

# **HACCP-BASED INSPECTION MODELS PROJECT (HIMP)**



## **YOUNG TURKEY INSPECTION**

**Implementation Date: 1/7/2002**

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## HACCP-BASED INSPECTION MODELS PROJECT (HIMP)

### Model Phase Performance Standards for Young Turkey Plants

<u>Performance Standard Categories</u>	<u>Performance Standards**</u>
<b>Food Safety (FS-1)</b> Condition – Infectious <b>(Examples: septicemia, toxemia)</b>	<b>Zero</b>
<b>Food Safety (FS-2)</b> Contamination – Digestive Content (Fecal material)	<b>Zero</b>
<b>Other Consumer Protection (OCP-1)</b> Condition - Animal Diseases* (Examples: airsacculitis, arthritis, ascites, cadaver, enteritis, erysipelas, generalized inflammatory process, neoplasms, nephritis, osteomyelitis, pericarditis, salpingitis, tenosynovitis)	<b>1.2%</b>
<b>Other Consumer Protection (OCP-2)</b> Condition- Miscellaneous (Examples: breast blister, bruises, external mutilation, fractures, overscald, scabs, localized inflammatory process)	<b>56.6%</b>
<b>Other Consumer Protection (OCP-3)</b> Contamination - Digestive Content (Ingesta)	<b>12.7%</b>
<b>Other Consumer Protection (OCP-4)</b> Dressing Defects – Other (Examples: extraneous material, feathers, lung, oil gland, trachea, bile)	<b>95.9%</b>
<b>Other Consumer Protection (OCP-5)</b> Dressing Defects – Digestive Tract Tissue (Examples: bursa of fabricius, cloaca,	<b>7.5%</b>

\* Conditions exhibiting a septicemia or toxemia are considered food safety hazards.

\*\*Performance standards for OCP-1 through 5 are based on the 75<sup>th</sup> percentile of the ranges of baseline data from 16 Young Turkey slaughter plants.

# MODIFIED HACCP-BASED INSPECTION MODELS PROJECT (HIMP)

## POULTRY INSPECTION

Modified HACCP-Based Inspection Models Project (HIMP) Poultry Inspection consists of three activities: Carcass Inspection, Verification Inspection, and System Inspection.

### Carcass Inspection

Carcass inspection accomplishes post-mortem inspection of each carcass following the plant's carcass sorting activities. The Carcass Inspector (CI) is stationed at a fixed location on the line and makes the critical determination to allow the application of the marks of inspection. Carcass inspection is not a system verification activity.

#### A. The Carcass Inspector (CI):

- Inspects each carcass on the line, at a fixed location prior to the chiller.
- Makes a critical appraisal by visually examining the exterior of the carcasses as they are presented, to determine if they are adulterated.
- Diseases or conditions to be identified include:

#### Disease/Conditions\*\*

**Septicemia/Toxemia**

**Fecal contamination**

**Cadaver**

**Mutilation**

**Overscald**

**Other Generalized, Extensive Conditions**

**\*\*NOTE:** If a carcass is condemned, the corresponding viscera will also be condemned, unless the carcass was condemned for fecal contamination, mutilation, or overscald. Particular viscera do not need to be identified if the plant discards all viscera produced within the time period in which the carcass was condemned. Plants that salvage viscera for human consumption must document that their procedure ensures that appropriate viscera are condemned. The Inspector-In-Charge (IIC)/Supervisory Veterinary Medical Officer (SVMO) may record carcasses condemned by the CI on Draft HIMP Form-14.

- Condemns carcasses that clearly exhibit condemnable conditions. (Carcasses and parts affected with nonconformances that are reasonably likely to result in condemnation decisions shall either be condemned by the CI or hung back for final veterinary disposition).
- If the CI notices that Other Consumer Protection (OCP) related defects are occurring at an unacceptable frequency, he or she should request that the IIC/SVMO direct an unscheduled verification test. However, OCP defects found by a CI, are not scored against the plant's performance standards for OCP defects.

**B. Identification of Defects by the Carcass Inspector (CI)**

1. If the CI, located **after the establishment CCP for FS-1 (Infectious Conditions) or FS-2 (Fecal Material Contamination)**, identifies an FS-1 or FS-2 defect he or she will:

- Stop the evisceration line, and verbally notify the establishment to hang the affected carcass back for condemnation or reprocessing. Once the carcass is removed from the evisceration line, the inspector will restart the line.
- Verbally notify the plant and the Inspector-In-Charge (IIC)/Supervisory Veterinary Medical Officer (SVMO) of the finding(s).
- Document the finding(s) on a Non-Compliance Record (NR), after leaving the CI fixed position, coded as a 03J02 procedure.
- Complete the 03J02 procedure after leaving the CI fixed position on the line (i.e., when rotated to verification inspection duty).

If a Verification Inspector (VI) finds additional food safety noncompliance in the same slaughter production lot, the VI will document these additional findings on an NR Continuation Sheet and attach it to the original NR initiated by the CI. All findings will be taken into consideration when the VI verifies the plant's corrective actions. (See "Verification Inspection" and Appendix 1, "Food Safety Documentation Procedures").

2. If the CI, located **before the establishment's CCP for FS-2 (Fecal Material Contamination)**, identifies an FS-2 defect he or she will:

- Stop the evisceration line, and verbally notify the establishment to hang the affected carcass back for condemnation or reprocessing. Once the carcass is removed from the evisceration line, the inspector will restart the line.
- Tally each FS-2 finding on a sheet of paper or other recording device.
- Notify the IIC/SVMO if he or she believes that the dressing processes for visible fecal contamination may not be under control.

The IIC/SVMO will then:

- Conduct or request the VI to conduct a verification test.
- Record FS-2 defects on Draft HIMP Form-14 when notified by CI.
- Evaluate findings and determine if the defects indicate a system noncompliance.
- Document the noncompliance on a Noncompliance Record (NR) if it is determined that there is a system noncompliance. In response to the noncompliance, the plant will follow regulatory procedures at 9 CFR §417.3(a).

## **Verification Inspection**

Verification inspection is a system verification activity that continuously monitors and evaluates the HACCP and OCP process control plans and determines whether the plant is meeting relevant regulatory requirements and performance standards.

### **A. The Verification Inspector (VI):**

- Examines plant records to assist in determining if regulatory compliance exists.
- Conducts scheduled and unscheduled sampling by examining carcasses, before the CI position, to determine if the plant is complying with relevant performance standards.
- Shows plant management all defects that are detected.
- Conducts ante-mortem inspection.

### **B. Food Safety Verification Procedures**

#### 1. Scheduled Food Safety Verification Sampling

The IIC/SVMO will:

- Schedule, prior to each shift, the randomized selection of eight 10-bird-sample sets per line.
- If the plant is engaged in product action to remedy a problem at the time a random sample is scheduled, the IIC will suspend random sample selection until the plant has completed its action.
- Compiles Draft HIMP Form-11 data for each shift.

The VI will:

- Inspect each carcass of the eight 10-bird-sample sets for FS-1 and FS-2 defect categories. (A finding of any FS-1 and FS-2 defects constitutes a failed set).
- Notify the plant of any failed sets.
- Record any food safety defects found on Draft HIMP Form-11.
- Document noncompliance on an NR (see below).
- Notify the plant if any OCP defects are identified during the FS verification activities. However, these OCP defects will not be scored against the plant's OCP performance standards.

2. Unscheduled Food Safety Verification Sampling

Unscheduled Food Safety Verification Sampling is conducted in the same manner as Scheduled Food Safety Verification Sampling and the duties of the IIC/SVMO and the VI are also the same (See above), except that the IIC/SVMO determines whether and when to schedule additional sampling and adjusts the Table 1 sample size accordingly.

**C. Food Safety Verification Documentation Procedures:**

If the VI finds a food safety defect (FS-1 or FS-2), he or she will document the noncompliance on a Noncompliance Record (NR).

- If the VI finds a food safety defect during a verification procedure, it is documented using either the 03J01 or 03J02 procedure code (See Appendix 1, "Food Safety Documentation Procedures").
- If the defect is documented using a 03J01 procedure code, the VI will also perform a 03J02 procedure to verify that all regulatory requirements have been met for this specific slaughter production lot. The VI will communicate the finding(s) to the IIC/SVMO. If, during this production lot, the CI finds additional food safety defects, he or she will document these findings on a NR Continuation Sheet and attach it to the original NR initiated by the VI. All findings will be taken into consideration when the VI verifies the plant's corrective actions (See Appendix 1, "Food Safety Documentation Procedures").

**D. Other Consumer Protection (OCP) Verification and Documentation Procedures**

The IIC/SVMO will:

- Schedule, prior to each shift, the randomized selection of OCP-verification samples.
- Determine the correct OCP-verification-sample size per shift.

The sample size is determined by the number of evisceration lines and is composed of 10 bird-sample-sets. The minimum number of sample sets per line is two sets (20 birds) and the minimum number of birds per shift is 40. In a one-line turkey plant, four of the eight 10-bird sample sets selected for food safety would also be sampled for OCP. The two OCP-verification-sample sets per line will be randomly selected from the previously selected 8 food-safety-sample sets.

- Authorize shifting sampling from one line to another, if indicated.
- Compile Draft HIMP Form-11 data for each shift.
- Evaluate OCP-verification data for each shift using Table 1, “Maximum Allowable Number of OCP Defects in a Given Sample Size” (See below) and record the findings on Draft HIMP Form-13.
- Inform plant of its OCP performance status.
- If the plant is engaged in product action to remedy a problem at the time a random sample is scheduled, the IIC will suspend random sample selection until the plant has completed its action.

The VI will:

- Examine each carcass of the 10-bird-sample-set for the OCP defect categories.
- Notify the plant of any OCP defects and have the defects removed prior to putting back on the line.
- Record any defects found on Draft HIMP Form-11.

**TABLE 1: Maximum Allowable Number of OCP Defects in a Given Sample Size**

	40 Bird Sample	50 Bird Sample	60 Bird Sample	70 Bird Sample	80 Bird Sample
OCP-1 Performance Standard*	1/40	1/50	1/60	1/70	2/80
OCP-2 Performance Standard*	25/40	31/50	37/60	43/70	49/80
OCP-3 Performance Standard*	7/40	8/50	10/60	11/70	13/80
OCP-4 Performance Standard*	40/40	50/50	60/60	70/70	80/80
OCP-5 Performance Standard*	4/40	5/50	6/60	7/70	8/80

\*See page 3 for description of OCP Performance Standard Categories

**E. Unscheduled Verification Sampling**

The IIC/SVMO will:

- Coordinate all unscheduled verification sampling.
- Verify that results are recorded on Draft HIMP Form-11.
- Document on Draft HIMP Form-14, the reason(s) for the unscheduled sampling. In some cases, the IIC/SVMO may request unscheduled verification sampling because a VI or CI has identified a problem that must be addressed immediately. In other instances, the IIC/SVMO may allow the plant an opportunity to correct an identified problem and then request unscheduled verification sampling to confirm that the problem has been corrected.
- Notify the plant of the results of all direct-bird examinations and plant records examinations.

**F. Evaluation of Verification Inspection for OCP-1 Performance Standards**

For OCP-1 evaluation, the IIC will:

- Determine if a plant exceeds the **maximum limit** at any time during a shift (see Table 2, “OCP-1 Maximum Limits for Various Sample Sizes”, below) using data accumulated from all Draft HIMP Form-11’s.
- Provide the plant with a copy of Draft HIMP Form-12 showing any failure that exceeds the maximum limit.
- Issue a noncompliance record (NR) for the failure. Refer to Appendix 2, “OCP-1 Documentation Procedures”.

**TABLE 2: OCP-1 Maximum Limits for Various Sample Sizes  
(Carcasses with defects allowed per sample)**

	40 Bird Sample	50 Bird Sample	60 Bird Sample	70 Bird Sample	80 Bird Sample
OCP-1 Performance Standard*	3/40	3/50	4/60	5/70	5/70

\*See page 3 for description the OCP-1 Performance Standard Category

In response to an OCP-1 maximum limit failure, the plant must:

- Maintain control of all identified product from the lot that exceeded the maximum limits. (Table 2, “OCP-1 Maximum Limits for Various Sample Sizes”, above).
- Immediately conduct post-chill sampling of a minimum of 40 birds.
- If the post-chill sample exceeds the maximum limit (Table 2, “OCP-1 Maximum Limits for Various Sample Sizes”, above) rework all of the represented product using good commercial practices for handling and reconditioning.
- After all product represented by the post-chill sample has been reworked, test a randomly selected subgroup of reworked product.
- If the tested subgroup exceeds the baseline maximum limits, again rework all represented product.
- Conduct pre-chill testing until re-establishment of process control is demonstrated by test results that show that pre-chill OCP-1 levels are at or below the performance standard for the appropriate sample size in Table 1, “Maximum Allowable Number of OCP Defects in a Given Sample Size”.
- Once process control is re-established, birds should be marked and placed in the chiller.
- Continue testing birds at post-chill until the all the marked birds have exited the chiller.
- Reassess their Process Control Plan.
- Respond to the NR that documented the failure of the OCP-1 maximum limits.(Table 2, “OCP-1 Maximum Limits for Various Sample Sizes”)

The IIC/SVMO will (during rework):

- Conduct or assign verification of plant segregation, identification, product control, and rework processes.
- Record observations, results, and actions on Draft HIMP Form-14.
- Initiate an unscheduled OCP verification check to verify that the process is under control. Utilize the performance standard as set for OCP-1 in Table 1, “Maximum Allowable Number of OCP Defects in a Given Sample Size”)
- Restart Table 1, “Maximum Allowable Number of OCP Defects in a Given Sample Size” testing.

### **G. Extended Process Evaluation for OCP Performance Standards (25 day period<sup>1</sup>)**

The IIC/SVMO will:

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<sup>1</sup> A 25-day period will end at a full 25 days provided that the Table 3 Maximum Allowable Days are not exceeded. If the Table 3 Maximum Allowable Days are exceeded before 25 days are completed, e.g. on the 13<sup>th</sup> day, the period stops and an NR is issued. The IIC/SVMO begins a new 25-day period at that time.

- Evaluate plant performance for OCP-1 through 5 defects, using the Draft HIMP Form-11 compiled data compared with Table 1, “Maximum Allowable Number of OCP Defects in a Given Sample Size”, over a 25-day period for each OCP category.
- Use Table 3, “Maximum Allowable Days OCP Performance Standards May Be Exceeded”, to assess whether the plant has exceeded the 25-day limits.
- Record on Draft HIMP Form-13 the plant performance for the 25-day period on a per shift basis.
- Notify the plant of its daily accomplishments.
- Issue an NR, if at any point within the 25-day period the 25-day limit, listed in Table 3, “Maximum Allowable Days OCP Performances Standards May Be Exceeded”(See below), is exceeded for any OCP category. (See Appendix 2, “OCP-1 Documentation Procedures”).

The plant must:

- Reassess its Process Control Plan when the Table 3, “Maximum Allowable Days OCP Performance Standards May Be Exceeded”, maximum days are exceeded.
- Meet with the IIC/SVMO to describe corrective and preventive actions.
- Respond to the NR that documented the plant’s failure in exceeding the maximum days for any OCP categories.

**TABLE 3: Maximum Allowable Days OCP Performance Standards May Be Exceeded (Per 25-Day Period)**

OCP-1	OCP-2	OCP-3	OCP-4	OCP-5
5 Days	8 Days	6 Days	N/A	7 Days

**H. Examination of OCP Plant Records**

The IIC/SVMO or VI will:

- Examine and review the plant’s OCP-sampling records four times per line per shift. Plant records examination may also include observations of plant sample selection and data recording procedures.
- Record the results of plant-records reviews on Draft HIMP Form-14 (IIC/SVMO only).
- Verify that the plant is sampling a minimum of 40 birds per line per shift.
- Verify that the plant is taking these samples before the CI position.

The IIC/SVMO or VI may:

- Examine and review fewer than four of the plant’s OCP-sampling records if more direct-bird-OCP examinations are conducted on a line, for example, when unscheduled verification sampling is conducted (see Unscheduled Verification Sampling Section, below). The total combined direct-bird-OCP examinations and plant OCP-sampling record examinations would typically not exceed six times per line per shift.

**I. Ante-mortem Inspection and Records Examination**

1. Ante-mortem Inspection

The IIC/SVMO will:

- Randomly select, prior to the start of the shift, the scheduled ante-mortem sampling time.
- Inspect live birds, or assign VI to inspect birds, at least once per shift.
- Request unscheduled live-bird examinations, as appropriate.
- Record results on Draft HIMP Form-14.

2. Ante-mortem Records Examination

The IIC/SVMO will:

- Randomly select the times for the ante-mortem records checks, prior to the start of the shift.
- Review, or assign the VI to review, ante-mortem records, twice per shift
- Request unscheduled record verifications, as appropriate.
- Record results on Draft HIMP Form-14.

**J. Off-Line Verification (See Appendix 4, “Off-Line Salvage and Reprocessing”)**

The VI will:

- Inspect each reworked part at the point designated in the plant’s HACCP or Process Control Plan.
- Inspect each part at the specified plant salvage area using as defect categories the Disease/Conditions included under “A. Carcass Inspection”, on page 3 of this document. Individual parts shall be passed or condemned.

The CI will:

- Inspect visually each carcass or major portion at the carcass inspection station.

## **System Inspection**

The IIC/SVMO is responsible for the following activities:

- Assessing the overall design and execution of all the plant processes under its HACCP and process control procedures.
- Supervises the effectiveness of carcass and verification inspection.
- Assuring that all adulterated product is condemned in accordance with the Poultry Products Inspection Act.
- Evaluates the effectiveness of the establishments TOC procedures through verification to ensure adequate removal of unwholesome tissues.
- Verify, or delegate the verification, of performance standards when notified by the CI, and at other scheduled or unscheduled times.
- Regularly conducting correlation meeting activities with the plant management. Regular correlation will assist FSIS and the plant in establishing a common basis for both FS and OCP determinations. The Agency expects that correlation will be frequent and ongoing.
- Completing Draft HIMP Form–14 on a daily basis. Also recording, on Draft HIMP Form - 14, flock test results and Verification/Corrective Action procedures which were performed, i.e. records review, organoleptic examination, ante-mortem examination, unscheduled verifications.

Appendix 1

**Food Safety Documentation Procedures**

Major points:

- All food safety noncompliances for a specific slaughter production lot are documented on one NR. This includes all FS-1 and FS-2 findings by the VI and may include product from multiple lines.
- The exception to using only one NR for all non-compliance's that occur in a single slaughter production lot would occur if a system noncompliance, coded using the 03J02 procedure designation, and a noncompliance coded for the 03J01 procedure were both found in the same slaughter production lot. In such a situation, two NRs would be issued. Note: HACCP and SSOP verification procedures, are systems verification tools and are therefore always based on 03J02 procedures, whereas a noncompliance based on a 03J01 procedure, such as a FS-1 or FS-2 defect finding, are specific to a given production lot.
- The HACCP plan defines production lots.
- The quality of the documentation for all NRs should be sufficient to justify subsequent Agency system verification actions.

Examples:

1. A plant's HACCP plan designates product lots on a time basis of 2 hours of production. Assume: The FS1 CCP is located at the final wash. The FS2 CCP is located after the CI.

At 8 am, the Line 2 VI finds a bird with fecal contamination while conducting a 03J01 procedure. He/she issues an NR and notifies the plant and the IIC/SVMO. The plant implements corrective actions in compliance with 9 CFR § 417.3. Fifteen minutes later, the Line 1 CI condemns a bird for sep-tox. The Line 1 CI also notifies the plant and the IIC/SVMO of this finding. In this example, the Line 1 CI would document his/her FS1 findings on an NR Continuation Sheet of the NR originally initiated by the Line 2 VI. The Line 2 VI would verify the plant's corrective actions (for all of the findings) as part of the 03J02 procedure.

At 2 PM (which would be in a different production lot), the Line 1 CI finds a bird with fecal contamination. He/she stops the line, has the affected carcass removed from the line, and tallies the FS2 finding.

2. The plant's HACCP plan describes a product lot as one day's production.

At 10 am, the Line 3 CI, located before the FS2 CCP, finds a bird with fecal contamination. He/she stops the line, has the affected bird removed, notifies the plant and the IIC/SVMO, and tallies the FS2 finding. At 10:05, the Line 3 VI, while conducting an 01 procedure, finds a bird with fecal contamination. The Line 3 VI also notifies the plant, the Line 3 CI, and the IIC/SVMO. At 3 PM (the same production lot), the Line 2 VI finds an additional bird with fecal contamination. He/she also notifies the plant, and the IIC/SVMO. In this example, the Line 3 VI is responsible for documenting the 03J01 NR and ensuring completion of the 03J02 procedure including verification of the corrective actions (for all of the findings). The Line 2 VI would document their findings on

## DRAFT 2

a NR Continuation Sheet and attach them to the NR completed by the Line 3 VI. The IIC/SVMO is responsible for coordinating the documentation of all of the findings.

3. The plant's HACCP Plan has a FS2 CCP after the Carcass Inspector.

At 10 am, the Line 3 CI, located before the zero fecal tolerance CCP, finds a bird with fecal contamination. He/she notifies the plant, has the affected carcass removed from the line, notifies the IIC/SVMO and the VI of the finding, and tallies the finding on a sheet of paper or other recording device. No other fecal defects are identified for this lot. The IIC/SVMO is responsible for coordinating all findings of food-safety noncompliances and for determining the appropriate conclusions based on those findings.

4. The HACCP Plan has a FS2 CCP before the CI.

At 8 am, the Line 2 CI, located after the plant's zero fecal tolerance CCP, finds a bird with fecal contamination. He/she notifies the plant and the IIC/SVMO and has the affected carcass removed from the line. The plant would implement corrective actions according to 9 CFR § 417.3. In this example, the Line 2 CI would document his/her findings on an NR as part of a 03J02 procedure upon rotating into the VI position.

Appendix 2

## OCP-1 Documentation Procedures

Major points:

- The relevant regulatory citation for a failure of either OCP-1 Maximum Limits or Maximum Allowable Days OCP Performance Standards May be Exceeded for an OCP-1 Performance Standard is 9 CFR § 381.3(b).
- The noncompliance classification indicator for a failure of either OCP-1 Maximum Limits or Maximum Allowable Days OCP Performance Standards May be exceeded for an OCP-1 Performance Standard is Product, economic, 04C01.

Examples of Documentation :

1. An example of a noncompliance description for a failure to meet the OCP-1 Maximum Limits (Table 2,) follows:

At 1300 hours during a verification sampling procedure for OCP-1 in *[insert name of plant]*, a *[insert number of lines]*-line plant, the OCP-1 Maximum Limits from Table 2 “Maximum Limits for Various Sample Sizes” of the Young Turkey Inspection HIMP draft 2, 12/30/2001 were exceeded. (Line 2 at 0630 hours – 4 airsacculitis defects out of 40 birds sampled). Notified *[insert name of notified persons]*.

2. An example of a noncompliance description for a failure to meet the Maximum Allowable Days OCP Performance Standards May be Exceeded for an OCP-1 Performance Standard (Table 3,) follows:

For the 25-day period from Jan 11 to Feb 14, 2001, the Maximum Allowable Days OCP Performance Standards May be Exceeded for an OCP-1 Performance Standard were exceeded on *[insert appropriate date, i.e., the date on which the allowable number of days was exceeded]*. As documented on Draft HIMP Form-13, the OCP-1 performance standard was exceeded on the following dates: *[insert appropriate dates]*. Notified *[insert appropriate name]*.

Appendix 3

**Poultry Pre-Chill Inspection Station**

Major points:

- The carcass inspection station is to be established at or after the zero tolerance verification location, i.e. between the final wash and before the chill step.
- Facility requirements must include:
  1. A level conveyor line for the entire length of the inspection station.
  2. At least 4 feet of space for the inspector on the inspection stand.
  3. A minimum of 200 foot-candles of shadow-free lighting with minimum color rendering index of 85.
  4. An “on-line” hand- rinsing facility for the inspector and helper, if a helper is present.
  5. Hang back racks positioned within easy reach of the inspector.
  6. A buzzer switch for notifying plant management.
  7. A condemn barrel.
  8. A clipboard for recording observed conditions.
  9. A conveyor line stop/start switch located within easy reach of the inspector.
  10. A helper or an alternative plan, for carcass removal, provided by the plant
- Presentation of carcasses must include the following:
  1. One carcass per shackle (occasional double hung carcasses are permitted).
  2. Both carcass hocks must be in the shackle (occasional one leg in the shackle is permitted).
  3. Consistent presentation with the back of the carcasses toward the inspector.
  4. Minimal carcass swinging motion.
- Safety issues to be addressed must include:
  1. TSP spray (e.g., barrier to prevent TSP from contacting inspector; goggles if requested by inspector).
  2. Water spray.
  3. High traffic area.
  4. Overhead structures.

**Appendix 4**

**Off-Line Salvage and Reprocessing**

Major points:

- Regarding salvage and reprocessing requirements, the plant must have in its HACCP or Process Control Plan an efficient and effective means of controlling salvaged and reprocessed product.
- The plant will determine where salvaged and reprocessed carcasses or “major portions” (as defined at 9 CFR § 381.170(b)(22)) are capable of being re-hung on the main evisceration line.
- FSIS will make a critical appraisal on each carcass that is moved to off-line salvage or reprocessing.

Plants must:

- Conduct a hazard assessment of all off-line salvage and reprocessing practices in accordance with 9 CFR § 417.2.
- Identify a sanitary means of handling product that is directed off-line.
- Maintain control of identified product.
- Rework product using good commercial practices for handling and reconditioning.
- Have each reworked carcass inspected by the CI by re-hanging on the main evisceration line all such carcasses and major portions.
- Present for inspection at a specified location all edible parts that are not able to be re-hung on the main evisceration line.