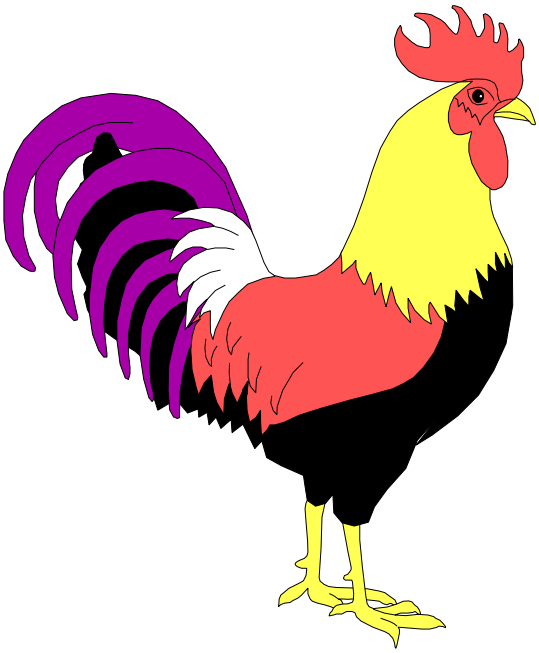

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OBJECTIVES

1. The maximum chill water temperature allowed to chill warm poultry.

2. The maximum time and product temperature requirements for chilling warm eviscerated poultry of all sizes.

3. The maximum product temperature requirements for holding chilled poultry and maximum amount of time that the chilled poultry is allowed to be submerged in water.

4. At least two approved product-handling procedures after poultry has been in water for the maximum allowed time.

5. Maximum time and temperature requirements for chilling giblets when chilled separately from the carcass.

6. At least two approved methods for chilling warm salvaged parts (wings, thighs, split carcasses, etc.)

7. At least one container requirement for ice pack poultry that relates to water drainage from the poultry.

8. Describe at least one difference that may be permitted between CO_2 and ice pack containers, and the product requirements to meet before the difference is allowed.

9. At least two requirements that a plant must meet before it is permitted to package warm (unchilled) poultry.

10. The minimum water usage requirements for continuous carcass chillers and giblet chillers expressed as volume per bird(s).

11. At least two recording thermometer requirements for continuous chillers and describe the procedure to follow when the recording thermometer is out of order.

12. The operating requirements specific to continuous chillers when the chiller elevator is stopped with poultry in the chiller.

13. The maximum temperature allowed for continuous giblet chillers.

14. The time and temperature requirement for freezing ready-to-cook poultry.

15. At least three common approved methods for thawing frozen poultry and the requirements for each method.

16. At least two approved methods for rechilling previously chilled poultry.

17. At least two requirements for storage of frozen poultry.

18. Identify seven requirements for an immediate container label.

19. Identify two requirements for a shipping label.

20. Identify the organs considered to be giblets.

21. Identify two situations in which the plant is allowed to divide giblets packed with individual bird carcasses.

This module is designed to acquaint you with chilling, freezing, and thawing procedures. It also contains basic labeling requirements.

CHILLING REQUIREMENTS

There are separate requirements for chilling carcasses and for chilling giblets. The minimum requirements for chilling warm eviscerated, ready-to-cook poultry are as follows.

- For carcasses

  The time allowed for the product to reach 40° F. after passing through the final wash on the eviscerating line depends on the ready-to-cook weight of the carcass. Carcasses under 4 pounds are allowed a maximum time of 4 hours to be chilled to 40° F. Carcasses from 4 to 8 pounds are allowed 6 hours to be chilled to 40° F., and carcasses over 8 pounds are allowed 8 hours.

- For giblets

  The requirements for chilling giblets depend upon the method used. If the giblets are chilled separately from the carcass, then they must be chilled to 40° F. or less within 2 hours from the time of harvest. If the giblets are chilled with the carcass, then they must meet the chilling requirements for the carcass.

- For salvage parts

  Parts like wings, legs and breasts that are salvaged must be chilled to 40° F. within 2 hours. Acceptable methods for cooling parts include layered icing in a box with continuous drainage, refrigeration, and freezing. Salvage parts should not be cooled in slush ice.

STORAGE IN WATER

Minimum requirements for storage of fresh poultry in water are as follows.

- Poultry is only allowed to remain in chilled water up to 24 hours. After that time, the water must be drained and the product maintained at 40° F. or less.

- Once poultry has been chilled to 40° F. or less, it cannot be allowed rechilled in water. If further chilling becomes necessary, either layered ice or refrigeration can be used provided the product continues to drain.

MINIMUM CONTINUOUS CHILLER REQUIREMENTS

When the chiller is used to chill poultry carcasses, there must be water meters to measure the amount of water used in the chill system. Also, a continuous recording thermometer is required to monitor the warmest part of the chill system. The giblet chillers are required to have water meters but not a recording thermometer. Water from ice melting in the continuous chillers may be counted toward the water usage requirement provided certain program requirements are met.

Any time the chiller elevator stops establishment personnel must immediately stop all chiller agitation in the system. If the elevator stops for 15 minutes or longer, the establishment must lower and maintain the temperature of the chiller system to 40° F. or less until the system is again in operation.

FREEZING REQUIREMENTS

For a number of years the poultry industry has used freezing as a method to lengthen the distribution life of their products. FSIS has several minimum requirements for freezing which the establishment must meet. For example, once ready-to-cook poultry (previously chilled to 40° F.) is placed into the freezer, the internal temperature of that poultry must reach 0° F. within 72 hours. If poultry is labeled “fresh frozen,” “quick frozen,” “flash frozen,” or any other term that implies the poultry underwent a rapid change from fresh to frozen, the poultry must be placed into the freezer within 48 hours after initial chilling.

THAWING REQUIREMENTS

In the poultry industry, thawing is done for several reasons. It may be to sell cut-up parts from whole frozen carcasses, to repackage the product in different sized containers, or to meet some other market request.

To protect the wholesomeness of the product, FSIS provides the industry with minimum thawing requirements.

- The poultry must not be allowed to gain moisture over its frozen weight during thawing.

- The wholesomeness of the poultry must be protected throughout the thawing process so the poultry does not become adulterated.

The most common thawing procedures involve the use of water. FSIS has temperature requirements for the thawing media.

- Once poultry has thawed, it is not allowed to be rechilled in water.

- The internal temperature of the thawed poultry must be maintained at 40° F. or less.

PACK-OUT DUTY

When the day's evisceration operation has been completed, it is usually necessary to assign an inspector to "pack-out" duty. In some plants a USDA grader will supervise this operation. If so, double coverage is not necessary. The duty may be rotated among GS-7 inspectors and is sometimes performed on overtime.

The duties of a pack-out inspector are generally supervising regulatory requirements for product, either during or after chilling. Some of these requirements involve the following:

- Chilling, freezing, and thawing
- Moisture control tests
- Labeling checks
- Net weight tests
- Cut-up inspection
- RTC inspection
- Finished product standards tests
- Condemned product disposal
- General operational sanitation

LABELING

The public expects products labeled with the mark of inspection to be wholesome, free of adulteration, and truthfully labeled.

The poultry **inspection legend** shows that the product has been inspected for wholesomeness. Product eligible to carry this legend was wholesome at the time of inspection.

The **shipping container** encloses fully labeled immediate containers. The container is used to bulk-pack smaller immediate containers such as tray packs.

The shipping container label must contain two features.

- the inspection legend
- the establishment or plant number

The **immediate container** encloses the product and comes in direct contact with the product. There are large immediate containers, like an ice-pack box; and there are small immediate containers, like the consumer-sized tray packs.

The features listed and described below must appear on the immediate container label.

- The **common** or **usual name** of the product tells the consumer what the contents of the package are.
- The **official inspection legend** indicates the product was inspected and found wholesome.
- The **official plant number** can be used to identify the origin of the product. The number may be in the circle of the inspection legend, outside the circle adjacent to the legend, or elsewhere, such as embossed on a closure clip.
- A **net weight statement** (or a statement that satisfies this requirement)
- The **name and address** of the packer or distributor of the product. This must include the zip code.

- An **ingredients statement** if the product is made from two or more ingredients

- A **special handling statement** if the product is perishable. CO_2 and ice pack poultry that is intended for further processing is exempt from this provision.

Giblets are properly prepared hearts, livers, and gizzards from a wholesome carcass. The neck is not a giblet even though, in many instances, it is included in the giblet pack.

Dividing giblets packed with individual bird carcasses is permitted; however, each carcass should contain a whole or part of a liver, heart, and gizzard. In each case of division, the giblet part shall not be less than one-half of the unit item (heart, liver, or gizzard). Division is allowed when giblets have been excessively condemned due to disease or when giblets are lost due to machinery failures. Division of giblets is not permitted where the shortage of giblets is a result of packing them separately from the carcasses to sell as a separate entity.

POULTRY PACKING ROOM PROCEDURES
Requirements For Chilling, Freezing, And Thawing Of Poultry

	CARCASS	GIBLETS
❄❄❄❄❄❄❄ **CHILLING** ❄❄❄❄❄❄❄		
Minimum water usage for continuous chillers	½ gallon per chicken 1 gallon per turkey	1 gallon per 40 chickens 1 gallon per 20 turkeys NECKS CHILLED WITH GIBLETS 1 gallon per 20 chickens 1 gallon per 10 turkeys
Maximum temperature of chilling media for continuous chillers	65° F. or the maximum (which may be lower than 65° F.) written on MP 528.	36° F.
Maximum time allowed for chilling product to 40° F. in ice and water	Under 4 lbs. ➔ 4 hours 4 – 8 lbs. ➔ 6 hours over 8 lbs. ➔ 8 hours	Same as carcass requirements when chilled with carcass or 2 hours from time of harvest if chilled separate from carcass
Maximum temperature that product is allowed to reach during further processing and packaging	55° F. (if originally and subsequently chilled to 40° F.)	
❄❄❄❄❄❄❄ **FREEZING** ❄❄❄❄❄❄❄		
Maximum time allowed for product to reach 0° F. after entering freezer	RTC ➔ 72 hours	Same as carcass
Maximum time allowed for "warm packaged" poultry to enter a blast freezer of -10° F.	2 hours from time of slaughter (bleeding)	Same as carcass
❄❄❄❄❄❄❄ **THAWING** ❄❄❄❄❄❄❄		
Maximum temperature of thawing media: • With overflow (continuous running water) • Without overflow	70° F. 50° F.	Same as carcass

CHILLING REQUIREMENTS

I. Minimum requirements for chilling warm eviscerated poultry

A. Ready-to-cook carcass requirements

IF	THEN
R-T-C carcass weighs less than 4 lbs.	The maximum time for the product to be chilled to 40° F. or less is 4 hours
R-T-C carcass weighs 4 to 8 lbs.	The maximum time for the product to be chilled to 40° F. or less is 6 hours
R-T-C carcass weighs over 8 lbs.	The maximum time for the product to be chilled to 40° F. or less is 8 hours

B. Giblet chilling requirements

IF	THEN
Giblets are chilled separately from carcass	They must be chilled to 40° F. or less within 2 hours from the time of harvest.
Giblets are chilled with the carcass	They must meet the carcass chilling requirements

II. Minimum requirements for storage of fresh (unfrozen) poultry in water
Limited to 24 hours in water

A. Poultry chilled in water

IF	THEN THE INSPECTOR MUST ASSURE THAT
Poultry is removed from water in less than 24 hours	The product temperature meets the chilling requirements and that after chilling it is maintained at 40° F. or less.
Poultry is in water 24 hours after slaughter	• The product temperature meets the chilling requirements and that after chilling it is maintained at 40° F. or less. • The establishment immediately removes the poultry from the water at the end of the 24-hour holding period.

B. Requirements for poultry after being in chill water 24 hours

IF THE ESTABLISHMENT ELECTS TO	THEN THE INSPECTOR MUST ASSSURE THAT
Hold the poultry after 24 hours by placing the poultry in a cooler	• The water is immediately drained from the poultry • The drained poultry is promptly placed in the cooler • The product temperature is maintained at 40° F. or less • The chilled product is held in continually drained containers during all of the additional holding time
Hold the poultry after 24 hours by holding it in containers that are placed in area at workroom temperatures	• The water is immediately drained from the poultry • The drained poultry is promptly transferred to clean containers with clean ice • The product temperature of the transferred poultry is maintained at 40° F. or less • The chilled product is held in continually drained containers during all of the additional holding time

C. **Exception**

All poultry that is slaughtered and eviscerated in the official establishment must be chilled immediately to 40° F. or less, *unless* such poultry is to be frozen or cooked immediately at the establishment.

IF THE ESTABLISHMENT CHOOSES TO	THEN THE INSPECTOR MUST ASSURE THAT
Warm package poultry	• The warm packaged poultry is placed into a freezer within two hours from the time of slaughter (point of being killed) • The freezer being used is a plate freezer, a freezer with a functioning air system with a temperature of -10° F. or less, or a freezer with proven product results equal to the freezers listed

D. **Rechilling of chilled poultry**

Once poultry is chilled to 40° F. or less it *cannot be rechilled in water.* This means that once poultry is removed from the original chilling procedure water it cannot be placed in water again. The following table gives examples of rechilling needs and acceptable rechilling procedures.

IF RECHILLING IS NEEDED BECAUSE THE PREVIOUSLY CHILLED POULTRY HAS	THEN THE INSPECTOR MUST ASSURE THAT
Continuously moved through the packaging operations	The establishment personnel rechill the poultry by one of the following procedures: • Place the poultry in cracked ice in clean continuously drained containers • Place the poultry in a continuously draining container with CO_2 if the moisture content is more than 8.00% • Place poultry in a container without holes with CO_2 if the moisture content is 8.00% or less. • Immediately place the poultry under refrigeration to lower and maintain the product temperature at 40° F. or less • Place the poultry under a cold water spray and provide continuous drainage for the water
Warmed up during storage after chilling Or Warmed up above 40° F. during the packing procedure or piled up Or Warmed up above 40° F. during the thawing or defrosting process	The establishment personnel correct and maintain their procedures to keep the product temperature to 40° F. or less

E. Poultry that is held in packaged form in the plant for more than 24 hours shall be kept under refrigeration in a room of 36° F. or less to maintain product temperature of 40° F. or less.

III. The minimum continuous chiller requirements are basically the same no matter what brand of chillers are used.

A. Minimum facility requirements

IF THE CHILLER IS USED TO CHILL	THEN THE INSPECTOR MUST ASSURE THAT THE ESTABLISHMENT
Poultry carcasses	• Installs and maintains a recording thermometer that monitors the warmest part of the chill system • Installs and maintains a water meter(s) to measure the amount of water used in the chill system
Poultry giblets	Installs and maintains a water meter(s) to measure the amount of water used in the chill system
Broken Recording Thermometer: If the recording thermometer is out of order, an establishment employee must take temperature readings manually every 15 minutes and maintain a record of the readings for the inspector to review.	

B. Maximum allowed chill media temperatures when using continuous chillers

IF THE CONTINUOUS CHILLER IS A	THEN THE INSPECTOR MUST ASSURE
Carcass chiller	That the established chilling procedure temperatures are met for each chiller
Giblet chiller	That the chilling media temperature is maintained at 36° F. or less
Comment: If the establishment does not meet its temperature requirements the inspector's corrective actions are determined by which system exceeds the maximum.	
IF THE CHILL SYSTEM IS	**THEN THE INSPECTOR MUST**
The carcass chilling system	Take product actions based on the moisture control requirements
The giblet chilling system	Take immediate action that will assure that the product is corrected and the system correction is maintained

C. Water usage requirements for continuous chillers are established to assure that the wholesomeness of the eviscerated poultry is maintained.

IF THE CONTINUOUS CHILLER IS FOR	THEN THE INSPECTOR MUST ASSURE THAT THE ESTABLISHMENT PERSONNEL
Carcass chilling	• Fill the chill system with water before placing poultry in the system • Load the water-filled chill system with poultry • Open the water intake when the chill system becomes full of poultry • Maintain constant overflow of chiller when poultry is being placed in the chiller • Adjust the intake valve to meet the minimum water usage requirement of the poultry class being processed as below.
IF THE CLASS BEING PROCESSED IS	**THEN THE ESTABLISHMENT PERSONNEL MUST SET THE WATER INTAKE TO ASSURE**
Young chickens	Not less than ½ gallon water per bird is placed in the chiller
Turkeys	Not less than 1 gallon per bird is placed in the chiller
Other classes of poultry	Not less than 1 gallon per bird is placed in the chiller (Continued)

Giblets	• Fill the giblet chiller to overflow before placing giblets in the chiller. • Load the water-filled chiller with giblets. • Maintain constant overflow of chiller water when giblets are being placed into the chiller. • Open the water intake valve of the giblet chiller when the chiller has been filled with giblets. • Adjust the water intake valve to meet the minimum water usage requirement for the class of giblets being chilled.
IF THE GIBLETS ARE FROM	**THEN ASSURE THAT THE ESTABLISHMENT PERSONNEL**
Young chickens chilled with giblets only	Set the water intake at not less than 1 gallon per 40 sets of giblets entering the chill system.
Young chickens chilled with giblets and necks	Set the water intake at not less than 1 gallon per 20 sets of giblets and necks entering the chill system.
A class of poultry other than young chickens	Set the water intake to be proportionally increased above the requirement for young chickens based on the size and condition of the giblets.
Ice Usage Requirement: Water from ice placed into the continuous chillers may be counted toward the above water usage requirements if the ice measuring system of the establishment is first approved by the district office. It is then the inspector's responsibility to assure that the approved procedure is followed.	

D. **Continuous Chiller Operational Requirements**
When an establishment uses continuous chillers there are specific minimum requirements. These requirements are to protect the consumer from adulteration in the form of excessive moisture (water) being added to the weight of the poultry.

IF	THEN ESTABLISHMENT PERSONNEL MUST
The chiller elevator is stopped	Immediately stop all chiller agitation (mechanical and air) into the system
The chiller is stopped for 15 minutes or more	(In addition to stopping agitation) promptly lower and maintain the temperatures of all portion of the chiller system to 40° F. or less until the system is operating again

FREEZING REQUIREMENTS

I. Freezing Procedure Requirements

Poultry is often frozen to lengthen its distribution life. Proper freezing and storage of frozen poultry provides the consumer with a wholesome product long after fresh poultry would have spoiled or decomposed. To assure that good commercial freezing procedures are used to protect the consumer, FSIS established minimum freezing requirements.

A. Once R-T-C poultry is placed into the freezer, the product's internal temperature must be 0° F. or less in the center of the package within 72 hours. This is the basic requirement for frozen poultry no matter how or where it is frozen.

B. Poultry may be frozen in a freezer at the official establishment or at a freezer located outside of the establishment.

IF THE FREEZER LOCATION IS	THEN THE INSPECTOR MUST ASSURE THAT ESTABLISHMENT PERSONNEL
In the official establishment	Meet product temperature requirements by spot checking product temperatures 72 hours after it enters the freezer to ensure that the internal product temperature is 0° F. or less
IF THE INTERNAL PRODUCT TEMPERATURE ENTERING THE FREEZER IS	**THEN THE ESTABLISHMENT MUST**
40° F. or less	Maintain the product temperature at 40° F. or less until placed in the freezer
55° F. or less but not 40° F. or less	Immediately after packaging place the poultry under refrigeration that will promptly lower the product temperature to 40° F. or less
Warm packaged (non-chilled)	Meet the previously stated warm packed requirements
IF THE FREEZER LOCATION IS	**THEN THE INSPECTOR MUST ASSURE THAT ESTABLISHMENT PERSONNEL**
Outside of the official establishment	• Get district approval to freeze off premises before shipping of poultry • Chill all poultry to 40° F. or less before shipping the poultry to the freezer • Ship the poultry in sanitary covered trucks to an approved freezer • Place poultry that warmed up during packaging (to a temperature of no more than 55° F.) into a freezer within 2 hours, or place it under refrigeration to lower and maintain the product temperature at 40° F. or less

C. Poultry that is labeled "fresh frozen," "quick frozen," "flash frozen," or any other term that implies that the poultry underwent a rapid change of state from fresh to frozen must be placed into the freezer within 48 hours after initial chilling.

STORING FROZEN POULTRY

I. Requirements

The requirements for storage of frozen poultry require that it be maintained in a solid frozen state at room temperature that remains as constant as possible, using good commercial practices. The regulations require that procedures used to process, store, or otherwise handle any poultry product shall be strictly in accordance with clean and sanitary practices and shall result in poultry products that are not adulterated [§381.65(a)]. Furthermore, it states that "containers to be used for packaging other poultry products shall be clean, free from substances and odors that would result in adulteration of the products, and of sufficient strength and durability to protect the products during normal distribution" [§381.65(j)].

Product wholesomeness must be maintained during the storage of frozen poultry. Poultry, though frozen, can be adulterated if good commercial practices are not followed. Some signs of improper work habits of plant personnel and inadequate containers are:

1. Broken packages that do not protect the wholesome product from adulteration.

2. Poultry on the floor exposed to adulteration and abuse.

3. Containers showing signs of employee abuse or mishandling.

THAWING REQUIREMENTS

I. Thawing

A. General requirements

Sometimes it is necessary for establishments to thaw freeze poultry. This is done for many reasons. It might be to sell cut up parts from whole frozen carcasses, to repackage the product into different size containers, etc. If the thawing, handling, repackaging, and temperature requirements are met, the wholesomeness of the product will be protected. Good commercial practices must be used throughout this procedure. To protect the wholesomeness and quality of the product, FSIS provides industry with minimum thawing requirements.

Two thawing requirements are basic, regardless of which type of thawing procedure the establishment chooses to use.

- The poultry must not be allowed to gain moisture over its frozen weight during thawing.

- The poultry's wholesomeness must be protected throughout the thawing process so it does not become adulterated.

The two most common thawing procedures in use involve thawing poultry in water. If either of these methods is used, the inspector must assure that the establishment meets the following requirements.

IF THE WATER IS	THE INSPECTOR SHOULD
Not recirculated during the thawing procedure	• Require the water temperature to be maintained at 70° F. or less • Require a constant water overflow throughout the thawing procedure • Require removal of the water immediately upon completion of poultry thawing • Require the thawed poultry to be continuously drained after thawing and the product temperatures to be maintained at 40° F. or less
Recirculated during the thawing procedure	• Require that water temperature be maintained at 50° F. or less • Require that water be drained from the poultry immediately upon completion of thawing • Require that thawed poultry be continuously drained after thawing and that the product temperature to be maintained at 40° F. or less

B. Once poultry has been thawed it cannot be rechilled in water. To maintain its internal temperature at 40° F. or less, it can be chilled in continuously drained containers with cracked ice. Thawed product must meet all time and temperature requirements for handling, storage, and freezing. Poultry that has been thawed cannot be labeled as “fresh frozen,” “flash frozen,” “quick frozen,” or any other statement indicating rapid change from fresh to frozen—even though it might have been labeled as such prior to thawing.

SUPPLEMENT

Using the module and chilling regulation (381.66) answer the following questions.

PACKING ROOM PROCEDURES EXERCISE

1. Give two approved product-handling procedures after poultry has been in water for the maximum allowed time.

2. Give two approved methods for chilling warm salvaged parts (wings, thighs, split carcasses, etc.)

3. Give one container requirement for ice pack poultry, which relates to water drainage.

4. Describe at least one difference which may be permitted between CO_2 and ice pack containers, and the product moisture limit requirement that must be met before the difference is allowed.

5. Give two requirements that must be met by a plant before it is permitted to package warm (unchilled) poultry.

6. Give the minimum water usage requirements for continuous carcass chillers and giblet chillers as volume per bird (young chickens).

7. Give three common approved methods for thawing frozen poultry and the requirements for each method.

8. Give two approved methods for rechilling previously chilled poultry.

9. Give two requirements for storage of frozen poultry.

10. How does the inspector know when frozen poultry is thawed?

11. Describe in general five pack-out duties of FSIS personnel.

12. Describe the procedure the establishment must follow if the recording thermometer on the continuous chiller breaks.

13. List the requirements specific to continuous carcass chillers when the elevator is stopped with poultry in the chiller.

    a. Less than 15 minutes:

    b. More than 15 minutes:

LABELING

1. What are the mandatory labeling requirements for immediate containers?

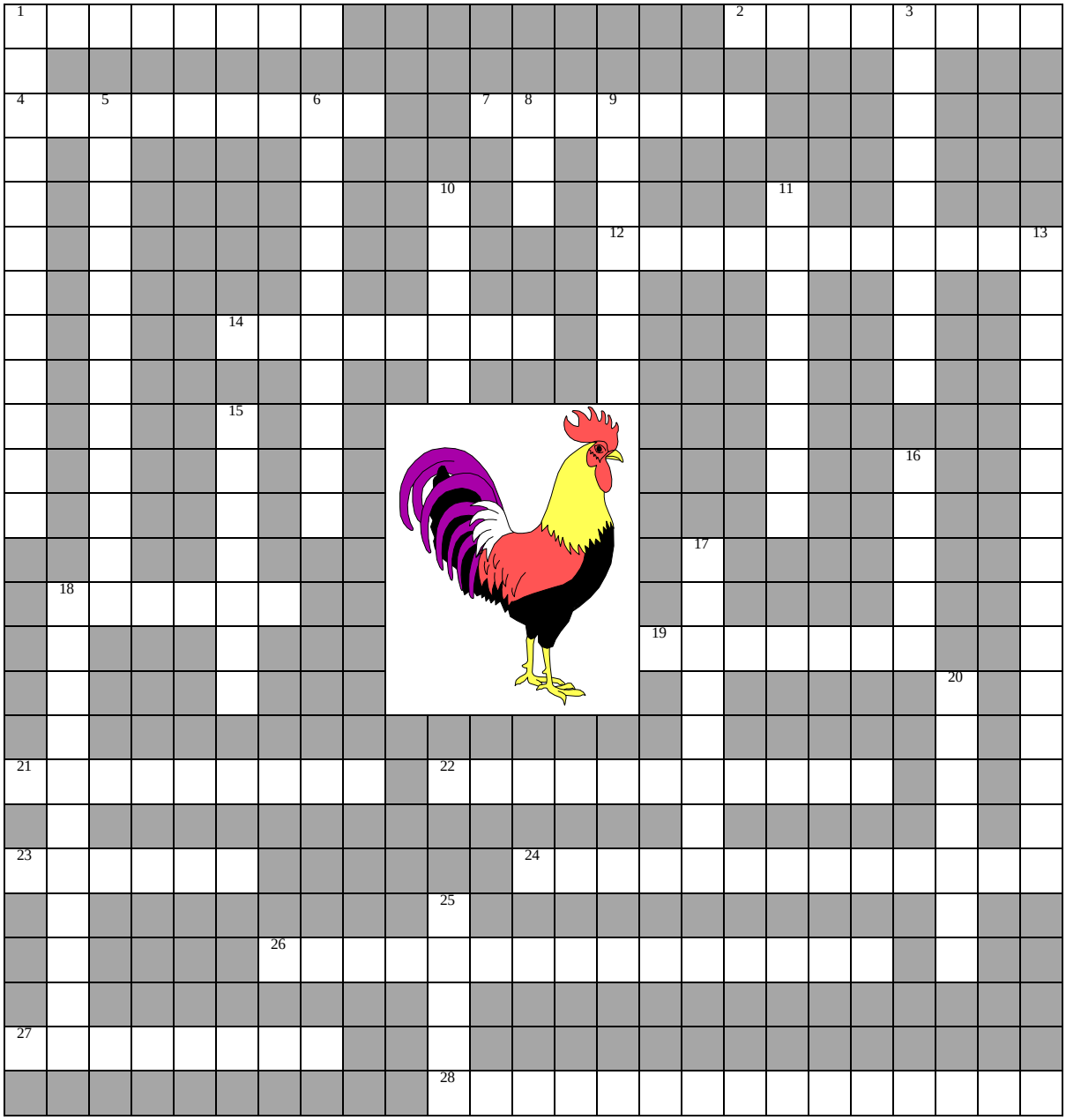
2. What are the mandatory labeling requirements for shipping containers?

3. List the organs considered to be giblets.

Across

1. How long a 3-pounds carcass has to reach 40° F
2. When it stops, agitation in the chiller must stop
4. Type of thermometer required in continuous carcass chillers
7. Number of minutes the chiller can be stopped before it must be chilled to 40° F
12. Used to measure amount of liquid entering chillers (2 words)
14. These type control tests can be completed during pack-out
18. Product with an internal temperature of 0° F is called _____
19. When continuous running tap water is used to thaw product, the water temperature cannot exceed _____ degrees
21. Water in the giblet chiller cannot exceed _____ degrees
22. Type of sanitation monitored during pack-out
23. Pack-out duty can be covered by a USDA _____ or an FSIS inspector.
24. FSIS provides industry with minimum thawing requirements to protect the _____ of the product.
26. Warm salvaged product may be chilled in ice with a _____ (2 words).
27. When poultry is placed in the freezer, its _____ temperature must reach 0° F.
28. Maximum amount of time carcasses may be kept in ice and water (3words)

Down

1. Temperature to which carcasses must be chilled (2 words)
3. When the elevator stops in the chiller, this must also be turned off.
5. Poultry can't stay in this more than 24 hours (2 words).
6. One of the things the pack-out inspector checks
8. Poultry may be rechilled in it.
9. Another thing the pack-out inspector checks
10. Inspection of this is a pack-out duty.
11. Checking this is a requirement of the pack-out inspector.
13. Amount of time allowed poultry to reach 0° F after it enters the freezer (3 words)
15. These must be chilled to 40° F within 2 hours.
16. Re-circulated water used to thaw poultry must be no more than _____ degrees
17. Pack-out is often performed on _____.
18. Poultry entering a freezer within 48 hours of chilling can be labeled this (2 words).
20. The recording thermometer must be put in the _____ part of the carcass chiller.
25. Number of hours carcasses over 8 pounds are allowed to reach 40° F

PACKING ROOM PROCEDURES CROSSWORD PUZZLE