analyses	03	A	A	A	A	A	A	A				
	Compositing Procedure	04	O	O	O	O	O	O	O				
	Interpret Comp Data	05	O	O	O	O	O	O	O				
	Data Reporting	06	A	A	A	A	A	A	A				
ANALYTICAL PROCEDURES	Acceptable Method	07	A	A	A	A	A	A	A				
	Correct Tissue(s)	08	A	A	A	A	A	A	A				
	Equipment Operation	09	A	A	A	A	A	A	A				
	Instrument Printouts	10	A	A	A	A	A	A	A				
QUALITY ASSURANCE PROCEDURES	Minimum Detection Levels	11	A	A	A	A	A	A	A				
	Recovery Frequency	12	A	A	A	A	A	A	A				
	Percent Recovery	13	A	A	A	A	A	A	A				
	Check Sample Frequency	14	A	A	A	A	A	A	A				
	All analyst w/Check Samples	15	A	A	A	A	A	A	A				
	Corrective Actions	16	A	A	A	A	A	A	A				
	International Check Samples	17	NA										
REVIEW	Corrected Prior Deficiencies	18	NA										
OTHER REVIEW		19											
		20											

SIGNATURE OF REVIEWER: *S. P. Singh* DATE: 7/15/03

FOREIGN COUNTRY LABORATORY REVIEW

REVIEW DATE

NAME OF FOREIGN LABORATORY

Comment Sheet

07-15-2003

Center for Veterinary Drug Residues

FOREIGN GOVT AGENCY

Canadian Food Inspection Agency

CITY & COUNTRY

SASKATOON, CANADA

ADDRESS OF LABORATORY

116, Veterinary road Sk S7n2r3

NAME OF REVIEWER

Dr. S. P. Singh

NAME OF FOREIGN OFFICIAL

Dr. James d. Macneal, Head

RESIDUE

ITEM NO.

COMMENTS

7-10-2013

Dartmouth Laboratory

FOREIGN COUNTRY LABORATORY REVIEW

FOREIGN GOV'T AGENCY
 Canada Food Inspection Agency

CITY & COUNTRY
 Halifax, Canada

ADDRESS OF LABORATORY
 1992, Agency Drive, Dartmouth, NS B3B1Y9

NAME OF REVIEWER
 Dr. S. P. Singh

NAME OF FOREIGN OFFICIAL
 Susan J. Shaw, Director Lab

Residue Code/Name			100	400	EC	LM	SL									
SAMPLING PROCEDURES	REVIEW ITEMS	ITEM #	EVALUATION CODE													
	Sample Handling	01	A	A	A	A	A									
	Sampling Frequency	02	A	A	A	A	A									
	Timely Analyses	03	A	A	A	A	A									
	Compositing Procedure	04	O	O	O	O	O									
	Interpret Comp Data	05	O	O	O	O	O									
Data Reporting	06	A	A	A	A	A										
ANALYTICAL PROCEDURES	Acceptable Method	07	A	A	A	A	A									
	Correct Tissue(s)	08	A	A	A	A	A									
	Equipment Operation	09	A	A	A	A	A									
	Instrument Printouts	10	A	A	A	A	A									
QUALITY ASSURANCE PROCEDURES	Minimum Detection Levels	11	A	A	NA	NA	NA									
	Recovery Frequency	12	A	A	NA	NA	NA									
	Percent Recovery	13	A	A	NA	NA	NA									
	Check Sample Frequency	14	A	A	A	A	A									
	All analyst w/Check Samples	15	A	A	A	A	A									
	Corrective Actions	16	A	A	A	A	A									
	International Check Samples	17	NA	NA	NA	NA	NA									
REVIEW	Corrected Prior Deficiencies	18	NA	NA	NA	NA	NA									
OTHER REVIEW		19														
		20														

SIGNATURE OF REVIEWER

Sushil P. Singh

DATE

7/15/13

FOREIGN COUNTRY LABORATORY REVIEW

REVIEW DATE

NAME OF FOREIGN LABORATORY

Comment Sheet

07-10-2016

Dartmouth Laboratory

FOREIGN GOV'T AGENCY

Canada Food Inspection Agency

CITY & COUNTRY

Halifax ,Canada

ADDRESS OF LABORATORY

1992, Agency Drive,Dartmouth,NSB3b1y9

NAME OF REVIEWER

Dr. S. P. Singh

NAME OF FOREIGN OFFICIAL

Susan J. Shaw, Director Lab

RESIDUE	ITEM NO.	COMMENTS
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Remarks

This a Regional Atlantic Provinces Laboartory, testing all kinds of foods ans seafood products. This lab's primary function is confirmation of Nutrtitional labelling regulations of all food products. It is well designed to seafood toxins, residues of drugs and chemicals. It is an official lab for cofirmation of all pathogens in meat, poultry,eggs and seafood. It is certified ISO17025 lab by CC of Canada.

FOREIGN COUNTRY LABORATORY REVIEW

06-26-03

Laboratoire d'Environnement Inc. Private - Acc. by
 CFIA for Microbiology

FOREIGN GOV'T AGENCY

Canadian Food Inspection Agency(CFIA).

CITY & COUNTRY

Sherbrook, Quebec, Canada

ADDRESS OF LABORATORY

740, Rue Galt West

NAME OF REVIEWER

DR. S.P. Singh

NAME OF FOREIGN OFFICIAL

Dr. Joan Reindeau and Ms. Nancy Allard

Residue Code/Name		SL	EC	157	ST					
SAMPLING PROCEDURES	REVIEW ITEMS	ITEM #	EVALUATION CODE							
	Sample Handling	01		A	A	A	A			
	Sampling Frequency	02		A	A	A	A			
	Timely Analyses	03		A	A	A	A			
	Compositing Procedure	04		O	O	O	O			
	Interpret Comp Data	05		O	O	O	O			
Data Reporting	06	A	A	A	A					
ANALYTICAL PROCEDURES	Acceptable Method	07	A	A	A	A				
	Correct Tissue(s)	08	A	A	A	A				
	Equipment Operation	09	A	A	A	A				
	Instrument Printouts	10	A	A	A	A				
QUALITY ASSURANCE PROCEDURES	Minimum Detection Levels	11	O	O	O	O				
	Recovery Frequency	12	O	O	O	O				
	Percent Recovery	13	O	O	O	O				
	Check Sample Frequency	14	A	A	A	A				
	All analyst w/Check Samples	15	A	A	A	A				
	Corrective Actions	16	A	A	A	A				
International Check Samples	17	NA	A	A	A					
REVIEW	Corrected Prior Deficiencies	18	A	A	A	A				
OTHER REVIEW		19								
		20								

SIGNATURE OF REVIEWER

Dr. S.P. Singh

DATE

6-26-03

FOREIGN COUNTRY LABORATORY REVIEW

REVIEW DATE

NAME OF FOREIGN LABORATORY

Comment Sheet

06-26-03

Laboratoire d'Environnement Inc. Private - Acc. by CFIA for Microbiology

FOREIGN GOV'T AGENCY

CITY & COUNTRY

ADDRESS OF LABORATORY

Canadian Food Inspection Agency(CFIA).

Sherbrook, Quebec, Canada

740, Rue Galt West

NAME OF REVIEWER

NAME OF FOREIGN OFFICIAL

DR.S.P.Singh

Dr. Joan Reindeau and Ms. Nancy Allard

RESIDUE	ITEM NO.	COMMENTS
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06-23-03

Saint-Hyacinthe Quebec Area Lab

FOREIGN COUNTRY LABORATORY REVIEW

FOREIGN GOV'T AGENCY Canadian Food Inspection Agency	CITY & COUNTRY Saint-Hyacinthe, Quebec, Canada	ADDRESS OF LABORATORY 3400, Boulevard Cesavant West
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NAME OF REVIEWER Dr. S. P. Singh	NAME OF FOREIGN OFFICIAL Dr. Yvon Louis Trottier and Dr. Pierre Marioux
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Residue Code/Name		SL	LM	EC	o157	
SAMPLING PROCEDURES	REVIEW ITEMS					
	ITEM #					
	Sample Handling	01	A	A	A	A
	Sampling Frequency	02	A	A	A	A
	Timely Analyses	03	A	A	A	A
	Compositing Procedure	04	O	O	O	O
SAMPLING PROCEDURES	Interpret Comp Data	05	O	O	O	O
	Data Reporting	06	A	A	A	A
ANALYTICAL PROCEDURES	Acceptable Method	07	A	A	A	A
	Correct Tissue(s)	08	A	A	A	A
	Equipment Operation	09	A	A	A	A
	Instrument Printouts	10	A	A	A	A
QUALITY ASSURANCE PROCEDURES	Minimum Detection Levels	11	NA	NA	NA	NA
	Recovery Frequency	12	NA	NA	NA	NA
	Percent Recovery	13	NA	NA	NA	NA
	Check Sample Frequency	14	A	A	A	A
	All analyst w/Check Samples	15	A	A	A	A
	Corrective Actions	16	A	A	A	A
International Check Samples	17	NA	NA	NA	NA	
REVIEW	Corrected Prior Deficiencies	18	A	A	A	A
OTHER REVIEW		19				
		20				

SIGNATURE OF REVIEWER: *S. P. Singh* DATE: *06/23/03*

FOREIGN COUNTRY LABORATORY REVIEW

REVIEW DATE

NAME OF FOREIGN LABORATORY

Comment Sheet

05-23-03

Saint-Hyacinthe Quebec Area Lab

FOREIGN GOV'T AGENCY

Canadian Food Inspection Agency

CITY & COUNTRY

Saint-Hyacinthe, Quebec, Canada

ADDRESS OF LABORATORY

3400, Boulevard Cesavant West

NAME OF REVIEWER

Dr. S. P. Singh

NAME OF FOREIGN OFFICIAL

Dr. Yvon Louis Trottier and Dr. Pierre Marioux

RESIDUE	ITEM NO.	COMMENTS
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Remarks

This laboratory carries out National Microbiological sampling of all food products. Accredatated by Standard Council of Canada. Technical Assessor of Health Canada has authority to determine the status of the lab. All methods are evaluated by a commitee of CFIA and HC.

June 26, 2003 Bodycote (Materials Testing Canada Inc.)

FOREIGN COUNTRY LABORATORY REVIEW

FOREIGN GOV'T AGENCY
 Canada Food Inspection Agency

CITY & COUNTRY
 Laval, Quebec, Canada

ADDRESS OF LABORATORY
 3025 Monte'e St-Aubin, Laval, QC Canada

NAME OF REVIEWER
 Dr. Don Carlson

NAME OF FOREIGN OFFICIAL
 Vania Atudorei, M.Sc. Microbiologist, Supervisor Microbiology Laboratories

Residue Code/Name			Ecol	Sal	List	Stap										
SAMPLING PROCEDURES	REVIEW ITEMS	ITEM #	EVALUATION CODE													
	Sample Handling	01	A	A	A	A										
	Sampling Frequency	02	A	A	A	A										
	Timely Analyses	03	A	A	A	A										
	Compositing Procedure	04	O	O	O	O										
	Interpret Comp Data	05	O	O	O	O										
Data Reporting	06	A	A	A	A											
ANALYTICAL PROCEDURES	Acceptable Method	07	A	A	A	A										
	Correct Tissue(s)	08	A	A	A	A										
	Equipment Operation	09	A	A	A	A										
	Instrument Printouts	10	A	A	A	A										
QUALITY ASSURANCE PROCEDURES	Minimum Detection Levels	11	O	O	O	O										
	Recovery Frequency	12	O	O	O	O										
	Percent Recovery	13	O	O	O	O										
	Check Sample Frequency	14	A	A	A	A										
	All analyst w/Check Samples	15	A	A	A	A										
	Corrective Actions	16	A	A	A	A										
International Check Samples	17	O	O	O	O											
REVIEW	Corrected Prior Deficiencies	18	O	O	O	O										
OTHER REVIEW		19														
		20														

SIGNATURE OF REVIEWER

Don Carlson DUM

DATE

June 26, 2003

FOREIGN COUNTRY LABORATORY REVIEW

(Comment Sheet)

REVIEW DATE

June 26, 2003

NAME OF FOREIGN LABORATORY

Bodycote (Materials Testing Canada Inc.)

FOREIGN GOV'T AGENCY

Canada Food Inspection Agency

CITY & COUNTRY

Laval, Quebec, Canada

ADDRESS OF LABORATORY

3025 Monte'e St-Aubin, Laval, QC Canada

NAME OF REVIEWER

Dr. Don Carlson

NAME OF FOREIGN OFFICIAL

Vania Atudorei, M.Sc. Microbiologist, Supervisor Microbiology Laboratories

RESIDUE	ITEM NO.	COMMENTS
Remarks		<p>This is a certified ISO 17025 private microbiological laboratory that is accredited by the Standard Council of Canada. The laboratory performs micro testing for E. coli O157:H7, E. coli, Salmonella, Listeria, Staphylococcus and water samples for official CFIA establishments for establishment. This laboratory performs testing for meat and poultry products but does not do official setting testing for the Salmonella Performance Standards. No concerns arose as a result of this audit.</p>

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Maple Leaf Meats 870 Lagimodiere Boulevard Winnipeg, Manitoba R2J 0T9	2. AUDIT DATE July 14,	3. ESTABLISHMENT NO. 0001	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Don Carlson		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	O
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X	49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	X
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

Canada. Est.0001. July 14, 2003

10. Hams were in contact with an employee's boot and the floor of a work platform in the Ham Stuffing Room. CFIA took immediate appropriate corrective action.
- 13/51) Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records.
- 15/51) Rework was not included in the flow chart or the hazard analysis for the cooked sausage HACCP plan.
- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.
C. Validation documentation was missing from the HACCP plan for corrective actions when a deviation occurred.
- (22/51) The employee monitoring critical limits for metal detection was recording results on a note pad and then transferring the information onto the official monitoring record at another time. Monitoring notes were not attached to the monitoring records.
- 41) A. Beading condensation was observed over the central mixing tank in the pickle preparation room.
B. Beading condensation was observed in front of the ham combo dump in the ham boning room.
- 50/51) Daily inspection coverage for processing shift number 2 was not always provided as required by FSIS Import Regulatory Requirements. Shift number 2 was producing product eligible for export to the United States.
- 51) CFIA performs pre-operational sanitation monitoring procedures two times per month, but there is no documentation of their activities. CFIA does not perform hands on pre-operational sanitation verification procedures.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

W. Don Carlson 07/14/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION MFI dba: inovatech St. Mary's, ON	2. AUDIT DATE July 17, 2003	3. ESTABLISHMENT NO. 16	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Marshall Thibodeaux		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP	<input type="radio"/>	33. Scheduled Sample	
8. Records documenting implementation.	<input type="radio"/>	34. Species Testing	<input type="radio"/>
9. Signed and dated SSOP, by on-site or overall authority.	<input type="radio"/>	35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	<input type="radio"/>	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.	<input type="radio"/>	37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	<input type="radio"/>	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	<input type="radio"/>	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.	<input type="radio"/>	41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	<input type="radio"/>	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.	<input type="radio"/>	43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.	<input type="radio"/>	44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.	<input type="radio"/>	46. Sanitary Operations	X
19. Verification and validation of HACCP plan.	<input type="radio"/>	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	<input type="radio"/>	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	<input type="radio"/>	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	<input type="radio"/>	49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	
24. Labeling - Net Weights		52. Humane Handling	<input type="radio"/>
25. General Labeling		53. Animal Identification	<input type="radio"/>
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	<input type="radio"/>	54. Ante Mortem Inspection	<input type="radio"/>
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	<input type="radio"/>
27. Written Procedures	<input type="radio"/>	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	<input type="radio"/>	56. European Community Directives	
29. Records	<input type="radio"/>	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	<input type="radio"/>	59.	
31. Reassessment	<input type="radio"/>		
32. Written Assurance	<input type="radio"/>		

60. Observation of the Establishment:

- # 46- Review individual observed excessive dust in both yellow drier area and yellow drier packaging room which may contribute to cross contamination issues. Yellow product is pasteurized prior to drying and packaging.
- #46-I also observed excessive powder in albumen drier area and packaging room which may contribute to cross contamination issues. Albumen is pasteurized after drying and packaging.

61. NAME OF AUDITOR
Marshall C. Thibodeaux

62. AUDITOR SIGNATURE AND DATE

Marshall C. Thibodeaux 8/12/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Les Oeufs Bee'O Inc. Upton, PQ	2. AUDIT DATE July 14, 2003	3. ESTABLISHMENT NO. 20	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Marshall Thibodeaux		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements		Audit Results	Part D - Continued Economic Sampling		Audit Results
7. Written SSOP		<input type="radio"/>	33. Scheduled Sample		
8. Records documenting implementation.		<input type="radio"/>	34. Species Testing		<input type="radio"/>
9. Signed and dated SSOP, by on-site or overall authority.		<input type="radio"/>	35. Residue		
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E - Other Requirements		
10. Implementation of SSOP's, including monitoring of implementation.		<input type="radio"/>	36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.		<input type="radio"/>	37. Import		
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		<input type="radio"/>	38. Establishment Grounds and Pest Control		
13. Daily records document item 10, 11 and 12 above.		<input type="radio"/>	39. Establishment Construction/Maintenance		
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan.		<input type="radio"/>	41. Ventilation		
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		<input type="radio"/>	42. Plumbing and Sewage		
16. Records documenting implementation and monitoring of the HACCP plan.		<input type="radio"/>	43. Water Supply		
17. The HACCP plan is signed and dated by the responsible establishment individual.		<input type="radio"/>	44. Dressing Rooms/Lavatories		
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			45. Equipment and Utensils		
18. Monitoring of HACCP plan.		<input type="radio"/>	46. Sanitary Operations		
19. Verification and validation of HACCP plan.		<input type="radio"/>	47. Employee Hygiene		
20. Corrective action written in HACCP plan.		<input type="radio"/>	48. Condemned Product Control		
21. Reassessed adequacy of the HACCP plan.		<input type="radio"/>	Part F - Inspection Requirements		
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		<input type="radio"/>	49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Coverage		
23. Labeling - Product Standards			51. Enforcement		
24. Labeling - Net Weights			52. Humane Handling		<input type="radio"/>
25. General Labeling			53. Animal Identification		<input type="radio"/>
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		<input type="radio"/>	54. Ante Mortem Inspection		<input type="radio"/>
Part D - Sampling Generic E. coli Testing			55. Post Mortem Inspection		<input type="radio"/>
27. Written Procedures		<input type="radio"/>	Part G - Other Regulatory Oversight Requirements		
28. Sample Collection/Analysis		<input type="radio"/>	56. European Community Directives		<input type="radio"/>
29. Records		<input type="radio"/>	57. Monthly Review		
Salmonella Performance Standards - Basic Requirements			58.		
30. Corrective Actions		<input type="radio"/>	59.		
31. Reassessment		<input type="radio"/>			
32. Written Assurance		<input type="radio"/>			

60. Observation of the Establishment

No Findings

61. NAME OF AUDITOR

Marshall C. Thibodeaux

62. AUDITOR SIGNATURE AND DATE

Marshall C. Thibodeaux 8/12/22

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION MFI dba: Inovatech Winnipeg, MB	2. AUDIT DATE July 21, 2003	3. ESTABLISHMENT NO. 22	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Marshall Thibodeaux		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP	<input type="radio"/>	33. Scheduled Sample	
8. Records documenting implementation.	<input type="radio"/>	34. Species Testing	<input type="radio"/>
9. Signed and dated SSOP, by on-site or overall authority.	<input type="radio"/>	35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	<input type="radio"/>	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.	<input type="radio"/>	37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	<input type="radio"/>	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	<input type="radio"/>	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.	<input type="radio"/>	41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	<input type="radio"/>	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.	<input type="radio"/>	43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.	<input type="radio"/>	44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.	<input type="radio"/>	46. Sanitary Operations	
19. Verification and validation of HACCP plan.	<input type="radio"/>	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	<input type="radio"/>	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	<input type="radio"/>	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	<input type="radio"/>	49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	
24. Labeling - Net Weights		52. Humane Handling	<input type="radio"/>
25. General Labeling		53. Animal Identification	<input type="radio"/>
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	<input type="radio"/>	54. Ante Mortem Inspection	<input type="radio"/>
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	<input type="radio"/>
27. Written Procedures	<input type="radio"/>	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	<input type="radio"/>	56. European Community Directives	
29. Records	<input type="radio"/>	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	<input type="radio"/>	59.	
31. Reassessment	<input type="radio"/>		
32. Written Assurance	<input type="radio"/>		

10. Observation of the Establishment

No Findings

61. NAME OF AUDITOR
Marshall C. Thibodeaux

62. AUDITOR SIGNATURE AND DATE

Marshall C. Thibodeaux 8/12/02

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Bumbræ Farms Limited Lyn, On	2. AUDIT DATE July 16, 2003	3. ESTABLISHMENT NO. 26	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Marshall Thibodeaux		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP	O	33. Scheduled Sample	
8. Records documenting implementation.	O	34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.	O	35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	O	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.	O	37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	O	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	O	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.	O	41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	O	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.	O	43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.	O	44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.	O	46. Sanitary Operations	X
19. Verification and validation of HACCP plan.	O	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	O	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	O	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	O	49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	
24. Labeling - Net Weights		52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	O	54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

#46- Review offices observed breaking Leakers, this was brought to the CFIA attention which took immediate corrective action and control procedures.

61. NAME OF AUDITOR
Marshall C. Thibodeaux

62. AUDITOR SIGNATURE AND DATE

Marshall C. Thibodeaux 9/12/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Global Eggs Ltd. Etobicoke, ON	2. AUDIT DATE July 16, 2003	3. ESTABLISHMENT NO. 36	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Marshall Thibodeaux		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP	O	33. Scheduled Sample	
8. Records documenting implementation.	O	34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.	O	35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	O	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.	O	37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	O	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	O	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.	O	41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	O	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.	O	43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.	O	44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.	O	46. Sanitary Operations	X
19. Verification and validation of HACCP plan.	O	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	O	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	O	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	O	49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	
24. Labeling - Net Weights		52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	O	54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O	60.	
32. Written Assurance	O	61.	

60. Observation of the Establishment

#46- Review offices observed breaking Dirties, this was brought to the CFIA attention which took immediate corrective action and control procedures

61. NAME OF AUDITOR
Marshall C. Thibodeaux

62. AUDITOR SIGNATURE AND DATE

Marshall Thibodeaux 8/12/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Lakeside Feeders Ltd P O Box 1868 Brooks, Alberta T1R 1C6	2. AUDIT DATE July 18,	3. ESTABLISHMENT NO 0038	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Don Carlson		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	X
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	X
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	O
29. Records		57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58. AMR	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

Canada. Est.0038. July 18, 2003

- 10) A. A product table for re-work in the combo storage room had wood splinters, cardboard fibers, unidentified black specks and black smears on the surface. CFIA took immediate action.
B. Black grease was observed on two product belts in the fabrication room. CFIA took immediate corrective action.

15/51) Multiple Critical Limits were set for a single Critical Control Point.

- 46) A. An edible product bucket was washed and cleaned in a hand wash sink and then set on a product contact surface (head boning table). CFIA took immediate corrective action.
B. A walk over stand on the slaughter floor over a product conveyer did not adequately protect the conveyer and product from foot debris. CFIA took immediate corrective action.
- 51) CFIA performs pre-operational sanitation by monitoring quality control two times per month, but does not document this activity. CFIA does not perform pre-operational sanitation hands on verification procedures.
- 54) The ante-mortem Veterinarian was asked to demonstrate proper ante-mortem procedures for cows. This establishment has a separate cow fabrication line and previously slaughtered cows on a regular bases. The ante-mortem Veterinarian performed adequate ante-mortem inspection for heifer and steers, i.e. walked around in the pen observing the animals at rest and in motion, but when demonstrating ante-mortem procedures for cows he did not observe each side of the cow one by one single file.
- 55) The alternative postmortem inspection procedure used in this establishment does not meet FSIS regulatory requirements for traditional inspection. The alternative procedure used was the "Cattle Inspection at High Line Speeds for Steers and Heifers".

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

Dr. Don Carlson 07/18/03

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Bellivo Transportation, Inc. Paroisse St-Paulin Route 350 Ste-Angele de Premont, Quebec JOK 3G0	2. AUDIT DATE June 25, 2003	3. ESTABLISHMENT NO. 0040	4. NAME OF COUNTRY Canada	5. NAME OF AUDITOR(S) Dr. Don Carlson	6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT
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Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements		Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP			33. Scheduled Sample	
8. Records documenting implementation.			34. Species Testing	<input type="checkbox"/>
9. Signed and dated SSOP, by on-site or overall authority.			35. Residue	<input type="checkbox"/>
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		X	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light	
14. Developed and implemented a written HACCP plan.			41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.			43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.			44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			45. Equipment and Utensils	
18. Monitoring of HACCP plan.			46. Sanitary Operations	
19. Verification and validation of HACCP plan.		X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.		X	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.			Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.			49. Government Staffing	
Part C - Economic / Wholesomeness			50. Daily Inspection Coverage	X
23. Labeling - Product Standards			51. Enforcement	X
24. Labeling - Net Weights		O	52. Humane Handling	O
25. General Labeling			53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)			54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing			55. Post Mortem Inspection	O
27. Written Procedures		O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		O	56. European Community Directives	O
29. Records		O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements			58.	
30. Corrective Actions		O	59.	X
31. Reassessment		O		
32. Written Assurance		O		

60. Observation of the Establishment

Canada Est. 0040 June 25, 2003

- 10) During pre-operational sanitation, several pieces of product contact equipment were inadequately cleaned prior to the start of operations. 1. Equipment identified in the boning room was: A. Two meat conveyors contained product residue. B. The ban saw blade was rusty. 2. Equipment identified in the skinning room was: A. The inside surfaces of two product barrels contained grease and black unidentified material. B. Fat residue was identified on hand operated surfaces of several hand tools. C. Two hand saws were identified with rust residue. 3. Equipment identified in the small carcass cooler was: A. Three white barrels contained bloody carcass wrapping material, blood residue and grease remaining from the previous day's production. 4. Packaging material in the multivac packaging room was left out during cleanup operations and was contaminated with cleaning water. CFIA took immediate and adequate corrective action.
- 12) Condensation was observed dripping on to carcasses on the carcass receiving dock and the 1st carcass cooler. These were the same areas of condensation identified during pre-operational sanitation. CFIA took immediate and adequate corrective action.
- 13/51) Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records.
- 15/51) A. Critical Control Points set in the HACCP Plan do not meet the definition of a CCP.
B. Multiple Critical Limits were set for a single Critical Control Point.
- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.
- 20/51) Preventive measures for corrective actions were not included in the written HACCP plan.
- 41) Beading condensation was identified during pre-operational sanitation over product or product ways on the carcass receiving dock, in the boning room, in the multivac packaging room, in the 1st carcass cooler and in the 2nd carcass cooler. CFIA inspection took immediate adequate corrective action.
- 50/51) Daily inspection coverage for processing activities was not always provided as required by FSIS Import Regulatory Requirements. All processed product produced in this establishment is eligible for export to the United States.
- 59) The internal supervisory reviewer who was leading the audit concluded on going HACCP requirements and SSOP implementation problems warranted the issuance of a Notice of Intent to Delist if corrective actions were not in place within 30 days of this audit. The FSIS auditor conducting the audit of this establishment was in agreement with this decision.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

 (for D. Carlson DVM) 6/25/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION BEST BRAND MEATS LTD. 500, Dawson Rd, Winnipeg, Manitoba R2J0T1	2. AUDIT DATE 07-14-03	3. ESTABLISHMENT NO. 041	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. S.P. Singh		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	X
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.	X	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	X	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	X
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	O
29. Records	X	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	X
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

Est. 041-Canada –Date: 07-14-2003

- 10/41/51) Sanitation procedures to prevent product contamination were not adequate to address condensation in coolers and in the slaughter area.
- 13/51) Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records.
- 20/51) Corrective actions for a deviation from a critical limit were not specific and adequate.
- 21/51) Annual reassessment of the HACCP plan was not preformed
- 29) Daily generic E. Coli testing was performed, but records review revealed that results were recorded for the incision method of sampling and not for sponge sampling.
- 39) The overhead structures and ceilings were maintained in poor condition with rust and peeling paint observed through out the overhead.
- 46) Sanitation procedures were not adequate to facilitate proper cleaning and sanitizing of overhead structures.
- 55)
 - A. A CFIA head inspector was not incising the lymph nodes properly at the head inspection station.
 - B. The same CFIA inspector was not sanitizing his knife properly.
 - C. Several bruises were missed on swine carcasses at the final inspection station.
- 59) The internal supervisory reviewer who was leading the audit concluded on going HACCP requirements and SSOP implementation problems warranted the issuance of a Notice of Intent to Delist if corrective actions were not in place within 30 days of this audit. The FSIS auditor conducting the audit of this establishment was in agreement with this decision.

61. NAME OF AUDITOR

Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE

J.P. Robinson (for D. Carlson DVM) 7/14/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION
Better Beef Limited
781 York Road
Guelph, Ontario N1E 6N1

2. AUDIT DATE
June 27, 2003

3. ESTABLISHMENT NO.
0051

4. NAME OF COUNTRY
Canada

5. NAME OF AUDITOR(S)
Dr. Don Carlson

6. TYPE OF AUDIT
 ON-SITE AUDIT DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements		Audit Results	Part D - Continued Economic Sampling		Audit Results
7. Written SSOP			33. Scheduled Sample		
8. Records documenting implementation.			34. Species Testing		O
9. Signed and dated SSOP, by on-site or overall authority.			35. Residue		
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E - Other Requirements		
10. Implementation of SSOP's, including monitoring of implementation.			36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import		
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		X	38. Establishment Grounds and Pest Control		
13. Daily records document item 10, 11 and 12 above.		X	39. Establishment Construction/Maintenance		X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan.			41. Ventilation		X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		X	42. Plumbing and Sewage		
16. Records documenting implementation and monitoring of the HACCP plan.			43. Water Supply		
17. The HACCP plan is signed and dated by the responsible establishment individual.			44. Dressing Rooms/Lavatories		
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			45. Equipment and Utensils		
18. Monitoring of HACCP plan.			46. Sanitary Operations		X
19. Verification and validation of HACCP plan.		X	47. Employee Hygiene		
20. Corrective action written in HACCP plan.		X	48. Condemned Product Control		
21. Reassessed adequacy of the HACCP plan.		X	Part F - Inspection Requirements		
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.			49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Coverage		
23. Labeling - Product Standards			51. Enforcement		X
24. Labeling - Net Weights		O	52. Humane Handling		
25. General Labeling			53. Animal Identification		
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)			54. Ante Mortem Inspection		
Part D - Sampling Generic E. coli Testing			55. Post Mortem Inspection		X
27. Written Procedures			Part G - Other Regulatory Oversight Requirements		
28. Sample Collection/Analysis			56. European Community Directives		O
29. Records			57. Monthly Review		X
Salmonella Performance Standards - Basic Requirements			58.		
30. Corrective Actions			59.		X
31. Reassessment					
32. Written Assurance					

60. Observation of the Establishment

Canada Est. 0051 June 27, 2003

- 12) The dropped meat procedure failed to prevent recontamination of dropped meat after completion of the reconditioning procedure. CFIA took immediate and adequate corrective actions.
- 13/51) Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records. (Comment: Missing requirements for preventive action had previously been identified but have not been incorporated as part of the written records.)
- 15/51) A. Critical Control Points set in the HACCP Plan do not meet the definition of a CCP.
B. Multiple Critical Limits were set for a single Critical Control Point.
- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.
C. Validation documentation was missing from the HACCP plan for corrective actions when a deviation occurred.
- 20/51) Corrective actions for a deviation from a critical limit for Cooked Roast Beef in the written HACCP Plan did not address identification of the cause of the deviation or measures to prevent recurrence. (Comment: Documentation of the deviation in the written records did address all four parts of corrective action. 9 CFR 417.3 (a).)
- 21/51) A risk assessment for the consideration of *Listeria monocytogenes* as a microbiological hazard reasonably likely to occur in their production practice for Cooked Roast Beef was not conducted.
- 39) The carcass rails and overhead supporting structures located in the area where cattle are slaughtered and processed were observed to be rusty. Carcass rails were observed to have a buildup of grease and black material on the top and sides.
- 41) Heavy beaded condensation was observed on the overhead structures, carcass rail supports and carcass rails in carcass cooler number 6 (Hot Box with Carcass Water Spray Chill System). The cooler did not contain carcasses but there was no written procedure to assure corrective action prior to filling with carcasses and CFIA could not verify establishment compliance.
- 46) A. Mildew was observed on the underside of a cover and unidentified foreign material was found in large plastic storage containers used for storage of ingredients used in the RTE Cooked Roast Beef Process. (Global Meats Room)
B. Unidentified black smears were observed on a product table in the RTE Cooked Roast Beef Global Meats Room.
- 51) CFIA pre-operational sanitation is performed randomly, less than monthly. There is little documentation. Monitoring of the establishment is performed but independent pre-operational sanitation is not performed.
- 55) A. Postmortem inspection procedures were not performed for abscessed and contaminated livers by a CFIA viscera inspector.
B. The alternative postmortem inspection procedure used in this establishment does not meet FSIS regulatory requirements for traditional inspection. The alternative procedure used was the "Cattle Inspection at High Line Speeds for Steers and Heifers".
- 57) Review of records for required monthly reviews conducted in the last 12 months (CFIA Form 1427) revealed monthly supervisory visits were performed for 9 of the last 12 months.
- 59) The Office of International Affairs and the Auditor concluded on going HACCP requirements and SSOP implementation problems warranted the issuance of a Notice of Intent to Delist if corrective actions were not in place within 30 days of this audit. This notice was issued July 31, 2003 during the exit meeting with inspection officials in Ottawa, Ontario, Canada.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE


 (for Dr. Don Carlson) 6/27/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION CAMPELL SOUP CO.LTD. 60, Birmingham Rd., Toronto, Ontario M8V2B8	2. AUDIT DATE 07-03-03	3. ESTABLISHMENT NO. 055	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. S.P. Singh		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements		Audit Results	Part D - Continued Economic Sampling		Audit Results
7. Written SSOP			33. Scheduled Sample		
8. Records documenting implementation.			34. Species Testing		
9. Signed and dated SSOP, by on-site or overall authority.			35. Residue		
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E - Other Requirements		
10. Implementation of SSOP's, including monitoring of implementation.			36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import		
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.			38. Establishment Grounds and Pest Control		
13. Daily records document item 10, 11 and 12 above.			39. Establishment Construction/Maintenance		
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan .			41. Ventilation		
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		X	42. Plumbing and Sewage		
16. Records documenting implementation and monitoring of the HACCP plan.			43. Water Supply		
17. The HACCP plan is signed and dated by the responsible establishment individual.			44. Dressing Rooms/Lavatories		
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			45. Equipment and Utensils		
18. Monitoring of HACCP plan.			46. Sanitary Operations		
19. Verification and validation of HACCP plan.			47. Employee Hygiene		
20. Corrective action written in HACCP plan.			48. Condemned Product Control		
21. Reassessed adequacy of the HACCP plan.			Part F - Inspection Requirements		
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.			49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Coverage		
23. Labeling - Product Standards			51. Enforcement		X
24. Labeling - Net Weights			52. Humane Handling		O
25. General Labeling			53. Animal Identification		O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)			54. Ante Mortem Inspection		O
Part D - Sampling Generic E. coli Testing			55. Post Mortem Inspection		O
27. Written Procedures		O	Part G - Other Regulatory Oversight Requirements		
28. Sample Collection/Analysis		O	56. European Community Directives		O
29. Records		O	57. Monthly Review		X
58.			59.		
Salmonella Performance Standards - Basic Requirements					
30. Corrective Actions		O			
31. Reassessment					
32. Written Assurance		O			

60. Observation of the Establishment:

Est. 055-Canada -Date: 07-03-2003

- 15/51) Process control steps listed in the flow chart did not reflect the actual processing order of operations.
- 57/51) Records review revealed monthly supervisory visits to verify FSIS requirements were conducted and documented one time in the previous three months.

61. NAME OF AUDITOR

Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE

Dr. S.P. Singh 07/23/03
Dr. S.P. Singh

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Vanderpoil's Eggs Ltd. Abbotsford, BC	2. AUDIT DATE July 23, 2003	3. ESTABLISHMENT NO. 66	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Marshall Thibodeaux		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP	<input type="radio"/>	33. Scheduled Sample	
8. Records documenting implementation.	<input type="radio"/>	34. Species Testing	<input type="radio"/>
9. Signed and dated SSOP, by on-site or overall authority.	<input type="radio"/>	35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. implementation of SSOP's, including monitoring of implementation.	<input type="radio"/>	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.	<input type="radio"/>	37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	<input type="radio"/>	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	<input type="radio"/>	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .	<input type="radio"/>	41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	<input type="radio"/>	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.	<input type="radio"/>	43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.	<input type="radio"/>	44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.	<input type="radio"/>	46. Sanitary Operations	<input checked="" type="radio"/>
19. Verification and validation of HACCP plan.	<input type="radio"/>	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	<input type="radio"/>	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	<input type="radio"/>	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	<input type="radio"/>	49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	<input checked="" type="radio"/>
24. Labeling - Net Weights		52. Humane Handling	<input type="radio"/>
25. General Labeling		53. Animal Identification	<input type="radio"/>
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	<input type="radio"/>	54. Ante Mortem Inspection	<input type="radio"/>
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	<input type="radio"/>
27. Written Procedures	<input type="radio"/>	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	<input type="radio"/>	56. European Community Directives	<input type="radio"/>
29. Records	<input type="radio"/>	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	<input type="radio"/>	59.	
31. Reassessment	<input type="radio"/>		
32. Written Assurance	<input type="radio"/>		

60. Observation of the Establishment:

#46 The salt room where salt is dumped in a hopper to be conveyed into processing room is constructed of material not easily cleanable or impervious to moisture. (Wood walls and no coving)

#46 & 51 Plant sampling collection not preformed in an aseptic manner, sample being collected using bare hand holding sampling container directly under dispenser directly over product container allowing excess dripping into product container. CFLA corrected procedure.

61. NAME OF AUDITOR

Marshall C. Thibodeaux

62. AUDITOR SIGNATURE AND DATE

Marshall C. Thibodeaux 8/22/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION MITCHELLS Gourmet FoodsLTD. 11th west, Saskatoon, SAS, SK3V4	2. AUDIT DATE 07-17-03	3. ESTABLISHMENT NO. 069	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. S.P. Singh	6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.	X	37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	X
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	X
19. Verification and validation of HACCP plan.		47. Employee Hygiene	X
20. Corrective action written in HACCP plan.	X	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	O
29. Records	X	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	X
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

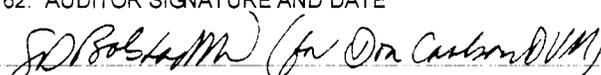
Est. 069-Canada –Date: 07-17-2003

- 10/11/51) Sanitation procedures to prevent product contamination were not adequate to address condensation in the slaughter area. A pre-operation sanitation audit was carried out by the FSIS auditor. The per-operation sanitation procedures in the SSOPs were ineffective.
- 13/51) Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records.
- 20/51) Corrective actions for a deviation from a Critical Limit were not specific and adequate.
- 29) Daily generic E. Coli testing was performed, but records review revealed that results were recorded for the incision method of sampling and not for sponge sampling.
- 39) The overhead structures and ceilings were maintained in poor condition.
- 41) Condensation was observed through out the overhead of the slaughter establishment.
- 44/51) Locker rooms were not kept clean. Dust collection was observed on the top of employee lockers. Government enforcement was ineffective regarding all aspect of locker room maintenance.
- 46) Sanitation procedures were not adequate to facilitate proper cleaning and sanitizing of overhead structures through out the slaughter establishment.
- 47/51) Employees wearing working coats were observed going outside and coming inside the establishment without a change of garments. Government enforcement was ineffective regarding all aspect of employee garment control.
- 59) The internal supervisory reviewer who was leading the audit concluded on going HACCP requirements and SSOP implementation problems warranted the issuance of a Notice of Intent to Delist if corrective actions were not in place within 30 days of this audit. The FSIS auditor conducting the audit of this establishment was in agreement with this decision.

61. NAME OF AUDITOR

Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE

 (for Dr. S.P. Singh) 7/17/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Lilydale Foods 7727-127 Avenue Edmonton, AB Canada	2. AUDIT DATE 07-22-03	3. ESTABLISHMENT NO. 92	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Dexter Reavis		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	X	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	X	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	
29. Records		57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

Canada, Est. 0092 July 22, 2003.

- 12) A. In a dry storage area there were several pallets of boxes that were already made up and nested without any protective covering. On one of the pallets the top layers of boxes had organic residues on the outside and inside of the cardboard, indicating this material had been in a production area previously. CFIA officials immediately rejected the pallets and plant personnel began corrective actions. 416.13 and 416.15
- B. The recessed area of a freezer cell had a frost/condensation layer approximately two inches thick. A two by four inch piece of the frost had released and fallen onto some boxed product. CFIA officials immediately rejected the freezer and retained all involved product. 416.13 and 416.15

13/51) Documented corrective actions do not list preventive measures as required by 416.15.

15/51) Most of the eleven CCP's of the HACCP plan contained multiple critical limits. The zero tolerance CCP for feces is incorporated with finished product standards at the pre-chill location and appears to have a tolerance for feces. This does not meet the intent of the regulations 417.1 and 417.2.

19/51) There is no validation to document the adequacy of the HACCP plan to control the identified food safety hazards. 417.4

20/51) Documented corrective actions for a HACCP deviation do not meet the requirements of 417.3.

61. NAME OF AUDITOR

DEXTER REAVIS

62. AUDITOR SIGNATURE AND DATE

Dexter Reavis DM July 22-03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Cargill Limited P O Bag 3850 472 Avenue & Highway 2A North High River, Alberta T1V 1 P4	2. AUDIT DATE July 21,2003	3. ESTABLISHMENT NO. 0093	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Don Carlson		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOPs have failed to prevent direct product contamination or adulteration.	X	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	X
18. Monitoring of HACCP plan.		46. Sanitary Operations	X
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	X
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	X
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	O
29. Records		57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	X
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

Canada, Est.0093 July 21, 2003

- 10) A. A toe guard at a work stand located over a product belt was not sealed properly. Fat and meat from the work stand was falling onto the product belt.
 B. One product gondola, one product table and two product tubs were contaminated with unidentified black material.
 C. Hind quarters were identified by management with grease smears (2 x 6 inches) and two other quarters with smears ½ x 2 inches were allowed to proceed to the hind breaking saw table with out trimming of the defects.
- 12) Condensation previously identified in cooler number one, cooler number two and the slaughter floor were re-identified upon re-checking the same areas.
- 13/51) A. Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records for each occurrence.
 B. Sanitation problems were not adequately described in the daily pre-operational sanitation records.
- 15/51) A. Critical Control Points set in the HACCP Plan do not meet the definition of a CCP.
 B. Multiple Critical Limits were set for a single Critical Control Point.
 C. A CCP for Zero-tolerance was included in the HACCP plan for carcasses contaminated with Ingesta and Milk but Fecal contamination was not described.
- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
- 41) Condensation was observed in the following product areas:
 1. Condensation was dripping from the overhead in the cryovac packaging area.
 2. Condensation was beading under an exhaust vent over product in the fabrication room.
 3. Condensation was beading under refrigeration units over product in coolers number one, two and three.
 4. Condensation was beading under refrigeration units, cement beams and pipes in the cryovac packaging storage room. One carton containing cryovac packaging material was totally soaked with condensate.
 5. Condensation was beading under refrigeration units in the grading cooler.
 6. Condensation was beading under the carcass rails from over spray in the hot box.
 7. Condensations was dripping in an employee walk way on the slaughter floor.
- 45) A. The hand saw used for hock removal on the high bench was rusty.
 B. The blades of the auxiliary dehorner were completely covered with rust.
- 46) A. A clean up hose was rolled up against the railing above a trim extruder.
 B. A wheeled cart was stored against a clean up hose.
 C. A large accumulation of dust/dirt and cardboard dust was found at the floor/wall junction, corners and walkways of the box storage cooler.
- 48/51) Livers saved for pet food were denatured but were not maintained under security or slashed into two inch by two inch squares.
- 55) The alternative postmortem inspection procedure used in this establishment does not meet FSIS regulatory requirements for traditional inspection. The alternative procedure used was the "Cattle Inspection at High Line Speeds for Steers and Heifers".
- 59) The internal supervisory reviewer who was leading the audit concluded on going HACCP requirements and SSOP implementation problems warranted the issuance of a Notice of Intent to Delist if corrective actions were not in place within 30 days of this audit. The FSIS auditor conducting the audit of this establishment was in agreement with this decision.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE


 (for Dr. Carlson DVM) 7/21/03

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Abattoir Les Cedres Limitee 1000 Montee Pilon Les Cedres, Cte. Soulanges, Quebec JOP ILO	2. AUDIT DATE June 19, 2003	3. ESTABLISHMENT NO. 0098A	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. Don Carlson	6. TYPE OF AUDIT <input type="checkbox"/> ON-SITE AUDIT <input checked="" type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	O
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Park Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	X
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

Canada. Est 0098A 6/19/03

- 13/51) Preventive measures for pre-operational and operational sanitation problems were not documented in the daily pre-operational and operational sanitation records.
- 15/51) A. Rework was not included in the flow chart or the Hazard Analysis.
B. Critical Control Points set in the HACCP Plan do not meet the definition of a CCP.
C. Multiple Critical Limits were set for a single Critical Control Point.
- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.
- 57/51) Review of the Regional Veterinary Officer's records for monthly reviews conducted in 2002 (CFIA Form 1427) revealed required monthly supervisory visits were performed for 10 of 12 months in 2002. (No operations were conducted in 2003.)

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

 (for Dr. Don Carlson) 6/19/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION McCain Foods Ltd Municipality of Grand Falls Madawaska County New Brunswick E0J 1M0	2. AUDIT DATE July 11, 2003	3. ESTABLISHMENT NO. 0173	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Don Carlson		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements		Audit Results	Part D - Continued Economic Sampling		Audit Results
7. Written SSOP			33. Scheduled Sample		
8. Records documenting implementation.			34. Species Testing		O
9. Signed and dated SSOP, by on-site or overall authority.			35. Residue		O
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E - Other Requirements		
10. Implementation of SSOP's, including monitoring of implementation.			36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import		
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.			38. Establishment Grounds and Pest Control		
13. Daily records document item 10, 11 and 12 above.			39. Establishment Construction/Maintenance		
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan.			41. Ventilation		
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		X	42. Plumbing and Sewage		
16. Records documenting implementation and monitoring of the HACCP plan.			43. Water Supply		
17. The HACCP plan is signed and dated by the responsible establishment individual.			44. Dressing Rooms/Lavatories		
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			45. Equipment and Utensils		X
18. Monitoring of HACCP plan.			46. Sanitary Operations		X
19. Verification and validation of HACCP plan.		X	47. Employee Hygiene		
20. Corrective action written in HACCP plan.			48. Condemned Product Control		
21. Reassessed adequacy of the HACCP plan.			Part F - Inspection Requirements		
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.			49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Coverage		X
23. Labeling - Product Standards			51. Enforcement		X
24. Labeling - Net Weights		O	52. Humane Handling		O
25. General Labeling			53. Animal Identification		O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)			54. Ante Mortem Inspection		O
Part D - Sampling Generic E. coli Testing			55. Post Mortem Inspection		O
27. Written Procedures		O	Part G - Other Regulatory Oversight Requirements		
28. Sample Collection/Analysis		O	56. European Community Directives		O
29. Records		O	57. Monthly Review		
Salmonella Performance Standards - Basic Requirements			58.		
30. Corrective Actions		O	59.		
31. Reassessment		O			
32. Written Assurance		O			

60. Observation of the Establishment

Canada. Est.0173. July 11, 2003

- 15/51) Multiple Critical Limits were set for a single Critical Control Point.
- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.
- 45) Product belts on two pizza crust conveyors were worn through to the rubberized surface exposing the cotton fiber core. Surfaces of the two belts were stained with unidentified black specks.
- 46) A. Frozen condensation was observed at the entrance, on walls and on the ceiling of two spiral blast freezers.
B. Box dust, wood splinters and miscellaneous debris was observed on the floor around the inside walls and corners of the dry storage room.
- 50/51) Daily inspection coverage for processing activities was not always provided as required by FSIS Import Regulatory Requirements. All processed product produced in this establishment is eligible for export to the United States.
- 51) CFIA performed pre-operational sanitation hands on verification one time in the last six months. Pre-operational sanitation is scheduled two times per month for monitoring of quality control. CFIA is not documenting pre-operational sanitation activities.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

 07/11/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION J. M. Schneider Incorporated 15350 Old Simcoe Road Port Perry, Ontario L9L 1A6	2. AUDIT DATE July 07, 2003	3. ESTABLISHMENT NO. 0218	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Don Carlson		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	O
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	X
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
18. Monitoring of HACCP plan.		45. Equipment and Utensils	X
19. Verification and validation of HACCP plan.	X	46. Sanitary Operations	X
20. Corrective action written in HACCP plan.	X	47. Employee Hygiene	
21. Reassessed adequacy of the HACCP plan.		48. Condemned Product Control	X
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	X
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Park Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	X
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

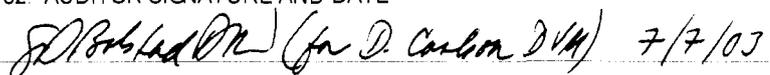
Canada. Est.0218. July 07, 2003

- 10/51) Black grease was smeared on the inside surface of a stainless steel edible product gondola and a dead insect was identified on the bottom surface of another stainless steel gondola in the same area.
- 13/51) A. Preventive measures for pre-operational sanitation were not documented in the daily pre-operational sanitation records.
B. Very few sanitation problems were documented in the daily pre-operational sanitation records.
C. Sanitation problems were not adequately described in the daily pre-operational sanitation records.
- 19/51) A. Verification procedures were not described in the written HACCP plan.
B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.
C. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
- 20) Preventive measures and steps to bring a CCP under control were not included in the corrective actions in the written HACCP plan.
- 38) Flies (15-20) were observed on the receiving dock for boxed product and supplies.
- 41) Condensation was observed on the bottom surface of three cooling units located on the receiving dock.
- 45) A product whisk was observed in a hand wash sink located in the crust baking room.
- 46) Non product sanitation problems: A. Packaging room: 1. Heavy grease and residue buildup was observed on non product storage shelves. 2. Meat, dough and residue build up on the top of three machines used for packaging and production of product. 3. All blue edible product tubs (15-20) were cut and scared over the entire product surface and several were broken and cracked. B. Two trucks were not properly backed up to the receiving dock causing a gap of one foot around the back of the truck. C. Cardboard used to cover pallets in the ingredient storage cooler, was stained with old product residue. D. The top of the closed loop cooler was covered with unidentified black material and product residue. E. The top of three pallets of meat that were in the process of tempering in the pre prep room were covered with unidentified back specks and wood splinters.
- 48) Inedible product was deposited in a trash container with the packaging wrapper intact. Inedible product in this establishment should be removed from the wrapper and denatured with a denaturant.
- 50/51) Daily inspection coverage for processing activities was not always provided as required by FSIS Import Regulatory Requirements. All processed product produced in this establishment is eligible for export to the United States.
- 59) The internal supervisory reviewer who was leading the audit concluded on going HACCP requirements SSOP implementation problems warranted the issuance of a Notice of Intent to Delist if corrective actions were not in place within 30 days of this audit. The FSIS auditor conducting the audit of this establishment was in agreement with this decision.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

 7/7/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Alberta Beef XL Foods Inc 4240 - 75 th Ave. SE Calgary, Alberta T2C 2HB	2. AUDIT DATE July 16, 2003	3. ESTABLISHMENT NO. 0235A	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) <p style="text-align: center;">Dr. Don Carlson</p>		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	X	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	X
18. Monitoring of HACCP plan.		46. Sanitary Operations	X
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	X	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	X
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	X
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

Canada. Est.0235A. July 16, 2003

- 10) A. Condensation was dripping onto carcasses quarters and retail cuts from a refrigeration unit in the holding cooler.
B. Condensation was dripping from drip pans onto a product conveyor and onto a carton of cryovac bags.
- 12/51) Carcasses quarters and retail cuts contaminated with condensation were loaded into combos. This process caused cross contamination of the meat and bone surfaces.
- 13/51) A. Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records.
B. Very few sanitation problems were documented in the daily pre-operational sanitation records.
C. Sanitation problems were not adequately described in the daily pre-operational sanitation records.
D. Condensation was not identified in the last thirty days of operational sanitation records. The last monthly supervisory review did identify condensation.
- 15/51) A. Critical Control Points set in the HACCP Plan do not meet the definition of a CCP.
B. Multiple Critical Limits were set for a single Critical Control Point.
- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.
C. Validation documentation was missing from the HACCP plan for corrective actions when a deviation occurred.
- 20/51) Preventive measures were not included in the corrective actions for a deviation from a critical limit.
- 39) A. Rusty overhead structures and peeling paint were observed through out the boning room.
B. Flaking paint was observed on the bottom surface of refrigeration units over carcasses in the second holding cooler.
- 41) A. Beading condensation was observed on the overhead structures and refrigeration units over product areas and product tables in the boning room.
B. Beading condensation was observed on over head structures above product areas on the wizard knife mezzanine.
C. Condensation was dripping from the product rail and over product structures above the lactic acid wash cabinet in the holding cooler.
D. Beading condensation was observed under refrigeration units and over carcasses in the second holding cooler.
- 45) Two dropped meat reconditioning stations consisted of a table with a cutting board. Washing and sanitizing facilities were not located next to the table. The cutting board for one reconditioning station was transported 20 feet and washed in a hand wash sink.
- 46) A. All boxes and packaging materials were stacked directly against the walls in the dry storage room.
B. A two gallon sprayer half full of an unidentified liquid was not labeled in the chemical storage room.
C. The bottom of a container used to store micro swab sample kits and a meat hook was covered with unidentified white particles and fat residue.
- 50/51) Daily inspection coverage for processing activities was not always provided as required by FSIS Import Regulatory Requirements. All processed product produced in this establishment is eligible for export to the United States.
- 51) CFIA performs hands on pre-operational sanitation verification two times per month, but their activities are not documented.
- 59) The CFIA auditor voluntarily removed this establishment from the list of establishments certified as eligible to export to the United States, effective as of the start of operations on the day of this audit. The FSIS auditor was in agreement with this decision.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE


 (for Dr. Carlson DVM) 7/16/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION MONDDIV 3810, Alfred Laliberte, Boisbriand Quebec	2. AUDIT DATE 06-18-03	3. ESTABLISHMENT NO. 251	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. S.P. Singh		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	O
29. Records		57. Monthly Review	X
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

Est 251-Canada -Date 6-18-2003

57/51) Records review revealed monthly supervisory visits to verify FSIS requirements were conducted and documented one time in the previous three months.

61. NAME OF AUDITOR

Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE

W. Don Carter 06/18/03
For Dr. Singh

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Fletcher Fine Foods (Premium Brands). 8385 Fraser Street, Vancouver, BC, V5X3X8	2. AUDIT DATE 07-23-03	3. ESTABLISHMENT NO. 270	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. S.P. Singh		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.	X	37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	X
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment:

Est. 270-Canada -Date: 07-23-2003

11.41) Sanitation procedures to prevent product contamination (416.13) were not adequate to address condensation in sausage production area. Water was pooling on the floors in the cooking area.

39) The overhead structures, ceilings and rails in cooking area of the establishment were rusty.

50/51) Daily inspection coverage for processing activities was not always provided as required by FSIS Import Regulatory Requirements. All processed product produced in this establishment is eligible for export to the United States.

61. NAME OF AUDITOR

Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE

Dr. S.P. Singh
For Dr. Singh.

07/23/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Volailles Marvid poultry 5671 Noul, Industriel Montreal-Nord, Quebec H1G3Z9	2. AUDIT DATE July 17, 2003	3. ESTABLISHMENT NO. 274	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Dexter Reavis		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X	49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQU/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	
29. Records		57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

Canada Est. 0274 July 17, 2005

- 13/51) Documented SSOP corrective actions do not, on a daily basis, contain preventive measures as required by 416.15
- 15/51) One of the CCP's (Zero Tolerance) contains two critical limits which does not meet the requirements of 417.1 and 417.5
- 19/51) There is no initial validation for decisions made concerning adequacy of the CCP's, critical limits, monitoring, recordkeeping procedures and corrective actions as required by 417.4.
- 22/51) Records do not indicate the performance of a pre-shipment review prior to the shipment of product as required by 417.5.

61. NAME OF AUDITOR

Dexter Reavis

62. AUDITOR SIGNATURE AND DATE

Dexter Reavis DVM *July 17-03*

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Tender Choice Foods, Inc 4480 Paletta Court Burlington, Ontario L7L 5R2	2. AUDIT DATE July 3, 2003	3. ESTABLISHMENT NO. 0275	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Don Carlson		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOPs have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	X
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	X	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X	49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	O
25. General Labeling	O	53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	O	54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58. AMR	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

Canada. Est.0275 July 3, 2003.

- 10) A. Plastic combos located in the raw product staging area used for edible product and ready for use contained pieces of meat and blood residue. CFIA took immediate and adequate corrective action.
- B. Black unidentified specks were scattered on the top of 75% of thirty six combos of exposed product stored in the south cooler. CFIA took immediate and adequate corrective action.
- 13/51) Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records.
- 15/51) A. Rework was not included in the flow chart or considered in the Hazard Analysis.
- B. Critical Control Points set in the HACCP Plan do not meet the definition of a CCP.
- C. Multiple Critical Limits were set for a single Critical Control Point.
- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points
- B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.
- 20/51) Preventive measures for corrective actions were not included in the written HACCP plan.
- 22/51) Preventive measures for corrective actions were not documented in the written records.
- 45) A. Equipment provided for the reconditioning of dropped meat was not adequate in two areas.
 - 1. A perforated bottom was not provided for the meat reconditioning sink located in the turkey cutup room.
 - 2. A sanitizer was not provided at the meat reconditioning sink located in the chicken cutup room.
- B. Broken plastic combos used for edible product was identified in two areas of the establishment.
- 51) Pre-operational sanitation is verification by CFIA through daily observations and weekly records review but hands on verification is performed two times per year.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

 07/03/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Cappola Food Inc. 25 Le Page Ct. Toronto, Ontario M3J 3M3 Canada	2. AUDIT DATE July 15, 2003	3. ESTABLISHMENT NO. 327	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Dexter Reavis		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements		Audit Results	Part D - Continued Economic Sampling		Audit Results
7. Written SSOP			33. Scheduled Sample		
8. Records documenting implementation.			34. Species Testing		
9. Signed and dated SSOP, by on-site or overall authority.			35. Residue		
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E - Other Requirements		
10. Implementation of SSOP's, including monitoring of implementation.			36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import		
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.			38. Establishment Grounds and Pest Control		
13. Daily records document item 10, 11 and 12 above.		X	39. Establishment Construction/Maintenance		
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan.			41. Ventilation		
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		X	42. Plumbing and Sewage		
16. Records documenting implementation and monitoring of the HACCP plan.			43. Water Supply		
17. The HACCP plan is signed and dated by the responsible establishment individual.			44. Dressing Rooms/Lavatories		
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			45. Equipment and Utensils		
18. Monitoring of HACCP plan.			46. Sanitary Operations		
19. Verification and validation of HACCP plan.		X	47. Employee Hygiene		
20. Corrective action written in HACCP plan.			48. Condemned Product Control		
21. Reassessed adequacy of the HACCP plan.			Part F - Inspection Requirements		
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		X	49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Coverage		X
23. Labeling - Product Standards			51. Enforcement		X
24. Labeling - Net Weights			52. Humane Handling		
25. General Labeling			53. Animal Identification		
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)			54. Ante Mortem Inspection		
Part D - Sampling Generic E. coli Testing			55. Post Mortem Inspection		
27. Written Procedures			Part G - Other Regulatory Oversight Requirements		
28. Sample Collection/Analysis			56. European Community Directives		
29. Records			57. Monthly Review		
Salmonella Performance Standards - Basic Requirements			58.		
30. Corrective Actions			59.		
31. Reassessment					
32. Written Assurance					

60. Observation of the Establishment:

Canada Est. 0327 July 15, 2003

- 13/51) Documented SSOP corrective actions do not contain preventive measures as required by 416.15
- 15/51) Two of the existing CCP's do not have a stated frequency for performance (they are monitored and documented for each lot) as required by 417.2.
- 19/51) There is no initial validation for decisions made concerning adequacy of the CCP's, critical limits, monitoring, recordkeeping procedures and corrective actions as required by 417.4.
- 22/51) Records do not indicate the performance of a pre-shipment review prior to the shipment of product as required by 417.5.
- 50/51) Daily inspection coverage for processing activities was not always provided as required by FSIS Import Regulatory Requirements. All processed product produced in this establishment is eligible for export to the United States.

61. NAME OF AUDITOR

Dexter Reavis DM

62. AUDITOR SIGNATURE AND DATE

Dexter Reavis DM

July 15-03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Les Viandes Pasco 2000, Inc. 11525, Rue 4 th Ave., Riviersdes prairies Montreal Quebec	2. AUDIT DATE 06-25-03	3. ESTABLISHMENT NO. 365	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. S.P. Singh		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	X	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

Est 365-Canada -Date 6-25-2003

21/51) A risk assessment was not conducted for *E. coli* 0157: H7 in processed boned and trim product from beef and veal carcasses.

61. NAME OF AUDITOR

Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE

Dr. S.P. Singh 06/25/03
For Dr. S. Singh

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Fletcher Fine Foods (Premium Brands). 8385 Fraser Street, Vancouver, BC, V5X3X8	2. AUDIT DATE 07-24-03	3. ESTABLISHMENT NO. 361	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. S.P. Singh	6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.	X	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	X	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	X
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

Est. 361-Canada -Date: 07-24-2003

- 15/51) Critical Limits set for Critical Control Points was not measurable.
- 20/51) The term deviation procedures was used for corrective actions with preventive measures lacking in all HACCP plans.
- 21/51) Annual reassessment of the HACCP plan was not preformed
- 50/51) Daily inspection coverage for processing activities was not always provided as required by FSIS Import Regulatory Requirements. All processed product produced in this establishment is eligible for export to the United States.

61. NAME OF AUDITOR

Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE


For Dr. S.P. Singh. 07/24/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Levinoff Meat Products, LTD. 8600 – 8 Avenue Ville St. Michel Montreal, Quebec H1Z 2W4	2. AUDIT DATE June 23, 2003	3. ESTABLISHMENT NO. 0366	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Don Carlson		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	O
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	X	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	X
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58. AMR	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

Canada, Est. 0366 June 23, 2003

- 12) A. The dropped meat procedure failed to prevent recontamination of dropped meat after completion of the reconditioning procedure. CFIA took immediate and adequate corrective actions.
- B. Dropped carcasses were picked up off the carcass trailer floor and commingled with clean carcasses on the unloading rail. Clean and contaminated carcasses were touching. CFIA took immediate and adequate corrective actions.

- 15/51) A. Critical Control Points set in the HACCP Plan do not meet the definition of a CCP.
- B. Multiple Critical Limits were set for a single Critical Control Point.

- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
- B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.

- 47) The contamination trimmer at the carcass receiving contamination trim station, was handling pieces of contaminated trim with his gloved hand and then turning the carcass with the same hand therefore contaminating the trimmed carcasses.

- 51) CFIA performs pre-operational sanitation verification hands on procedures one time per month.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

Dr. Don Carlson 06/27/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION NESTLE CANADA Inc. 1, Douglas Rd. TRENTON, Ontario K8V557	2. AUDIT DATE 07-07-03	3. ESTABLISHMENT NO. 368	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. S.P. Singh		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	X	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	X
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment			
32. Written Assurance	O		

60. Observation of the Establishment:

Est. 368-Canada -Date: 07-07-2003

- 13/51) Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records.
- 21/51) Hazards reasonably likely to occur in a production process were not addressed in the Hazard Analysis.
- 41) Condensation was observed in one of the product coolers. CFIA took immediate corrective action.
- 50/51) Daily inspection coverage for processing activities was not always provided as required by FSIS Import Regulatory Requirements. All processed product produced in this establishment is eligible for export to the United States.

61. NAME OF AUDITOR
Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE

D. S. P. Singh 07/07/03
For Dr. Singh.

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION CULINARY DESTINATIONS LIMITED, 777 The Queensway, Unit G Toronto, Ontario M8Z1N4	2. AUDIT DATE 07-02-03	3. ESTABLISHMENT NO. 399	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. S.P. Singh		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements		Audit Results	Part D - Continued Economic Sampling		Audit Results
7. Written SSOP			33. Scheduled Sample		
8. Records documenting implementation.			34. Species Testing		
9. Signed and dated SSOP, by on-site or overall authority.			35. Residue		
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E - Other Requirements		
10. Implementation of SSOP's, including monitoring of implementation.			36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import		
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.			38. Establishment Grounds and Pest Control		
13. Daily records document item 10, 11 and 12 above.			39. Establishment Construction/Maintenance		X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan .			41. Ventilation		
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.			42. Plumbing and Sewage		
16. Records documenting implementation and monitoring of the HACCP plan.			43. Water Supply		
17. The HACCP plan is signed and dated by the responsible establishment individual.			44. Dressing Rooms/Lavatories		
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			45. Equipment and Utensils		
18. Monitoring of HACCP plan.			46. Sanitary Operations		
19. Verification and validation of HACCP plan.			47. Employee Hygiene		
20. Corrective action written in HACCP plan.			48. Condemned Product Control		
21. Reassessed adequacy of the HACCP plan.		X	Part F - Inspection Requirements		
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.			49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Coverage		
23. Labeling - Product Standards			51. Enforcement		X
24. Labeling - Net Weights			52. Humane Handling		O
25. General Labeling			53. Animal Identification		O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Park Skins/Moisture)			54. Ante Mortem Inspection		O
Part D - Sampling Generic E. coli Testing			55. Post Mortem Inspection		O
27. Written Procedures		O	Part G - Other Regulatory Oversight Requirements		
28. Sample Collection/Analysis		O	56. European Community Directives		O
29. Records		O	57. Monthly Review		X
Salmonella Performance Standards - Basic Requirements			58.		
30. Corrective Actions		O	59.		
31. Reassessment					
32. Written Assurance		O			

60. Observation of the Establishment

Est. 399-Canada -Date:02-07-2003

- 21/51) A risk assessment for the consideration of *Listeria monocytogenes* as a microbiological hazard reasonably likely to occur in their production practice was not conducted.

- 39) A. Broken floors were observed in production areas.
B. The ceiling was taped with duct tape.

- 57/51) A records review revealed monthly supervisory visits to verify FSIS requirements were conducted and documented one time in the previous three months.

61. NAME OF AUDITOR

Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE

Dr. S.P. Singh 02/02/03
For Dr. Singh

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Lucerne Foods Limited 3440 – 56 th Avenue South East Calgary, Alberta T2C 2C3	2. AUDIT DATE July 22, 2003	3. ESTABLISHMENT NO. 0400	4. NAME OF COUNTRY Canada
		5. NAME OF AUDITOR(S) Dr. Don Carlson	6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	O
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	X
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	X	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X	49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

Canada. Est.0400. July 22, 2003

- 10/51) Over spray from a chlorine spray cabinet for incoming quarter carcasses located on the carcass receiving dock was dripping onto quarter carcasses from the trolley rail.
- 13/51) A. Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records for each occurrence.
B. Sanitation problems were not adequately described in the daily pre-operational sanitation records.
- 15/51) A. Critical Control Points set in the HACCP Plan do not meet the definition of a CCP.
B. Multiple Critical Limits were set for a single Critical Control Point.
- 19/51) Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
- 20/51) Preventive measures for a deviation from a critical limit were not included for corrective actions in Cooked Roast Beef HACCP plan.
- 22/51) A pre-shipment review form had not been developed for use in this establishment.
- 39) Peeling paint was observed over product in the Vacuum Seal Packaging room.
- 41) Beading condensation was observed over product areas in the Vacuum Seal Packaging room and over the oven doors in the Cooked Roast Beef room.
- 46) Pallets in the Vacuum Seal Packaging room were contaminated with black unidentified particles.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

Dr. Don Carlson (for D. Carlson) 7/22/03

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION XL Foods Incorporated 5101 – 11 th Street South East Calgary, Alberta T2H 1M7	2. AUDIT DATE July 17, 2003	3. ESTABLISHMENT NO. 0401	4. NAME OF COUNTRY Canada
		5. NAME OF AUDITOR(S) Dr. Don Carlson	6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements		Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP			33. Scheduled Sample	
8. Records documenting implementation.			34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.			35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	X		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light	
14. Developed and implemented a written HACCP plan .			41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.			43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.			44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			45. Equipment and Utensils	
18. Monitoring of HACCP plan.			46. Sanitary Operations	
19. Verification and validation of HACCP plan.	X		47. Employee Hygiene	
20. Corrective action written in HACCP plan.	X		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.			Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X		49. Government Staffing	X
Part C - Economic / Wholesomeness			50. Daily Inspection Coverage	
23. Labeling - Product Standards			51. Enforcement	X
24. Labeling - Net Weights	O		52. Humane Handling	
25. General Labeling			53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)			54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing			55. Post Mortem Inspection	X
27. Written Procedures			Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis			56. European Community Directives	O
29. Records			57. Monthly Review	
Salmonella Performance Standards - Basic Requirements			58.	
30. Corrective Actions			59.	X
31. Reassessment				
32. Written Assurance				

60. Observation of the Establishment

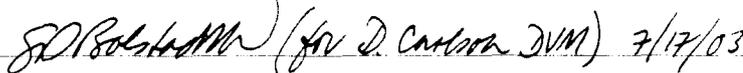
Canada. Est.0401 July 17, 2003.

- 10/51) A. The stainless steel load buggy for carcass quarters had meat particles and blood from the previous day's production.
B. Two pieces of product contact equipment was stored on the floor.
C. A bundle of long meat hooks were hanging from an insanitary overhead structure and were covered with meat and fat from the previous days operations.
- 12) Three white plastic product tubs smeared with black marks were identified by CFIA to be re-cleaned, but were not cleaned sufficiently when re-checked.
- 13/51) Preventive measures for pre-operational and operational sanitation were not documented in the daily pre operational and operational sanitation records for each occurrence. This is a repeat finding from the previous audit.
- 15/51) A. Critical Control Points set in the HACCP Plan do not meet the definition of a CCP.
B. Multiple Critical Limits were set for a single Critical Control Point.
C. A CCP for Zero-Tolerance was not included in the HACCP plan for carcasses contaminated with Fecal, Ingesta and Milk.
- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
- 20/51) Preventive measures were not included in the corrective actions for a deviation from a critical limit.
- 22/51) The employee monitoring the lactic acid CCP was recording lactic acid concentrations on a note pad and then later transferring the information to official monitoring records. The note pads were not attached to the records.
- 49/55) Adequate staffing was not provided for this establishment. This establishment produces heifer & steers at 130 head per hour with tongue-in presentation. The configuration of CFIA line inspectors was 1 at head inspection, 2 at viscera inspection and 1 at rail inspection. 9 CFR 310.1 (2) (B) (ii) states the configuration should be 2 at head inspection, 2 at viscera inspection and 1 at rail inspection for 87 to 143 head per hour with tongue-in presentation for heifers and steers. The CFIA rail inspector was stationed in front of the splitting saw at floor level, 5 feet away from the front of the carcasses and 10 feet away from the viscera table. The CFIA inspector was not actively observing all carcasses. The inspector could not palpate the Iliac, Inguinal or Mammary Lymph Nodes. The inspector could not observe the hind quarters for fecal, milk, ingesta or other defects or pathological conditions. The establishment will periodically slaughter 100 to 350 cows per day. During the day of this audit some cows were scheduled to be slaughtered.
- 51) CFIA performs pre-operational sanitation verification hands on procedures one time per month.
- 55) The viscera inspectors were not performing the following post-mortem procedures:
A. The ventral side of the liver was not palpated.
B. The dorsal side of the lungs was not palpated.
C. The lungs were not turned over and observed.
D. The rumen/reticular junction was not palpated.
- 59) The CFIA auditor voluntarily removed this establishment from the list of establishments certified as eligible to export to the United States, effective as of the start of operations on the day of this audit. The FSIS auditor was in agreement with this decision.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

 (for Dr. Carlson DVM) 7/17/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION R. F. G. Canada Incorporated 50A Claireport Crescent Toronto, Ontario M9W 6P4	2. AUDIT DATE July 03, 2003	3. ESTABLISHMENT NO. 0411	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Don Carlson		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	O
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOPs have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	X
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	O	54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

Canada.Est.0411 July 04, 2003

- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
- B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.

- 45) The components and parts of a pizza sauce spreader located over an exposed product conveyor were rusty.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

Dr. Don Carlson 07/03/03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION MARSON FOODS LTD. 160, Thermos Rd, Toronto, Ontario MIL4w2	2. AUDIT DATE 07-04-03	3. ESTABLISHMENT NO. 424	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. S.P. Singh		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	X	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	X
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment			
32. Written Assurance	O		

60. Observation of the Establishment:

Est. 424-Canada -Date: 07-04-2003

- 21/51) A risk assessment for the consideration of *Listeria monocytogenes* as a microbiological hazard reasonably likely to occur in their production practice for Cooked Roast Beef was not conducted.
- 41) Condensation was observed over the Chicken Tikka Masala line in the production area. CFIA took immediate corrective action.
- 57/51) A records review revealed monthly supervisory visits to verify FSIS requirements were conducted and documented one time in the previous three months.

61. NAME OF AUDITOR

Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE

Dr. Don Carter 07/04/03
for Dr. Singh.

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION NOSTRANO, Inc. 6795, Marconi, Montreal Quebec	2. AUDIT DATE 06-19-03	3. ESTABLISHMENT NO. 476	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. S.P. Singh		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	X	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Park Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

Est 476-Canada -Date 6-19-2003

21/51. A risk assessment for the consideration of *Listeria monocytogenes* as a microbiological hazard reasonably likely to occur in their production practice was not conducted.

61. NAME OF AUDITOR

Dr. S.P. Singh

62. AUDITOR SIGNATURE AND DATE

W-Wan Carlson 06/19/03
For Dr. Singh -

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Delta Dailyfood (Canada) Inc. 26 rue Seguin Rigaud (Quebec) Canada J0P 1P0	2. AUDIT DATE 07-18003	3. ESTABLISHMENT NO. 489	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Dexter Reavis		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.	X	35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	X	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	
29. Records		57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59. See Remarks	X
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment:

Canada Est. 0489 July 18, 2003

- 9.51) The written SSOP does not contain a signature (only initials, one previous modification to the SSOP did contain a signature) as required by 416.2
- 12) There was excessive frost (condensate) around the door, on walls and the overhead around the door in two freezers. This frost was falling onto both exposed and boxed product. The strip curtains covering the door opening, were moist from the frost causing the boxed product entering and exiting the freezers to become directly effected. (Note: CFI inspection personnel rejected both freezers and retained all products in the freezers.
- 13/51) Documented SSOP corrective actions do not contain preventive measures as required by 416.15
- 15/51) Two of the existing CCP's have two critical limits which does not meet the requirements of 417.2.
- 19/51) There is no initial validation for decisions made concerning adequacy of the CCP's, critical limits, monitoring, recordkeeping procedures and corrective actions as required by 417.4.
- 59) The internal supervisory reviewer who was leading the audit concluded on going HACCP requirements and SSOP implementation deficiencies warranted the issuance of a Notice of Intent to Delist if corrective actions were not in place within 30 days of this audit. The FSIS auditor conducting the audit of this establishment was in agreement with this decision.

61. NAME OF AUDITOR

DEXTER REAVIS

62. AUDITOR SIGNATURE AND DATE

Mike Reavis DVM July 18-03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Superior Poultry Processing LTD 2784 Aberdeen Avenue Coquitlam, BC, Canada V3B 1A3	2. AUDIT DATE July 24, 2003	3. ESTABLISHMENT NO. 545	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Dexter Reavis		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	X	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	X	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	
29. Records		57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

Canada Est. 0545 July 24, 2003

- 12) Water from poultry carcasses, shackles and condensation from a drip pan was dripping into a tub with two poultry carcasses. CFIA officials immediately retained the product for corrective actions. 416.13 and 416.1
- 13/51) Documented corrective actions do not list preventive measures as required by 416.15.
- 15/51) Most CCP's contain multiple critical limits. This does not meet the intent of the regulations 417.1 and 417.2.
- 19/51) There is no validation to document the adequacy of the HACCP plan to control the identified food safety hazards. 417.4
- 20/51) Documented corrective actions do not contain all four components of the regulatory requirements of 417.3.

61. NAME OF AUDITOR

Dexter Reavis

62. AUDITOR SIGNATURE AND DATE

Dexter Reavis July 24-03

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Canafric Incorporated 5341 John Lucas Drive Burlington, Ontario L7L 6A8	2. AUDIT DATE July 02, 2003	3. ESTABLISHMENT NO. 0579	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. Don Carlson		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	0
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	0
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	X
19. Verification and validation of HACCP plan.	X	47. Employee Hygiene	
20. Corrective action written in HACCP plan.	X	48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	X
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights	O	52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

Canada. Est.0579 July 02, 2003.

- 13/51) Preventive measures for pre-operational and operational sanitation were not documented in the daily pre-operational and operational sanitation records.
- 15/51) A. Critical Control Points set in the HACCP Plan do not meet the definition of a CCP.
B. Multiple Critical Limits were set for a single Critical Control Point.
- 19/51) A. Initial validation documentation was missing from the Hazard Analysis used to set Critical Control Points.
B. Validation documentation was missing from the HACCP plan for establishing Critical Limits.
- 20/51) Corrective action as described in 9 CFR Part 417.3 (a) was not written into the HACCP plan (all four parts were omitted).
- 41) Condensation was dripping onto 75% of boxed product stored in the small raw boxed product freezer.
- 46) A. Unidentified black grease particles were scattered on the top of exposed dough trays and plastic milk containers in the raw product non meat cooler.
B. A large amount of identifiable black dirt was on a pallet of protected packaging material in the dry storage room.
- 50/51) Daily inspection coverage for processing activities was not always provided as required by FSIS Import Regulatory Requirements. All processed product produced in this establishment is eligible for export to the United States.
- 51) CFIA performs pre-operational sanitation hands on verification one time per month.

61. NAME OF AUDITOR

Dr. Don Carlson

62. AUDITOR SIGNATURE AND DATE

W - Don Carlson 07/02/03



Canadian Food Inspection Agency Agence canadienne
d'inspection des aliments
159 Cleopatra Drive Tel: (613) 221-7003
Ottawa, Ontario Fax: (613) 228-6636
K1A 0Y9

December 10, 2003

Karen Stuck
Assistant Administrator
Office of International Affairs
Food Safety and Inspection Service
United States Department of Agriculture
Washington, D.C. 20250
United States of America

Dear Ms. Stuck:

Thank you for your letter of September 25th, 2003 and the accompanying copy of the Draft Final Report of an audit carried out in Canada during the period June 17th to July 31st, 2003, and the opportunity to provide comments on the report. Foreign audit reports are generally welcomed as an additional source of information to assess the performance of Canada's meat inspection system and to contribute to our objectives for continuous improvement.

As previously confirmed in letters to your staff, all seven (7) establishments that received a "30-day Notice Of Intent to Delist", as a result of the audit, implemented appropriate corrective measures within the prescribed time frame. These actions have been verified by CFIA inspection staff.

All plant-specific deficiencies that were noted in the inspection reports produced at the end of the site visits have been either corrected immediately or are being corrected through the implementation of action plans, with the exception of those referred to below as differences or items under equivalence discussion. The plant-specific FSIS reports, which were enclosed with the audit reports, have also been forwarded to each establishment for appropriate follow up.

In addition to corrective and preventive measures taken by each individual plant, we have developed a checklist of the deficiencies that were the most frequently observed during the recent and previous audits, so that appropriate corrective and preventive measures will be taken in all federally registered establishments.

General comments:

We would first like to reiterate our objection to certain features of the audit. In particular, we contend that a number of the audit findings included in the draft

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audit report are based on misunderstandings and present a false picture of the performance of our system.

In 1992, after a thorough review by a team of experts from FSIS, the entire Canadian meat inspection system was formally recognized as being equivalent to the U.S. system. At that time, the Canadian meat inspection system already included the less-than-daily inspection presence in stand alone meat processing establishments with a good record of compliance, coupled with the beef High Line Speed Inspection program. In fact, the former had been implemented more than 20 years ago and the latter about 15 years ago, meaning that both were in place at the time of the 1992 equivalence system review. Since then, numerous audits of Canadian establishments have been conducted while these systems were in place. It is troublesome that these differences are now being reported as deficiencies. We request that you reconsider your conclusions in this regard in light of historical information provided and the absence of observed adverse effects.

Since the 1992 conclusion on equivalence, each time significant changes to the U.S. inspection system were introduced by the FSIS and communicated to us, we responded by implementing corresponding changes that were either the same as, or equivalent to, the changes implemented in the U.S. This is exemplified by the way we responded to the introduction of USDA/FSIS's Pathogen Reduction/HACCP Final Rule in 1996. With some modifications to incorporate certain specific features of the Rule, the related provisions of Canada's prerequisite programs were judged by FSIS to be equivalent to the Standard Sanitary Operating Procedures (SSOP) requirements. We implemented the same *E. coli* guidelines and developed an alternative approach for *Salmonella* testing that was recognized by FSIS as equivalent. FSIS also accepted the equivalence of our approach to implementing HACCP under our Food Safety Enhancement Program. More recently, we developed a policy to control *E. coli* O157 H:7 in beef making all efforts to ensure that the Canadian policy is equivalent to the FSIS policy.

In 1998-99, FSIS and CFIA agreed on a mutually acceptable approach for the annual assessment of our respective meat inspection systems, based on the performance of a systems audit in each country to verify on-going maintenance of equivalence. As such, the scope of the audit was to be directed toward assessing compliance with the domestic standards of the exporting country and only considering compliance directly in relation to the requirements of the importing country for measures that had not yet been recognized as equivalent. In contrast, it is apparent that the recent audit was not designed to verify

compliance with Canadian requirements, notwithstanding their equivalence, focusing instead exclusively on compliance with U.S. domestic standards. This led to a relatively large number of differences being incorrectly reported as deficiencies in many establishments rather than as the "differences" they really are. This explains why the tabulation of the number of establishments not meeting or enforcing U.S. requirements appears so high. In addition, rather than being reported in each individual establishments, it would have been more appropriate to identify those differences at the systems level and to assess them accordingly. If there are differences in sanitary measures, they will be identified in each of the various establishments visited. This also brings a severe distortion of the overall audit results as reported in the draft report.

Specific comments:

As far as the draft report content, we would like to offer the following comments:

Section 6.3.1, the first sentence is inaccurate and should read: "The Central Headquarters staff is responsible for maintaining the National Training Program and training modules. Operational Supervisors are responsible to ensure that adequate training has been provided to inspectors before assigning them to a position. Each Area Office..."

Section 11.2 of the Draft Report states that in 19 out of 31 establishments audited, verification and validation documentation was missing. This conclusion was reached by taking into account only the U.S. definition of validation without fully understanding or considering measures in place in Canada. For USDA/FSIS, the term validation is defined in section 417.4 of the CFR:

Sec. 417.4 Validation, Verification, Reassessment.

(a) Every establishment shall validate the HACCP plan's adequacy in controlling the food safety hazards identified during the hazard analysis, and shall verify that the plan is being effectively implemented.

(1) Initial validation. Upon completion of the hazard analysis and development of the HACCP plan, the establishment shall conduct activities designed to determine that the HACCP plan is functioning as intended. During this HACCP plan validation period, the establishment shall repeatedly test the adequacy of the CCP's, critical limits, monitoring and record keeping procedures, and

corrective actions set forth in the HACCP plan. Validation also encompasses reviews of the records themselves, routinely generated by the HACCP system, in the context of other validation activities.

Our Canadian HACCP program is based on *Codex Alimentarius* guidelines. A very detailed and formal recognition process is in place to validate and verify that establishments implement a complete and effective HACCP system. The full documentation package had already been submitted to your staff as indicated previously. You can also access all required information at:
<http://www.inspection.gc.ca/english/fssa/polstrat/haccp/haccpe.shtml>.

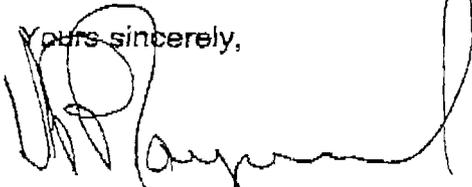
Another "deficiency" appearing in several inspection reports is the fact that more than one critical limit is set for a specific critical control point (CCP). We would submit that this is an arbitrary and unjustified deduction. We would also like to draw your attention to some of the generic models referenced on the FSIS website (<http://haccpalliance.org/alliance/haccpmodels/fullycooked.pdf>) which include multiple critical limits. As well, FSIS's website uses our Canadian Food Safety Enhancement Program manuals and generic models as references.

Similarly, the draft report is again reporting for some establishments that pre-shipment reviews and monthly supervisory reviews were not completed. These subjects are currently under equivalence discussion with your staff. Obviously, to report them again adds another bias to the report.

Regarding specific establishments' reports, we have noted a number of factual inaccuracies. For example, in the case of est. 001, the following deficiency is reported under Item 51: "*CFIA performs pre -operational sanitation monitoring procedure two times per month, but there is no documentation of their activities. CFIA does not perform hands on pre - operational sanitation verification procedures.*" There appears to have been a misunderstanding during the audit. In fact, verifiable "hands on", pre-operational inspections are being done at this establishment by the evening shift inspector prior to operations and the result recorded on the applicable report. Unsatisfactory inspections are recorded /documented appropriately. Satisfactory inspections are also noted. CFIA documentation is present, verifiable and available upon request. Similarly, in the case of establishment 069, item 29 identifies a deficiency in the generic E. coli testing. However, as opposed to what is indicated in the report, our staff confirmed that the generic E. coli testing conducted at that establishment was found satisfactory by the FSIS auditor. We would appreciate if the reports could be amended accordingly.

Notwithstanding the above, we remain fully committed to provide the FSIS with all necessary documentation on the differences identified for information. We also remain committed to maintaining the equivalence status of our meat inspection program and will be contacting the FSIS in separate correspondence to continue ongoing or initiate new equivalence discussions on identified subjects.

Yours sincerely,

A handwritten signature in black ink, appearing to read 'D. Raymond', with a large, sweeping flourish extending to the right.

Donald P. Raymond
A/Director
Food of Animal Origin Division
Canadian Food Inspection Agency