



United States
Department of
Agriculture

Food Safety
and Inspection
Service

Washington, D.C.
20250

JAN 31 2006

Q.F.B. Amada Vélez Méndez
Director General de Inocuidad Agroalimentaria,
Acuícola y Pesquera
Servicio Nacional de Sanidad, Inocuidad y
Calidad Agroalimentaria (SENASICA)
Secretaría de Agricultura, Ganadería, Desarrollo
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Municipio Libre 377
Piso 7 Ala "B"
Santa Cruz Atoyac
México, D.F.
C.P. 03310 México

Dear Ms. Vélez:

The Food Safety and Inspection Service (FSIS) conducted an on-site audit of Mexico's meat and processed poultry inspection system June 28 through July 14, 2005. Enclosed is a copy of the FSIS final audit report. Your comments regarding the information in the FSIS draft final audit report are included as an addendum to the final audit report.

If you have any questions regarding the audit or need additional information, please contact me by telephone at 202-720-3781, by fax at 202-690-4040, or by electronic mail at sally.white@fsis.usda.gov.

Sincerely,

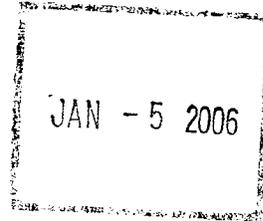
Sally White
Director
International Equivalence Staff
Office of International Affairs

Enclosure

Cc:

Suzanne Heinen, Minister-Counselor, American Embassy, Mexico City
Enrique Lobo, Agricultural Minister, Embassy of Mexico, Washington, DC
Robert Macke, Assistant Deputy Administrator, ITP, FAS
Jeanne Bailey, FAS Area Director
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Barbara McNiff, Director, FSIS CODEX Programs Staff, OIA, FSIS
Country File (Mexico)

FINAL



FINAL REPORT OF AN AUDIT CARRIED OUT IN MEXICO
COVERING MEXICO'S MEAT AND PROCESSED POULTRY
INSPECTION SYSTEM

JUNE 28, 2005 THROUGH JULY 14, 2005

Food Safety and Inspection Service
United States Department of Agriculture

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ABBREVIATIONS AND SPECIAL TERMS USED IN THE REPORT

BSE	Bovine Spongiform Encephalopathy
SENASICA	Central Competent Authority [Servicio Nacional de Sanidad Inocuidad y Calidad Agroalimentaria (SENASICA)]
CFR	U.S. Code of Federal Regulations
CVO	Chief Veterinary Officer
<i>E. coli</i>	<i>Escherichia coli</i>
FSIS	Food Safety and Inspection Service
MVZ	Medical Veterinarian and Animal Protection (Medico Veterinario Zootecnista)
NOID	Notice of Intent to Delist
PR/HACCP	Pathogen Reduction/Hazard Analysis and Critical Control Point System
SAGARPA	Secretary for Agriculture, Livestock, Rural Development, Fisheries and Food (Secretaria de Agricultura, Ganaderia, Desarrollo Rural, Pesca Y Alimentación)
<i>Salmonella</i>	<i>Salmonella</i> species
SENASICA	National Service for Animal Health, Food Safety, and Agricultural and Food Quality Assurance (Servicio Nacional de Sanidad Inocuidad y Calidad Agroalimentaria)
SSOP	Sanitation Standard Operating Procedures
TIF	Federal Inspection Type (Tipo Inspeccion Federal)

1. INTRODUCTION

The audit took place in the Republic of Mexico from June 28 through July 14, 2005.

An opening meeting was held on June 28, 2005 in Mexico City with the Central Competent Authority (CCA). At this meeting, the audit team confirmed the objective and scope of the audit, the auditors' itineraries, and requested additional information needed to complete the audit of Mexico's meat and processed poultry inspection system.

The auditors were accompanied during the entire audit by representatives from the CCA, the Servicio Nacional de Sanidad Inocuidad y Calidad Agroalimentaria (SENASICA) and/or representatives from the state 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 and processing establishments certified by the CCA as eligible to export meat products to the United States.

In pursuit of the objective, the following sites were visited: one SENASICA state office, and fourteen meat and/or processed poultry processing establishments.

Competent Authority Visits			Comments
Competent Authority	Central	1	
	State	1	Nuevo Leon State Office
Laboratories		0	.
Meat Slaughter Establishments		5	Establishments
Meat/Poultry Processing Establishments		9	producing beef, pork and/or poultry products

3. PROTOCOL

This on-site audit was conducted in three parts. One part involved visits with the CCA 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 or regional offices. The third part involved on-site visits to five slaughter/processing and nine processing establishments.

Program effectiveness determinations of Mexico'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 testing programs for *Salmonella* and *Listeria monocytogenes*.

During all on-site establishment visits, the auditors 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 Mexico and determined if establishment and inspection system controls were in place to ensure the production of meat products that are safe, unadulterated and properly labeled.

At the opening meeting, the auditors explained that Mexico's meat inspection system would be audited against two standards: (1) FSIS regulatory requirements and (2) any equivalence determinations made for Mexico. 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, testing for generic *E. coli* and *Salmonella* in raw products, and testing for *Listeria monocytogenes* and *Salmonella* in ready-to-eat products.

Equivalence determinations are those that have been made by FSIS for Mexico under provisions of the Sanitary/Phytosanitary Agreement. Currently, Mexico has an equivalence determination regarding an exemption from performing species verification testing.

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.

5. SUMMARY OF PREVIOUS AUDITS

Final audit reports are available on FSIS' website at the following address:
http://www.fsis.usda.gov/Regulations_&_Policies/Foreign_Audit_Reports/index.asp

During the FSIS audit of Mexico's inspection system conducted in November 2004, the following deficiencies were noted:

- Two establishments were cited for inadequate implementation of SSOP requirements.
- One establishment was cited for inadequate sanitation.
- One establishment received a Notice of Intent to Delist (NOID).
- One establishment was cited for animal disease control.
- One establishment was cited for inadequate humane slaughter.

- Nine establishments were cited for inadequate implementation of HACCP requirements.
- Nine establishments were cited for inadequate government enforcement.

During the FSIS audit of Mexico's inspection system conducted in March 2005, the following deficiencies were noted:

- Two establishments received a Notice of Intent to Delist (NOID).
- Six establishments were cited for inadequate government enforcement of inspection requirements.
- One establishment was cited for inadequate sanitation performance standards (SPS).
- Two establishments were cited for not documenting all four parts of corrective actions (especially to prevent recurrence) for SSOP deviations.
- Five establishments were cited for inadequate implementation of HACCP requirements.
- One establishment was cited for not using a government certified laboratory for its *Listeria monocytogenes* and *Salmonella* testing.
- One establishment was cited for not conducting Salmonella testing of its RTE product.
- One establishment was cited for not including sanitation measures as required by establishments adopting Alternative 3 to address *Listeria monocytogenes*.

6. MAIN FINDINGS

6.1 Government Oversight

SENASICA is responsible for regulating Mexico's meat and processed poultry inspection system and live animal health requirements. This responsibility includes certifying and regulating TIF establishments for the exportation of meat or processed poultry products to the United States.

The production of meat and poultry products in Mexico is either conducted in TIF establishments or municipal establishments. SENASICA has authority only over TIF establishments whereas Mexico's Department of Health has authority over municipal establishments. The majority of the meat and poultry production in Mexico is conducted in TIF establishments. Only TIF establishments have the authority to produce product for export to other countries.

6.1.1 CCA Control Systems

The audit of the CCA control systems included the following documents reviews during on-site visits to SENISICA office:

- Supervisory visits to establishments that were certified to export to the United States.
- New laws and implementation documents such as regulations, notices, directives and guidelines.
- Sampling and analyses for residues and water supply.

- Pathogen reduction and other food safety initiatives such as SSOP and HACCP programs, generic *E. coli*, *Salmonella* species, and *Listeria monocytogenes* testing.
- Sanitation, slaughter and processing inspection procedures and standards.
- Control of products from livestock with conditions such as tuberculosis, cysticercosis, etc., and inedible and condemned materials.
- Export product inspection and control including export certificates.
- National residue control program and monitoring results.
- Enforcement records including examples of criminal prosecutions, consumer complaints, recalls, seizures 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.

6.1.2 Ultimate Control and Supervision

Each TIF establishment is under the direct authority of a SAGARPA state office. Each state office has at least one SENASICA state supervisor who is assigned to provide government oversight of all TIF establishments within the state and to assure that inspection requirements are being enforced at the TIF establishments. Based on the size of the state and/or the number of TIF establishments, SENASICA may assign two or more state supervisors. In addition, SENASICA has assigned an MVZ supervisor to each TIF establishment certified to export meat or processed poultry to the United States. Additional MVZ inspection officials are assigned to certified establishments to carry out government inspection responsibilities. Daily inspection by inspection officials is being carried out in all TIF establishments certified to export to the United States.

SENASICA has adequate levels of authority (headquarters, state offices, and certified establishments) to ensure effective oversight of all U.S. import inspection requirements.

6.1.3 Assignment of Competent, Qualified Inspectors

Upon entering government employment as an official inspector, new employees undergo induction training as well as participate in on-the-job practical training under the supervision of experienced veterinarians. Training is supplemented by refresher courses on inspection requirements and participation in U.S. government technical assistance programs. Limited resources have restricted SENASICA's ability to conduct sufficient training for its inspection personnel. However, since the April-May 2004 FSIS audit, Mexico has provided three training courses for its inspection personnel regarding implementation and oversight of the U.S. import inspection requirements. Additional training regarding HACCP requirements is scheduled for its inspection personnel.

6.1.4 Authority and Responsibility to Enforce the Laws

SENASICA has the authority and responsibility to enforce the applicable laws relevant to establishments producing product for export to the United States. However, additional personnel at SENASICA headquarters' office would enhance Mexico's ability to ensure continued compliance of the U.S. inspection requirements.

6.1.5 Adequate Administrative and Technical Support

During the audit, the audit team found that SENASICA has administrative and technical support to operate Mexico's inspection system and has the ability to support a third-party audit.

6.2 Headquarters Audit

The auditors conducted a review of inspection system documents that 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.
- 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.
- 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.

7. ESTABLISHMENT AUDITS

The FSIS auditors visited a total of 14 slaughter/processing and processing establishments. None of the establishments audited were de-listed by Mexico. One establishment received a Notice of Intent to Delist (NOID) from Mexico's inspection officials due to inadequate implementation of HACCP and SSOP requirements.

This establishment may retain its certification for export to the United States provided that they correct all deficiencies noted during the audit within 30 days of the date the establishment was reviewed.

Specific deficiencies are noted on the attached foreign establishment audit checklists.

8. RESIDUE AND MICROBIOLOGY LABORATORY AUDITS

No laboratories conducting residue and microbiological testing were audited during this audit.

9. SANITATION CONTROLS

As stated earlier, the FSIS auditors focus on five areas of risk to assess Mexico's meat inspection system. The first of these risk areas that the FSIS auditors reviewed was Sanitation Controls.

Based on the on-site audits of establishments, and except as noted below, Mexico'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, Mexico's inspection system had controls in place for water potability records, chlorination procedures, back-siphonage prevention, separation of operations, temperature control, work space, ventilation, ante-mortem facilities, welfare facilities, and outside premises.

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. Of the 14 establishments audited, there was inadequate implementation of SSOP requirements in six establishments.

SSOP implementation deficiencies are noted on the attached foreign establishment audit checklists.

9.2 Sanitation

The following deficiencies were noted:

- Rust and/or beaded condensation was observed on the entire drive chain of the slaughter line and in carcass coolers in one establishment.
- Boxes containing packaging material were observed being stored on the floor in one establishment.
- Overhead structures above exposed product/equipment (mixer, stuffer, etc.) in several production areas had been neglected to varying degrees in two establishments, with rust, loose and flaking paint/sealer materials, dripping condensation, and holes in walls/ceilings in evidence.
- The documentation of corrective actions for SSOP deficiencies was incomplete in five establishments.
- Water from an overhead pipe was leaking onto carcasses in one establishment.

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 Mexico's inspection system had adequate controls in place. No deficiencies were noted.

There had been no outbreaks of animal diseases with public health significance since the last FSIS audit.

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 establishments, implementation of a testing program for generic *E. coli* and *E. coli* O157:H7 in slaughter establishments, *Listeria monocytogenes* in processing establishments, and the implementation of the BSE control measures.

11.1 Humane Handling and Slaughter

No deficiencies were identified.

11.2 HACCP Implementation.

All establishments approved to export meat 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.

The HACCP programs were reviewed during the on-site audits of the fourteen establishments. Of these establishments, there was inadequate implementation of HACCP requirements in twelve establishments.

HACCP implementation deficiencies are noted on the attached foreign establishment audit checklists.

11.3 Testing for Generic *E. coli*

- One establishment had not developed a Statistical Process Control chart.

11.4 Testing for *Listeria monocytogenes*

Two of the establishments audited were producing ready-to-eat products for export to the United States. In accordance with United States requirements, the HACCP plans in these

establishments had been reassessed to include *Listeria monocytogenes* as a hazard reasonably likely to occur.

Deficiencies identified by the FSIS auditors are noted on the attached foreign establishment audit checklists.

- One establishment had not validated the frequency of *Listeria monocytogenes* testing.

12. RESIDUE CONTROLS

No residue laboratory was reviewed.

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*.

Specific deficiencies identified by FSIS auditors are noted on the attached foreign establishment audit checklists.

13.1 Daily Inspection in Establishments

Inspection was being conducted daily in all slaughter/processing and processing establishments audited.

13.2 Testing for *Salmonella*

No deficiencies were identified.

13.3 Species Verification

FSIS had previously granted Mexico an exemption from conducting species verification. The FSIS auditors verified that adequate controls were in place to assure clear separation of meat products of different species.

13.4 Monthly Reviews

During this audit it was found that in all establishments visited, monthly supervisory reviews of certified establishments were being performed and documented as required.

13.5 Inspection System Controls

The SENASICA had controls in place for restricted product, inspection samples, and prevention of commingling of product intended for export to the United States with product intended for the domestic market.

In addition, 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, products entering the establishments from outside sources, and shipment security with the exception of the following:

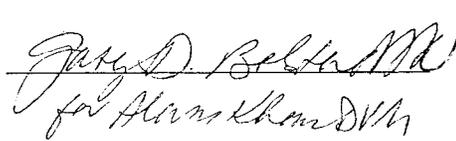
Government officials did not provide a uniform method for sample oversight, integrity, and security when shipping samples to the laboratory.

14. CLOSING MEETING

A closing meeting was held on July 14, 2005 in Mexico City with the SENASICA. At this meeting, the primary findings and conclusions from the audit were presented by the auditor.

The SENASICA understood and accepted the findings.

Dr. Alam Khan
Program Auditor



José D. Beltrán
for Alam Khan DVM

15. ATTACHMENTS

Individual Foreign Establishment Audit Forms
Foreign Country Response to Draft Final Audit Report

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Grupo Kowi KM 1788 Carretera Inter, Mexico-Nogales C.P. 85800 Navojoa, Sonora, Mexico	2. AUDIT DATE 07/06/05	3. ESTABLISHMENT NO. TIF 74	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Jonathan B. Coleman DVM		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 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	
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.		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/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

July 6, 2005: Establishment TIF 74 - Grupo Kowi, KM 1788 Carretera Inter, Mexico-Nogales, C.P. 85800 Navojoa, Sonora, Mexico

Type of Operation: Pork Slaughter and Simple Processing Facility

20/51 Corrective measures taken for deviations from the critical limit of CCP 1 of the establishment's HACCP plan for Slaughter did not meet all of the regulatory requirements. [9 CFR 417.3a]

22/51 The following HACCP recordkeeping non-compliances were observed.

- The HACCP records associated with the establishment's HACCP plans for Slaughter and Raw – not ground did not record the actual times, temperatures or other quantifiable values of the results of the establishment's monitoring activities. Each entry made on these records did not include the signature or initials of the establishment employee who made them. [9 CFR 417.5]
- The HACCP records associated with the establishment's HACCP plans for Slaughter and Raw – not ground did not contain the results of the verification activities performed. [9 CFR 417.5a3]

SAGARPA officials initiated control actions for all HACCP non-compliances identified on the day of the audit and proposed a plan of actions to ensure that the establishment complies with all appropriate FSIS regulations.

61. NAME OF AUDITOR

Jonathan B. Coleman, DVM

62. AUDITOR SIGNATURE AND DATE

 JBC DVM 07/06/05

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Productos Chata, S.A. DE C.V. TIF N. 89 y TIF N. 169 Camino Real No.5 Col. Bachigualato C.P. 80140 Cuitacan, Sin. Mexico	2. AUDIT DATE 07/08/05	3. ESTABLISHMENT NO. TIF 89	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Jonathan B. Coleman DVM		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.	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	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Park 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

July 8, 2005: Establishment TIF N. 89 and TIF N. 169 - Productos Chata, S.A. de C.V., Camino Real No.5 Col. Bachigualato, C.P. 80140 Culiacan, Sin. Mexico
Type of Operation: Thermal Processing (Canning) Facility

22/51 The HACCP records associated with the establishment's HACCP plans for Thermally processed-commercially sterile products did not contain the results of the verification activities performed. [9 CFR 417.5a3]

The SAGARPA officials initiated control actions and proposed a plan of action to ensure that the establishment complies with all appropriate FSIS regulations.

61. NAME OF AUD Jonathan B. Coleman, DVM

62. AUDITOR SIGNATURE AND DATE

 DVM 07/08/05

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Grupo Bafar Km. 7.5 Carr. A Cuauhtemoc Col. Las Animas C. P. 31450 Chihuahua, CHIH. Mexico	2. AUDIT DATE 07/02/05	3. ESTABLISHMENT NO. TIF 90	4. NAME OF COUNTRY Mexico
	5. NAME OF AUDITOR(S) Jonathan B. Coleman DVM		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.	X	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.		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	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

July 2, 2005: Establishment TIF 90 - Grupo Bafar, Km. 7.5 Carr. A Cuauhtemoc Col. Las Animas C. P.
31450, Chihuahua, CHIH. Mexico
Type of Operation: Complex Processing

10 In the hot dog peeling area, a plant employee was observed manually removing a string of cooked hot dogs that were on the floor, disposing of them then returning to handle product on contact surfaces without restoring sanitation to his gloved hands. [9 CFR 416.13]

12/51 Corrective measures taken because of incidences of direct product contamination or adulteration of product did not include preventative measures. [9 CFR 416.15]

22/51 The HACCP records associated with the establishment's HACCP plans for Fully cooked product – not shelf stable and Heat treated but not fully cooked – not shelf stable did not contain the results of the verification activities performed. [9 CFR 417.5a3]

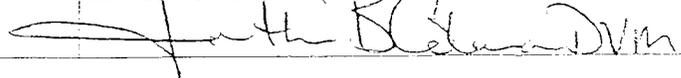
39 There was an accumulation of flaking rust on an air vent above the sausage and ham cooking vats in the product cooking room. [9 CFR 416.4]

SAGARPA officials initiated control actions for all SSOP and HACCP noncompliances identified on the day of the audit and proposed a plan of actions to ensure that the establishment complies with all appropriate FSIS regulations.

61. NAME OF AUDITOR

DR. JONATHAN B COLGHAN

62. AUDITOR SIGNATURE AND DATE

 07/02/05

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Union Sanitaria de Productos Alimenticios, S.A. de C.V. Calle J.M. Salvatierra y A. Humbolt No. 17538 Fracc. Garita de Otay Tijuana, Baja California, Mexico C.P. 22500	2. AUDIT DATE 06/29/05	3. ESTABLISHMENT NO. TIF 95	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Jonathan B. Coleman DVM		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.	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	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		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.	
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

June 29, 2005: Establishment TIF 95 - Union Sanitaria de Productos Alimenticios, S.A. de C.V.
Calle J.M. Salvatierra y A. Humbolt No. 17538 Fracc. Garita de Otay, Tijuana, Baja California, Mexico
C.P. 22500
Type of Operation: Simple Processing

22/51 The following HACCP recordkeeping noncompliances were observed:

- The establishment could not produce decision-making documents to support the selection and development of CCP2 and CCP3 in the establishment's HACCP plan for raw product – not ground. The establishment has elected to set critical limits for the temperature of ambient air in the cold storage rooms at two different steps (CCP2 and CCP3) in the production process as their standards for determining product safety and demonstrating control of products produced under this HACCP plan; however there were no documents available to support this decision. [9 CFR 417.5a2]
- The HACCP records did not document the results of all verification activities performed. [9 CFR 417.5a3]

SAGARPA officials documented the noncompliances on the day of the audit and proposed a plan of actions to ensure that the establishment complies with all appropriate FSIS regulations.

61. NAME OF AUDITOR

Jonathan B. Coleman, DVM

62. AUDITOR SIGNATURE AND DATE



06/29/05

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Ganaderia Integral S.K. S.A. de C.V. Libramiento Noreste Km. 25, s/n Carretera Laredo Saltillo, Escobedo Nuevo Leon, Mexico	2. AUDIT DATE 07/08/2005	3. ESTABLISHMENT NO. TIF 105	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Dr. Alam Khan		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	
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	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

2

60. Observation of the Establishment

Est.#: TIF 105 Slaughter/ Processing (Raw Not Ground)
City and Country: Escobedo, NL, Mexico
Date: 07/08/2005

- 10/51 Water was observed dripping from an overhead leaking pipe at the zero-tolerance check station onto the passing beef carcasses. The SAGARPA official leading the audit retained the carcasses on the rail and also those from the entire production shift in the cooler, and ordered an immediate corrective action from the management, {9CFR part 416.13}.
- 13/51 Some of the SSOP records did include preventive measures. The SAGARPA officials assured the auditors of prompt compliance by the management. [9CFR 416.15(b)(3)]

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE

for ALAM KHAN

07/08/05

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION SuKarne 13.5 Carreterra a Tijuana Pobladao La Rosita Mexicali, Baja California	2. AUDIT DATE 06/30/05	3. ESTABLISHMENT NO. TIF 120	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Jonathan B. Coleman DVM			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.	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		57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

60. Observation of the Establishment

June 30, 2005: Establishment TIF 120 – SuKarne, 13.5 Carreterra a Tijuana Pobladao La Rosita, Mexicali, Baja California, Mexico
Type of operation: Beef Slaughter and Simple Processing

20/51 Corrective actions taken in response to deviation from the critical limit for CCP 3b, which occurred on June 28, 2005, were not recorded in the establishment's HACCP records for their HACCP plan for Slaughter. [9CFR 417.3(a)]

SAGARPA officials documented the noncompliances on the day of the audit and proposed a plan of actions to ensure that the establishment complies with all appropriate FSIS regulations.

61. NAME OF AUDITOR

Jonathan B. Coleman. DVM

62. AUDITOR SIGNATURE AND DATE



United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Keken Comercializadora Porcicola Mexicana Km. 3.5 Carret. Uman – Poxila Uman Yucatan, Mexico	2. AUDIT DATE 07/04/05	3. ESTABLISHMENT NO. TF 152	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Jonathan B. Coleman DVM		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.		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.	X	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.		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/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. NOID	X
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

3

60. Observation of the Establishment

July 4, 2005: Establishment TIF 152 – Keken, Comercializadora Porcicola Mexicana
Km. 3.5 Carret. Uman – Poxila Uman, Yucatan, Mexico
Type of operation: Pork slaughter and simple processing

12/51 The corrective actions in the establishment's SSOP records in response to noncompliances identified by the establishment did not include preventive measures. [9 CFR 416.15]

18/51 The monitor for the establishment's CCP 1 (Food Safety Standard – 'Zero tolerance') was not performing monitoring procedures for this CCP as described in the HACCP plan for Slaughter. [9 CFR 417.2]

20/51 Corrective actions documented in the records associated with the establishment's HACCP plans for Slaughter and raw-not-ground products did not meet the requirements. [9 CFR 417.3a]

22/51 The following findings did not meet the requirements of 9 CFR 417.5:

- The establishment could not provide documents to support their decision to establish the critical limits for the CCPs of their HACCP plan for raw-not-ground products.
- The monitoring records for the establishment's slaughter HACCP plan did not include the actual times when the monitor performed the monitoring activities or the results from the monitoring activities.
- The HACCP records associated with the establishment's HACCP plans for Slaughter and raw-not-ground products did not include the results of verification activities that were performed, the actual times that these specific events occurred, or the initials of the individual responsible for performing these verification activities.
- The pre-shipment records did not include documentation that demonstrates the completeness of measures taken by establishment to ensure that all critical limits were met and that corrective actions taken for deviations were appropriate.

39/51 Rust was observed throughout the entire length of the overhead drive chains for the slaughter line, and in three carcass chilling coolers. [9 CFR 416.2]

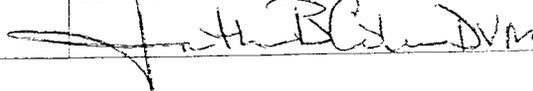
41/51 Beaded and dripping condensation was observed on the ceilings of three carcass coolers and on the ceiling, overhead pipes, two turn wheels for the drive chain, and other overhead structures that were in an adjacent hallway and in close proximity to the entrances of these coolers. [9 CFR 416.2]

The SAGARPA officials took immediate action on the finding listed under number 41. The SAGARPA officials plan to issue a NOID to this establishment in response to the Sanitation, SSOP and HACCP noncompliances identified on the day of the audit.

61. NAME OF AUDITOR

Jonathan B. Coleman, DVM

62. AUDITOR SIGNATURE AND DATE

 07/04/05

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Sigma Alimentos Centro S.A. de C.V. Planta Atitalaquia Atitalaquia, Hidalgo	2. AUDIT DATE 06/29/2005	3. ESTABLISHMENT NO. TIF-158	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Dr. Alam Khan		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.		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.	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/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		

4

60. Observation of the Establishment

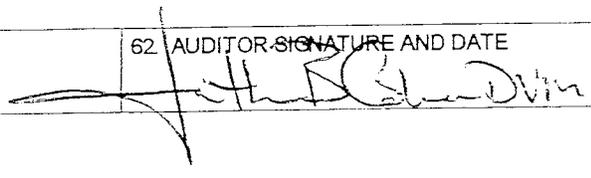
Est.#: TIF 158 Sigma Alimentos Centro Processing (Raw Not Ground)
City and Country: Atitalaquia, Hidalgo, Mexico
Date: 06/29/2005

- 13/51. The SSOP corrective action records did not include preventive measures. [9CFR part 416.15]
- 22/51 The calibration records did not include the times of the events and some entries were not initialed. [9CFR part 417.5(b)]
- 46 Several boxes of packaging material were stored on the floor in the cooler room. The Mexican Inspection officials rejected the boxes and requested immediate action by the plant management. [9CFR part 416.4]
- 46/51 Condensate was dripping from a short black rubber hose into a container with approximately 10 -15 packages of hot dogs for rework. No product was exposed to the condensation. A PVC pipe running over the same area was covered with a layer of dust approximately ¼ inch thick. The SAGARPA officials requested the plant to condemn the product and the plant complied. [9CFR part 416.4 and 416.13(c)]

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE

 For DR. KHAN
06/29/05

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Sigma Alimentos Congelados S.A. de C.V. Industria Alimenticia No. 760, Parque Industrial, 67735 Linares Nuevo Leon, Mexico	2. AUDIT DATE 07/07/2005	3. ESTABLISHMENT NO. TIF 209	4. NAME OF COUNTRY MEXICO
	5. NAME OF AUDITOR(S) Dr. Alam Khan		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	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.	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	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

Est. #: TIF 209

Operation: Fully cooked not shelf stable (RTE)

City and Country: Linares, NL, Mexico

Date: 07/07/2005

- 46/51 1) The equipment washroom did not have a distinct separation between clean and unclean pieces of equipment.
- 2) Two of the hand-wash stations had neither hand towels nor trash receptacles. The management corrected the deficiency immediately [9CFR 416.4(d)].
- 19/51 1) The sampling methodology identified in the documentation did not support the sampling methodology being used in the analysis for *Salmonella* in RTE products as part of their on-going verification procedures.
- 2) The establishment had chosen Alternative 3 to control *Listeria monocytogenes* through its sanitation program and testing of food contact surface, however the program did not explain why test frequency is sufficient, although they are sampling daily according to records.
- 22/51 Some HACCP verification records had missing entries [9CFR 417.5(b)].

Either all findings were corrected on the day of the audit or SENASICA officials indicated they would initiate a plan of actions to ensure that the establishment complies with all appropriate USDA FSIS regulations.

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE

Handwritten signature of Dr. Alam Khan in black ink, appearing as a stylized cursive script.DVM For. DR. KHAN
07/07/05

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Especialidades Tipicas Mexicanas S.A. de C.V. Camino a Rancho Blanco, KM 2 Para je Las Verduras Espriritu Santo Jilitzingo Edo De Mexico	2. AUDIT DATE 06/30/2005	3. ESTABLISHMENT NO. TIF 281	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Dr. Alam Khan		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	
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	X
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.	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/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

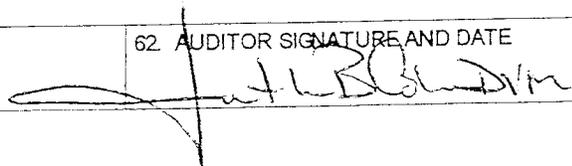
Est.#: TIF 281 Especialidades Tipicas Mexicanas - Thermally Processed, Commercially Sterile (Canned Product)
City and Country: Las Verduras Esprititu Santo Jilitzingo Edo De Mexico
Date: 06/30/2005

The establishment was currently not producing any product for export to the US.

- 22/51 Corrective actions associated with CCP for can specifications as stated in HACCP plan did not address all four parts of 9 CFR 417.3(a).
- 11/51 Ball valves at the bottom of the cooking and receiving vessels, which also connected the containers via rubber hose, were cleaned utilizing a clean-in-place (CIP) cleaning procedure. The establishment management stated that they disassemble the pipes every 6 months for visual examination. Neither the CIP procedure nor the visual inspection were included in the written SSOP program {9CFR 416.14 and 416.4(a)}.
- 44 The lavatories for employees were not provided with toilet paper rolls {9CFR 416.2(h)}.

61. NAME OF AUDITOR
Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE

 FOR DR. ALAM KHAN
06/30/05

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Master Meat, S.A. de C.V. Ignacio Zaragoza No. 525 Col. Centro, C.P. 67100 Guadalupe, N.L. Mexico	2. AUDIT DATE 07/04/2005	3. ESTABLISHMENT NO. TIF 300	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Dr. Alam Khan		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.	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/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		

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Elaboradora La Esperanza, S.A. de C.V. Eulogio Reyes No. 435 Bellavista, C.P. 65270 Sabinas Hilalgo Nuevo Leon, Mexico	2. AUDIT DATE 07/05/2005	3. ESTABLISHMENT NO. TIF 304	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Dr. Alam Khan		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)	Audit Results	Part D - Continued Economic Sampling	Audit Results
Basic Requirements			
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)		Part E - Other Requirements	
Ongoing 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	
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.#: TIF 300 Master Meat, Processing (Raw Not Ground)
City and Country: Guadalupe, Mexico
Date: 07/04/2005

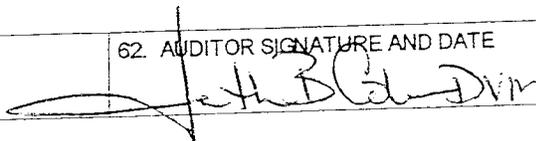
22/51 The calibration records were missing several verification entries; the establishment attributed the finding to an unfilled position at the plant, {9CFR 417.4(a) (3)}.

Either all findings were corrected on the day of audit or SENASICA officials indicated they would initiate a plan of actions to ensure that the establishment complies with all appropriate USDA, FSIS regulations.

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE

 DVM FOR DR. KHAN

08/03/05

60. Observation of the Establishment

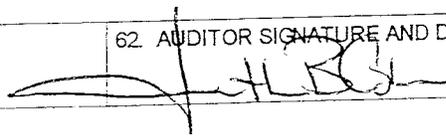
Est. TIF-304 - Processing Establishment
City and Country: Sabinas Hilalgo Nuevo Leon, Mexico
Date : 07/05/2005

There were no significant findings to report after consideration of the nature, degree and extent of all observations.

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE

 DVM for Dr. ALAM KHAN

07/07/05

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Mantiquera San Jose S.A. de C.V. Presa Lazaro Cardenes No. 5014 Col. Scop, C.P. 67190 Cd. Guadalupe, N.L. Mexico	2. AUDIT DATE 07/06/2005	3. ESTABLISHMENT NO. TIF 316	4. NAME OF COUNTRY Mexico
		5. NAME OF AUDITOR(S) Dr. Alam Khan	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		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	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

Est. TIF-316 - Mantequera San Jose, Processing Establishment
City and Country : Guadalupe, N.L. Mexico
Date : 07/05/2005

- 15/51 1. Returned product was not included in the flow chart or considered in the hazard analysis, {9CFR 417.2 and 417.8}.
2. The critical limit at CCP 1 for receiving raw meat products had been set for 4°C, however per HACCP plan, in case of deviation the affected product could reach a temperature as high as 7C°, before a corrective action would be employed to bring the CCP under compliance, {9CFR 417.3} .

SAGARPA officials leading the audit fully concurred with the findings and assured the auditor that the establishment complies with all appropriate regulations FSIS regulations.

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE

 for Dr ALAM KHAN

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Master Meat, S.A. de C.V. Rastro CADEREYTA, JIMNEZ N.L. MEXICO CP 67450	2. AUDIT DATE 07/01/2005	3. ESTABLISHMENT NO. TIF 367	4. NAME OF COUNTRY Mexico
		5. NAME OF AUDITOR(S) Dr. Alam Khan	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 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	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		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	X	56. European Community Directives	O
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

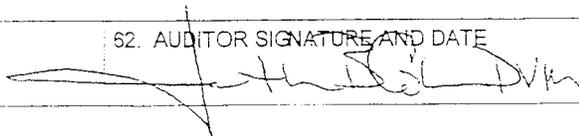
Est.#: TIF 367 Master Meat
Operation: Slaughter Caprine/Ovine
City and Country: Cadereyta Jimenez, NL Mexico
Date: 07/01/2005

- 15/51 1) The establishment is using an FDA approved anti-microbial intervention step prior to the carcasses being placed in the cooler. This step was not included in the flow chart or hazard analysis. {9CFR 417.2(a) (1) & (2)}.
- 2) Returned product was not included in the flow chart or considered in the hazard analysis, {9CFR 417.2(a)(1)&(2)}. The establishment will reassess the HACCP plan to correct the noncompliance.
- 28/51 The establishment is conducting generic *E. coli* testing as outlined in CFR 310.25, except for developing a statistical process control (SPC), although the plant did have all test results that had been conducted for the last several months. 9 CFR 310.25 (a)(2)(ii). The establishment management assured the SAGARPA official that they develop the SPC immediately.
- 46 Non-dripping beaded condensate was observed in the cooler over the caprine carcasses. The SAGARPA officials leading the audit retained all products and rejected the cooler. The management corrected the noncompliance while the audit was still in progress. No product was affected {9 CFR 416.4(d) and 416.14}.
- 13/51 Corrective action records did not included all three parts of corrective action for some deficiencies documented in the records. 9CFR. 416.15(b). The establishment assured compliance to SAGARPA officials.

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE



for Dr. ALAM
KHAN
07/01/05

[SEAL]

United States of Mexico
Ministry of Agriculture, Livestock, Fish, and Food Products

National Agri-Food Health and Quality Service
General Safety Office for of Agriculture and Food Production, Aquaculture, and
Fisheries

Memorandum BOO.04.00.01.01 6024

Mexico City, November 30 of 2005

Ms. Sally White,
Director
International Equivalence Staff
Office of International Affairs
1400 Independence Avenue, SW
20250 Washington, D.C.

I am writing in reference to the final audit report for the System Type Federal Inspection (TIF), which was carried out, from June 28 to July 14, 2005 by the Food Safety and Inspection Service (FSIS) of the United States Department of Agriculture (USDA).

In that regard, I would like to inform you of the measures taken in response to the comments described in the "Draft Final Audit Report" applied to each one of the audited establishments:

TIF Establishment No. 74 "Frigorifico Kowl, S.A. de C.V."

Comment

20/51 The corrective measures taken after the deviation in a PCC of the HACCP slaughtering plan for the establishment do not comply with all the requirements of 9 CFR 417.3a.

Response

Upon receiving this comment, the changes to the matrix were made, incorporating the four actions mentioned in 9 CFR 417.3, and the staff were trained.

Comment

22/51 The following violations were found in the HACCP logs:

-Real times, temperatures, or other quantifiable variables for results of monitoring activities are not recorded. None of the entries for these logs includes the signature or initials of the establishment employee that made it. (9 CFR 417.5)

Response

Upon receiving this comment, the changes were made to the logs, incorporating the actions mentioned in 9 CFR 417.5, (a) 3, and the staff was trained.

[SEAL]

United States of Mexico

Ministry of Agriculture, Livestock, Fish, and Food Products

National Agri-Food Health and Quality Service

General Safety Office for of Agriculture and Food Production, Aquaculture, and Fisheries

Memorandum BOO.04.00.01.01

6024

-2-

TIF Establishment No. 89 "Productos Chata, S.A. de C.V."

Comment

22/51 The logs do not contain the results for the completed activities described in 9 CFR 417.5 a 3

Response

The logs for product sterilization were modified to reinforce monitoring of critical control points, information, and times at when specific events occurred.

TIF Establishment No. 90 "Intercarnes, S.A. de C.V."

Comment

10 In the sausage packing area, a cleaning employee was discovered who had been picking up the casing in which the sausage had been cooked from the floor, and then touching contact surfaces (bag in which reprocessed material is disposed of) 9 CFR 416.13

Response

Feedback was given to staff on Manufacturing Best Practices for their particular areas of work.

Comment

12/51 Corrective measures focused on the handling of products contaminated by cleaning to prevent product contamination and adulteration.

Response

Preventive measures are included in the follow-up and implementation logs for the Standard Sanitization Operations Program (POES).

Comment

22/51 A request was made to establish a method for recording dates and times related to the verification activities regarding the revision of monitoring logs 9 CFR 417.5 a.

Response

The time of revision was attached to the monitoring format by the verifying party, and the verification format includes comments or observations arising from the verification.

Comment

39 Deteriorated steam extraction ducts for the ham and sausage cooking pans

Response

They were cleaned and the establishment will avoid the accumulation of detritus.

[SEAL]

United States of Mexico

Ministry of Agriculture, Livestock, Fish, and Food Products

National Agri-Food Health and Quality Service

General Safety Office for of Agriculture and Food Production, Aquaculture, and Fisheries

Memorandum BOO.04.00.01.01

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TIF Establishment No. 95 “Unión Sanitaria de Productos Alimenticios, S.A. de C.V.”

Comment

22/51 The establishment could not make the decision or document the selection of the PCC for raw non-ground product. The establishment selected the critical limit for the ambient temperature for the warehouse room in two different steps (PCC2 and PCC3). Therefore, there was no documentation to support this decision.

-The HACCP logs do not document the results for all the 9 CFR 417.5 a 3 activities carried out.

Response

The company’s HACCP plan was modified in the following manner: Flowchart, Master sheet, risk analysis and PCC monitoring formats taking into account the 9 CFR 417.5 a 3.

TIF Establishment No. 105 “Ganaderia Integral SK, S.A. de C.V.”

Comment

10/51 Water was observed leaking from a pipe in the roof above the inspection area and the zero tolerance station over a carcass that was passing through this area. The SAGARPA official carrying out the audit stopped the carcass on the rail and also the carcasses for the whole shift that were in the cooling chamber, and gave instructions for the company to take immediate corrective measures.

Response

The water leak was repaired the same day, and all the carcasses of that shift up until the time of the deviation were inspected properly and sanitized completely and were then released by official SAGARPA personnel. A program of inspection and replacement of all the pipes in the processing area was carried out as well.

Comment

13/51 Some POES logs do not include preventive measures. The SAGARPA officials ensured the auditors that the company would shortly be in compliance.

Response

The immediate corrective action taken was the description of the preventive measures in the logs and training of staff regarding the importance of these measures.

[SEAL]
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TIF Establishment No. 120 "Sukarno Producción, S.A. de C.V."

Comment

20/51 The corrective measures taken at the deviation from the PCC3 b critical limit, which occurred on June 28 2005, were not written down in the HACCP logs of the establishment's HACCP slaughter plan.

Response

As a preventive measure, the following phrase appears in the PCC3 b monitoring log: "When a temperature in excess of 39.2 F is recorded within a period of less than one hour, describe the cause in the log's comment section; in the event that this temperature does not decrease, implement the corresponding corrective measure and attach to this log the report for the corrective measure, and staff were trained.

TIF Establishment No. 152 "Grupo Porcicola Mexicano, S.A. de C.V."

Comment

12/51 The corrective measures in the establishment's POES logs in response to violations identified do not include preventive measures. 9 CFR 416.15

Response

The format was modified to comply with the requirements 9 CFR 416.15

Comment

18/51 The PCC 1 monitoring (0 tolerance) was not carrying out the monitoring procedure for this PCC in the manner described in the HACCP slaughter plan 9 CFR 417.2

Response

The person responsible for monitoring was trained in carcass inspection techniques, and the platform utilized to inspect carcasses was modified to facilitate inspection of the complete carcass.

Comment

20/51 The corrective measures documented in the logs associated with the establishment's HACCP slaughter and non-ground raw product plan did not comply with the requirements. 9 CFR 417.3

Response

The format was modified to comply with the requirements 9 CFR 417.3

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Comment

22/51 The following findings did not comply with the 9 CFR 417.5 requirements:

- The establishment was not able to provide documents to support its decision to establish critical limits for the PCC of its HACCP plan for non-ground raw products.
- The establishment's monitoring logs for the HACCP slaughter plan do not include the real time when the monitor or the result of the monitoring activity.
- The logs associated with the establishment's HACCP plan for non-ground raw products did not include the results for verification activities carried out, the real times at which these specific events occurred, or the initials of the persons responsible for carrying out such verification activities.
- The pre-shipping logs did not include documentation that showed the conclusion of the measures taken at the establishment to ensure that all critical limits were met and that all corrective measures taken were adequate.

Response

- The PCC were redefined according to 9 CFR 417.5 and the critical limits were supported with the corresponding scientific literature available.
- Staff was trained to record the real time of the monitoring activity.
- The formats were modified to include the results of verification activities, real times, and initials of the responsible parties.
- The format was modified to include the documentation that shows the conclusion of the measures taken to ensure that critical limits are met, and that the corrective measures taken are adequate.

Comment

39/51 Rust was noted along the upper chain of the slaughter line and in the three carcass chambers. 9 CFR 416.2

Response

The chamber and carcass chain was cleaned and rustproofed, and on the slaughter line the chain was replaced with a new one.

Comment

41/51 Condensation was noted on the roof of the three carcass chambers, ceiling, aerial tubing, two parts of the chain and in another structure above an adjacent corridor next to the entrance of these chambers. 9 CFR 416.2

Response

Fans were installed in order to generate ventilation sufficient to reduce the condensation. Thermal insulation of some refrigeration pipes was replaced. Heating elements were installed in the evaporation pans of the carcass chambers. The frequency of condensation removal was increased through use of a sanitized sponge.

[SEAL]

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TIF Establishment No. 158 "Sigma Alimentos Centro, S.A. de C.V." (Atitalaquia Plant)

Comment

13/51 The logs for the POES corrective measures do not include the 9 CFR 416.15 preventive measures

Response

The cleaning log format was updated to include preventive measures.

Comment

22/51 The calibration logs do not include the event dates and some fields are not initialed 9 CFR 417.5 b

Response

The thermometer verification procedure was modified.

Comment

46 Boxes of packing material stored on the floor of the refrigeration chamber. The official SAGARPA inspectors rejected the boxes and requested that plant administration take immediate action. 9 CFR 415.4.

Response

They were immediately removed; the packing material that had been in direct contact with the floor was discarded in the trash. The procedure was modified, indicating the corresponding activity.

Comment

46/51 Condensation was noted dripping from a hose towards a box that contained approximately 10 to 15 packages of sausage for re-processing. There was no product exposed to the condensation. A PVC tube that runs along the upper portion of the same area was covered with a layer of dust measuring approximately ¼ " thick. 9 CFR 416.4 and 416.13.

Response

The tubing, walls, and ceilings in the pasteurizing area were cleaned.

TIF Establishment No. 209 "Alimentos Sigma Conagra Foods, S.A. de C.V."

Comment

48/51 -1) The equipment cleaning area does not have a separation distinguishing between clean and unclean equipment pieces.

2) Two of the hand-washing stations do not have paper towel or trash receptacles.

The management corrected this deficiency immediately.

Response

1) The clean equipment area was clearly marked separate from the dirty equipment.

2) Immediate corrective measures.

[SEAL]

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Comment

19/51 1) The sampling methodology identified in the documentation does not support the sampling methodology used in Salmonella analysis for RTE products as part of the verification procedures.

- 2) The establishment chose alternative 3 to control Lm through a program of sanitization and testing of the surfaces in contact with the food product. Nevertheless, the program does not explain why the frequency of testing is sufficient, although according to the logs they carry out sampling on a daily basis.

Response

- 1) The methodology described in the program was implemented
- 2) There is a microbiological analysis that supports and confirms the certainty afforded by complying with said procedures.

Comment

22/51 Some HACCP verification logs do not have log entries 417.5 b

Response

Verification personnel were retrained to assure there are no doubts as to the importance of the plan verification (review of logs, direct observation, and taking of measurements).

TIF Establishment No. 281 (Especialidades Típicas Mexicanas, S.A. de C.V.”

Comment

22/51 The PCC corrective measures in the HACCP plan do not completely specify the four points in the 9 CFR 417.3 a.

Response

The log forms were corrected clearly and completely with the 3 corrective action activities described in the 9 CFR 417.3 a. Staff were trained regarding this point.

Comment

11/51 The procedure for cleaning the tubing for the lard-dispensing pot, which is done every 6 months, is not specified, nor is the visual inspection in the POES program in accordance with the 9 CFR 416.14 and 416.4 (a).

Response

The POES includes the complete procedure for the lard-dispensing pot, which includes disassembling the tubing in order to perform the required cleaning, as well as including it on the inspection log when this procedure is carried out.

[SEAL]

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TIF Establishment No. 300 "Carnes Viba, S.A. de C.V."

Comment

22/51 The calibration logs were losing several verification entries. The findings were attributed to the fact that they had been improperly filled out by the establishment 9 CFR 417.4 (a) 3.

Response

Staff in charge of verification was trained.

TIF Establishment No. 304 "Elaboradora la Esperanza, S.A. de C.V."

Comment

None.

TIF Establishment No. 316 "Mantequera San Jose, S.A. de C.V."

Comment

15/51 1) The flow chart does not include product return and is not taken into consideration in the risk analysis. 9 CFR 417.2 and 417.8

2) The PCC 1 critical limit for receiving raw materials (raw meat) was 4 degrees C. However, according to the HACCP plan, in case of deviation the affected product may reach a temperature of as high as 7 degrees C before corrective measures are taken. 9 CFR 417.3.

Response

- 1) Product return was included in the flow chart and in the risk analysis.
- 2) The risk was analyzed and in our opinion it was not a PCC, only a PC.

TIF Establishment No. 367 "Master Meat, S.A. de C.V."

Comment

15/51 1) The establishment is using an anti-microbial product approved by the FDA to treat the carcasses prior to the refrigeration chambers. This step is not included in either the flow chart or the risk analysis.

2) Product which has been returned is not included on either the flow chart or the analysis 9 CFR 417.2 (a) (1) and (2)

Response

- 1) The application of the anti-microbial to the carcasses before entering the refrigeration chambers has been included in both the flow chart and the risk analysis.
- 2) The return of product has been included in both the flow chart and the risk analysis.

[SEAL]

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Comment

28/51 The establishment is conducting generic *E. coli* in accordance with CFR 310.25, except they still need to develop a control of the statistical process (SPC), even though the plan had all the results for the test that they had directed over the last few months. 9 CFR 310.25 (a) (2) (ii)

Response

The results for the generic *E. coli* sampling were incorporated into a statistical procedure control graph.

Comment

46 Condensation was noted above the caprine carcasses in the refrigerator. The establishment corrected the problem before the audit was finished. No product was affected. 9 CFR 416.4 (d) and 416.14

Response

Immediate corrective action regarding the condensation and the process was included in the risk analysis.

Comment

13/51 The logs recording corrective measures do not include the three parts mentioned 9 CFR 416.15 (b).

Response

The three parts mentioned in the 9 CFR 416.15 (b) were included in the logs, in the reports as well as the logs.

I would like to take this opportunity to send you my warmest regards.

SINCERELY

“EFFECTIVE SUFFAGE, NOT RE-ELECTION”

THE DIRECTOR GENERAL

[Signature]

QFB. AMADA VELEZ MENDEZ

[Seal: SENASICA, General Safety Office
for of Agriculture and Food Production,
Aquaculture, and Fisheries, Dec. 6 2005

SENT

DOCUMENTATION IN TRANSIT
MUNICIPALITY No. 372
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