



United States Department of Agriculture

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Food Safety and
Inspection Service

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Ms. Christine Middlemiss
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Dear Ms. Middlemiss,

The Food Safety and Inspection Service (FSIS) conducted an ongoing on-site equivalence verification audit of England's pork products inspection system from September 18 through September 29, 2017. Enclosed is a copy of the final audit report. The comments received from the Government of England are included as an attachment to the report.

FSIS acknowledges that DEFRA has provided documentation to address the findings noted during the on-site audit. FSIS is the process of evaluating your response, and once complete, FSIS will notify you as to whether England's pork products inspection system remains equivalent to that of the United States.

For any questions regarding the FSIS audit report, please contact us at (202) 708-9543, or by electronic mail at internationalcoordination@fsis.usda.gov.

Sincerely,

Todd Furey
Acting International Coordination Executive
Office of International Coordination

Enclosure

FINAL REPORT OF AN AUDIT CONDUCTED IN
ENGLAND

September 18-29, 2017

EVALUATING THE FOOD SAFETY SYSTEMS GOVERNING
RAW PORK PRODUCTS
EXPORTED TO THE UNITED STATES OF AMERICA

May 14, 2018

Food Safety and Inspection Service
United States Department of Agriculture

Executive Summary

This report describes the outcome of an onsite equivalence verification audit conducted by the Food Safety and Inspection Service (FSIS) from September 18-29, 2017. The purpose of the audit was to determine whether England's food safety system governing raw pork products remains equivalent to that of the United States, with the ability to export products that are safe, wholesome, unadulterated, and correctly labeled and packaged. England is eligible to export raw pork products (i.e., primal and sub-primal, boneless manufacturing trimmings, cuts, and edible offal) to the United States.

The audit focused on six system equivalence components: (1) Government Oversight (e.g., Organization and Administration); (2) Government Statutory Authority and Food Safety and Other Consumer Protection Regulations (e.g., Inspection System Operation, Product Standards and Labeling, and Humane Handling); (3) Government Sanitation; (4) Government Hazard Analysis and Critical Control Points (HACCP) System; (5) Government Chemical Residue Testing Programs; and (6) Government Microbiological Testing Programs.

An analysis of each component did not identify any deficiencies that represented an immediate threat to public health. The FSIS auditor identified the following findings:

Government Oversight

- The Central Competent Authority (CCA) uses contract employees to conduct inspection (e.g., ante-mortem inspection, final carcass disposition during post-mortem inspection, and sanitation and HACCP verification activities) during the production of pork product to export to the United States.

Government Statutory Authority and Food Safety and Other Consumer Protection Regulations

- At two of the four audited pork slaughter establishments, inspection personnel did not take appropriate regulatory control actions when carcasses were not presented with their organs or viscera, when carcasses were presented with the wrong organs, or when carcasses were presented with punctured viscera.

During the audit exit meeting, the CCA committed to address the preliminary findings as presented. FSIS will evaluate the adequacy of the CCA's documentation of proposed corrective actions and base future equivalence verification activities on the information provided.

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I. INTRODUCTION

The Food Safety and Inspection Service (FSIS) of the United States Department of Agriculture (USDA) conducted an onsite audit of England's food safety system from September 18-29, 2017. The audit began with an entrance meeting held in London with representatives from the Central Competent Authority (CCA)-the Department for Environment, Food, and Rural Affairs (DEFRA), representatives from the Food Standards Agency (FSA), and the FSIS auditor.

II. AUDIT OBJECTIVE, SCOPE, AND METHODOLOGY

This was a routine ongoing equivalence verification audit. The audit objective was to verify whether the food safety system governing raw pork products remains equivalent to that of the United States, with the ability to export products that are safe, wholesome, unadulterated, and correctly labeled and packaged. The scope of this audit included all aspects of England's meat inspection system for producing and exporting meat products to the United States. England is eligible to export the following raw pork products to the United States: primal and sub-primal, boneless manufacturing trimmings, cuts, and edible offal.

FSIS applied a risk-based procedure that included an analysis of country performance within six equivalence components, product types and volumes, frequency of prior audit-related site visits, point-of-entry (POE) testing results, specific oversight activities of government offices, and testing capacities of laboratories. The review process included an analysis of data collected by FSIS over a three-year period, in addition to information obtained directly from DEFRA through the self-reporting tool (SRT).

Representatives from DEFRA and FSA accompanied the FSIS auditor throughout the entire audit. Determinations concerning program effectiveness focused on performance within the following six components upon which system equivalence is based: (1) Government Oversight (e.g., Organization and Administration); (2) Government Statutory Authority and Food Safety and Other Consumer Protection Regulations (e.g., Inspection System Operation, Product Standards and Labeling, and Humane Handling); (3) Government Sanitation; (4) Government Hazard Analysis and Critical Control Points (HACCP) System; (5) Government Chemical Residue Testing Programs; and (6) Government Microbiological Testing Programs.

The FSIS auditor reviewed administrative functions at the CCA headquarters, FSA headquarters, and five local inspection offices. The FSIS auditor evaluated the implementation of control systems in place that ensure the national system of inspection, verification, and enforcement is being implemented as intended.

Five establishments were selected for the audit from the nine establishments certified as eligible to export to the United States. Four establishments perform pork slaughter and processing operations and the fifth establishment is a cold storage establishment. The raw pork products these establishments produce and export to the United States include primal and sub-primal, boneless manufacturing trimmings, cuts, and edible offal.

During the establishments' visits, the FSIS auditor paid particular attention to the extent to which industry and government interacted to control hazards and prevent noncompliances that impact food safety. The FSIS auditor examined the CCA's ability to provide oversight through supervisory reviews conducted in accordance with FSIS equivalence requirements for foreign inspection systems outlined in Title 9 of the United States Code of Federal Regulations (9 CFR) §327.2.

Additionally, two analytical laboratories were audited to verify their ability to provide adequate technical support to the inspection system and to assess the oversight that DEFRA maintains over their functions: a chemical residue laboratory, Food and Environmental Research Agency (FERA), located in York and a microbiology laboratory, Australian Laboratories Services (ALS), located in Cambridgeshire.

Competent Authority Visits		#	Locations
Competent Authority	Central	1	• DEFRA, London
	Regional	1	• FSA, York
Laboratories		2	<ul style="list-style-type: none"> • FERA, York: residue testing (government to private share is 25% to 75%, respectively) • ALS, Cambridgeshire: microbiology testing (private laboratory)
Pork slaughter and processing establishments		4	<ul style="list-style-type: none"> • Establishment UK2060EC, Karro Food Ltd, Yorkshire • Establishment UK2093EC, Cranswick Country Foods, Hull • Establishment UK4085EC, Tulip Ltd, Dukinfield • Establishment UK5091EC, Daleheads Foods-Dulip Ltd, Lincolnshire
Cold storage facility		1	• Establishment UKXA007, Hull Cold Storage, Hull

The audit was performed to verify whether the country's food safety system met requirements equivalent to those under the specific provisions of United States laws and regulations, in particular:

- The Federal Meat Inspection Act (21 United States Code [U.S.C.] 601, *et seq.*);
- The Humane Methods of Livestock Slaughter Act (7 U.S.C. 1901, *et seq.*); and
- The Food Safety and Inspection Service Regulations for Imported Meat (9 CFR Part 327).

The audit standards applied during the review of England's inspection system for raw pork products included: (1) all applicable legislation originally determined by FSIS as equivalent as part of the initial review process, and (2) any subsequent equivalence determinations that have been made by FSIS under provisions of the World Trade Organization's Sanitary/Phytosanitary Agreement, and includes the following:

- Regulation European Commission (EC) No. 178/2002;
- Regulation (EC) No. 852/2004;

- Regulation (EC) No. 853/2004;
- Regulation (EC) No. 854/2004;
- Regulation (EC) No. 882/ 2004;
- Regulation (EC) No. 2073/2005;
- Regulation (EC) No. 1069/2009;
- Regulation (EC) No. 1099/2009;
- Regulation (EC) No. 142/2011;
- Council Directive 93/119/EC;
- Council Directive 96/22/EC;
- Council Directive 96/23/EC; and
- Council Directive 97/74/EC.

III. BACKGROUND

From January 1, 2014 to May 31, 2017, FSIS import inspectors performed 100 percent reinspection for labeling and certification on 35,215,828 pounds of raw pork products, such as primal and sub-primal, boneless manufacturing trimmings, cuts, and edible offal, exported by England to the United States. Of that amount, additional types of inspection were performed on 6,917,836 pounds at point-of-entry (POE), including testing for residues and *Salmonella*, of which a total of 36,768 pounds were rejected for shipping damage, label verification, and certification. No products were rejected for food safety reasons.

The FSIS audit in May 2014 identified issues pertaining to post-lethality exposed (PLE) ready-to-eat (RTE) products in one establishment. The CCA has delisted that establishment and informed FSIS that England would not export PLE-RTE products to the United States. The 2014 audit also identified issues regarding the assignment of contracted inspection personnel at the establishments certified as eligible to export product to the United States. This issue has not been resolved since 2014 audit and is considered a repeat finding in this audit as discussed in component one of this report.

The FSIS final audit reports for England’s food safety system are available on the FSIS Web site: <http://www.fsis.usda.gov/wps/portal/fsis/topics/international-affairs/importing-products/eligible-countries-products-foreign-establishments/foreign-audit-reports>

IV. COMPONENT ONE: GOVERNMENT OVERSIGHT (E.G., ORGANIZATION AND ADMINISTRATION)

The first of six equivalence components that the FSIS auditor reviewed was Government Oversight. FSIS import regulations require the foreign inspection system to be organized by the national government in such a manner as to provide ultimate control and supervision over all official inspection activities; ensure the uniform enforcement of requisite laws; provide sufficient administrative technical support; and assign competent qualified inspection personnel at establishments where products are prepared for export to the United States.

The evaluation of all six equivalence components included a review and analysis of

documentation previously submitted by the CCA as support for the responses provided in the SRT. The FSIS onsite audit included record reviews, interviews, and observations made by the FSIS auditor. The audited facilities included the CCA's headquarters, one regional office, two laboratories, and five establishments certified as eligible to export to the United States.

DEFRA has overall responsibility for policy development and policy delivery in relation to exports of products of animal origin. DEFRA's Chief Veterinary Officer (CVO) is the global veterinary representative and is responsible for shaping animal health and welfare policy and delivery across England. DEFRA is responsible for international trade of food including food of animal origin and for animal health and welfare. DEFRA has overarching oversight and consults with the devolved administrations in developing policy on animal health, animal welfare, and trade. The animal health policy in England is delivered by executive agencies to DEFRA. These are separate organizations, which act on behalf of DEFRA's Secretary of State for the Environment. They include the FSA, the Animal and Plant Health Agency (APHA), and the Veterinary Medicines Directorate (VMD).

The FSA is the competent authority for food safety. It is responsible for the enforcement of food safety regulation and has the authority and the ability to request corrective actions in establishments exporting to the United States and to take additional enforcement measures as appropriate, if corrective actions are not met. FSA is a non-ministerial government department accountable to the Westminster government in London through the Secretary of State for Health. FSA provides direction and oversight to local food authorities and delivers official controls for food safety in establishments and cold storage facilities as per the Food Law Code of Practice for England. The enforcement actions taken at establishments approved for export to the United States are examined during the regular audits performed at each establishment, and DEFRA is notified of audit results via the FSA Exports Branch in London.

APHA oversees the operational delivery of animal health and welfare inspection as well as the delivery of export certification. APHA provides advice to policy makers and delivers international trade operations for England. The market access team is made up of both DEFRA policy officials and APHA veterinary advisers; they work closely together on negotiations, preparation of export health certification, completion of country risk assessment processes, and collaboration with their delivery partners.

VMD is the competent authority for the Veterinary Residues Surveillance Program in England, which monitors the use of authorized and unauthorized substances in meat products. VMD runs the program in accordance with Council Directive 96/23/EC. This is implemented in England under the Animals and Animal Products (Examination for Residues and Maximum Residue Limits) (England and Scotland) Regulations 2015. VMD holds an annual planning meeting, attended by sample collection agencies, independent experts, and the laboratories to discuss and determine species-specific substances that should be sampled and included in the surveillance plan for the following year. DEFRA has the authority to approve or disapprove laboratories under Regulation (EC) No. 882/2004 to carry out the analysis of samples taken during official controls.

DEFRA, APHA and FSA work in partnership under a Memorandum of Understanding of roles

and responsibilities in England's exports work. DEFRA has assigned FSA the tasks of verifying that the establishments certified as eligible to export product to the United States comply with the FSIS requirements. The FSA recommends to DEFRA whether an establishment is certified eligible to ship products to the United States or should be delisted. Meat establishments other than slaughter operations, which may include cold storage facilities, and meat processing establishments are under local authority control but any establishment exporting to United States also has FSA's oversight.

DEFRA also oversees pesticide residues surveillance for which the competent authority is the Chemicals Regulations Directorate (CRD), an agency of the Health and Safety Executive. CRD ensures safe use of pesticides and delivers pesticides residues surveillance. CRD works closely with FSA to protect consumer interests in relation to food safety and standards. Pesticide residues in food and drink are monitored through an official surveillance program conducted by CRD and overseen by DEFRA's Expert Committee on Pesticide Residues in Food.

The FSIS auditor verified through record reviews and interviews that the FSA outlines the operational policy for the approval of meat establishments to be certified as eligible to export to the United States. The FSA implements these requirements in accordance with Regulation (EC) No. 853/2004 and 882/2004 for approving meat establishments for export to the United States. Regulation (EC) No. 853/2004 requires approval from the competent authority for food business establishments that handle food of animal origin. Regulation (EC) No. 882/2004 provides official controls for animal health and animal welfare, and sets out the approach that competent authorities of member states (MS) must adopt for official controls.

The European Union (EU) regulations are implemented by the Official Feed and Food Controls Regulations 2009, No. 3255. Regulation (EC) No. 178/2002 requires the MS to enforce food law by monitoring and verifying that food laws are fulfilled by food business operators at all stages of production, processing, and distribution. Additionally, the MS are required to maintain a system of official controls covering all stages of production, processing, and distribution, and must have rules on measures and penalties applicable when food laws are not followed. Regarding exports to countries outside the EU, Regulation (EC) No. 178/2002, Article 12 requires that food exported from the EU must comply with the requirements of food law or with the laws, regulations, and other legal and administrative procedures of the importing country.

The DEFRA and FSA exports branch maintain a Required Methods of Operation Procedures (RMOP) and Verification Document under Article 12 of Regulation (EC) No. 178/2002, which all establishments certified for export to the United States have to meet. This sets out how compliance will be achieved and what enforcement measures will be used if corrective actions are not taken in the case of a noncompliance. In addition, the main reference document for officials responsible for administering the inspection system for meat products in England is the FSA's Manual for Official Controls (MOC). Enforcement action is carried out in accordance with Chapter 7 of the MOC. Additionally, FSA has guidance for industry called the Meat Industry Guide (MIG). The MIG contains an interpretation of the EU regulations and extensive, detailed guidance on how industry may achieve effective compliance with the legislative requirements.

The FSIS auditor verified that records associated with meat intended for export to the United States is certified by FSA Official Veterinarian (OV). If the meat is not produced, stored, and transported in compliance with the FSIS requirements, the certifying OV will not issue and sign the Internal Movement Certificate, the Support Health Attestation, or the final Export Health Certificate. The ultimate sanction for noncompliance with export requirements would be de-certification of the establishment's ability to export. For establishments certified as eligible to export pork products to the United States, this would be preceded by the issuance of a Notice of Intention to Delist and an increase in the frequency of inspection and audits.

Through records review and direct observation, the FSIS auditor verified that establishments certified as eligible to export pork products to the United States are under FSA supervision and the onsite OV maintains records reflecting issues identified regarding noncompliance with food hygiene legislation. Remedial Action notices are used if there is no immediate risk for public health or animal welfare and the OV and establishments agree on a completion date. If there is an immediate risk to public health or animal welfare, the OV requires that corrective actions are taken immediately and enforcement is carried out by issuing a Hygiene Improvement Notice as required in Chapter 7 of the MOC. The formal notice will remain in place until adequate corrective action is taken.

If the FSIS requirements are not met, the Official Veterinarian appointed on behalf of DEFRA as the competent authority, will refuse to issue and sign the export health certificate, and increase the frequency of inspections, audits, and supervision to ensure that corrective and preventive actions have been taken. DEFRA has the authority to suspend and delist an establishment's approval to export to the United States. There are also penalties for violations of EU food hygiene legislation, including fines.

The CCA designates official control laboratories (OCLs) that are assessed and accredited in accordance with the International Organization of Standardization (ISO) 17025 on "*General requirements for the competence of testing and calibration laboratories*" and ISO 17011 on "*Conformity Assessment-General requirements for accreditation bodies accrediting conformity assessment bodies.*"

The FSIS auditor verified through records review and interviews that establishments eligible to export raw pork to the United States are utilizing laboratories that are accredited by the United Kingdom Accreditation Service (UKAS) and the analytical methods used are acceptable by FSIS as listed in the Microbiology Laboratory Guidebook, unless the EU method is recognized as equivalent. This is also verified by the FSA Field Veterinary Leader and audited by the FSA Veterinary Auditor. Any unsatisfactory laboratory results as reported to the OV by the laboratory is investigated, followed up, and enforced as described in the RMOP.

The FSIS auditor verified that the competent authority ensures that adequate administrative and technical support is available to certified establishments and laboratories performing food safety testing. DEFRA has overall responsibility for organizing and carrying out official controls and is assisted by the National Reference Laboratories, the OCLs and a number of independent third party laboratories to which specific control tasks have been delegated under Regulation (EC) No. 882/2004. The EC has created a network of EU Reference Laboratories to provide technical and

scientific support for the official controls framework.

The FSIS auditor observed that pork products destined for export to the United States are packaged, labeled, and stored properly under sanitary conditions. DEFRA and FSA maintain a statutory definition of an adulterated product in line with Regulation (EC) No. 1069/2009 and Regulation (EC) No. 142/2011, for adulterated meat. Regulation (EC) No. 178/2002, Article 18 outlines the responsibilities of industry when placing food on the market, and these include traceability must be established at all stages of production, processing and distribution, based on requirements in Regulation (EC) No. 178/2002.

The FSIS auditor verified through records review that DEFRA ensures and verifies that the source of raw pork products in the establishments certified as eligible to export product to the United States originates only from domestic livestock in England. The FSIS auditor verified that animals arriving to certified slaughter establishments are correctly identified and have the relevant food chain information from the farm. FSA uses this information for traceability and has the authority to recall any material exported to any country. Notification about incidents requiring product recall is sent to the EU Rapid Alert System for Food and Feed database.

The FSIS auditor verified that the FSA Field Veterinary Leader carries out the initial approval of the certified establishments and the FSA Veterinary Auditor carries out the regularly monthly or quarterly audits. The approval audit focuses on establishment structures, establishment monitoring and verification procedures, establishment documentation, and implementation of appropriate corrective action, and inspection verification procedures. If the initial approval inspection is satisfactory, the Field Veterinary Leader will issue a recommendation to the FSA Export Veterinary Lead of Exports Branch, which will then inform DEFRA, who communicates its decisions with FSIS. At a minimum, all establishments wanting to export product have to comply with Regulation (EC) No. 178/2002 and export requirements established by the authorities of the importing country.

FSA has a dedicated team of skilled and trained veterinary auditors carrying out audits in England. This team is separate from inspection personnel that carry out routine official controls and inspections. Audit reports for certified establishments in England are produced by the FSA Veterinary Auditor and reviewed by the FSA Exports Branch before being reported to DEFRA. DEFRA works in close association with the FSA Exports Branch to provide the necessary guidance to the inspection personnel as well as the operators to ensure compliance. The RMOP lists and describes the special conditions of certified establishments would have to meet and demonstrate for export to the United States, including regulatory requirements, verification methodology, and enforcement tools to ensure compliance with the FSIS requirements.

The FSIS auditor verified by records review that DEFRA ensures that veterinarians and inspectors have appropriate educational credentials, adequate training, and appropriate experience to carry out their inspection tasks. Only those inspectors that have undergone training and passed an examination are eligible for employment. To be appointed as an OV, an applicant must possess a recognized veterinary degree and undergo competency assessment through regular audits. All veterinarians and meat hygiene inspectors must undergo specific training before they are hired for meat hygiene work. All veterinarians and inspectors are then

specifically trained in FSIS import requirements.

The FSIS auditor verified that DEFRA and FSA ensure that the inspection staffing plan provides continuous government inspection at least once per shift and on the line during all slaughter operations in establishments certified as eligible to export pork products to the United States. The government meat inspection staff consists of both direct-hire by the government and contracted personnel. The contracted supervising veterinarian has overall responsibility for ensuring staffing requirements in slaughter establishments are met and that processing establishments have the required number of inspection personnel to conduct once per shift inspection activities. There is a procedure in place to provide inspection coverage in certified establishments due to planned or unplanned absences of inspection personnel. The MOC states that the speed of the slaughter line and the number of inspection staff present must ensure proper inspection is completed and records maintained. In addition, the RMOP lists the special conditions that certified establishments would have to meet for export to the United States.

The inspection system is funded by public funds through an annual budget from the central government. However, the FSA is a net-running-cost agency and the costs for inspection are recovered from the operators of the approved establishments. The charges are explained in the FSA “*Charge for the Delivery of Official Controls in Approved Meat Establishments*” documents. Regulation (EC) No. 882/2004, Articles 26-28 state that member states shall ensure that adequate financial resources are available to provide the necessary staff and other resources for official controls by whatever means considered appropriate, including through general taxation or by establishing fees or charges for routine or additional expenses that may come as result of additional official control. The regulation also requires EU member states to ensure that staff carrying out official controls is free from any conflict of interest. The onsite audit identified the following finding:

- The CCA uses contracted employees to conduct inspection (e.g., ante-mortem inspection, final carcass disposition during post-mortem inspection, and sanitation and HACCP verification activities) during the production of product for export to the United States. The government and contract inspection personnel routinely rotate inspection activity on post-mortem inspection stations (head, viscera, and final carcass inspection), and there was no system in place to ensure that only government inspection personnel accomplish final carcass inspection. These non-governmental inspection personnel are not under the direct supervision of a government employee who is physically present in the establishment whenever slaughter of source materials for use in processed product intended for export to the United States occurs.

While the CCA maintains many of the administrative and technical elements to operate its inspection system, the use of contracted employees to conduct ante-mortem inspection, final carcass disposition during post-mortem inspection, sanitation, and HACCP verification activities when establishments are producing products for the United States does not meet FSIS’ statutory requirements. Furthermore, the current level of oversight provided by the DEFRA and FSA to the contracted personnel conducting post-mortem inspection is not sufficient.

V. COMPONENT TWO: GOVERNMENT STATUTORY AUTHORITY AND FOOD SAFETY AND OTHER CONSUMER PROTECTION REGULATIONS (E.G., INSPECTION SYSTEM OPERATION, PRODUCT STANDARDS AND LABELING, AND HUMANE HANDLING)

The second of six equivalence components that the FSIS auditor reviewed was Government Statutory Authority and Food Safety and Other Consumer Protection Regulations. The system is to provide for humane handling and slaughter of livestock; ante-mortem inspection of animals; post-mortem inspection of carcasses and parts; controls over condemned materials; controls over establishment construction, facilities, and equipment; inspection at least once per shift during processing operations and on-line inspection during slaughter operations, and periodic supervisory visits to official establishments.

The FSIS auditor verified that DEFRA ensures that animals are handled and slaughtered humanely. DEFRA maintains written requirements to provide for the humane treatment of livestock at slaughter facilities and ensures that establishments are employing requirements for humane handling and slaughter of livestock. The written requirements ensure that animals present within the facility are handled humanely prior to slaughter in a manner consistent with 9 CFR 313.2, as required by Chapter II, Article 3.1 of Regulation (EC) No. 1099/2009, and in accordance with the MOC, Chapter 2.2.

Any breaches of the animal welfare regulations are reported on the FSA animal welfare verification document held at each slaughterhouse and FSA enforcement system database. The MOCs directs veterinarians in England's slaughterhouses to verify compliance with the Regulations (EC) No. 1099/2009. This regulation has been transferred into the England's Welfare Regulation No. 1782. The OV verifies compliance with relevant EU and domestic legislation on animal welfare prior to and during slaughter and taking proportionate enforcement action where necessary. The MOC addresses the animal welfare assessment database as the verification program for animal welfare in slaughterhouses. It is used to confirm daily compliance with legislative animal welfare requirements. The daily welfare input screen requires a declaration to say whether there have been any noncompliance issues each day. Where animal welfare complies with all aspects of the legislation, there will be no entries on the animal welfare assessment database, other than confirmation at the first screen that there are no noncompliances to record. Data from the database is shared with DEFRA on a monthly basis.

The FSIS auditor verified through document reviews, interviews, and observation that the animal welfare assessment reports are routinely completed when slaughter is carried out on the premises and maintained at each establishment as specific record of duties performed. Establishment personnel carry out regular checks to ensure that swine are stunned effectively and rendered unconscious immediately using a carbon dioxide gas chamber of 90 percent concentration. The FSA inspection personnel at each establishment routinely monitor the implementation of humane handling and animal welfare regulations. The OV has overall responsibility to ensure compliance with FSIS regulations and EU legislation and take enforcement action where necessary as detailed in the MOC.

The FSIS auditor verified that the competent authority ensures that official inspectors and veterinarians in establishments certified as eligible to export pork products to the United States perform ante-mortem inspection of livestock prior to slaughter. Ante-mortem inspection activities are performed by official inspection personnel in which all animals are subjected to ante-mortem inspection, in accordance with the requirements of Regulation (EC) No. 854/2004, regardless of whether they are intended for export to the United States. During ante-mortem inspection the OV observes each animal moving and at rest sufficient to identify animals showing neurological symptoms, change in gait, or external abnormalities. The MOC states that animals must receive ante-mortem inspection no more than 24 hours prior to slaughter and within 24 hours of arrival at the slaughterhouse. It also details the requirements for dealing with suspect animals. Suspect animals are to undergo detailed ante-mortem examination in order for the OV to make a decision whether the animal is fit for slaughter for human consumption.

The FSIS auditor observed that all audited pork slaughter establishments have designated isolation pens suitable for suspect hogs per Regulation (EC) No. 854/2004. Any pathological conditions that would affect fitness for human consumption are reflected in the food chain information and ante-mortem inspection records. Animals that might contain residues of veterinary medicinal products in excess of the levels allowed or residues of forbidden substances are to be sampled in accordance with the Regulation (EC) No. 854/2004. There is a positive release system in operation at each slaughter establishment, signed by an OV, so that no animal can proceed for slaughter until satisfactory ante-mortem inspection is completed.

The FSIS auditor verified through document reviews and observations that DEFRA and FSA ensure that official inspection personnel in establishments certified as eligible to export pork products to the United States perform continuous post-mortem inspection of swine carcasses. DEFRA and FSA requires inspection personnel to perform post-mortem inspection and further processing of carcasses and parts at the time of slaughter at all slaughter establishments. A team of official inspectors (government inspection personnel and contract inspection personnel) and veterinarians conducts post-mortem procedures.

The purpose of post-mortem inspection and procedures are detailed in the MOC, Chapter 2.4 and specific requirements for all species are listed in Regulation (EC) No. 854/2004, Annex I, Section IV. Post-mortem inspection takes into account ante-mortem inspection results and takes place immediately after slaughter; and includes carcasses and accompanying offal. Official inspectors carry out post-mortem inspection under the direct responsibility of OVs who verify their performance as set out in the MOC, Chapter 2.4, Section 2. Staff duties for official inspectors and veterinarians are described in the MOC, Chapter 2.4 and specific requirements for all species are listed in Regulation (EC) No. 854/2004. Swine heads, viscera, and offal (lungs, liver, and heart) of all ages undergo manual inspection procedures (palpation and/or incision) and carcasses undergo manual inspection procedures. Post-mortem inspection results are recorded on the verification electronic form, which may be printed out and completed manually when undertaking the post-mortem verification checks then recorded online, on a daily basis.

The FSIS auditor verified through observation that designated inspection positions (head, viscera, organs, carcass, and rework stations) are posted along the slaughter lines have sufficient lighting to perform post-mortem inspection tasks without hindrance. All establishments certified

as eligible to export product to the United States and those approved under EU Regulation Nos. 852/2004 and 853/2004 are required to provide inspection personnel with appropriate facilities. All establishments have staff changing facilities, equipment sterilizers, and hand washing facilities, and the flow of staff or product is set up to avoid cross contamination.

FSA has written procedures to address condemnation of the entire animal, when adulterated, to preclude it from human consumption. Portions of carcasses, which are not passed for human consumption (inedible), are considered animal by-products (ABP) and are classed as categories 1, 2, or 3 as described in Regulation (EC) Nos. 1069/2009 and 142/2011. In the audited pork slaughter establishments, detained carcasses are rectified on the rectification station by FSA meat inspectors. Color-coded plastic hook tags are used to identify and retain carcasses with pathology, contamination, or other concerns for trimming or required action as detailed in Chapter 7 of the MOC's enforcement provisions.

The FSIS auditor assessed whether certified establishments are maintaining correlation between the carcass, viscera, and offal during post-mortem inspection as part of the approval process, application of mark-of-inspection, and FSIS requirements for exports to the United States (9-CFR 310.2 and 310.3). The FSIS auditor observed the following finding:

- At two of the four audited pork slaughter establishments, inspection personnel did not take appropriate regulatory control action when carcasses were not presented with their organs or viscera, when carcasses were presented with the wrong organs, or when carcasses were presented with punctured viscera. The inspection personnel did not follow the government's MOC Section 2.5.3 which states "...meat may be declared unfit for human consumption if it derives from animals the offal of which has not undergone post-mortem inspection." At one of the slaughter establishments, one carcass was presented without its liver and right lobe of the lung. The other half of the lung and heart were adhered to the thoracic cavity. This carcass was later released for human consumption by the rectification station meat inspector without the benefit of inspecting its liver and lungs lymph nodes (bronchial & mediastinal). Section 2.1.8 of the MOC does not list this condition as "common" for the meat inspector to make a disposition without consulting the OV.

The FSIS auditor verified through document review that FSA has a representative who makes periodic supervisory visits to establishments certified as eligible to export product to the United States by veterinary auditor. The establishments are initially inspected monthly and, if consistent compliance is demonstrated, the audits are then carried out quarterly and kept under review. This process is governed by service level agreement between DEFRA, APHA, and the FSA Exports Branch. All establishments eligible to export pork to the United States are subject to a risk-based frequency of audit. The audit risk assessment scheme determining frequency applies the requirements of Regulation (EC) No. 854/2004, Article 4.

Supervisory visits to the establishment are also required to confirm satisfactory performance by the OV and implementation of appropriate corrective action by the establishment management. After each visit, a report is required to be completed assessing establishment's compliance with FSIS requirements and standards. Topics of report assessments include but are not limited to ante-mortem inspection; post-mortem inspection; official controls over establishment construction, facilities, and equipment; direct and continuous official inspection of slaughtering

and preparation of product; requirements for sanitation; official controls over condemned material; and Sanitation Standard Operating Procedures (Sanitation SOPs) and HACCP verification activities. A copy of the audit report is shared with the veterinary adviser in DEFRA for assessment.

The FSIS auditor verified through document reviews and observation that DEFRA and FSA maintains complete separation of establishments certified to export raw pork products to the United States from those that are not certified to export by keeping separate identification and listing for each. Certified establishments are subject to specific checks to ensure there is spatial or temporal separation throughout slaughtering and processing when producing for export to the United States as specified in the RMOP and the FSA Verification Procedures document.

FSA official veterinarians routinely verify compliance with both the EU and United States requirements on a daily basis. FSA official veterinarians and inspection personnel continuously perform inspection tasks and monitor production and review of the related documentation such as Internal Movement Certificate and Support Health Attestation to ensure that the meat exported to the United States originates from animals slaughtered in establishments certified as eligible to export product to the United States. DEFRA and FSA also ensure that establishments have documented standard operating procedures for segregating raw pork products eligible to export to the United States from other products in appropriately marked areas.

The FSIS auditor verified that the competent authority has control over condemned animals and inedible material until destroyed or otherwise denatured. Reasons for declaring pork meat is unfit for human consumption at post-mortem are outlined in MOC, Chapter 2.4, Section 2.5. Meat may be declared unfit for human consumption if it is derived from animals that have not undergone ante-mortem inspection or derived from animals the offal of that has not undergone post-mortem inspection under Regulation (EC) Nos. 853/2004 or 854/2004. Animals that are judged unfit for human consumption are classed as ABPs, treated as such in accordance with EU legislation, and reflected in the MOC, Chapter 2.8.

The FSIS auditor verified through observation and interviews that all receptacles containing adulterated product bear a label to indicate what type of adulterated product they contain, as detailed in the MOC, Chapter 2.8. Where containers are used for collection within the processing area and transfer to storage containers, the certified establishment ensured that ABP bins are used only for the correct category of ABP, and not used for material intended for human consumption. FSA inspection personnel are responsible for enforcement within all certified establishments, acting on behalf of DEFRA.

The FSIS auditor's analysis and onsite verification activities indicate that the DEFRA and FSA post-mortem inspection procedures and official regulatory control actions in two of the four audited pork slaughter establishments were not consistent with England's meat inspection system or FSIS requirements, because the organs and meat of individual carcasses did not move together through inspection.

VI. COMPONENT THREE: GOVERNMENT SANITATION

The third of six equivalence components that the FSIS auditor reviewed was Government Sanitation. The FSIS auditor verified that the CCA requires each official establishment to develop, implement, and maintain written standard operating procedures to prevent direct product contamination or insanitary conditions.

The FSIS auditor verified that the competent authority ensured that each certified establishments operates in a sanitary manner. The OV onsite verifies that the establishment implements sanitary dressing procedures throughout the slaughter process on a daily basis. The MOC provides guidance to inspection personnel on official control procedures for slaughter hygiene verification and ongoing assessment of the establishment's compliance with food hygiene requirements from acceptance of the animals for slaughter through carcass dressing and chilling. Official Veterinarians and meat inspectors ensure that carcasses with visible fecal contamination are quarantined and rectified before entering the chiller, verifying an establishment's ability to maintain process control and compliance with Regulation (EC) Nos. 852/2004 and 178/2002. The slaughter hygiene verification system monitors contamination at final inspection as a key point to satisfy FSA regulatory requirements and focuses on the need for establishment to take the necessary actions to correct and prevent recurrence.

The FSIS auditor verified that the certified establishments' construction, facilities, and equipment are designed to prevent the contamination or adulteration of raw pork destined for export to the United States. The FSA inspection system has official controls over establishment construction, facilities, and equipment. DEFRA and FSA have the authority to not approve establishments if deficiencies are identified; however, conditional approval may be granted but subject to meeting all requirements within a specified time. Government veterinarians grant approval only after an assessment of the construction, facilities, and equipment.

FSA has the authority to take formal enforcement action to direct an establishment to rectify both hygiene and structural deficiencies. FSA requires a facility to be of sound construction prior to issuing approval to operate as a meat establishment. The FSA official veterinarian and inspection team onsite ensure that the establishment maintains the facility in good functioning order as part of the daily inspection of hygiene by performing regular audits and recording any noncompliances in the enforcement program.

The FSIS auditor verified that the DEFRA and FSA ensure that each certified establishment develops, implements, and maintains daily pre-operational and operational sanitation procedures sufficient to prevent the direct contamination or adulteration of raw pork products. DEFRA and FSA requires and routinely verifies that all food contact surfaces and nonfood contact surfaces of facilities, equipment, and utensils be cleaned and sanitized as frequently as necessary to prevent product adulteration. This is checked daily by the establishments and verified by the FSA inspection team onsite and FSA routine audits.

The establishment is required to have Sanitation Performance Standards for non-food contact surfaces and Sanitation SOPs for food contact surfaces. Continued compliance with the Sanitation SOP requirements is part of the approval process and for the establishment to be able

to continue exporting to the United States. This is checked at the time the establishment is approved for export to the United States and on a regular basis thereafter during daily inspection by the OV and the monthly/quarterly audits by the veterinary auditor. The RMOP requires establishments to have a written Sanitation SOPs that identify areas of risk of direct product contamination; identify the cleaning procedure, including frequency and accountability for cleaning; and identify corrective actions to be taken. Corrective actions must address the noncompliance, restore sanitary conditions as soon as possible, and avoid a repetition of the noncompliance. Establishments' level of compliance and trends are analyzed along with their most recent audit scores by FSA in relation to hygienic production, environmental hygiene, prerequisites, and HACCP. These establishments are given the opportunity to work with DEFRA and FSA to implement actions to raise their levels of compliance and bring standards to acceptable levels.

All establishments operating under EU legislation have a food safety management system to avoid insanitary conditions. Verifying establishments maintain these systems is part of the daily routine inspection duties of the FSA official inspection team in line with the MOC, Chapter 2.8. The RMOP and FSA verification procedures reinforce these duties in establishments certified to export to the United States. DEFRA and FSA routinely verify the adequacy of establishments' written records showing the design of Sanitation SOPs, including all procedures necessary to prevent direct contamination or adulteration of product, the implementation of Sanitation SOPs, and corrective actions taken in response to deficiencies.

The DEFRA and FSA verifies that each official establishment routinely evaluates and maintains the effectiveness of its Sanitation SOP procedures. Chapter 7 of the MOC describes various enforcement tools used which range from informal to formal action: Hygiene Improvement Notices, Remedial Action Notices, Hygiene Emergency Prohibition Notices, and Hygiene Emergency Prohibition Orders. In establishments exporting to the United States, the Notice of Intention to Delist is also used, if necessary.

The FSIS auditor's analysis and onsite verification activities indicate that the meat inspection system of England requires that all certified establishments develop, implement, and maintain sanitation programs, including Sanitation SOPs, to prevent the creation of insanitary conditions and direct product contamination.

VII. COMPONENT FOUR: GOVERNMENT HAZARD ANALYSIS AND CRITICAL CONTROL POINTS (HACCP) SYSTEM

The fourth of six equivalence components that the FSIS auditor reviewed was Government HACCP System. The inspection system is to require that each official establishment develop, implement, and maintain a HACCP system. The FSIS auditor reviewed the HACCP plans and associated verification records generated by the inspection personnel and observed the actual verification activities conducted by the inspection personnel.

The FSIS auditor verified that DEFRA and FSA requires that each establishment exporting to the United States develop, implement, and maintain a HACCP plan. The DEFRA and FSA, HACCP requirement is outlined in the MOC, Chapter 4, Section 2. The FSA veterinarian audits

establishments' HACCP plans during routine compliance audits and the in-plant OV is required to conduct audits to verify that establishments are applying HACCP-based procedures continuously and properly.

The MIG contains information for industry on the application of HACCP-based principles to comply with the legal requirements. The RMOP and FSA verification procedures reinforce these requirements in slaughter establishments certified to export pork products to the United States. The HACCP plans for these establishments specifically address carcass contamination with fecal material, ingesta, or milk as a biological hazard. A critical control point (CCP) of zero tolerance with 100 percent carcass-by-carcass monitoring controls these biological hazards. DEFRA and FSA's official veterinarian performs required hands-on verification activities for zero tolerance once per shift during the production of pork products intended to export to the United States. When noncompliances are observed during zero tolerance checks, establishment employees stop the inspection line and notify official inspection personnel for rectification.

The FSIS auditor verified through document review and observation that the product process flow in the HACCP systems of the audited establishments accurately reflects the process steps listed in hazard analysis documents. This is a requirement by FSA and DEFRA as detailed in Chapter 4, Part 2 of the MOC. In addition, Chapter 1, Part 3 of the MIG provides comprehensive information on this for establishments' guidance. FSA and DEFRA requires and routinely verifies that establishments are monitoring and keeping adequate records for each of the prerequisite programs via part of the regular checks that the OVs undertake during daily inspection and the veterinary auditors at the time of their regular audits. FSA and DEFRA require and routinely verifies that the CCPs put in place by the establishment will prevent, eliminate, or reduce to acceptable levels the hazards identified. The MOC, Chapter 4, Sections 2 and 4 explain the requirements for auditing HACCP-based procedures.

The FSIS auditor verified through records review and interviews that OVs are performing and documenting daily verification task, that consist of reviewing the establishments' pre-shipment records for signatures and times, and HACCP monitoring records with actual times, temperatures, or other quantifiable values, before certification of each lot intended for export to the United States. These records are maintained for 2 years.

The FSIS auditor's analysis and onsite verification activities indicate that DEFRA and FSA require operators of establishments certified to export to the United States to develop, implement, and maintain HACCP programs for each processing category.

VIII. COMPONENT FIVE: GOVERNMENT CHEMICAL RESIDUE TESTING PROGRAMS

The fifth of six equivalence components that the FSIS auditor reviewed was Government Chemical Residue Testing Programs. The inspection system is to present a chemical residue-testing program, organized and administered by the national government, which includes random sampling of internal organs, fat, and muscle of carcasses for chemical residues identified by the exporting country's meat inspection authorities or by FSIS as potential contaminants. There have not been any chemical residue testing POE violations since last audit.

The FSIS auditor verified that England's inspection system has a national residue control program, which is managed by a central unit, to carry out effective regulatory activities to prevent contamination of food products with chemical residues. There are two types of schemes: a surveillance scheme and a suspect sampling scheme. The annual Veterinary Residues Surveillance Program analyzes samples from food producing animals and their products for residues of veterinary medicines and environmental contaminants. The EC's Food and Veterinary Office (FVO, now called the Health and Food Audits and Analysis Directorate) generates an audit report and recommendations.

VMD is the competent authority for the Veterinary Residues Surveillance program, which monitors the use of authorized and unauthorized substances in products. VMD implements the veterinary residues surveillance program. The FSA and APHA collect the samples for raw pork and FERA tests them. VMD runs the veterinary residues surveillance program in accordance with the Animals and Animal Products (Examination of Residues and Maximum Limits) (England and Scotland) Regulations 2015 SI No. 787 and implements the Requirements of Council Directive 96/22/EC and 96/23/EC. The Directives require targeted sampling for veterinary residues by Member States. They lay down the frequency of sampling required for substances. Council Directive 96/22/EC prohibits the use of substances having a hormonal or thyrostatic action, and beta-agonists for growth promotion purposes in livestock farming.

The veterinary residue surveillance program does not control, but monitors the exposure to industrial and environmental chemicals, including plant protection products (mainly pesticides). Under the program, heavy metals (cadmium and lead), mycotoxins (aflatoxin), organochlorines, and organophosphates are monitored. Commission Regulation (EU) No. 1881/2006 establishes maximum permitted levels of contaminants, including environmental contaminants, in food. There are limits for cadmium and lead, as well as dioxins and polychlorinated biphenyls. DEFRA works closely with the CRD, which is responsible for policy on pesticides and monitors pesticides to protect consumer interests in relation to food safety and standards. Pesticide residues in food and drink are monitored through an official surveillance program conducted by CRD and overseen by an expert committee Pesticide Residues in Food.

The annual residue sampling and testing plan is determined by Directive 96/23/EC, which sets out the substances to be tested, numbers, and species to be sampled. Samples are collected throughout the calendar year. VMD holds an annual planning meeting attended by sample collection agencies, independent experts, and the laboratories. Specific species and substances that should be sampled are discussed at this meeting and if agreed included in the plan for the following year.

DEFRA has the authority and capability to regulate veterinary medicines and veterinary biologicals, alone, or in coordination with other agencies. The process and controls in place in respect of veterinary medicinal products are applicable to all member states of the EU and these are set in EU legislation. The authorization of veterinary medicinal products is governed by Directive 2004/28/EC and by Directive 2009/9/EC.

Procedures of residue samples collected in slaughter establishments are contained in the MOC, Chapter 5, Section 2. Blood, urine and feed samples are taken on-farm by APHA officers and

the majority of these are tested for prohibited substances, particularly those with growth promoting properties. DEFRA has compiled the results from the 2016 sampling plan “Residues of veterinary medicines in food: 2016.”

The FSIS auditor verified through document reviews and interviews that the FSA residue program provides for enforcement actions to be taken when positive or violative results occur. An investigation is undertaken for all non-compliant samples, and in the majority of cases advice is provided to the farmer to avoid a re-occurrence in the future. If a farmer is in receipt of a single farm payment and has used an unauthorized/prohibited substance or is in breach of an MRL, he can be financially penalized. In more serious cases of unauthorized/ prohibited substances violations, the animals can be destroyed without any compensation to the farmer. In the most severe cases, enforcement notices can be issued leading to a criminal prosecution.

The FSIS auditor verified through document reviews and interviews that the analytical methods used are those validated in accordance with Commission Decision 2002/657/EC based on guidance from the EC. The laboratory that carries out chemical residue testing for England is FERA, which is an NRL. FERA is the government OCL contracted by VMD to undertake the Veterinary Residues Surveillance Program in England and has UKAS accreditation for ISO/17025 and ISO/17011 in the specific area of residues of pesticides, organic contaminants, anabolic steroids, veterinary medicines, and metals.

Procedures for taking samples (kidneys/liver/spleen, blood, serum) at slaughter establishment by FSA officers are detailed in the MOC, Chapter 5, Part 1, Section 2. Procedures that address collection and packaging of the tissue sample to prevent contamination and deterioration during shipment (sample integrity) to the FERA laboratory are detailed in the MOC, Chapter 5, Section 2. DEFRA also has written procedures addressing the disposition of animals suspected to be affected by drug residues in the MOC Chapter 2.4, Section 2. Meat from such animals is deemed unfit for human consumption and must be disposed of as an ABP.

The FSIS auditor performed an onsite audit of the FERA laboratory, reviewed the latest accreditation by UKAS on April 1, 2016, and found no issues. The FSIS auditor verified through document reviews and interviews that DEFRA has ensured that collection and analyses of tissue samples is conducted in accordance with standard protocols that meet the FSIS criteria. The FSIS auditor’s review concluded that the laboratory conditions, records generated, and the results of past UKAS audits met ISO 17025 standards. Additionally, the residue laboratory demonstrated the ability to produce timely and accurate data. The FSIS auditor concluded that laboratory personnel are qualified, adequately trained, subject to proficiency testing, and capable of conducting assigned analytical methods.

The FSIS auditor concluded that England’s meat inspection system has regulatory requirements for a chemical residue-testing program that is administered nationally by DEFRA.

IX. COMPONENT SIX: GOVERNMENT MICROBIOLOGICAL TESTING PROGRAMS

The sixth of six equivalence components that the FSIS auditor reviewed was Government Microbiological Testing Programs. The system is to implement certain sampling and testing programs to ensure that raw pork products produced for export to the United States are safe and wholesome. There have not been any POE violations related to this component since the last FSIS audit.

The FSIS auditor verified the implementation of control measures for relevant pathogens in pork slaughter establishments certified to export to the United States. Establishments comply with the microbiological sampling requirements, laid down in Regulation (EC) No. 2073/2005 to assess the safety of meat products and show that the production processes are working properly. The following sanitary measures were determined to be equivalent: *Enterobacteriaceae* and Total Viable Count in lieu of generic *E. coli*; the use of an alternative laboratory testing method ISO 6579 for *Salmonella*; the use of private laboratories to analyze samples for *Salmonella*; and the use of establishment employees to collect samples for *Salmonella* because of the adequate CCA oversight of all these activities.

The FSIS auditor verified document reviews and interviews that DEFRA maintains a written sampling plan detailing instructions for sample collection and sample processing for verification purposes. Procedures for samples collection, packaging, and shipping to the laboratory are detailed in Chapter 13 of the MIG. The sample bag is labeled with the date of sampling, species, and origin of animal. Sponge samples are kept cool and delivered to the laboratory within two hours or placed into an insulated cool-box so that sample testing commence within 24 hours of sample collection. The ISO 17604 requirements for storage and transport of samples to ensure integrity and ‘continuity of evidence’ are followed. The FSA official veterinarian in certified establishments verifies compliance with the microbiological sampling requirements according to the MOC.

The FSIS auditor verified that microbiological testing for *Salmonella* performance standards to meet FSIS requirements for equivalence and comply with the EU “process hygiene” and “food safety” criteria is carried out by all establishments certified as eligible to export product to the United States. DEFRA and FSA does not carry out any in-plant microbiological testing, however the in-plant official veterinarian verifies establishment compliance as required in Chapter 4, Part 3 of the MOC. Test results of samples submitted by an establishment are transmitted directly to the FSA for review and action as appropriate.

The FSIS auditor observed establishment personnel collecting samples for Aerobic Colony Count, *Salmonella*, and *Enterobacteriaceae* testing by the carcass swap method. *Enterobacteriaceae* is the reference indicator organism specified in Regulation (EC) No. 2073/2005. The sample collection frequency for *Enterobacteriaceae* testing is five samples per week, collected from randomly selected carcasses before chilling by swabbing the animal neck, brisket, flank, and rump with an abrasive sponge, covering an area of at least 400 sq. cm. The laboratory methods are specified in Regulation (EC) No. 2073/2005, and detailed in the MIG Chapter 1.

The FSIS auditor verified through document reviews and interviews that establishments certified to export raw pork products to the United States implement effective microbiological control

programs for all pathogens of concern. Testing of *Salmonella*, *Enterobacteriaceae*, and Aerobic Colony Count for process hygiene is performed at a frequency of five carcasses per week. The FSA veterinary auditor reviews and evaluates testing procedures, frequencies, and results. The FSIS auditor verified that the four pork slaughter and processing establishments audited have written procedures for sampling for *Salmonella* and *Enterobacteriaceae*, which include identification of the staff designated to collect the samples, the location of samples collection, sampling method, sampling frequency, and sample handling to ensure sample integrity. Test results are recorded by colony forming units (CFU/cm²) with graphs and/or tables to illustrate acceptability limits.

The FSIS auditor assessed the operations of the ALS laboratory, reviewed the latest accreditation of ALS, dated November 22, 2016, by UKAS, and found no issues. The FSIS auditor verified that DEFRA has ensured that collection and analyses of tissue samples are conducted in accordance with standard protocols that meet the FSIS criteria. DEFRA has mechanisms in place to determine the national prevalence of *Salmonella* in raw meat products where England carries out food surveys and contributes to the annual EU report on trends of zoonosis.

The FSIS auditor's document analysis and onsite verification activities demonstrate that England's meat inspection system includes requirements for a microbiological sampling and testing program. Samples testing is administered at official control laboratories to verify that raw pork products destined for export to the United States are unadulterated, safe, wholesome, and in accordance with the United States requirements.

X. CONCLUSIONS AND NEXT STEPS

An exit meeting was held on September 29, 2017, in London, England with DEFRA. At this meeting, the FSIS auditor presented the preliminary findings from the audit.

An analysis of each component did not identify any deficiencies that represented an immediate threat to public health. The FSIS auditor identified the following findings:

Government Oversight

- The CCA uses contracted employees to conduct inspection (e.g., ante-mortem inspection, final carcass disposition during post-mortem inspection, and sanitation and HACCP verification activities) during the production of pork product to export to the United States.

Government Statutory Authority and Food Safety and Other Consumer Protection Regulations

- At two of the four audited pork slaughter establishments, inspection personnel did not take appropriate regulatory control actions when carcasses were not presented with their organs or viscera, when carcasses were presented with the wrong organs, or when carcasses were presented with punctured viscera.

During the audit exit meeting, the CCA committed to address the preliminary findings as presented. FSIS will evaluate the adequacy of the CCA's documentation of proposed corrective actions and base future equivalence verification activities on the information provided.

APPENDICES

Appendix A: Individual Foreign Establishment Audit Checklists

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Karro Food Ltd Hugdon Way, Norton Grove Industrial Estate, Malton, North Yorkshire	2. AUDIT DATE 09/21/2017	3. ESTABLISHMENT NO. UK 2060	4. NAME OF COUNTRY England
	5. AUDIT STAFF OIEA International Audit Staff (IAS)		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.	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.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.	X	Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	X
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	X
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	
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

11/51 SSOP Maintenance:

The Sanitation SOP dated 08/31/2017 was reassessed and revised but not signed by an overall responsible authority.

12/51 SSOP Corrective action:

Corrective actions of insanitary conditions observed during pre-operational inspection on September 20, 2017 were not verified; absence of verifier initials.

21/51 HACCP reassessment:

HACCP plan was last reviewed/ reassessed on January 04, 2017 but not signed by an overall responsible authority.

49/51 Government Staffing:

The CCA of England uses government and contracted employees to conduct meat inspection activities (ante-mortem inspection, final carcass disposition during post-mortem inspection, and sanitation and HACCP verification activities) during the production of pork products intended for export to the United States. The government and contract inspection personnel routinely rotate inspection activity on post-mortem inspection stations (head, viscera, and final carcass inspection), and there was no system in place to ensure that only government inspection personnel perform final carcass inspection. These non-governmental inspection personnel are not under the direct supervision of a government employee who is physically present in the establishment whenever slaughter of source materials for use in processed product intended for export to the United States occurs.

55/51 Post Mortem Inspection:

At the post-mortem inspection station, inspection personnel did not take appropriate regulatory control action when carcasses were not presented with its organs or viscera, when carcasses were presented with the wrong organs, or when carcasses were presented with punctured viscera-covered with gross fecal material.

In one occasion, swine carcass was presented at post-mortem inspection station without its organs. That carcass was later released for human consumption by the rectification (reinspection) station meat inspectors, without the benefit of final disposition by a veterinarian. In another occasion during post-mortem inspection, meat inspection personnel did not take appropriate control actions when the presentation of swine carcasses with corresponding viscera or organs was not accurate and misaligned. In three additional incidents, swine carcasses were presented with missing viscera at the viscera inspection station.

At the viscera inspection station, meat inspection personnel did not take appropriate control action when the disposal system of condemned viscera that was covered with fecal material did not operate properly, allowing several viscera covered with gross fecal material to enter the offal-edible product processing area. It appears that this process was not monitored frequently by industry personnel or the FSA meat inspection personnel.

The inspection personnel did not follow the government's MOC Section 2.5.3 which states "...meat may be declared unfit for human consumption if it derives from animals the offal of which has not undergone post-mortem inspection." Additionally, Section 2.1.8 of the MOC does not list incidents of missing organs or viscera during PM inspection as "common" for meat inspectors to make the final disposition on carcasses without consulting with the attending veterinarian.

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Cranswick Country Foods PLC Staithe Road, Preston Hull HU12 8TB	2. AUDIT DATE 09/22/2017	3. ESTABLISHMENT NO. UK 2093	4. NAME OF COUNTRY England
	5. AUDIT STAFF OIEA International Audit Staff (IAS)		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.		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	X
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	X
27. Written Procedures		Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis		56. European Community Directives	
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

12/51 SSOP Corrective action:

At one establishment, plant personnel did not describe how insanitary conditions were corrected in SSOP records (repeated occurrence),

20/51 HACCP Corrective action:

At establishment UK 2093 on September 18, 2017, HACCP monitoring records showed noncompliance with CCP3 (metal detection) at raw products packing room, however there were no documentation of the product involved, the disposition of the product, or corrective action taken to prevent recurrence.

49/51 Government Staffing:

The CCA of England uses government and contracted employees to conduct meat inspection activities (ante-mortem inspection, final carcass disposition during post-mortem inspection, and sanitation and HACCP verification activities) during the production of pork products intended for export to the United States. The government and contract inspection personnel routinely rotate inspection activity on post-mortem inspection stations (head, viscera, and final carcass inspection), and there was no system in place to ensure that only government inspection personnel perform final carcass inspection. These non-governmental inspection personnel are not under the direct supervision of a government employee who is physically present in the establishment whenever slaughter of source materials for use in processed product intended for export to the United States occurs.

55/51 Post Mortem Inspection:

At the post-mortem inspection station, inspection personnel did not take appropriate control action when carcasses were not presented with its organs, when carcasses were presented with the wrong organs, or when carcasses were presented with punctured viscera covered with gross fecal material.

At establishment UK 2093, two swine carcasses were not presented with its organs at the post-mortem inspection station. One of those carcasses was presented without the liver, heart, and the right lobe of the lung. The left lobe of the lung and heart were attached to the carcass thoracic cavity due to extensive adhesion. These carcasses were later released for human consumption by the meat inspectors at the rectification (reinspection) station without the benefit of final disposition by the attending veterinarian.

At establishment UK 2093, the meat inspector at the viscera station did not take appropriate control action (condemn viscera) when multiple viscera were presented covered with gross fecal material. In one incident, the viscera and back of corresponding carcass was covered with fecal material; the meat inspectors at the viscera and initial carcass inspection failed to immediate corrective action. This carcass was later trimmed before further processing.

In another occasion during post-mortem inspection, meat inspection personnel did not take appropriate control actions when the presentation of swine carcasses with corresponding viscera or organs was not accurate and misaligned. This problem was shortly corrected by establishment's personnel by running a correlation test.

The inspection personnel did not follow the government's MOC Section 2.5.3 which states "...meat may be declared unfit for human consumption if it derives from animals the offal of which has not undergone post-mortem inspection." Additionally, Section 2.1.8 of the MOC does not list incidents of missing organs or viscera during PM inspection as "common" for meat inspectors to make the final disposition on carcasses without consulting with the attending veterinarian.

61. AUDIT STAFF

OIEA International Audit Staff (IAS)

62. DATE OF ESTABLISHMENT AUDIT

09/22/2017

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Tulip Ltd Bow Street, Dukinfield, Cheshire SK 16 4HY	2. AUDIT DATE 09/25/2017	3. ESTABLISHMENT NO. UK 4085	4. NAME OF COUNTRY England
	5. AUDIT STAFF OIEA International Audit Staff (IAS)		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	X
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		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**49/51 Government Staffing:**

The CCA of England uses government and contracted employees to conduct meat inspection activities (ante-mortem inspection, final carcass disposition during post-mortem inspection, and sanitation and HACCP verification activities) during the production of pork products intended for export to the United States. The government and contract inspection personnel routinely rotate inspection activity on post-mortem inspection stations (head, viscera, and final carcass inspection), and there was no system in place to ensure that only government inspection personnel perform final carcass inspection. These non-governmental inspection personnel are not under the direct supervision of a government employee who is physically present in the establishment whenever slaughter of source materials for use in processed product intended for export to the United States occurs.

61. AUDIT STAFF

OIEA International Audit Staff (IAS)

62. DATE OF ESTABLISHMENT AUDIT09/25/2017

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Daleheads Foods- Dulip Ltd Fulney Lane, Spalding, Lincolnshire HY PE 12 6EP	2. AUDIT DATE 09/26/2017	3. ESTABLISHMENT NO. UK 5091	4. NAME OF COUNTRY England
	5. AUDIT STAFF OIEA International Audit Staff (IAS)		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOPs have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		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	X
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 Establishment10/51 Monitoring of SSOP:

During pre-operation sanitation verification at establishment UK 5091, inspection personnel observed multiple particles of fat or blood, from previous day's production, were observed on conveyor belts of cutting raw pork department. Also, two spots of chipping paint and one area of rust (approx. 60 cm x 3 cm) were observed on overhead structure. These deficiencies were corrected before the start of operation.

49/51 Government Staffing:

The CCA of England uses government and contracted employees to conduct meat inspection activities (ante-mortem inspection, final carcass disposition during post-mortem inspection, and sanitation and HACCP verification activities) during the production of pork products intended for export to the United States. The government and contract inspection personnel routinely rotate inspection activity on post-mortem inspection stations (head, viscera, and final carcass inspection), and there was no system in place to ensure that only government inspection personnel perform final carcass inspection. These non-governmental inspection personnel are not under the direct supervision of a government employee who is physically present in the establishment whenever slaughter of source materials for use in processed product intended for export to the United States occurs.

61. AUDIT STAFF

OIEA International Audit Staff (IAS)

62. DATE OF ESTABLISHMENT AUDIT09/26/2017

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Hull Cold Storage Corporation Road, King George Dock, Hull Hu9 5NF	2. AUDIT DATE 09/22/2017	3. ESTABLISHMENT NO. UK XA 007	4. NAME OF COUNTRY England
	5. AUDIT STAFF OIEA International Audit Staff (IAS)		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	
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	
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

There were no findings to report.

61. AUDIT STAFF

OIEA International Audit Staff (IAS)

62. DATE OF ESTABLISHMENT AUDIT

09/22/2017

Appendix B: Foreign Country Response to the Draft Final Audit Report



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United States Department of Agriculture
Food Safety and Inspection Service
The Office of International Co-ordination
Room 3143
1400 Independence Avenue, SW
Washington D.C 20250
By Email: Mary.Stanley@fsis.usda.gov

April 2018

Dear Mary,

**FOOD SAFETY AND INSPECTION SERVICE (FSIS) ON SITE AUDIT OF ENGLAND –
18TH-29TH SEPTEMBER 2017 DRAFT FINAL REPORT.**

Thank you for your letter and accompanying draft final audit report received on the 14th February 2018, regarding the FSIS audit of pork production systems in England. I am grateful for the work undertaken by Dr Ismail during his visit and the comprehensive draft audit report he has generated, which on the whole, is very positive.

As regards the preliminary findings, the corrective actions taken by the Food Standards Agency on behalf of Defra, and those taken by the individual food business operators (FBOs), are outlined as follows:

Annex A – addresses the finding “Government Statutory Authority and Food Safety and Other Consumer Protection Regulations” (**55/51 Post Mortem Inspection**) identified in two of the establishments audited. Our response describes the legal framework for post mortem inspection and how this is captured in our Manual of Official Controls; the measures that the Competent Authority (Food Standards Agency) has taken in response to this finding; and the corrective actions that have been taken by the two FBOs.

Annex B - In response to the point concerning Government oversight and the use of contract employees to conduct inspection (49/51 Government staffing), which is mentioned in a number of sections within the report, please refer to the letter sent by my predecessor Nigel Gibbens dated 27th October 2017. I trust Nigel’s letter provided a satisfactory response on this matter, however, if you have any further questions I will be happy to address them.

As regards other findings listed in Appendix A of the draft audit report:

Annex C – provides details of corrective actions taken by the relevant FBOs. These actions have been verified by the Official Veterinarians based at these plants.

Annex D – outlines specific comments and suggested amendments on information provided within the draft audit report.

Defra, by virtue of the FSA, has disseminated the results of the FSIS audit to Official Veterinarians throughout the UK responsible for auditing of approved establishments to ensure that these findings do not recur.

I hope this meets with your satisfaction and I look forward to continuing the good working relations that you and your colleagues had with my predecessor.

Yours sincerely



CHRISTINE MIDDLEMISS
UK CHIEF VETERINARY OFFICER

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Cc Steve Knight
Jennifer Hopkins

Enc: Annex A - D UK corrective actions

ANNEX A

Finding by auditor:

“Government Statutory Authority and Food Safety and Other Consumer Protection Regulations (55/51 Post Mortem Inspection)”

At two of the four audited pork slaughter establishments, inspection personnel did not take appropriate regulatory control actions when carcasses were not presented with their organs or viscera, when carcasses were presented with the wrong organs, or when carcasses were presented with punctured viscera.”

UK Legal framework for post mortem inspection:

Regulation (EC) 853/2004, Annex III, Section I, chapter IV, point 12 states that ‘slaughterhouse operators must follow the instructions of the competent authority to ensure that post mortem inspection of all slaughtered animals is carried out under suitable conditions in accordance with Regulation (EC) No 854/2004’.

Point 13 (a) of the aforementioned provision states that ‘Until post-mortem inspection is completed, parts of a slaughtered animal subject to such inspection must remain identifiable as belonging to a given carcass’.

Regulation (EC) 854/2004, Annex I, Section I, chapter II, point D1 states that ‘Carcasses and accompanying offal must be subjected without delay after slaughter to post-mortem inspection’.

Manual of Official Controls (MOC) that has to be observed by all UK officials:

The legal requirements quoted above are captured in sections two and three of chapter 2.4 of our MOC, where Food Business Operator (FBO) and Food Standards Agency (FSA) responsibilities are respectively described.

Additionally, section 12 of chapter 2.4 of the MOC explains the ‘Slaughter Hygiene Verification System in Red Meat’ that FSA officials must carry out in approved establishments.

The following table extracted from Section 12 of the MOC, details the scope of verification during product checks.

Area of verification	Scope
1 Pathology	Meat is free from all pathological conditions
2 Statutory requirements	Post-mortem inspection has been carried out in accordance with legal requirement
3 Faecal / ingesta / milk	Meat is free from faecal / ingesta / milk contamination
4 Health marking	Meat is correctly and legibly health marked
5 Other	Record any identified deficiency (for example, contamination with bile / hair / wool, tonsils, stick wounds, SRM, rail flake)

As per the table below, the correlation between carcasses and offal must be verified daily, regardless of previous audit outcomes that the plant may have obtained.

The following table lists the establishment verification areas and the minimum frequency of checks based on FBO audit outcome.

Establishment verification tasks and their frequency	FBO audit outcome	
	Improvement necessary / Urgent improvement necessary	Good / Generally satisfactory
1 Intake / FCI	Daily	Daily
2 Ante-mortem arrangements	Daily	Daily
3 Correlation of carcasses and offal	Daily	Daily

Section 12 also mentions that the 'presentation for inspection' must be checked daily by FSA officials, as per the table below;

Verification Step	Basic frequency	Reduced frequency
1 Cleanliness of animals	Daily	Once a week
2 Bleeding	Daily	Once a week
3 Skinning / hair removal	Daily	Once a week
4 Evisceration / udder removal	Daily	Once a week
5 Presentation for inspection	Daily	Daily

Note: The frequency of the verification checks at the step 'Presentation for Inspection' cannot be reduced and they should be always carried out daily.

This same section of chapter 2.4 of the MOC indicates that FSA officials are 'expected to verify hygienic standard of the process to assess if the FBO has adequate controls in place to minimise contamination and if corrective actions are taken when contamination incidents occur'.

Food Standards Agency corrective actions at establishment: Karro 2060:

1. The plant Official Veterinarian (OV) held a meeting with the plant inspection team on Monday 25 Sep 2017 to discuss the deficiencies raised during the audit and agree actions to prevent recurrence (Annex 1).



Annex 1_FSA plant
team meeting.pdf

2. The Official Veterinarian delivered a refresher training on post mortem inspection to the plant FSA team. During this session, a memo was also agreed and signed by the plant FSA officials (Annex 2).



Annex 2_FSA
Refresher training.pdf

3. The deficiencies were also discussed at area level ('cluster meeting') for awareness of FSA local management (Annex 3).



Annex 3_Cluster
meeting.pdf

4. The Official Veterinarian (OV) is present, twice a day, during the checks on correlation that the FBO carries out every 30 minutes. Checks on fecal contamination are also carried out. A form has been implemented in the plant whereby the OV will record these verification checks (Annex 4).



Annex 4_OV checks
on correlation.pdf

5. The Official Auxiliaries (OA), also known as Meat Hygiene Inspectors (MHI), verify all the checks carried out by the FBO on correlation and the 'disposal system of condemned viscera' (gut pan reject) every 30 minutes (Annex 5).



Annex 5_MHI
verification checks.pdf

6. Ensuring that the equipment is working properly and that all parts of the carcass are presented for post mortem inspection is an FBO responsibility; thus, enforcement action was taken by plant officials. Escalation of the enforcement has not been necessary due to the prompt FBO response (Annex 6).



Annex
6_Enforcement.pdf

Karro 2060: Food Business Operator corrective actions

The plant management has taken corrective action to ensure that all viscera are presented for post mortem inspection, correlation of the carcasses and viscera is reliable and that viscera contaminated with fecal material are rejected after inspection. Please see documents below.

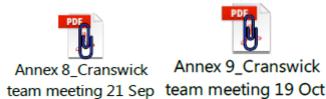


Food Standards Agency corrective actions at establishment: Cranswick 2093:

1. The inspection pack that all the MHIs receive as an induction when they start working in that plant has been updated to clarify the post mortem inspection process and a prevent the recurrence of these findings. All the inspectors have read and understood the instructions (Annex 7).



2. The plant Official Veterinarian (OV) held a meeting with the plant inspection team on 21 Sep and 10 Oct 2017; the presentation of viscera and alignment with the carcass at post mortem inspection were discussed in order to clarify inspection arrangements and ensure adherence to MOC instructions (Annex 8 and 9).



3. As per annex 3 above, the deficiencies were also discussed at area level ('cluster meeting') for awareness of FSA local management.
4. The OVs carry out daily checks on (faecal) contamination and also include correlation in their post mortem inspection verification checks.



Cranswick 2093: Food Business Operator corrective actions

The plant has taken corrective action to address this deficiency; contamination is monitored by the FBO as well as correlation of the carcasses and viscera. Please see document below.



Cranswick 55 51
Correlation Correcti

ANNEX B

Ref 49/51 in report

Letter regarding government oversight from Nigel Gibbens dated 27th October 2017



CVO letter to Mary
Stanley 27 October 2

ANNEX C

Food Establishment corrective actions taken to address findings identified at Karro 2060:

Ref 11/51, 12/51, 21/51, in report.

The plant has provided a root cause analysis report. Please see document below.



Karro MAJOR - Root
Cause Analysis and

11/51 & 12/51 SSOP maintenance and corrective action

The SSOP has been signed by an overall responsible authority in the plant. Verification system described in the documents and verified by the onsite veterinarian. Please see document below.



Karro SSOP Version
31 20th September 2

21/51 HACCP reassessment

The HACCP plan has been signed by an overall responsible authority in the plant. Please see documents below.



Food Business Operator corrective actions to address findings identified at Cranswick 2093:

Ref 12/51, 20/51 in report.

The plant has provided a corrective and preventive action plan. Please see document below.



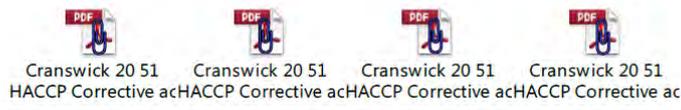
12/51 SSOP corrective action

The plant has described how insanitary conditions are corrected in SSOP records. Please see the documents below.



20/51 HACCP corrective action

Documentation about the product involved has been provided by the Food Business Operator. Please see information below.



FBO corrective actions taken as a result of findings identified at Daleheads Foods-Tulip Ltd 5091:

Ref 10/51 in report: monitoring of SSOP

The plant has taken corrective action to address this deficiency; all cleaning instruction cards have been reviewed and re-issued with focus on pictorial standards for compliance. Please see documents below.


5091_Corrective and
Preventive Action rep


5091_Belt
Cleaning.pdf

ANNEX D

Specific comments to information provided in the audit report

Chapter IV. COMPONENT ONE: GOVERNMENT OVERSIGHT (E.G., ORGANIZATION AND ADMINISTRATION)

Page 4 – Paragraph 2 reads:

‘The animal health policy in England is delivered by the executive agencies of DEFRA. These are separate organizations, which act on behalf of DEFRA’s Secretary of State of Health. They include the Food Standards Agency (FSA), the Animal and Plant Health Agency (APHA), and the Veterinary Medicines Directorate (VMD)’.

Amendment:

The animal health policy in England is delivered by executive agencies to DEFRA. These are separate organizations, which act on behalf of DEFRA’s Secretary of State for the Environment. They include the Animal and Plant Health Agency (APHA), and the Veterinary Medicines Directorate (VMD).

Page 4 - Paragraph 3 reads:

‘FSA is responsible for the enforcement of food safety standards and has the authority and the ability to require corrective actions in establishments exporting to the United States and to take additional enforcement measures as appropriate’.

Amendment:

‘The FSA is the competent authority for food safety. It is responsible for the enforcement of food safety regulation and has the authority and the ability to request corrective actions in establishments exporting to the United States and to take additional enforcement measures as appropriate, if corrective actions are not met’.

Page 4 – Paragraph 4 reads:

'APHA oversees the operational delivery of animal health and welfare inspection as well as the international trade policy for England'.

Amendment:

'APHA oversees the operational delivery of animal health and welfare inspection as well as the delivery of export certification'.

Page 4 – Paragraph 5 reads:

'This is implemented in England under the Animals and Animal Products Regulations of 1997'.

Amendment:

'This is implemented under The Animals and Animal Products (Examination for Residues and Maximum Residue Limits) (England and Scotland) Regulations 2015'.

Page 6 – Paragraph 3 reads:

'If the FSIS requirements are not met, the DEFRA will refuse to issue and sign the export health certificate, and increase the frequency of inspections, audits, and supervision to ensure that corrective and preventive actions have been taken'.

Amendment:

If the FSIS requirements are not met, the Official Veterinarian appointed on behalf of DEFRA as the competent authority, will refuse to issue and sign the export health certificate, and increase the frequency of inspections, audits, and supervision to ensure that corrective and preventive actions have been taken.

Chapter VII. COMPONENT FOUR: GOVERNMENT HAZARD ANALYSIS AND CRITICAL CONTROL POINTS (HACCP) SYSTEM

Page15 – Paragraph 4 reads:

'These records are maintained for 3-6 years'.

Amendment:

'These records are maintained for at least 2 years'.

Chapter VIII. COMPONENT FIVE: GOVERNMENT CHEMICAL RESIDUE TESTING PROGRAMS

Page 16 – paragraph 2 reads:

'VMD runs the veterinary residues surveillance program in accordance with Council Directive 96/23/EC and implements it in England in accordance with the Animals and Animal Products Regulations 1997'.

Amendment:

'The VMD runs the veterinary residues surveillance program in accordance with The Animals and Animal Products (Examinations for Residues and Maximum Limits) (England and Scotland) Regulations 2015 SI No. 787 and implements the Requirements of Council Directives 96/22/EC and 96/23/EC. The Directives require targeted sampling for veterinary residues by Member States. They lay down the frequency of sampling required for substances'.

Page 16 – paragraph 6 reads:

'Blood, urine and feed samples are taken on-farm and the majority of these are tested for prohibited substances, particularly those with growth promoting properties'.

Amendment:

'Blood, urine and feed samples are taken on-farm by APHA officers and the majority of these are tested for prohibited substances, particularly those with growth promoting properties'.



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Mary H. Stanley
Office of International Coordination
Food Safety and Inspection Service
1400 Independence Avenue, SW.
Washington, D.C. 20250

27 October 2017

Dear Ms Stanley,

I refer to your letter dated 5th October 2017 as regards equivalence with FSIS statutory requirements for inspection activities during the production of meat products intended for export to the United States. In our response, we are guided by the US principles for equivalence:

"...while foreign food regulatory systems need not be identical to the U.S. system, they must employ equivalent sanitary measures that provide the same level of protection against food hazards as is achieved domestically"

In the UK, Official Veterinarians (OVs) and Official Auxiliaries (OAs) responsible for final carcase disposition are either directly *employed* by Government (Northern Ireland and several in England, Wales and Scotland) or employed through a third party organisation contracted to conduct inspection activities on behalf of Government *and* individually *appointed* and *authorised* by Government. In all cases, the Government has supervisory oversight of all appointed OVs and OAs in the course of their duties through the audit systems in place. I believe this is equivalent to The Federal Meat Inspection Act (21 USC 603(a)) which allows inspectors to be 'appointed' by the Government - the Food Standards Agency (FSA) and Food Standards Scotland (FSS) - to deliver official controls on the Government's behalf. I also believe this system provides an equivalent level of protection to that of FSIS in keeping with example 3 laid out in FSIS letter dated 5th July 2016 (enclosed).

The FSA and FSS have a rigorous system in place to monitor and manage appointed OVs and OAs - please find enclosed a full description of the system and a copy of the contracts between the FSA and Eville and Jones (E&J) UK Limited (England and Wales) and FSS and Hall Mark Veterinary Compliance Services (Scotland). The contracts contain full details of the government's expectations of the role, competencies and qualification requirements of appointed officials.

Official controls in slaughterhouses in the UK are organised in accordance with EU requirements laid down in Regulation (EC) 854/2004. In the UK, training of officials, as described in this regulation, is the same for all officials regardless of whether they are employed or appointed. Warrants (designations/authorisations) are issued by the FSA/FSS/DAERA to all officials (employed or appointed) only on completion of the required training.

The performance of appointed inspectors is observed by the FSA/FSS during the routine plant audits carried out for the delivery of official controls. Additionally, the performance of officials is actively assessed every three months during the audits that plants approved to export to the USA are subjected to. The performance of the contract OVs and OAs is evaluated against the 'key performance indicators' included in the contract with E&J and Hall Mark on a monthly basis by FSA/FSS management.

All FSA/FSS Veterinary Auditors are directly employed by the FSA/FSS (Government). There are also Field Veterinary Leaders and Field Veterinary Coordinators employed by the FSA/FSS who carry out spot checks and can intervene when required. FSA/FSS must ensure that at least one OV is present in slaughterhouses throughout post-mortem inspection. OVs carry out ante mortem inspection of all animals, verify the plant's monitoring/verification of the Critical Control Points, including 'zero faecal tolerance', and carry out checks on implementation of operational and pre-operational sanitation procedures.

OVs, by virtue of their appointment are deemed to be working on behalf of the Government exclusively in the discharge of their duties. Their professional standards are overseen by the Royal College of Veterinary Surgeons who uphold strict principles in this regard.

The UK inspection systems, while not executed in the same way as US systems, share the same objective to identify and dispose of adulterated product to protect public health, and achieve an equivalent effect through the robust systems described above and in the Annexes to this letter.

I hope this provides a satisfactory response, however, we stand ready to address any concerns you may still have.

Yours sincerely,



PROFESSOR NIGEL GIBBENS CBE
CHIEF VETERINARY OFFICER

T: +44 (020) 7238 6495

Nigel.gibbens@defra.gsi.gov.uk

Enc. Annex 1 - FSIS letter to UK CVO 05/07/16
Annex 2 - description of Government oversight of appointed Officials
Annex 3 - copy of FSA / Eville and Jones UK Limited contract
Annex 4 - copy of FSS / Hall Mark Meat Hygiene Limited contract

Cc. Steve Knight, Embassy of the United States Department of Agriculture, Steve.Knight@fas.usda.gov
Stan Phillips, Agricultural Counselor for the United Kingdom, Stan.Phillips@fas.usda.gov

MHI Name (name and signature)	Date	OV given the training (if applicable)
PIOTR KROBATV	1.10.2017	RM
GEORGIAN BIJU	1.10.2017	RM
CATALIN ARSTICE	01.10.2017	RM
MARTA PAWAL	07.10.2017	RM
Aulton	30/10/17	RM
Fikolă Andrei - Eugen	20.10.2017	RM
ARKADIUSZ CZERMINSKI	20/11/2017	RM
VILMA KMITIENE	28/11/2017	RM
ALEXANDRU MOSTORU	04/12/2017	AM
Z-Stancu	04/12/2017	RM
Tutor Orea	06/12/2017	RM
Căndin Loure	06/12/2017	RM
SOFIA IOPET	06/12/2017	RM
Josée PERET	06/12/2017	RM
TROU MARIUS	19/02/2018	RM
		RM

CCF team meeting 21 September 2017

Minutes

OV:

- **MOC update – 11 Sept 2017 MOC Amendment 79 – chapter 2.4**
Additional instruction that the OV must have an auditable system in place to check that all health marks have been returned at the end of each operational day. CCF complies.
- **Enforcement – Slaughter line enforcement for period refers to chillers, condensation and cleanliness. MHIs to pay attention on bunching in Rectification Room.**
- **Animal welfare – No welfare letters sent this period.**
- **Contamination records – 0.3% carcasses, 3.5% on offal on average for the period. Offal contamination decreased by 1.5% comparing to the previous period.**
- **RIM sampling – Richard looking into the possibility to deploy 1 MHI which could be in charge of collecting RIM samples.**
- **Razvan pointed out that following FBO hand swabs on Slaughter line operatives, FSA staff was swabbed as well, and embarrassing results came up. 1 MHI got unsatisfactory results, meaning that hand washing procedure was not followed. Team briefed again on the correct procedure. E-mail already sent to the team on the day of the incident.**
- **The OV expressed his disappointment regarding the lack of interest of the MHI team in FBO Tier 1 Meetings, when we agreed that 1 FSA representative to attend every Thursday. This was not happening in the last 3 weeks.**

Action points from July meeting:-

- **Punctuality – Return from offline duties on time please – still reoccurring. Formal complains to be forwarded to the OV**

MHIs:

- **Green offal – Check rejection cards are free from excessive contamination prior to inspection at the beginning of the day. Line to be stopped when no cards available.**
- **All MHI's to be on the line at 07:30 – any pressure by the FBO to start earlier to be forward to the OV.**
- **Finishing times – OV suggested that MHIs to record the finishing times at the end of each operational day on Carcass Inspection Point to avoid any misunderstandings and frustration generated by the finishing times recorded by the FBO. Complains from MHI team that**

FBO is not recording correctly. New system to be agreed on the next meeting.

FBO Issues:

- **Livers presented for inspection by FBO operatives and not coming on the hook to be recorded as processing fault. Liver not presented, line should be stopped.**
- Slap Marks not readable or wrong – OV to be informed straight away, issue to be recorded in personal notebook.

Attended: Richard Grossman, Razvan Milea, Jorge Perez, Georgian Biju, Ninel Oncica, Tudor Oprea, Zeljika Stefanic, Valentina Silvestri, Lucasz Czerwinski, Grzegorz Rusinowicz

Thank you to everyone who attended the meeting and contributed with the above information. Please email Bernice any points you would like taking forward to Octobers meeting at bernice.wheeldon@foodstandards.gsi.gov.uk

Please book NOTH for the meeting period with a note stating CCF MHI team meeting.

Thank you.

Minutes

OV:

- MOC update – no MOC updates
- Enforcement – Slaughter line enforcement for period refers to chillers, condensation.
- Animal welfare – No welfare letters sent this period.
 - Contamination records – 0.3% carcasses, 4.5% on offal on average for the period. Offal contamination increased by 1% comparing to the previous period.
 - RIM sampling – Richard cannot allocate extra resources for the time being.
 - Following USDA audit new system of inspecting back of the carcasses to be implemented as soon as the FBO provides a wide mirror on carcass inspection point.
 - **Team reminded that carcasses presented without one of the organs to be declared not fit for human consumption as per MOC.**
 - **Lack of correlation, line to be stopped, OV to be informed.**
 - New Finishing Times form to be implemented so as from next week. Meat inspection team to be in control to avoid any misunderstanding with the FBO in regards with the finishing times. OV to draft the new form. Clock from Carcass inspection point to be used

Action points from September meeting:-

- Punctuality – Return from offline duties on time please – still reoccurring. Formal complains to be forwarded to the OV

MHIs:

- Green offal – New cleaner hanging two livers on the same pluck – OV to discuss with FBO.
- Slap marks mixed – making difficult for the MHIs to keep track – OV to discuss with FBO.
- Hellenic screen Red Offal 2 going slow sometimes, slaps displayed mixed – OV to discuss with FBO.



FBO Issues:

- **Cleaner on green offal not hanging properly the liver on the spike, and not presented on red offal stand. Offal to be brought for inspection only on Red Offal position. Line to be stopped otherwise.**

Atended: Razvan Milea(OV), Jorge Perez(MHI Supervisor), Fifiala Andrei(MHI), Oprea Tudor(MHI), Grzegorz Rusinowicz(MHI), Ciudin Laura(MHI), Ninel Oncica(MJI), Zeljka Stefanic(MHI), Catalin Hritcu(MHI), Piotr Kroban(MHI), Sofia Lopez(MHI-trainee)

Thank you to everyone who attended the meeting and contributed with the above information. Please email Bernice any points you would like taking forward to Novembers meeting at

bernice.wheeldon@foodstandards.gsi.gov.uk

Please book NOTH for the meeting period with a note stating CCF MHI team meeting.

Thank you.

Approval number: UK2093EC

Inspection Date: 17/11/2017

Location if other than at the end of the line:

Tick if electronic form done:

Pass: No Fail: Use initials to specify deficiency.

Inspector: RAZVAN MILEA

Has sampling of carcasses being supervised: time; sampler; country (USA, China, Korea); refrigeration:

P (Pathology), S (Statutory), C (Contamination), H (Health marking), O (Others)

	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
A. Any finding on Carcasses? ** Time: 0725	NO	NO																		
B. Any Finding on Offal? ** Time: 0708	NO	NO																		
Indicate the individual number of the inspected carcass	483		484		485		486		487		488		489		490		491		492	
	483		484		485		486		487		488		489		490		491		492	
	493		494		495		496		497		498		499		500		501		502	
	498		499		500		501		502		503		504		505		506		507	

	AM	PM
C. ABP Are rejected carcasses being stained?	empty Time: 0810	STAINED Time: 1605

D. Condensation***

Time: 0738/1200

Chiller 1/8	Y	N
	X	V

Input of information on Hellenic:

Time	Station
0815	Pl. Off. I

V. M. S. M. - M. S. M. S.

E. Others (indicate times, carcass affected, platform where issues were found, person involved, etc.) Time: 0915 I: CORRELATION

	SLAPMARK	GREEN OFFAL	RED OFFAL	CARCASE
Is the floor clear of excessive water/debris? YES	M. S. M. S.	✓	✓	✓
Are the carcasses being properly singed? YES				
Are doors being kept closed? YES				

** Note: If you find any issues write on the verification findings: who you informed, action taken to sort the problem, what happened with the product affected, if any. Issued: 20171101

0855

F. Check of carcasses at Evisceration point	
N of carcass checked	N of faecal incidents
60	0

0908

G. Check of carcasses at inspection point	
N of carcass checked	N of faecal incidents
60	0

Any other comments for F or G: 13; 20

H: Edible Co-Products/Gut Room -

Del fat - faecal contamination
1 Solen - Cut 3 - see Verification Findings

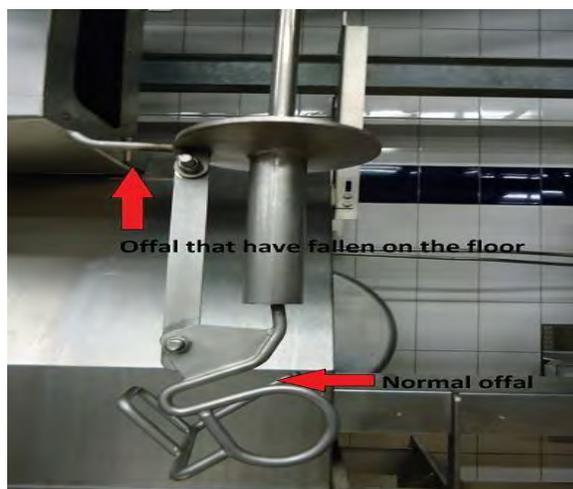
Maintenance of Correlation on the line at UK2093EC

- Correlation exercises are carried out by the plant staff once a week to ensure that the defined correlation points are maintained.
- There is a member of the plant staff specifically positioned to pick and rehung on the line any offal that accidentally might fall on the floor during evisceration.

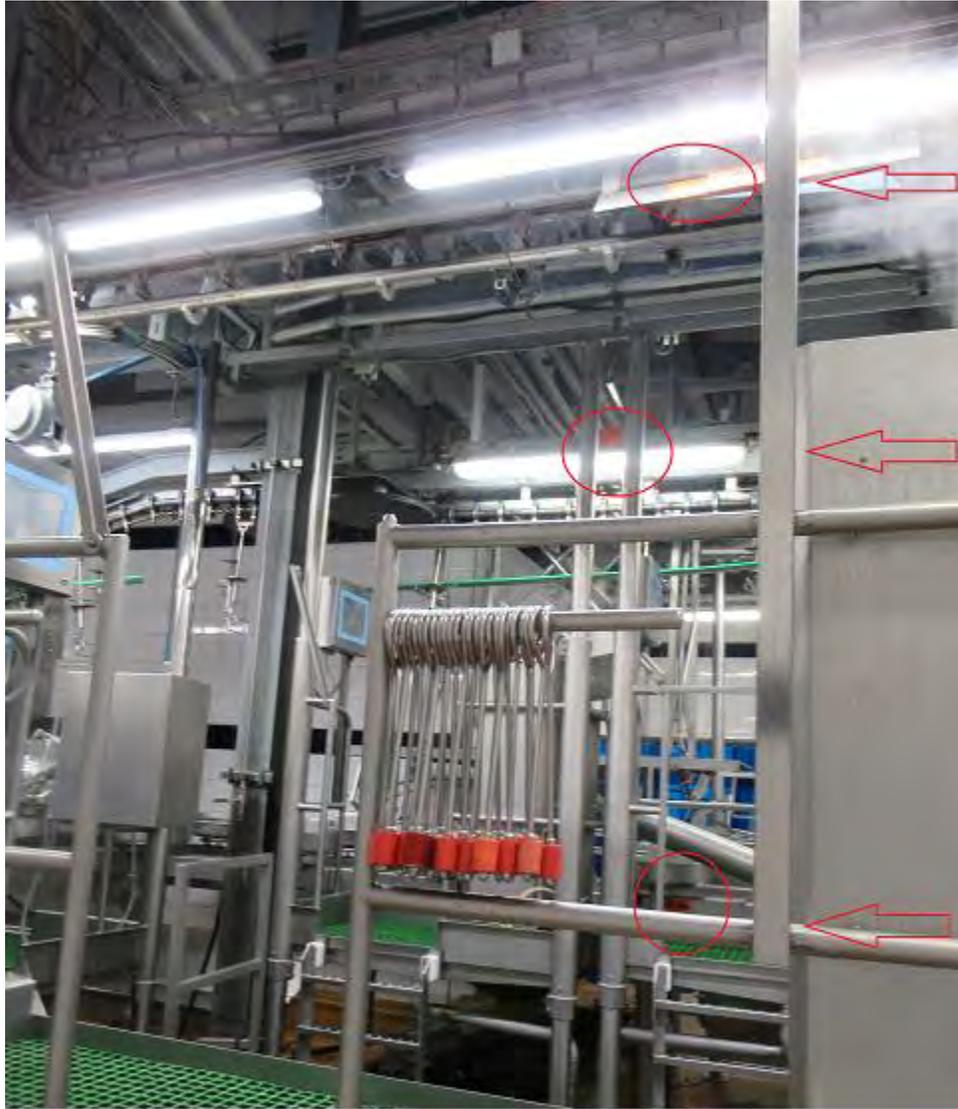


Note: picture was taken just before production started.

- If the hole pluck (liver; heart and lungs) or part the pluck falls on the floor and are rehung, they will be rehung in a specific way so meat inspection personal is aware that they were picked from the floor and need to be rejected after inspection as animal by products. The whole pluck will be rejected and not only the one that was collected from the floor due to risk of cross contamination.



- Correlation points are marked on the line with orange marks; from top to bottom: carcass location; red offal location; green offal location.



CORRECTIVE AND PREVENTIVE ACTION PLAN

Name of Establishment: Cranswick Country Foods	Establishment Address: Staithe Rd, Preston, Hull HU12 8TB
Plant number : UK2093EC	Audit date: 22/09/2017
Date prepared (dd/mm/yyyy):	
Prepared by: Jose Osuna (Compliance Inspector)	Approved by: Katie Hibberd (Technical Manager)
QC Supervisor / Production Supervisor / Production Manager (Name & Designation of establishment's authorized representative)	Owner/Management Representative (Name & Designation of establishment's authorized representative)

Deficiency number (1)	Description of deficiency (Please affix picture if possible) (2)	Corrective Action and Preventive Actions (3)	Evidence of compliance (please take a picture/photo after the institution of Corrective Action) (4)	Completion or proposed completion date dd/mm/yyyy (5)	Person Responsible (6)	Verified by the on-site OV (7)
1	12/51 SSOP Corrective actions. Plant personnel did not describe how insanitary conditions were corrected in SSOP records (repeated occurrence)	Actions taken to rectify the issues are now being recorded on the designated section.	See attached documents 12 51 SSOP Corrective actions 01 12 51 SSOP Corrective actions 02 12 51 SSOP Corrective actions 03 12 51 SSOP Corrective actions 04 12 51 SSOP Corrective actions 05	25/09/2018	Przemyslaw Pietrowski	
2	20/51 HACCP Corrective actions. At establishment UK2093 on September 18, 2017, HACCP monitoring records showed noncompliance with CCP03 (metal detection) at raw products packing room, however there were no documentation of product	QA department raised a non-conformance because the procedure was not followed: metal-contaminated product was	See attached documents: 20 51 HACCP Corrective action 01 20 51 HACCP Corrective action 02 20 51 HACCP Corrective action 03 20 51 HACCP Corrective	25/09/2017	Jessica Mackintosh	

CORRECTIVE AND PREVENTIVE ACTION PLAN

Deficiency number (1)	Description of deficiency (Please affix picture if possible) (2)	Corrective Action and Preventive Actions (3)	Evidence of compliance (please take a picture/photo after the institution of Corrective Action) (4)	Completion or proposed completion date dd/mm/yyyy (5)	Person Responsible (6)	Verified by the on-site OV (7)
	involved, the disposition of the product, or preventive action taken to prevent reoccurrence.	taking directly to management by-passing the QA department. This was the document that the USDA official inspector saw (20 51 HACCP Corrective action 01). At that time the document showing the investigation was not available; now this has been completed and appears as an annex of 20 51 HACCP Corrective action 01 (20 51 HACCP Corrective action 04) The CCP record also showed that the product was	action 04			

CORRECTIVE AND PREVENTIVE ACTION PLAN

Deficiency number (1)	Description of deficiency (Please affix picture if possible) (2)	Corrective Action and Preventive Actions (3)	Evidence of compliance (please take a picture/photo after the institution of Corrective Action) (4)	Completion or proposed completion date dd/mm/yyyy (5)	Person Responsible (6)	Verified by the on-site OV (7)
		removed from the line but it did not show the final disposition (20 51 HACCP Corrective action 02) Preventive action an investigation was carried out and the farmer was contacted (20 51 HACCP Corrective action 03).				
3	55/51 FBO needs to ensure that correlation is maintained.	There is a member of the plant staff specifically positioned to rehang any offal that might fall on the floor; correlation points are marked on the line; Correlation exercises are carried on a	55 51 Correlation Corrective action 01 55 51 Correlation Corrective action 02	25/09/2018	Kevin Purvis	<i>JP</i>

CORRECTIVE AND PREVENTIVE ACTION PLAN

Deficiency number (1)	Description of deficiency (Please affix picture if possible) (2)	Corrective Action and Preventive Actions (3)	Evidence of compliance (please take a picture/photo after the institution of Corrective Action) (4)	Completion or proposed completion date dd/mm/yyyy (5)	Person Responsible (6)	Verified by the on-site OV (7)
		weekly basis (55 51 Correlation Corrective action 02). A summary of these actions can be found on: 55 51 Correlation Corrective action 01.				
4						
5						
6						
7						
8						
9						
10						
11						
12						

**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
BUTCHERY ENTRANCE			
Date & time: 12-01-18 0455	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Doors & curtains	A/U		
Lights	A/U		
Sterilisers	A/U		
Steam hood	A/U		
Hand wash station	A/U		
Boot wash	A/U		
Waste bins	A/U		
Equipment lockers & contents	A/U		
Apron hanger	A/U		
Equipment wash & brushes	A/U		
Knife sharpening tables	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
BUTCHERY 1			
Date & time: 19-01-18 0510	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	condensation	
Lights	A/U		
Evaporators	A/U		
Conveyors	A/U	broken belt	
Blocks/tables	A/U		
Leg derinders	A/U		
Loin derinders	A/U		
Belly derinder	A/U		
Shoulder derinders	A/U		
Demembraners	A/U		
Blade bone pullers	A/U		
Defatting machines	A/U		
Automatic scoring machine	A/U		
Overhead conveyers	A/U		
Deboflex line (including conveyers, butchery blocks, stainless steel tables, saws, derinders)	A/U		
Motor motors	A/U		

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Authorised By:

Date: 09.10.17
Issue No. 8

**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Chine saw & table	A / U		
Shoulder Bone puller	A / U		
Air Inflation Machine	A / U		
Trays	A / U		
Scales	A / U		
Internal use dolavs	A / U		
Inspection table	A / U		
Surface condensation	A / U		
Hand wash station	A / U		
Lifts	A / U		
Strip curtains	A / U		
Miscellaneous	NA		
CUTTING ROOM			
Date & time: 19-01-18 0455	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation	
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Pre-cut Stands	A / U		
Hand wash station	A / U		
Foot saw	A / U		
Leg saw	A / U		
Shoulder saw	A / U		
Middle saw	A / U		
Chine/scribe saw	A / U		
Fillet machine	A / U		
Metal detector	A / U		
Blocks/tables	A / U		
Gambrel return line	A / U		
Trays	A / U		
Inspection tables	A / U		
Tote bins	A / U		
Scales & printers	A / U		
Sterilisers	A / U		
Internal use dolavs	A / U		
Unfit meat bins	A / U		

Ref.: CP4.033	Authorised By:	Date: 09.10.17
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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Surface condensation	A / U		
Carcass guard rail	A / U		
Perspex screens	A / U		
Conveyor catch trays	A / U		
Fillet strapper	A / U		
Miscellaneous	NA		

RAW CHILL

Date & time: 15-01-18 0455	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation ceiling	
Curtains	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Ground pork bone conveyor	A / U		
Lift	A / U		
Metal detector	A / U		
Tables	A / U		
Unfit meat bins	A / U		
Scales	A / U		
Gravity rollers	A / U		
Surface condensation	A / U		
Miscellaneous	NA		

LOADING BAY

Date & time: 16-01-18 0505	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Dock levellers	A / U		
Scales & framework	A / U		
Doors & curtains	A / U		
Waste bins	A / U		
Ground pork bone conveyor	A / U		
Boot wash	A / U		
Sample rack	A / U		
Hand wash stations	A / U		
Surface condensation	A / U		

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Date: 09.10.17
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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Engineers entrance	A/U		
Miscellaneous	NA		
OLD LOADING BAY			
Date & time: 12-01-18 0530	QA print & sign: MLUNOX		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Doors	A/U		
Ground pork bone conveyor	A/U		
Miscellaneous	NA		
PACKED CHILL			
Date & time: 11-01-18 0500	QA print & sign: MLUNOX		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Tables	A/U		
Curtains	A/U		
Metal detectors	A/U		
Scales Inc. tables	A/U		
Conveyors	A/U	meat debris and packaging	
Strapper	A/U		
Gravity rollers	A/U		
Waste bins	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
CRYOVAC AREA			
Date & time: 17-01-18 0455	QA print & sign: MLUNOX		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Conveyors	A/U		
Cryovac bag trim vacuum	A/U		
Gravity rollers	A/U		
Cryovac plates	A/U		
Cryovac panels	A/U		
Steam tunnel	A/U		
Table	A/U		
Metal detectors	A/U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Surface condensation	A / U		
Miscellaneous	NA		
CHINA PACKING ROOM			
Date & time: 17-01-18 0510	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Curtains	A / U		
Conveyors	A / U		
Scales	A / U		
Tables	A / U		
Waste bin	A / U		
Inspection table	A / U		
Unfit meat bins	A / U		
Gravity rollers	A / U		
Hand wash station	A / U		
Surface condensation	A / U		
Conveyor catch trays	A / U		
Miscellaneous			
STRINGING ROOM			
Date & time: 17-01-18 0535	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Trim tippers	A / U		
Netter	A / U		
Stringers	A / U		
Netting tube loaders	A / U		
Vacuum pouch loaders	A / U		
Tables	A / U		
Inspection table	A / U		
Unfit meat bins	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
PACKAGING STORE			
Date & time: 17-01-18 0545	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		

Ref.: CP4.033	Authorised By:	Date: 09.10.17
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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Doors & curtains	A / U		
Lights	A / U		
Large bag holders	A / U		
Surface condensation	A / U		
Waste bin	A / U		
Miscellaneous	NA		
TRAYWASH			
Date & time: 19-01-18 0545	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors & curtains	A / U		
Trays	A / U		
Tray wash machine	A / U		
High level tray feed chute	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
OUT FEED CORRIDOR			
Date & time: 12-01-18 0520	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
LINK CORRIDOR			
Date & time: 19-01-18 0535	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation	
Lights	A / U		
Doors & curtains	A / U		
Evaporators	A / U		
Lift	A / U		
Scales & printers	A / U		
Gravity rollers	A / U		
Strapper	A / U	NO Strapper.	
Surface condensation	A / U		
Metal detector	A / U	NO metal detector.	
Miscellaneous	NA		
AMENITY BLOCK			
Date & time: 10-01-18 0510	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Lights	A / U		
Bins	A / U		
Doors	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
GLOVE WASH ROOM			
Date & time: 15-01-18 0527		QA print & sign: MLUNOY	
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Washer machines	A / U	door locked at time of check.	
Storage Rack	A / U		
Lockers	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
BUTCHERY CHANGING			
Date & time: 16-01-18 0500		QA print & sign: MLUNOY	
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Bins	A / U		
Lockers	A / U		
Hand wash station	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
LADIES CHANGING			
Date & time: 16-01-18 0455		QA print & sign: MLUNOY	
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors & curtains	A / U		
Bins	A / U		
Lockers	A / U		
Hand wash stations	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
TOILET FACILITIES			
Date & time: 10-01-18 0520		QA print & sign: MLUNOY	
Men's toilets	A / U		
Ladies toilets	A / U		
Miscellaneous	NA		
CANTEENS			

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**CRANSWICK COUNTRY FOODS PRESTON SITE
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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Date & time: 16-01-18 0515		QA print & sign: MLUNDY MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U	Cracked tile Small Canteen	
Lights	A/U		
Bins	A/U		
Tables & chairs	A/U		
Windowsills	A/U		
Fridges	A/U		
Microwaves	A/U		
Surface condensation	A/U		
Miscellaneous	N/A		

EXPORT ROOM (Old production 80 room)

Date & time: 15-01-18 05:10		QA print & sign: MLUNDY MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors	A/U	N/A	
Bandsaw	A/U		
Conveyers	A/U	Red gloves left on top - USECA	
Table	A/U		
Stringing machines	A/U		
Evaporators	A/U		
Bins	A/U	no bin at time of check.	
Hand wash station	A/U		
Surface condensation	A/U		
Strapper	A/U		
Metal Detector	A/U		
Miscellaneous Curtains	A/U		

EXPORT ROOM BLAST

Date & time: 15-01-18 0520		QA print & sign: MLUNDY MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U		
Doors	A/U		
Surface condensation	A/U		
Miscellaneous - Pipe tape splitting		tape around pipe splitting	

RIB ROOM

Date & time: 19-01-18 0525		QA print & sign: MLUNDY MLUNDY MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U	seal coming off pipe to evaporator	Condensation
Lights	A/U		
Doors	A/U		
Evaporators	A/U		
Scales	A/U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Gravity rollers	A / U		
Conveyors	A / U		
Rib wrapper	A / U		
Tables	A / U		
Strapper	A / U		
Rib saws	A / U		
Surface condensation	A / U		
Metal detector	A / U		
Lima machine & lift	A / U		
Miscellaneous	NA		
GPM HOLDING CHILL			
Date & time: 16-01-18 0530	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Evaporators	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
TRAINING ROOM			
Date & time: 11-01-18 0520	QA print & sign: MLUNDY		
Floor	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Tables	A / U		
Hand wash station	A / U		
Steriliser	A / U		
Miscellaneous	NA		
MARSHALLING CHILL			
Date & time: 11-01-18 0530	QA print & sign: MLUNDY		
Floor & drains	U A / U	meat near gas machines.	
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Evaporators	A / U		
Table	A / U		
Dolav gas flush	A / U		
Scale	A / U		
Conveyors	A / U		
Gravity rollers	A / U		
Surface condensation removed	A / U		
Metal detectors	A / U		

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PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Miscellaneous	NA		
BUTCHERY 2			
Date & time: 18-01-18 0610	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Evaporators	A / U		
Hand wash station	A / U		
Derinders	A / U		
Demembraters	A / U		
Whizzers	A / U		
Pace lines	A / U		
Conveyors	A / U	Broken belt - engineers informed.	
Leg Slicer	A / U		
Tables	A / U		
Trays	A / U		
Dolavs	A / U		
Scales	A / U		
Stringers	A / U		
Cryovac machine	A / U		
Steam tunnel	A / U		
Gravity rollers	A / U		
Supervac machine	A / U		
Office windows	A / U		
Stairs	A / U		
Unfit meat bins	A / U		
Surface condensation	A / U		
QAS Holders	A / U		
X-ray machine	A / U		
X-ray machine stands	A / U		
X-ray machine stand blocks	A / U		
Fat cutter	A / U		
Retail metal detector	A / U	dirt and dust (green)	
Butchery metal detector	A / U		
Automatic scorer	A / U		
Miscellaneous	NA		
BUTCHERY 2 ENTRANCE			
Date & time: 18-01-18 0535	QA print & sign: 0535 MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Boot wash	A / U		

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CODE: A = ACCEPTABLE

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COMMENTS / CORRECTIVE ACTION:

Butchery 1 - Condensation cleared by hygiene, broken belt on middle line reported to engineers and put on pirana.

Cutting line - Condensation removed by hygiene.

Raw chill - Condensation removed by hygiene.

packed chill - meat debris and packaging left overnight on the line, hygiene informed and cleaned the area.

Link Corridor - Condensation removed by hygiene.

Canteens - 1 small cracked tile, engineers informed, completed by the end of the day.

Butchery 2 intake - meat debris cleared by hygiene. cic followed.

Audited by print & sign: *AR A. ANDRUSZAK*

Date & time: 23.01.18

B:07

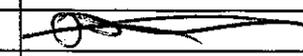
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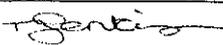
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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
BUTCHERY ENTRANCE			
Date & time: 02-02-18 0510	QA print & sign: M LUNDY  0525.		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation 	
Doors & curtains	A / U		
Lights	A / U		
Sterilisers	A / U		
Steam hood	A / U	Condensation 	
Hand wash station	A / U		
Boot wash	A / U		
Waste bins	A / U		
Equipment lockers & contents	A / U		
Apron hanger	A / U		
Equipment wash & brushes	A / U		
Knife sharpening tables	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
BUTCHERY 1			
Date & time: 23-01-18 0520	QA print & sign: M LUNDY 		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U	reg line middle conveyor meat debris. 	
Blocks/tables	A / U		
Leg derinders	A / U		
Loin derinders	A / U		
Belly derinder	A / U		
Shoulder derinders	A / U		
Demembraners	A / U		
Blade bone pullers	A / U		
Defatting machines	A / U		
Automatic scoring machine	A / U		
Overhead conveyers	A / U		
Deboflex line (including conveyers, butchery blocks, stainless steel guides, saws, derinders)	A / U		
Whizzer motors	A / U		
Chine saw & table	A / U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Perspex screens	A / U		
Conveyor catch trays	A / U		
Fillet strapper	A / U		
Miscellaneous		metal plate loose foreign body meat debris (X1)	
RAW CHILL			
Date & time: 29-01-18 0510	QA print & sign: M LUNOY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Curtains	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Ground pork bone conveyor	A / U		
Lift	A / U		
Metal detector	A / U		
Tables	A / U		
Unfit meat bins	A / U		
Scales	A / U		
Gravity rollers	A / U		
Surface condensation	A / U		
Miscellaneous	U		
LOADING BAY			
Date & time: 24-01-18 0525	QA print & sign: M LUNOY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Dock levellers	A / U		
Scales & framework	A / U		
Doors & curtains	A / U		
Waste bins	A / U		
Ground pork bone conveyor	A / U		
Boot wash	A / U		
Sample rack	A / U		
Hand wash stations	A / U		
Surface condensation	A / U		
Engineers entrance	A / U		
Miscellaneous			

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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
OLD LOADING BAY			
Date & time: 30-01-18 0505	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Doors	A/U		
Ground pork bone conveyor	A/U		
Miscellaneous	NA		
PACKED CHILL			
Date & time: 29-01-18 0525	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Tables	A/U		
Curtains	A/U		
Metal detectors	A/U		
Scales Inc. tables	A/U		
Conveyors	A/U		
Strapper	A/U		
Gravity rollers	A/U		
Waste bins	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
CRYOVAC AREA			
Date & time: 26/1/18 0500	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Conveyors	A/U	parts frozen off the belt	
Cryovac bag trim vacuum	A/U		
Gravity rollers	A/U		
Cryovac plates	A/U		
Cryovac panels	A/U		
Steam tunnel	A/U		
Table	A/U		
Metal detectors	A/U		
Surface condensation	A/U		
Miscellaneous	NA		

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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
CHINA PACKING ROOM			
Date & time: 24-01-18 0540	QA print & sign: M LUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Evaporators	A/U		
Curtains	A/U		
Conveyors	A/U		
Scales	A/U		
Tables	A/U		
Waste bin	A/U		
Inspection table	A/U		
Unfit meat bins	A/U		
Gravity rollers	A/U		
Hand wash station	A/U		
Surface condensation	A/U		
Conveyor catch trays	A/U		
Miscellaneous			
STRINGING ROOM			
Date & time: 26/1/18 0515	QA print & sign: M LUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Evaporators	A/U		
Conveyors	A/U		
Trim tippers	A/U		
Netter	A/U		
Stringers	A/U		
Netting tube loaders	A/U		
Vacuum pouch loaders	A/U		
Tables	A/U		
Inspection table	A/U		
Unfit meat bins	A/U		
Surface condensation	A/U		
Miscellaneous			
PACKAGING STORE			
Date & time: 30-01-18 0515	QA print & sign: M LUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Doors & curtains	A/U		
Lights	A/U		
Large bag holders	A/U		
Surface condensation	A/U		
Waste bin	A/U		
Miscellaneous	NA		

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PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
TRAYWASH			
Date & time: 31-01-18 0505	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors & curtains	A/U		
Trays	A/U		
Tray wash machine	A/U		
High level tray feed chute	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
OUT FEED CORRIDOR			
Date & time: 26-01-18 0500	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	MICADO	Condensation	
Doors	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
LINK CORRIDOR			
Date & time: 30-01-18 0530	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Doors & curtains	A/U		
Evaporators	A/U		
Lift	A/U		
Scales & printers	A/U		
Gravity rollers	A/U		
Strapper	A/U		
Surface condensation	A/U		
Metal detector	A/U		
Miscellaneous	NA		
AMENITY BLOCK			
Date & time: 01-02-18 0540	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Bins	A/U		
Doors	A/U		
Surface condensation	A/U		
Miscellaneous	NA		

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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
GLOVE WASH ROOM			
Date & time: <u>M LUNDY</u>		QA print & sign: <u>02-02-18 0525</u>	
Floor & drains	<u>A/U</u>		
Walls & ceiling	<u>A/U</u>		
Lights	<u>A/U</u>		
Washer machines	<u>A/U</u>		
Storage Rack	<u>A/U</u>		
Lockers	<u>A/U</u>		
Surface condensation	<u>A/U</u>		
Miscellaneous	<u>NA</u>		
BUTCHERY CHANGING			
Date & time: <u>01-02-18 0510</u>		QA print & sign: <u>M LUNDY</u>	
Floor & drains	<u>A/U</u>		
Walls & ceiling	<u>A/U</u>		
Lights	<u>A/U</u>		
Bins	<u>A/U</u>		
Lockers	<u>A/U</u>		
Hand wash station	<u>A/U</u>		
Surface condensation	<u>A/U</u>		
Miscellaneous	<u>NA</u>		
LADIES CHANGING			
Date & time: <u>01-02-18 0515</u>		QA print & sign: <u>M LUNDY</u>	
Floor & drains	<u>A/U</u>		
Walls & ceiling	<u>A/U</u>		
Lights	<u>A/U</u>		
Doors & curtains	<u>A/U</u>		
Bins	<u>A/U</u>		
Lockers	<u>A/U</u>		
Hand wash stations	<u>A/U</u>		
Surface condensation	<u>A/U</u>		
Miscellaneous	<u>NA</u>		
TOILET FACILITIES			
Date & time: <u>01-02-18 0520</u>		QA print & sign: <u>M LUNDY</u>	
Men's toilets	<u>A/U</u>		
Ladies toilets	<u>A/U</u>		
Miscellaneous	<u>NA</u>		
CANTEENS			
Date & time: <u>01-02-18 0530</u>		QA print & sign: <u>M LUNDY</u>	
Floor & drains	<u>A/U</u>		
Walls & ceiling	<u>A/U</u>		
Lights	<u>A/U</u>		
Bins	<u>A/U</u>		
Tables & chairs	<u>A/U</u>		

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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Windowsills	A/U		
Fridges	A/U		
Microwaves	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
EXPORT ROOM (Old production 80 room)			
Date & time: 31-01-18 OS2S	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors	A/U		
Bandsaw	A/U		
Conveyers	A/U		
Table	A/U		
Stringing machines	A/U		
Evaporators	A/U		
Bins	A/U		
Hand wash station	A/U		
Surface condensation	A/U		
Strapper	A/U		
Metal Detector	A/U		
Scales	A/U		
Miscellaneous	NA		
EXPORT ROOM BLAST			
Date & time: 30-01-18 OS4S	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Doors	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
RIB ROOM			
Date & time: 25/1/18 OS1S	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	Seals hanging down/condensation	
Lights	A/U		
Doors	A/U		
Evaporators	A/U		
Scales	A/U		
Gravity rollers	A/U		
Conveyors	A/U		
Rib wrapper	A/U		
Tables	A/U		
Strapper	A/U		
Rib saws	A/U		

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PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE

U = UNACCEPTABLE

AREA / ITEM	A / U (M)	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Surface condensation	A/U		
Metal detector	A/U		
Lima machine & lift	A/U		
Miscellaneous	NA		
GPM HOLDING CHILL			
Date & time: 22-01-18 0505	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Doors/Curtains	A/U		
Evaporators	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
TRAINING ROOM			
Date & time: 22-01-18 0515	QA print & sign: MLUNDY		
Floor	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Tables	A/U		
Hand wash station	A/U		
Steriliser	A/U		
Miscellaneous	NA		
MARSHALLING CHILL			
Date & time: 22-01-18 0530	QA print & sign: 0530 (M) MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Doors/Curtains	A/U		
Evaporators	A/U		
Table	A/U		
Dolav gas flush	A/U		
Scale	A/U		
Conveyors	A/U		
Gravity rollers	A/U		
Surface condensation removed	A/U		
Metal detectors	A/U		
Miscellaneous	NA		
BUTCHERY 2			
Date & time: 02-02-18 0530	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors/Curtains	A/U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Evaporators	A / U	Condensation	
Hand wash station	A / U		
Derinders	A / U		
Demembraters	A / U		
Whizzers	A / U		
Pace lines	A / U		
Conveyors	A / U		
Leg Slicer	A / U		
Tables	A / U		
Trays	A / U		
Dolavs	A / U		
Scales	A / U		
Stringers	A / U		
Cryovac machine	A / U		
Steam tunnel	A / U		
Gravity rollers	A / U		
Supervac machine	A / U		
Office windows	A / U		
Stairs	A / U		
Unfit meat bins	A / U		
Surface condensation	A / U		
QAS Holders	A / U		
X-ray machine	A / U		
X-ray machine stands	A / U		
X-ray machine stand blocks	A / U		
Fat cutter	A / U		
Retail metal detector	A / U		
Butchery metal detector	A / U		
Automatic scorer	A / U		
Miscellaneous		foreign body Diastec	
BUTCHERY 2 ENTRANCE			
Date & time: 26-01-18 0535	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation	
Lights	A / U		
Doors/Curtains	A / U		
Boot wash	A / U		
Hand wash station	A / U		
Knife sharpening tables	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
BUTCHERY 2 INTAKE			
Date & time: 0540	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation	

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PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



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COMMENTS / CORRECTIVE ACTION:

All engineers issue reported and put on pirana.

Butchery entrance / = Condensation removed by hygiene, leg line re-cleaned and removed the meat off the line and floor (sic followed).
Butchery 1

Cutting Line - Condensation removed by hygiene metal plate on the wall was loose, engineers informed and job added to pirana.

Cryovac - Condensation cleared by hygiene, engineers informed about missing parts on belt, job put on pirana.

China packing - Condensation cleared by hygiene

Stringing room - Condensation cleared by hygiene

outfeed corridor - Condensation cleared by hygiene

Link Corridor - Condensation cleared by hygiene

Rib Room - Engineers informed about silicone hanging job put on pirana

CPM/Training - Hygiene removed condensation
Marshalling

B2, B2 entrance - Hygiene removed condensation
Export rm

Audited by print & sign:

S. D. J. C. L. H. J. C. L.

Date & time:

13.03.2018 14:25

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
BUTCHERY ENTRANCE			
Date & time: 15/2/18 0500	QA print & sign: M LUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation	
Doors & curtains	A / U		
Lights	A / U		
Sterilisers	A / U		
Steam hood	A / U	Condensation	
Hand wash station	A / U		
Boot wash	A / U		
Waste bins	A / U		
Equipment lockers & contents	A / U		
Apron hanger	A / U		
Equipment wash & brushes	A / U		
Knife sharpening tables	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
BUTCHERY 1			
Date & time: 15/2/18 0515	QA print & sign: M LUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation	
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Blocks/tables	A / U		
Leg derinders	A / U		
Loin derinders	A / U		
Belly derinder	A / U		
Shoulder derinders	A / U		
Demembraters	A / U		
Blade bone pullers	A / U		
Defatting machines	A / U		
Automatic scoring machine	A / U		
Overhead conveyers	A / U		
Deboflex line (including conveyers, butchery blocks, stainless steel guides, saws, derinders)	A / U		
Whizzer motors	A / U		
Line saw & table	A / U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Shoulder Bone puller	A / U		
Air Inflation Machine	A / U		
Trays	A / U		
Scales	A / U		
Internal use dolavs	A / U		
Inspection table	A / U		
Surface condensation	A / U		
Hand wash station	A / U		
Lifts	A / U		
Strip curtains	A / U		
Miscellaneous		Rusty Speakers-	
CUTTING ROOM			
Date & time: 12-02-18 0455	QA print & sign: MLUND X		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Pre-cut Stands	A / U		
Hand wash station	A / U		
Foot saw	A / U		
Leg saw	A / U		
Shoulder saw	A / U		
Middle saw	A / U		
Chine/scribe saw	A / U		
Fillet machine	A / U		
Metal detector	A / U		
Blocks/tables	A / U		
Gambrel return line	A / U		
Trays	A / U		
Inspection tables	A / U		
Tote bins	A / U		
Scales & printers	A / U		
Sterilisers	A / U		
Internal use dolavs	A / U		
Unfit meat bins	A / U		
Surface condensation	A / U		
Carcass guard rail	A / U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE

U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Perspex screens	A / U		
Conveyor catch trays	A / U		
Fillet strapper	A / U		
Miscellaneous	NA		
RAW CHILL			
Date & time: 2-02-18 0510	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Curtains	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Ground pork bone conveyor	A / U		
Lift	A / U		
Metal detector	A / U		
Tables	A / U		
Unfit meat bins	A / U		
Scales	A / U		
Gravity rollers	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
LOADING BAY			
Date & time: 06/02/18 0530	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Dock levellers	A / U		
Scales & framework	A / U		
Doors & curtains	A / U		
Waste bins	A / U		
Ground pork bone conveyor	A / U		
Boot wash	A / U		
Sample rack	A / U		
Hand wash stations	A / U		
Surface condensation	A / U		
Engineers entrance	A / U		
Miscellaneous	NA.		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
OLD LOADING BAY			
Date & time: 13-02-18 0535	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Doors	A/U		
Ground pork bone conveyor	A/U		
Miscellaneous	NA		
PACKED CHILL			
Date & time: 09-02-18 0515	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Tables	A/U		
Curtains	A/U		
Metal detectors	A/U		
Scales Inc. tables	A/U		
Conveyors	A/U		
Strapper	A/U		
Gravity rollers	A/U		
Waste bins	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
CRYOVAC AREA			
Date & time: 08/02/18 0525	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Conveyors	A/U		
Cryovac bag trim vacuum	A/U		
Gravity rollers	A/U		
Cryovac plates	A/U		
Cryovac panels	A/U		
Steam tunnel	A/U		
Table	A/U		
Metal detectors	A/U		
Surface condensation	A/U		
Miscellaneous	NA		

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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
CHINA PACKING ROOM			
Date & time: 08/02/18	OSIO	QA print & sign: MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U	Hanging down - engineer informed and fixed	
Evaporators	A/U		
Curtains	A/U		
Conveyors	A/U		
Scales	A/U		
Tables	A/U		
Waste bin	A/U		
Inspection table	A/U		
Unfit meat bins	A/U		
Gravity rollers	A/U		
Hand wash station	A/U		
Surface condensation	A/U		
Conveyor catch trays	A/U		
Miscellaneous	NA		
STRINGING ROOM			
Date & time: 13-02-18	OSFO	QA print & sign: MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Conveyors	A/U		
Trim tippers	A/U		
Netter	A/U		
Stringers	A/U		
Netting tube loaders	A/U		
Vacuum pouch loaders	A/U		
Tables	A/U		
Inspection table	A/U		
Unfit meat bins	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
PACKAGING STORE			
Date & time: 13-02-18	OSUS	QA print & sign: MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U		
Doors & curtains	A/U		
Lights	A/U		
Large bag holders	A/U		
Surface condensation	A/U		
Waste bin	A/U		
Miscellaneous	NA		

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PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE

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AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
TRAYWASH			
Date & time: 05-02-18 0535	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors & curtains	A/U		
Trays	A/U		
Tray wash machine	A/U		
High level tray feed chute	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
OUT FEED CORRIDOR			
Date & time: 09-02-18 0905	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Doors	A/U	Condensation	
Surface condensation	A/U		
Miscellaneous	NA		
LINK CORRIDOR			
Date & time: 09-02-18 0525	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	condensation	
Lights	A/U		
Doors & curtains	A/U		
Evaporators	A/U	Condensation	
Lift	A/U		
Scales & printers	A/U		
Gravity rollers	A/U		
Strapper	A/U		
Surface condensation	A/U		
Metal detector	A/U		
Miscellaneous	NA		
AMENITY BLOCK			
Date & time: 16-2-18 0500	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Bins	A/U		
Doors	A/U		
Surface condensation	A/U		
Miscellaneous	MA		

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PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
GLOVE WASH ROOM			
Date & time: 15/2/18 0500	QA print & sign:	MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Washer machines	A/U		
Storage Rack	A/U		
Lockers	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
BUTCHERY CHANGING			
Date & time: 16-2-18 0510	QA print & sign:	MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Bins	A/U		
Lockers	A/U		
Hand wash station	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
LADIES CHANGING			
Date & time: 16-2-18 0510	QA print & sign:	MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors & curtains	A/U		
Bins	A/U		
Lockers	A/U		
Hand wash stations	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
TOILET FACILITIES			
Date & time: 16-2-18 0525	QA print & sign:	MLUNDY	
Men's toilets	A/U		
Ladies toilets	A/U		
Miscellaneous	NA		
CANTEENS			
Date & time: 16-2-18 0540	QA print & sign:	MLUNDY	
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Bins	A/U		
Tables & chairs	A/U		

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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Windowsills	A / U		
Fridges	A / U		
Microwaves	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
EXPORT ROOM (Old production 80 room)			
Date & time: 13-02-18 0520	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors	A / U		
Bandsaw	A / U		
Conveyers	A / U		
Table	A / U		
Stringing machines	A / U		
Evaporators	A / U		
Bins	A / U		
Hand wash station	A / U		
Surface condensation	A / U		
Strapper	A / U		
Metal Detector	A / U		
Scales	A / U		
Miscellaneous	NA		
EXPORT ROOM BLAST			
Date & time: 13-02-18 0520	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Doors	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
RIB ROOM			
Date & time: 14-02-18 0510	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors	A / U		
Evaporators	A / U	Condensation	
Scales	A / U		
Gravity rollers	A / U		
Conveyors	A / U		
Rib wrapper	A / U		
Tables	A / U		
Strapper	A / U		
Rib saws	A / U		

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AREA / ITEM	A/U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Surface condensation	A/U		
Metal detector	A/U		
Lima machine & lift	A/U		
Miscellaneous	NA		
<u>GPM HOLDING CHILL</u>			
Date & time: 16-02-18 0525	QA print & sign: MLUNOY		
Floor & drains	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Doors/Curtains	A/U		
Evaporators	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
<u>TRAINING ROOM</u>			
Date & time: 09-02-18 0540	QA print & sign: MLUNOY		
Floor	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Tables	A/U		
Hand wash station	A/U		
Steriliser	A/U		
Miscellaneous	NA		
<u>MARSHALLING CHILL</u>			
Date & time: 06/02/18 0515	QA print & sign: MLUNOY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors/Curtains	A/U		
Evaporators	A/U		
Table	A/U		
Dolav gas flush	A/U		
Scale	A/U		
Conveyors	A/U		
Gravity rollers	A/U		
Surface condensation removed	A/U		
Metal detectors	A/U		
Miscellaneous	NA		
<u>BUTCHERY 2</u>			
Date & time: 12/2/18 0530	QA print & sign: MLUNOY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors/Curtains	A/U		

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AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Evaporators	A / U		
Hand wash station	A / U		
Derinders	A / U		
Demembraners	A / U		
Whizzers	A / U		
Pace lines	A / U		
Conveyors	A / U		
Leg Slicer	A / U		
Tables	A / U		
Trays	A / U		
Dolavs	A / U		
Scales	A / U		
Stringers	A / U		
Cryovac machine	A / U		
Steam tunnel	A / U		
Gravity rollers	A / U		
Supervac machine	A / U		
Office windows	A / U		
Stairs	A / U		
Unfit meat bins	A / U		
Surface condensation	A / U		
QAS Holders	A / U		
X-ray machine	A / U		
X-ray machine stands	A / U		
X-ray machine stand blocks	A / U		
Fat cutter	A / U		
Retail metal detector	A / U		
Butchery metal detector	A / U		
Automatic scorer	A / U		
Miscellaneous	NA		
BUTCHERY 2 ENTRANCE			
Date & time: 06/02/18 0530	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Boot wash	A / U		
Hand wash station	A / U		
Knife sharpening tables	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
BUTCHERY 2 INTAKE			
Date & time: 06/02/18 0540	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		

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AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Lights	A / U		
Doors/Curtains	A / U		
Evaporators	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
EXPORT ROOM			
Date & time: 08-02-18 0515.		QA print & sign: MLUNDY <i>ML</i>	
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Waste bins	A / U		
Hand wash station	A / U		
Conveyors	A / U		
Strapping machine	A / U		
Metal detector	A / U		
Dolav lifter	A / U		
Scales	A / U		
Stringers	A / U		
Surface condensation	A / U		
Miscellaneous	NA		

When checking "Hand wash stations" please ensure that the sink is clean, soap & sanitiser are full and that the hand dryers are clean and in working order.

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CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT



CODE: A = ACCEPTABLE

U = UNACCEPTABLE

COMMENTS / CORRECTIVE ACTION:

Butchery entrance/ Butchery 1 - Hygiene came and removed condensation.
Rusty spearkers in several areas issue was reported to engineers and put on prana

Cryovac area - hygiene came and cleared the condensation.

china packing - light hanging from the ceiling engineers called and came straight away and put back in place.

outfeed Corridor - Hygiene cleared condensation

Link Corridor - Hygiene cleared condensation

Rib Room - Hygiene cleared condensation.

CAM Holding - Hygiene cleared condensation.

Audited by print & sign: *V. Whitman*

Date & time: 22.02.18 07.10

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CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT



CODE: A = ACCEPTABLE

U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
BUTCHERY ENTRANCE			
Date & time: 23/2/18 0530	QA print & sign: MLUNDY		
Floor & drains	A U		
Walls & ceiling	A U		
Doors & curtains	A U		
Lights	A U		
Sterilisers	A U		
Steam hood	A U	Condensation	
Hand wash station	A U		
Boot wash	A U		
Waste bins	A U		
Equipment lockers & contents	A U		
Apron hanger	A U		
Equipment wash & brushes	A U		
Knife sharpening tables	A U		
Surface condensation	A U		
Miscellaneous	NA		
BUTCHERY 1			
Date & time: 26/02/18 0500	QA print & sign: MLUNDY		
Floor & drains	A U		
Walls & ceiling	A U		
Lights	A U		
Evaporators	A U		
Conveyors	A U		
Blocks/tables	A U		
Leg derinders	A U		
Loin derinders	A U		
Belly derinder	A U		
Shoulder derinders	A U		
Demembraners	A U		
Blade bone pullers	A U		
Defatting machines	A U		
Automatic scoring machine	A U		
Overhead conveyers	A U		
Deboflex line (including conveyers, butchery blocks, stainless steel guides, saws, derinders)	A U		
Whizzer motors	A U		
Chine saw & table	A U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Shoulder Bone puller	A/U		
Air Inflation Machine	A/U		
Trays	A/U		
Scales	A/U		
Internal use dolavs	A/U		
Inspection table	A/U		
Surface condensation	A/U		
Hand wash station	A/U		
Lifts	A/U		
Strip curtains	A/U		
Miscellaneous	NA		
CUTTING ROOM			
Date & time: 01/03/18 0530	QA print & sign: MLUNOX		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Conveyors	A/U		
Pre-cut Stands	A/U		
Hand wash station	A/U		
Foot saw	A/U		
Leg saw	A/U		
Shoulder saw	A/U		
Middle saw	A/U		
Chine/scribe saw	A/U		
Fillet machine	A/U		
Metal detector	A/U		
Blocks/tables	A/U		
Gambrel return line	A/U		
Trays	A/U		
Inspection tables	A/U		
Tote bins	A/U		
Scales & printers	A/U		
Sterilisers	A/U		
Internal use dolavs	A/U		
Unfit meat bins	A/U		
Surface condensation	A/U		
Carcass guard rail	A/U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE

U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Perspex screens	A / U		
Conveyor catch trays	A / U		
Fillet strapper	A / U		
Miscellaneous	NA		
RAW/CHILL			
Date & time: 26/2/18 0535	QA print & sign: MLUNOY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Curtains	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Ground pork bone conveyor	A / U		
Lift	A / U		
Metal detector	A / U		
Tables	A / U		
Unfit meat bins	A / U		
Scales	A / U		
Gravity rollers	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
LOADING BAY			
Date & time: 19/02/18 0505	QA print & sign: MLUNOY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Dock levellers	A / U		
Scales & framework	A / U		
Doors & curtains	A / U		
Waste bins	A / U		
Ground pork bone conveyor	A / U		
Boot wash	A / U		
Sample rack	A / U		
Hand wash stations	A / U		
Surface condensation	A / U		
Engineers entrance	A / U		
Miscellaneous	NA		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE

U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
OLD LOADING BAY			
Date & time: 19/2/18 0525	QA print & sign: MLUNOY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Doors	A/U		
Ground pork bone conveyor	A/U		
Miscellaneous	NA		
PACKED CHILL			
Date & time: 27/2/18 0500	QA print & sign: MLUNOY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Tables	A/U		
Curtains	A/U		
Metal detectors	A/U		
Scales Inc. tables	A/U		
Conveyors	A/U	meat left on conveyor.	
Strapper	A/U		
Gravity rollers	A/U		
Waste bins	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
CRYOVAC AREA			
Date & time: 27/2/18 0515	QA print & sign: MLUNOY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Conveyors	A/U		
Cryovac bag trim vacuum	A/U		
Gravity rollers	A/U		
Cryovac plates	A/U		
Cryovac panels	A/U		
Steam tunnel	A/U		
Table	A/U		
Metal detectors	A/U		
Surface condensation	A/U		
Miscellaneous	NA		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
CHINA PACKING ROOM			
Date & time: 27/2/18 0525	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Curtains	A / U		
Conveyors	A / U		
Scales	A / U		
Tables	A / U		
Waste bin	A / U		
Inspection table	A / U		
Unfit meat bins	A / U		
Gravity rollers	A / U		
Hand wash station	A / U		
Surface condensation	A / U		
Conveyor catch trays	A / U		
Miscellaneous	NA		
STRINGING ROOM			
Date & time: 27/2/18 0535	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Trim tippers	A / U		
Netter	A / U		
Stringers	A / U		
Netting tube loaders	A / U		
Vacuum pouch loaders	A / U		
Tables	A / U		
Inspection table	A / U		
Unfit meat bins	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
PACKAGING STORE			
Date & time: 01/03/2018 0550	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Doors & curtains	A / U		
Lights	A / U		
Large bag holders	A / U		
Surface condensation	A / U		
Waste bin	A / U		
Miscellaneous	NA		

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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
TRAYWASH			
Date & time: 19/2/18 0540	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors & curtains	A/U		
Trays	A/U		
Tray wash machine	A/U		
High level tray feed chute	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
OUT FEED CORRIDOR			
Date & time: 22/2/18 0500	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
LINK CORRIDOR			
Date & time: 22/2/18 0510	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors & curtains	A/U		
Evaporators	A/U		
Lift	A/U		
Scales & printers	A/U		
Gravity rollers	A/U		
Strapper	A/U		
Surface condensation	A/U		
Metal detector	A/U		
Miscellaneous	NA		
AMENITY BLOCK			
Date & time: 21/2/18 0520	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Bins	A/U		
Doors	A/U		
Surface condensation	A/U		
Miscellaneous	NA		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
GLOVE WASH ROOM			
Date & time: 02/03/18 0445	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Washer machines	A/U		
Storage Rack	A/U		
Lockers	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
BUTCHERY CHANGING			
Date & time: 21/2/18 0500	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Bins	A/U		
Lockers	A/U		
Hand wash station	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
LADIES CHANGING			
Date & time: 21/2/18 0500	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors & curtains	A/U		
Bins	A/U		
Lockers	A/U		
Hand wash stations	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
TOILET FACILITIES			
Date & time: 21/2/18 0520	QA print & sign: MLUNDY		
Men's toilets	A/U		
Ladies toilets	A/U		
Miscellaneous	NA		
CANTEENS			
Date & time: 21/2/18 0530	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Bins	A/U		
Tables & chairs	A/U		

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AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Windowsills	A / U		
Fridges	A / U		
Microwaves	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
EXPORT ROOM (Old production 80 room)			
Date & time: 28/02/18 0500	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation	
Lights	A / U		
Doors	A / U		
Bandsaw	A / U		
Conveyers	A / U		
Table	A / U		
Stringing machines	A / U		
Evaporators	A / U		
Bins	A / U		
Hand wash station	A / U		
Surface condensation	A / U		
Strapper	A / U		
Metal Detector	A / U		
Scales	A / U		
Miscellaneous	NA		
EXPORT ROOM BLAST			
Date & time: 28-02-18 0515	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Doors	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
RIB ROOM			
Date & time: 20/2/18 0525	QA print & sign: MLUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Silicone / mouldy / conductor wet	
Lights	A / U		
Doors	A / U		
Evaporators	A / U		
Scales	A / U		
Gravity rollers	A / U		
Conveyors	A / U		
Rib wrapper	A / U		
Tables	A / U		
Strapper	A / U		
Rib saws	A / U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE

U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Surface condensation	A / U		
Metal detector	A / U		
Lima machine & lift	A / U		
Miscellaneous	NA		
CPM HOLDING CHILL			
Date & time: 28/2/18 0520	QA print & sign: MUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation	
Lights	A / U		
Doors/Curtains	A / U		
Evaporators	A / U		
Surface condensation	A / U		
Miscellaneous			
TRAINING ROOM			
Date & time: 28/2/18 0535	QA print & sign: MUNDY		
Floor	A / U		
Walls & ceiling	A / U	Condensation	
Lights	A / U		
Tables	A / U		
Hand wash station	A / U		
Steriliser	A / U		
Miscellaneous	NA		
MARSHALLING CHILL			
Date & time: 23/2/18 0500	QA print & sign: MUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Evaporators	A / U		
Table	A / U		
Dolav gas flush	A / U		
Scale	A / U		
Conveyors	A / U		
Gravity rollers	A / U		
Surface condensation removed	A / U		
Meta! detectors	A / U		
Miscellaneous	NA		
BUTCHERY 2			
Date & time: 02/03/18 0500	QA print & sign: MUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U	Condensation.	
Lights	A / U		
Doors/Curtains	A / U		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Evaporators	A / U		
Hand wash station	A / U		
Derinders	A / U		
Demembraners	A / U		
Whizzers	A / U		
Pace lines	A / U		
Conveyors	A / U		
Leg Slicer	A / U		
Tables	A / U		
Trays	A / U		
Dolavs	A / U		
Scales	A / U		
Stringers	A (U)	meat & string inside	DD
Cryovac machine	A / U		
Steam tunnel	A / U		
Gravity rollers	A / U		
Supervac machine	A / U		
Office windows	A / U		
Stairs	A / U		
Unfit meat bins	A / U		
Surface condensation	A / U		
QAS Holders	A / U		
X-ray machine	A / U		
X-ray machine stands	A / U		
X-ray machine stand blocks	A / U		
Fat cutter	A / U		
Retail metal detector	A / U		
Butchery metal detector	A / U		
Automatic scorer	A / U		
Miscellaneous	NA		

BUTCHERY 2 ENTRANCE

Date & time: 20/3/18 0500	QA print & sign: M LUNDY	
Floor & drains	A / U	
Walls & ceiling	A / U	Condensation
Lights	A / U	
Doors/Curtains	A / U	
Boot wash	A / U	
Hand wash station	A / U	
Knife sharpening tables	A / U	
Surface condensation	A / U	
Miscellaneous	NA	

BUTCHERY 2 INTAKE

Date & time: 20/3/18 0515	QA print & sign: M LUNDY	
Floor & drains	A / U	
Walls & ceiling	A / U	

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PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE

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AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Evaporators	A / U		
Surface condensation	A / U		
Miscellaneous	NA		
EXPORT ROOM			
Date & time: 20/3/18 0530		QA print & sign: MULLNOY	
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Waste bins	A / U		
Hand wash station	A / U		
Conveyors	A / U		
Strapping machine	A / U		
Metal detector	A / U		
Dolav lifter	A / U		
Scales	A / U		
Stringers	A / U		
Surface condensation	A / U		
Miscellaneous	NA		

When checking "Hand wash stations" please ensure that the sink is clean, soap & sanitiser are full and that the hand dryers are clean and in working order.

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PRIMAL PRE-PRODUCTION HYGIENE AUDIT



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COMMENTS / CORRECTIVE ACTION:

Butchery Entrance - hygiene came and cleared the condensation.

Packed Chill - hygiene removed 2 packaged shoulder joints from the line, left overnight. hygiene disposed of meat.

Export Room - hygiene came and removed condensation

Rib Room - Hygiene came and cleared condensation engineers informed about silicone and mould.

CPM Holding - Hygiene came and cleared condensation

Training Room - Hygiene cleared the condensation

Butchery 2/- Hygiene cleared the condensation.

Butchery 2 entrance. Hygiene came back to the area and re-cleaned stringers and removed. String. cic followed.

Audited by print & sign: J. Wojcik

Date & time: 08.03.2018 13:25

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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
BUTCHERY ENTRANCE			
Date & time: 14/03/18 0505		QA print & sign: MLUNDY	
Floor & drains	A / U		
Walls & ceiling	A / U		
Doors & curtains	A / U		
Lights	A / U		
Sterilisers	A / U		
Steam hood	A / U		
Hand wash station	A / U		
Boot wash	A / U		
Waste bins	A / U		
Equipment lockers & contents	A / U		
Apron hanger	A / U		
Equipment wash & brushes	A / U		
Knife sharpening tables	A / U		
Surface condensation	A / U		
Miscellaneous	NA.		
BUTCHERY 1			
Date & time: 14/03/18 0520		QA print & sign: MLUNDY	
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Blocks/tables	A / U		
Leg derinders	A / U		
Loin derinders	A / U		
Belly derinder	A / U		
Shoulder derinders	A / U		
Demembraters	A / U		
Blade bone pullers	A / U		
Defatting machines	A / U		
Automatic scoring machine	A / U		
Overhead conveyers	A / U		
Deboflex line (including conveyers, butchery blocks, stainless steel guides, saws, derinders)	A / U		
Whizzer motors	A / U		
Chine saw & table	A / U		

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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Shoulder Bone puller	A / U		
Air Inflation Machine	A / U		
Trays	A / U		
Scales	A / U		
Internal use dolavs	A / U		
Inspection table	A / U		
Surface condensation	A / U		
Hand wash station	A / U		
Lifts	A / U		
Strip curtains	A / U		
Miscellaneous	NA		
CUTTING ROOM			
Date & time: 14/02/18 05:00	QA print & sign: M. LUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Pre-cut Stands	A / U		
Hand wash station	A / U		
Foot saw	A / U		
Leg saw	A / U		
Shoulder saw	A / U		
Middle saw	A / U		
Chine/scribe saw	A / U		
Fillet machine	A / U		
Metal detector	A / U		
Blocks/tables	A / U		
Gambrel return line	A / U		
Trays	A / U		
Inspection tables	A / U		
Tote bins	A / U		
Scales & printers	A / U		
Sterilisers	A / U		
Internal use dolavs	A / U		
Unfit meat bins	A / U		
Surface condensation	A / U		
Carcass guard rail	A / U		

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CODE: A = ACCEPTABLE

U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Perspex screens	A / U		
Conveyor catch trays	A / U		
Fillet strapper	A / U		
Miscellaneous	NA		
RAW CHILL			
Date & time: 5/3/18 4:50	QA print & sign: IAN SMITH		
Floor & drains	A / U		
Walls & ceiling	A / U		
Curtains	A / U		
Lights	A / U		
Evaporators	A / U		
Conveyors	A / U		
Ground pork bone conveyor	A / U		
Lift	A / U		
Metal detector	A / U		
Tables	A / U		
Unfit meat bins	A / U		
Scales	A / U		
Gravity rollers	A / U		
Surface condensation	A / U		
Miscellaneous			
LOADING BAY			
Date & time: 12/03/18 05:45	QA print & sign: M LUNDY		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Evaporators	A / U		
Dock levellers	A / U		
Scales & framework	A / U		
Doors & curtains	A / U		
Waste bins	A / U		
Ground pork bone conveyor	A / U		
Boot wash	A / U		
Sample rack	A / U		
Hand wash stations	A / U		
Surface condensation	A / U		
Engineers entrance	A / U		
Miscellaneous	NA		
OLD LOADING BAY			

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CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A/U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
OS DS			
Date & time: 13/03/18	QA print & sign: <i>MUNOY</i>		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Doors	A/U		
Ground pork bone conveyor	A/U		
Miscellaneous	NA		
PACKED CHILL			
Date & time: 5/3/18	QA print & sign: <i>IAN SMITH</i>		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Tables	A/U		
Curtains	A/U		
Metal detectors	A/U		
Scales Inc. tables	A/U		
Conveyors	A/U		
Strapper	A/U		
Gravity rollers	A/U		
Waste bins	A/U		
Surface condensation	A/U		
Miscellaneous			
CRYOVAC AREA			
Date & time: 13/03/18	QA print & sign: <i>MUNOY</i>		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Conveyors	A/U		
Cryovac bag trim vacuum	A/U		
Gravity rollers	A/U		
Cryovac plates	A/U		
Cryovac panels	A/U		
Steam tunnel	A/U		
Table	A/U		
Metal detectors	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
CHINA PACKING ROOM			

Ref.: CP4.033	Authorised By:	Date: 28.02.18
Page 4 of 12	P.Pietrowski	Issue No. 10

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
STRINGING ROOM			
Date & time: 16/3/18 0535	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Curtains	A/U		
Conveyors	A/U		
Scales	A/U		
Tables	A/U		
Waste bin	A/U		
Inspection table	A/U		
Unfit meat bins	A/U		
Gravity rollers	A/U		
Hand wash station	A/U		
Surface condensation	A/U		
Conveyor catch trays	A/U		
Miscellaneous	NA		
STRINGING ROOM			
Date & time: 16/3/18 0545	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Evaporators	A/U		
Conveyors	A/U		
Trim tippers	A/U		
Netter	A/U		
Stringers	A/U		
Netting tube loaders	A/U		
Vacuum pouch loaders	A/U		
Tables	A/U		
Inspection table	A/U		
Unfit meat bins	A/U		
Surface condensation	A/U		
Miscellaneous			
PACKAGING STORE			
Date & time: 15/03/18 0510	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Doors & curtains	A/U		
Lights	A/U		
Large bag holders	A/U		
Surface condensation	A/U		
Waste bin	A/U		
Miscellaneous	NA		
TRAYWASH			

Ref.: CP4.033	Authorised By:	Date: 28.02.18
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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
OUT FEED CORRIDOR			
Date & time:	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors & curtains	A/U		
Trays	A/U		
Tray wash machine	A/U		
High level tray feed chute	A/U		
Surface condensation	A/U		
Miscellaneous			
LINK CORRIDOR			
Date & time: 15/03/18 0800	QA print & sign: MUNDY		
Floor & drains	A/U		
Walls & ceiling	NA	Condensation.	
Lights	A/U		
Doors	A/U		
Surface condensation	A/U		
Miscellaneous	NA		
AMENITY BLOCK			
Date & time: 6/3/18 5-15	QA print & sign: LAW SMITH		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Bins	A/U		
Doors	A/U		
Surface condensation	A/U		
Miscellaneous			
GLOVE WASH ROOM			
Date & time: 6/3/18 5-30	QA print & sign: LAW SMITH		

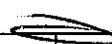
Ref.: CP4.033	Authorised By:	Date: 28.02.18
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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Washer machines	A / U		
Storage Rack	A / U		
Lockers	A / U		
Surface condensation	A / U		
Miscellaneous			
BUTCHERY CHANGING			
Date & time: 7/3/18 5.30	QA print & sign: IAIN SMITH 		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Bins	A / U		
Lockers	A / U		
Hand wash station	A / U		
Surface condensation	A / U		
Miscellaneous			
LADIES CHANGING			
Date & time: 9/3/18 5.00	QA print & sign: IAIN SMITH 		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors & curtains	A / U		
Bins	A / U		
Lockers	A / U		
Hand wash stations	A / U		
Surface condensation	A / U		
Miscellaneous			
TOILET FACILITIES			
Date & time: 8/3/18	QA print & sign: IAIN SMITH 		
Men's toilets	A / U		
Ladies toilets	A / U		
Miscellaneous			
CANTEENS			
Date & time: 8/3/18	QA print & sign: IAIN SMITH 		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Bins	A / U		
Tables & chairs	A / U		
Windowsills	A / U		
Fridges	A / U		
Microwaves	A / U		

Ref.: CP4.033	Authorised By:	Date: 28.02.18
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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A/U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Surface condensation	A/✓		
Miscellaneous			
EXPORT ROOM (Old production 80 room)			
Date & time: 15/03/18 0505	QA print & sign: MLUNDY		
Floor & drains	A/✓		
Walls & ceiling	X/U	Condensation	
Lights	A/✓		
Doors	A/✓		
Bandsaw	A/✓		
Conveyers	X/U	Condensation	
Table	A/✓		
Stringing machines	A/✓		
Evaporators	A/✓		
Bins	A/✓		
Hand wash station	A/U		
Surface condensation	A/✓		
Strapper	A/✓		
Metal Detector	A/✓		
Scales	A/✓		
Miscellaneous	NA		
EXPORT ROOM BLAST			
Date & time: 15/03/18 0520	QA print & sign: MLUNDY		
Floor & drains	A/✓		
Walls & ceiling	A/✓		
Doors	X/U	Condensation	
Surface condensation	A/✓		
Miscellaneous	NA		
RIB ROOM			
Date & time: 15/03/18 0530	QA print & sign: MLUNDY		
Floor & drains	A/✓		
Walls & ceiling	A/✓		
Lights	A/✓		
Doors	A/✓		
Evaporators	A/✓		
Scales	A/✓		
Gravity rollers	A/✓		
Conveyors	A/✓		
Rib wrapper	A/✓		
Tables	A/✓		
Strapper	A/✓		
Rib saws	A/✓		
Surface condensation	A/✓		
Metal detector	A/✓		
Lima machine & lift	A/✓		

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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Miscellaneous	NA		
CPM HOLDING CHILL			
Date & time: 12/03/18 0500	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U	Condensation	
Lights	A/U		
Doors/Curtains	A/U		
Evaporators	A/U	Condensation	
Surface condensation	A/U		
Miscellaneous	NA		
TRAINING ROOM			
Date & time: 12/03/18 0515	QA print & sign: MLUNDY		
Floor	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Tables	A/U		
Hand wash station	A/U		
Steriliser	A/U		
Miscellaneous	NA		
MARSHALLING CHILL			
Date & time: 12/03/18 0535	QA print & sign: MLUNDY		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors/Curtains	A/U		
Evaporators	A/U		
Table	A/U		
Dolav gas flush	A/U		
Scale	A/U		
Conveyors	A/U		
Gravity rollers	A/U		
Surface condensation removed	A/U		
Metal detectors	A/U		
Miscellaneous	NA		
BUTCHERY 2			
Date & time: 7/3/18 5-00	QA print & sign: SAUL LAW SMITH		
Floor & drains	A/U		
Walls & ceiling	A/U		
Lights	A/U		
Doors/Curtains	A/U		
Evaporators	A/U		
Hand wash station	A/U		
Derinders	A/U		

Ref.: CP4.033	Authorised By:	Date: 28.02.18
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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Demembraters	A / U		
Whizzers	A / U		
Pace lines	A / U		
Conveyors	A / U		
Leg Slicer	A / U		
Tables	A / U		
Trays	A / U		
Dolavs	A / U		
Scales	A / U		
Stringers	A / U		
Cryovac machine	A / U		
Steam tunnel	A / U		
Gravity rollers	A / U		
Supervac machine	A / U		
Office windows	A / U		
Stairs	A / U		
Unfit meat bins	A / U		
Surface condensation	A / U		
QAS Holders	A / U		
X-ray machine	A / U		
X-ray machine stands	A / U		
X-ray machine stand blocks	A / U		
X-ray conveyors	A / U		
X-ray rollers	A / U		
Loading conveyors	A / U		
Drop meat hatch	A / U		
Fat cutter	A / U		
Retail metal detector	A / U		
Butchery metal detector	A / U		
Automatic scorer	A / U		
Miscellaneous			
BUTCHERY 2 ENTRANCE			
Date & time: 8/3/18 5:20	QA print & sign: IAIN SMITH		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Boot wash	A / U		
Hand wash station	A / U		
Knife sharpening tables	A / U		
Surface condensation	A / U		
Miscellaneous			
BUTCHERY 2 INTAKE			
Date & time: 8/3/18 5:45	QA print & sign: IAIN SMITH		
Floor & drains	A / U		

Ref.: CP4.033	Authorised By:	Date: 28.02.18
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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT**



CODE: A = ACCEPTABLE U = UNACCEPTABLE

AREA / ITEM	A / U	ITEM & DEFICIENCY	HYGIENE TO SIGN OFF WHEN CLEAN
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Evaporators	A / U		
Surface condensation	A / U		
Miscellaneous			
EXPORT ROOM			
Date & time: 21/3/18 5:25	QA print & sign: IAIN SMITH		
Floor & drains	A / U		
Walls & ceiling	A / U		
Lights	A / U		
Doors/Curtains	A / U		
Waste bins	A / U		
Hand wash station	A / U		
Conveyors	A / U		
Strapping machine	A / U		
Metal detector	A / U		
Dolav lifter	A / U		
Scales	A / U		
Stringers	A / U		
Surface condensation	A / U		
Miscellaneous			

When checking "Hand wash stations" please ensure that the sink is clean, soap & sanitiser are full and that the hand dryers are clean and in working order.

Ref.: CP4.033	Authorised By:	Date: 28.02.18
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CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL PRE-PRODUCTION HYGIENE AUDIT



CODE: A = ACCEPTABLE

U = UNACCEPTABLE

COMMENTS / CORRECTIVE ACTION:

outfeed Corridor - hygiene came and cleared the
Condensation.

Export Room - hygiene came and cleared the
Condensation
Export room
blast.

CPM HOLDING - hygiene came and cleared the
Condensation

Audited by print & sign:

P. Pietrowski

Date & time:

19.03.2018 12:29

Ref.: CP4.033	Authorised By:	Date: 28.02.18
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**CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL METAL DETECTOR SHEET**



Area	Settings	Ferrous	Non Ferrous	Stainless Steel
1	Marshalling Chill 1	1	7.0mm	7.0mm
2	Marshalling Chill 2	1	7.0mm	7.0mm
3	Cryovac Dip Tank 1	1	6.0mm	8.0mm
4	Cryovac Dip Tank 2	1	6.0mm	8.0mm
5	Butchery 2	1	5.0mm	7.0mm
6	Raw Chill	1	7.0mm	9.0mm
7	Rib Room	1	3.5mm	4.5mm
8	Rib Room	2	4.0mm	4.5mm
9	Rib Room	3	8.0mm	8.0mm
10	Offal packing	1	5.5mm	5.5mm
11	Offal packing	2	8.0mm	7.0mm
12	Offal Tongue packing	1	2.0mm	3.0mm
13	Butchery 1	1	7.0mm	7.0mm
14	Link corridor	1	8.0mm	8.0mm
15	Link corridor	2	7.0mm	7.0mm

Date: 18-9-17 Line/Area: 2.15 Room

Time	EVERY NEW BATCH DELIVERED QA'S ARE TO TEST : 1 OF EACH SIZE PLASTER & 1 PEN	QA Print & Sign
Delivery date:	Plaster batch code:	Rejected Yes/No:
Delivery date:	Pen batch code:	Rejected Yes/No:
Delivery date:	Highlighter pen batch code:	Rejected Yes/No:
Delivery date:	Marker pen batch code:	Rejected Yes/No:

Time	Product Description	Area (As Listed Above)	Ferrous Pass/Fail **	Non Ferrous Pass/Fail **	Stainless Steel Pass/Fail **	Belt Stop Pass/Fail **	Reset & cage keys Removed Yes/No	Check Conducted by, Print and Sign
Pre-Test								
6:30	L/Ribs	9	Pass	Pass	Pass	Pass	Yes	Bristow Cowan
Post-Test								
7:05	L/Ribs	7	Pass	Pass	Pass	Pass	Yes	Whitaker Cowan
7:30	L/Ribs	7	Pass	Pass	Pass	Pass	Yes	Whitaker Cowan
8:30	L/Ribs	7	Pass	Pass	Pass	Pass	Yes	Whitaker Cowan
9:20	L/Ribs	7	Pass	Pass	Pass	Pass	Yes	Whitaker Cowan
10:15	L/Ribs	7	Pass	Pass	Pass	Pass	Yes	Bristow Cowan
11:45	L/Ribs	7	Pass	Pass	Pass	Pass	Yes	Whitaker Cowan
12:15	L/Ribs	7	Pass	Pass	Pass	Pass	Yes	Whitaker Cowan
13:15	L/Ribs	7	Pass	Pass	Pass	Pass	Yes	Whitaker Cowan

** Please note the PASS / FAIL must be wrote in full **

Ref: CCP3.1	Authorised By:	Date: 04.08.17
Page: 1 of 2		Issue No. 36

Any signature on this form denotes that the task has been completed satisfactorily in accordance with the instructions.

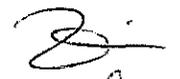
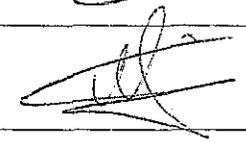
CRANSWICK COUNTRY FOODS PRESTON SITE
PRIMAL METAL DETECTOR SHEET

CRANSWICK
COUNTRY FOODS

Verification Check:

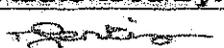
Time	Line No	Product Description	Settings (Products listed above)	Ferrous Pass/Fail	Non Ferrous Pass/Fail	Stainless Steel Pass/Fail	Belt stop Pass/Fail	Reset & cage keys Removed Yes/No	Can unauthorised personnel reset the metal detector? Yes or No	Metal Present Yes/No	Verified by Print & Sign
7.30	Rib room	L/Ribs	7	Pass	Pass	Pass	Pass	Yes	NO	NO	Burton

(Corrective Action must be stated, and must state as a result what is going to happen to prevent reoccurrence of the same issue)

INCIDENT & TIME	AREA/PRODUCT	PERSON(S) INFORMED	ROOT CAUSE - 5 Whys	CORRECTIVE ACTION TAKEN and PREVENTION METHOD	SIGNATURE
8:55 am METAL FOUND ON RIBS (L/R)	RIBS ROOM LOW RIBS	Neil Willis QA SUPERVISOR		REMOVED FROM LINE INFORMED QA + Neil Willis	
					

** Please note PASS / FAIL must be wrote in full **

Audited By Print/Sign D. KONIUNY Date/Time 18.09.17 23:10

Ref: CCP3.1	Authorised By:	Date: 04.08.17
Page: 2 of 2		Issue No. 36

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Jose Osuna

From: Jessica MacKintosh
Sent: 18 September 2017 14:17:23
To: John Clappison
Cc: Matthew Brown
Subject: FW: Bullet

Hi John,

Following my call earlier please see the images attached of the item found, as mentioned, it is light in weight but definitely metal as it was the metal detector that found it.

Slapmark: YD1809, killed on 15/09/2017.

We think it is likely the pig (piglet) was accidentally shot on the breeding unit by someone who shouldn't have been there with a BB gun or similar aiming at a target and missing.

Please could you ask all breeding, nursery and finishing units to keep an eye out for people shooting, entry wounds on piglets and signs of people being around the pigs without permission. Can you please confirm via email that this has been done so I can close the investigation.

Kind regards,

Jess

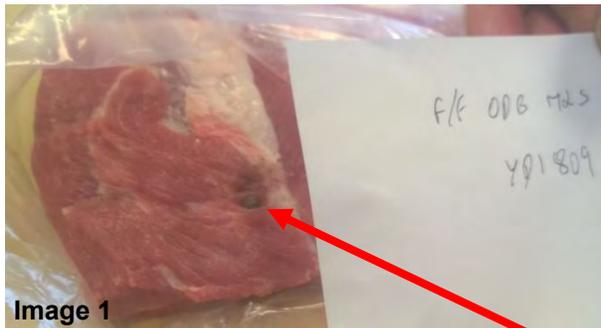
Jessica Mackintosh
Cranswick Country Foods | Agriculture Supply Chain Manager |
Staites Road | Preston | Hull | HU12 8TB |
Mob:07881091310 | Email: jessica.mackintosh@cranswick.co.uk



Reference:Annex CP3.015 18/09/17 F8

Metal found in rib rack: 18/09/17

Issue: A 5mm metal ball was picked up by the metal detector found within a rib rack being produced for M&S.



Images 1 & 2 show the metal found in the meat. Image 3 shows the metal is about 5mm round.

This was traced back to the slap: YD1809 (Packington Pork), killed on 15.09.17, nothing was stated on the FCI regarding metal in any pig.

Conclusion: Looking at the shape of the metal and its weight it is likely it has come from some type of BB gun. As the pigs are outdoor bred it is likely that someone was shooting/ target practicing close by, possibly in the surrounding trees and accidentally shot a piglet, rather than it occurring in the finishing stages. The entry wound would have healed quickly and gone unnoticed hence why nothing was declared on the FCI as the farmer would have been unaware of any issues.

Action taken: Packington Pork were contacted on 18.09.17 regarding this incident. An email was sent to John Clappison, Production Director at Packington Pork. They are going to contact

all breeding units and ask them to be alert for any incidences like this occurring and signs of someone shooting close by. They will also contact all nursery and finishing units and ask them to be aware of people trespassing and shooting the pigs.

Meat was disposed of as animal by-product after investigation was concluded.

Investigation carried out 18.09.17 by Jessica Mackintosh, Agriculture Supply Chain Manager.

SIGNATURE

Cy
Carols Easton (OV)

PAGE 1

Monday 25th September 2017

- Pre-operational: Area 2 (spall) See pre-operational report. *Cy-*

- Operational:

545. Meeting held with MHIS (and Keith Master) about last week's USDA visit. They were told that if there is a gut/plick missing they have to ~~check~~^{STPP} the line and if gut/plick is not presented the carcass have to be rejected.

They are going to verify as well that the plant is doing the correlation checks. I informed plant management (Steve Field, N Jackson, I Hunt, etc) *Cy-*
dist of attendees in plant day books.

- Excessive number of carcasses going to the rectification room with contamination. Reported to managers and supervisor; ^(9:17. from 8:00 to 9:00) improved (it seems there was a problem with the bug gun) but management have to improve *Cy-*
operatives and corrective actions.

Tuesday 26th September 2017

- Pre-operational: Area 8 (main butchery) See pre-op report.

- Operational: Satisfactory.

Food Standards Agency

Day MONDAY Date 25th Month SEPTEMBER 2017

Print name	Designation	Arrival time	Departure time	Health mark			Signature
				H/M no. used	Time out	Time returned	
M. MAIDMENT	MHI	5:30	17:15				<i>M. Maidment</i>
C GAZDAR	OV	6:00	17:45				<i>C. Gazdar</i>
D. CONNOR	MS	06:15	17:45				<i>D. Connor</i>
M. PORTER	OA	06:45	17:45				<i>M. Porter</i>
<i>W. ...</i>	MHI	06:45	17:45				<i>W. ...</i>
<i>J. ...</i>	ZL	06:00					<i>J. ...</i>
<i>A. ...</i>	MHI	06:30	17:45				<i>A. ...</i>
<i>R. ...</i>	OA	6:45	18:15				<i>R. ...</i>
<i>M. ...</i>	MS	06:45	18:15				<i>M. ...</i>
<i>P. ...</i>	MM	06:00	18:15				<i>P. ...</i>
<i>P. ...</i>	MS	06:00	17:00				<i>P. ...</i>
ALESSANDRO PALUSCHINO	OV	06:00	17:00				<i>Alessandro Paluschino</i>

FSA Inspection Correlation Protocol (Reminder) UK2060

Carcases and accompanying offal are to be subjected without delay after slaughter to post-mortem inspection.

Annex I Section II Chapter V Point 1 of Regulation (EC) No 853/2004 states:
“Meat is to be declared unfit for human consumption if it derives from animals the offal of which has not undergone post-mortem inspection”
(unless otherwise provided for under Regulation (EC) No 853/2004 or (EC) No 853/2004)

Annex III Section I Chapter IV Point 13 of Regulation (EC) No 853/2004 states:

“Until post-mortem inspection is completed, parts of a slaughtered animal subject to such inspection must:

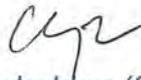
- (a) remain identifiable as belonging to a given carcass; and
- (b) come into contact with no other carcass, offal or viscera, including those that have already undergone post-mortem inspection”.

To fully comply with the above Regulations the following protocol (agreed by the Food Standards Agency and Karro Food Group (UK2060)) must be always followed:

If any green or red offal is missing from the pan or hook at the designated inspection point to carry out Official controls, the inspector must check to see if a carcass is being presented. If either green or red offal is not presented then the inspector will immediately stop the line and ask the FBO representative to present the missing offal. If this is not presented then the carcass and remaining presented offal is rejected. The line is not to be started until: either all parts are presented, or the FBO representative agrees to reject all presented parts and carcass.

In the event of a break-down of one line, the FSA must immediately stop the line and ask the FBO representative to comply with the above mentioned legislation.

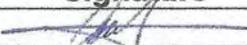
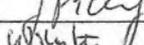
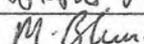
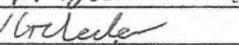
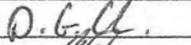
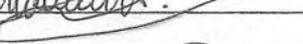
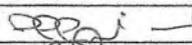
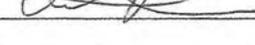
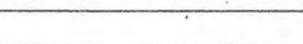
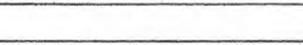
This document was produced by Carlos Gabaldon (OV) on 04/10/17 and signed by all the FSA Team members the same week. Previous meetings to remind and reiterate the above procedures took place on 25/09/17 and 26/09/17.



Carlos Gabaldon (06/10/17)

I have understood the above

This protocol will be followed by the FSA team:

Name	Position	Signature
Oscar Flores	OV	
Carlos Gabaldon	OV	
Nikolaos Armaos	OV	
Julia Pickering	OV	
Keith Masters	ITL	
Martin Blundell	MHI	
Victor Checker	MHI	
Derek Conder	MHI	
Andrew Dent	MHI	
Edward Hodgson	MHI	
Mark Maidment	MHI	
Damian Paxton	MHI	
Darren Pickering	MHI	
Mark Porter	MHI	
Thomas Wright	MHI	
PETER CULHAN	ITL	

FSA Team Meeting, Cluster 03 26th September 2017

Present: Andrew Dent (MHI-FSA), Roy Hodgson(MHI-FSA), Mark Maidment(MHI-FSA), Damian Paxton(MHI-FSA), Derek Conder (MHI-FSA), Victor Checker (MHI-FSA), Martin Blundell (MHI-FSA), Darren Pickering (MHI-FSA), Mark Porter (MHI-FSA), Carlos Gabaldon (OV-E&J), Keith Masters (ITL-FSA)

Apologies: Tom Wright (MHI-FSA), Oscar Flores (MHI-FSA)

CC: Head of Operational Delivery (CL) (on request)
Operational Manager (RL) (on request)
Area Manager (AJH) (on request)

		Action by	Timing
1	<p>Points arising from previous meeting</p> <ul style="list-style-type: none"> IT connectivity - slight improvement - no printing capabilities, this has been escalated by Littlefish Ref No: 10128. 2 new Chip PC on order. Ref No:11561 Contamination - see below 	<p>KM</p> <p>CG</p>	<p>Ongoing</p> <p>Ongoing</p>
2	<p>Veterinary Update</p> <p>MOC update:</p> <ul style="list-style-type: none"> New amendment version 79 discussed and attached to the minutes. <p>Enforcement:</p> <ul style="list-style-type: none"> HIN served due to the leaking roof. Letters sent regarding issues with rusty lockers, incorrect storage of co-products, and condensation in several areas. Current enforcement programme can be found on the home drive. KM reminded the team that all enforcement is the team's responsibility and not just OV. <p>Welfare:</p> <ul style="list-style-type: none"> No reported deficiencies. <p>Contamination records:</p> <ul style="list-style-type: none"> Following on from Martin documenting contamination, the FBO now uses a system that means if the hourly rectification for contamination rises over 3% the plant will put into place their corrective measures. Martin has agreed to carry out another contamination survey. Green flags that the plant replaces the red flags with are for a customer specification and not a legislative requirement. <p>RIM Sampling:</p> <ul style="list-style-type: none"> 100% compliance. Well done. 	<p>All</p> <p>CG CG</p> <p>All All</p> <p>MB All</p>	<p>Ongoing</p> <p>Ongoing Ongoing</p> <p>Ongoing Ongoing</p> <p>Ongoing Complete</p>

	<p>Operational issues:</p> <ul style="list-style-type: none"> The staff resource issue has been documented and KM has reminded the team that any issues should be given to him as soon as possible, to include time, dates, and issues. These will be documented and escalated accordingly. All entries in Day Book must be accurate and factual, no personal opinions. Discussed new signing in and out of Stamps document to comply with new amendment and Stamp security following on from lost stamp. Timekeeping - accurately record start and finish times, mindful of others when on rotational changes. Reminder about removing of whites and no eating/drinking in changing rooms. <p>FCI/CCIR:</p> <ul style="list-style-type: none"> IRIS is rejecting all Hellenic sent conditions. FBO is sending all FSA findings to the producer and storing all our information for as long as needed. KM asked the team to document all occasions the "Other" button is used. <p>Audit Outcomes:</p> <ul style="list-style-type: none"> Following on from the USDA visit and after being discussed at the meeting held by Carlos Gabaldon (OV), Keith Masters (ITL) and FSA Team on Monday 25th September, please ensure that the following protocol (in line with plant procedure FP-64 attached) is always followed: <p><i>If any green or red offal is missing from the pan or hook at the designated inspection point to carry out Official controls, the inspector must check to see if a carcass is being presented. If either green or red offal is not presented then the inspector will immediately stop the line and ask the FBO representative to present the missing offal. If this is not presented then the carcass and remaining presented offal is rejected. The line is not to be started until: either all parts are presented, or the FBO representative agrees to reject all presented parts and carcass.</i></p>	<p>All</p> <p>All</p> <p>All</p> <p>All</p> <p>All</p> <p>KM</p> <p>All</p> <p>All</p>	<p>Ongoing</p> <p>Ongoing</p> <p>Ongoing</p> <p>Ongoing</p> <p>Ongoing</p> <p>Complete</p> <p>Ongoing</p> <p>Complete</p>
3	<p>Key messages from RMT</p> <ul style="list-style-type: none"> No key messages to report as KM was not at the last meeting. 		
4	<p>Performance Management Report</p> <ul style="list-style-type: none"> Mid-Year Reviews to be carried out in October Please remember to update iHR with all 1-1's and any training you undertake, including e-learning. 	<p>All</p> <p>All</p>	<p>Ongoing</p> <p>Ongoing</p>
5	<p>NEG Update & Cluster Update</p> <ul style="list-style-type: none"> Launch of Staff Survey on Monday 2nd October - played and watched Jason Feeney message. Discussed latest NEG meeting and minutes attached. 	<p>All</p>	<p>Complete</p>

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
Title: Carcass Correlation Procedure		Ref: FP-64	Page 1 of 1

DEFINITION:

This procedure details the requirements for the correlation of the carcass, pluck and guts for inspection.

SCOPE

All carcasses presented to Meat Hygiene Inspectors as fit for human consumption.

RESPONSIBILITY:

- General Manager – Fresh Meat
- Slaughter line Manager
- Slaughter line Supervisor
- Slaughter line Charge hands
- Slaughter line Operatives

METHOD:

It is a legal requirement that the carcass, pluck and guts must be presented at the same time (in correlation) to the Meat Hygiene Inspectors in order for the carcass to be stamped and deemed fit for human consumption.

If any of the three components (carcass, pluck or guts) are missing at point of inspection then the Meat Hygiene Inspector or Slaughter line Operative will immediately stop the line. The location of the missing component must be located for inspection or the carcass will not be stamped and must be disposed of as not fit for human consumption into Category 2 waste.

If correlation goes out of sync for any of the 3 components then the line MUST be stopped immediately. Immediately contact the Slaughter line Manager.

Corrective Actions

Missing component - The location of the missing component must be located for inspection or the carcass will not be stamped and must be disposed of as not fit for human consumption into Category 2 waste.

Correlation - Correlation must be regained and then the line can restart.

Gut Pan Reject – Reject mechanism must be working at all times. Line can only run once the gut pan reject mechanism is fixed and working correctly.

Verification

Verification of the **correlation** takes place every 20 minutes during production. The charge hand checks the alignment of the slaughter line and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
Title: Carcass Correlation Procedure		Ref: FP-64	Page 2 of 1

Verification that the **gut pan reject mechanism** also takes place every 20 minutes during production. The charge hand checks the reject mechanism of the gut pan and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Both will be verified once daily by the QA department.

Correlation check sheet will be formally reviewed by the Slaughter line Manager/Supervisor daily.

CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed: _____ Date: _____

Print Name: _____ Clock Number: _____

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
26/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical



UK 2060 EC
Karro Food Ltd UK Malton
Weekly Verification report

Week commencing on *23.10.17*

Faecal Contamination checks	Mon	Tue	Wed	Thu	Fri
Time	<i>11:55</i>	<i>11:00</i>	<i>12:00</i>	<i>14:40</i>	<i>11:00</i>
Are carcasses visually free from contamination?	<i>YES</i>	<i>YES</i>	<i>YES</i>	<i>YES</i>	<i>YES</i>
Number of carcasses inspected	<i>20</i>	<i>20</i>	<i>20</i>	<i>20</i>	<i>20</i>

Correlation Checks	Mon		Tue		Wed		Thu	
	AM	PM	AM	PM	AM	PM	AM	PM
Time	<i>11:10</i>	<i>14:00</i>	<i>12:00</i>	<i>16:40</i>	<i>11:00</i>	<i>15:45</i>	<i>08:00</i>	<i>14:30</i>
Is correlation maintained? YES/NO	<i>YES</i>							
FBO records created as planned? YES/NO	<i>YES</i>							
Observation of monitoring	<i>YES</i>	<i>YES</i>	<i>YES</i>	<i>YES</i>	<i>NO</i>	<i>YES</i>	<i>YES</i>	<i>YES</i>
Comments and action taken in case of failure <i>Friday: check done @ 11:15</i>								

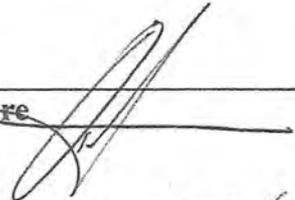
Carcasses Temperature	Mon	Tue	Wed	Thu	Fri	Sat
Time	/	<i>06:15</i>	<i>06:25</i>	<i>06:20</i>	<i>07:00</i>	/
1st	/	<i>3.9°C</i>	<i>4.5°C</i>	<i>5.0°C</i>	<i>2.3°C</i>	/
2nd	/	<i>3.6°C</i>	<i>3.9°C</i>	<i>4.6°C</i>	<i>2.6°C</i>	/
3rd	/	<i>3.6°C</i>	<i>4.1°C</i>	<i>5.0°C</i>	<i>2.2°C</i>	/

Calibration of probe	Mon	Tue	Wed	Thu	Fri
OV	<i>NO</i>	<i>NO</i>	<i>YES</i>	<i>YES</i>	
FBO CCP Probes	<i>NO</i>	<i>NO</i>	<i>YES</i>	<i>YES</i>	

Contamination checks	Mon	Tue	Wed	Thu	Fri	Sat
Any condensation observed on overhead structure?	<i>NO</i>	<i>NO</i>	<i>NO</i>	<i>NO</i>	<i>NO</i>	/
Are carcasses and meat free from lubricant contamination?	<i>YES</i>	<i>YES</i>	<i>YES</i>	<i>YES</i>	<i>YES</i>	/
Is all meat properly covered?	<i>YES</i>	<i>YES</i>	<i>YES</i>	<i>YES</i>	<i>YES</i>	/

PM Verification	Mon	Tue	Wed	Thu	Fri
Is on-line verification form completed?	<i>YES</i>	<i>YES</i>	<i>YES</i>	<i>YES</i>	

Comments

Signature 
OSCAR FLORES (OV)

Enforcement Programme



Approval Number **2060**

Page **1** of **48**

Company Name **KARRO FOOD LTD**

Ref No	Deficiency	Legislation	Audit Section	Action Required	Verbal Advice		Written Advice		RAN		Compliance Date	Status
					Date Served	Target Date	Date Served	Target Date	Date Served	Target Date		
2060/17/00191	Rejection button for gut pans was not working and rejected guts were used for h.c. (co-products)	Regulation (EC) 853/2004: Point:16, Annex:III, Section:I, Chapter:V, Regulation (EC) 853/2004: Point:12, Annex:III, Section:I, Chapter:IV,	Slaughterhouse / Game Handling Establishment Hygiene Where relevant, all edible co-products are handled hygienically and subject to relevant controls (including raw materials intended for further processing)	Repair rejection button or provide any other system to allow the MHI to reject parts unfit for human consumption. All guts produced until the button was repaired were disposed of as ABP.	21 Sep 2017	21 Sep 2017					21 Sep 2017	Complied
2060/17/00192	Inadequate correlation of carcasses with red and green offal and three guts not presented for post mortem inspection	Regulation (EC) 853/2004: Point:13, Annex:III, Section:I, Chapter:IV, Regulation (EC) 853/2004: Point:12, Annex:III, Section:I, Chapter:IV,	Slaughterhouse / Game Handling Establishment Hygiene Correlation and correct presentation of parts of slaughtered red meat animals required to be inspected. Correct presentation of carcasses and accompanying offal of birds for post-mortem inspection	FBO to ensure that until post-mortem inspection is completed, parts of a slaughtered animal subject to such inspection remain identifiable as belonging to a given carcase. Carcasses not adequately correlated were voluntarily disposed of as Category 2 by the FBO.	21 Sep 2017	21 Sep 2017					21 Sep 2017	Complied

Data as of: **13 Mar 2018**

Animal By-Products Commercial (Movement Document)

For ABP collected and delivered in compliance with the Animal By-Products Regulations (EC) No. 1069/2009

Part 4: to be retained by the Consignor/Sender (to be retained for 2 years from date of dispatch)

YK 17 LME

Section 1 (to be completed by Consignor/Sender) **Consignment No:**

Date of consignment: 23 09 17

Name of Consignor/Sender: KARE FOOD GROUP Lic/App/Reg No of Consignor/Sender: 2060

Address of Consignor/Sender: HUNDON WAY, WESTON GROVE INDUSTRIAL ESTATE, WESTON

Description of the Material including species (Label Wording) Quantity/Weight/Volume of Material Category No.

CHAFAL (BONE MEAT, GROSS WEIGHT 3 x 15kg) CAT-2

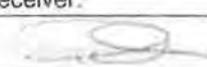
Name of Haulage/Transport Company: HAWTHORNE WILSONS

Address of Haulage/Transport Company: QUINCY GARDEN STAMTON, RENOVA CHURCH

Name of intended Consignee/Receiver: DIRECTOR BUSINESS

Address of intended Consignee/Receiver: 100 WILSON WAY, HATHORNE R-10, TROTTON ROAD, EDINBURGH ED13 3JG

Approval No. of intended Consignee/Receiver:

Signed for Consignor/ Sender:  Name: NEEDHAM

(Colour of signature to be different to that of the printing) (Print)

Section 2 (to be completed by Haulier)

Date Collected: 23 09 17 Time: 15 30

Signed for Haulier:  Name: JALEX

(Driver) (Print)

Section 3 (to be completed by Consignee/Receiver)

Name of Consignee/Receiver:

Address of Consignee/Receiver:

I confirm that the material identified in Section 1 above was received at the named Consignee/Receiver premises from the named haulier.

Material Description	Quantity/Weight	Approval/Registration No. of Consignee/Receiver	Site	Signature & Date Received
CHAFAL	45,630kg	441301/502/100/100		
CHAFAL	15,630kg			
Date Received: 24 09 17				Signature & Date Received: [Signature] 24 09 17
Signed for Consignee/Receiver:				Name: [Signature] 24 09 17

(Print)

→ After this date please return to [unclear]

Animal By-Products Category 2 Movement Document

Section 1 (to be completed by Consignor)

A 6577

Date: 23/11/17

Name of Consignor: K...

Lic/App/Reg No of Consignor:

Address of Consignor:

Description of the Material:

Quantity of Material:

Name of Haulier: **THE HAULAGE (HOLDINGS) ORGANISATION LTD**

Signed for Consignor: Name:

CATEGORY

2

FOR DISPOSAL ONLY

Section 2 (to be completed by the Haulier)

The above material was collected from the Consignor and delivered to the Consignee in compliance with the EU Animal By-Products Regulation.

Hauliers Address: **THE HAULAGE (HOLDINGS) ORGANISATION LTD, SWALESMOOR ROAD, HALIFAX, WEST YORKSHIRE HX3 6UF**

Drivers Signature: Name:

Section 3 (to be completed by the Consignee/Receiver)

Name of Consignee:

Approval/Registration No of Consignee:

Address of Consignee:

Omega Proteins Ltd 49/528/8010/ABP/REN ERLINGS WORKS BRADFORD BD13 3SG Please tick (✓) to confirm <input type="checkbox"/>	Scot Proteins Ltd 66/065/8004/ABP/MED 66/065/8004/ABP/REN SOUTH COTTOWN, KINTORE, ABERDEENSHIRE, AB51 0XS Please tick (✓) to confirm <input type="checkbox"/>	Robinson Mitchell Ltd 75/304/8003/ABP/MED RACKS, COLLIN DUMFRIES DG1 4PU Please tick (✓) to confirm <input type="checkbox"/>	Other: Please tick (✓) to confirm <input type="checkbox"/>
--	--	--	---

I confirm that the material identified in section 1 above was received at the named Consignee's premises from the named haulier.

Signed for Consignee: Name:

Date	Day	Opening Stock	Delivered	Collected	Closing Stock	Name Consignor	Name Receiver
	Mon						
	Tues						
	Wed						
	Thurs						
	Fri						
	Sat						

Important:- It will be necessary to obtain confirmation of the bin movement on a weekly basis by fax. Failure to reply will be acknowledged as an agreement.

Receivers Copy - White

Return Copy - Pink

Hauliers Copy - Blue

Consignors Copy - Yellow

Weighbridge Ticket No <17\266\008953>

Vehicle Reg : YK17LUE
Haulier : Z150 - HAULAGE HOLDINGS
Haulier Ref : PN
Product Code : 400630WB
Product Desc : OFFAL (CAT 2)

1ST WEIGHING

Time : 07:17
Date : 23/09/2017
Gross wt : 15860 kg
RN : 008953

2ND WEIGHING

Time : 15:26
Date : 23/09/2017
Gross wt : 45680 kg
RN : 008956
Net Weight : 29820 kg

Signed Driver : JAREK

Signed on behalf of KARRO FOOD UK

An Electronic tally roll record of this transaction
is available for inspection for up to 6 months.

Report Ref: TS001, Requiem v9.29m.9861

* 408 Pcs over BOTH LOADS

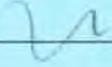
Animal By-Products Commercial (Movement Document)

For ABP collected and delivered in compliance with the Animal By-Products Regulations (EC) No. 1069/2009

Part 4: to be retained by the Consignor/Sender (to be retained for 2 years from date of dispatch)

YK 17 LUD.

Section 1 (to be completed by Consignor/Sender)		Consignment No:	
Date of consignment: 23-09-17			
Name of Consignor/Sender: KARRIS FOOD GROUP		Lic/App/Reg No of Consignor/Sender: 2060	
Address of Consignor/Sender: HUGDEN WAY, NOTTON GROVE INDUSTRIAL ESTATE, NOTTON			
Description of the Material including species (Label Wording)		Quantity/Weight/Volume of Material	Category No.
OFFAL (PORK MOTT, GUTS, CARCASSES + PIG HAIR)			CAT-2
Name of Haulage/Transport Company: HAULAGE HOLDINGS			
Address of Haulage/Transport Company: QUARRY GARAGE, STANTON FENITH, CALLOW			
Name of intended Consignee/Receiver: OMEGA PROTEINS			
Address of intended Consignee/Receiver: OFFAL WORK, WILFORD ROAD, THROTON, LEICESTER LE13 3EG			
Approval No. of intended Consignee/Receiver:			
Signed for Consignor/ Sender: 		Name: N CEDRAM	
(Colour of signature to be different to that of the printing)		(Print)	

Section 2 (to be completed by Haulier)	
Date Collected: 23-09-17	Time: 17:35
Signed for Haulier: 	Name: ZEGARWECZ
(Driver)	(Print)

Section 3 (to be completed by Consignee/Receiver)				
Name of Consignee/Receiver:				
Address of Consignee/Receiver:				
I confirm that the material identified in Section 1 above was received at the named Consignee/Receiver premises from the named haulier.				
Material Description	Quantity/Weight	Approval/Registration No. of Consignee/Receiver	Site	Signature & Date Received
CAT-2 ABP	WT IN 16,440KG	49/529/2010/ABP/RCW		
OFFAL	WT OUT 39,820KG			
Date Received: MATT WT 23,370KG		Time:	TRAILER NO: 508	
Signed for Consignee/Receiver:		Name:	TRAILER NO: 501	
(Print)				

Animal By-Products Category 2 Movement Document

Section 1 (to be completed by Consignor)

A 15455

Date: 23/04/11

Name of Consignor: JAMES TOOP LIMITED LTD

Lic/App/Reg No of Consignor: 2060

Address of Consignor: WATSON

Description of the Material: OFFAL CAT-2

Quantity of Material: 23,300KG

Name of Haulier: THE HAULAGE (HOLDINGS) ORGANISATION LTD

Signed for Consignor: [Signature] Name: [Name]

CATEGORY
2
FOR DISPOSAL ONLY

Section 2 (to be completed by the Haulier)

The above material was collected from the Consignor and delivered to the Consignee in compliance with the EU Animal By-Products Regulation.

Hauliers Address: THE HAULAGE (HOLDINGS) ORGANISATION LTD, SWALESMOOR ROAD, HALIFAX, WEST YORKSHIRE HX3 6UF

Drivers Signature: [Signature] Name: [Name]

Section 3 (to be completed by the Consignee/Receiver)

Name of Consignee:

Approval/Registration No of Consignee:

Address of Consignee:

Omega Proteins Ltd 49/528/8010/ABP/REN ERLINGS WORKS BRADFORD BD13 3SG Please tick (✓) to confirm <input checked="" type="checkbox"/>	Omega Proteins Ltd 49/349/8015/ABP/MED SWALESMOOR ROAD, HALIFAX HX3 6UF Please tick (✓) to confirm <input type="checkbox"/>	Scot Proteins Ltd 66/065/8004/ABP/MED 66/065/8004/ABP/REN SOUTH COTTOWN, KINTORE, ABERDEENSHIRE, AB51 0XS Please tick (✓) to confirm <input type="checkbox"/>	Robinson Mitchell Ltd 75/304/8003/ABP/MED RACKS, COLLIN DUMFRIES DG1 4PU Please tick (✓) to confirm <input type="checkbox"/>	Other: Please tick (✓) to confirm <input type="checkbox"/>
---	---	--	--	---

I confirm that the material identified in section 1 above was received at the named Consignee's premises from the named haulier.

Signed for Consignee: [Signature] Name: [Name]

Date	Day	Opening Stock	Delivered	Collected	Closing Stock	Name Consignor	Name Receiver
	Mon						
	Tues						
	Wed						
	Thurs						
	Fri						
	Sat						

Important:- It will be necessary to obtain confirmation of the bin movement on a weekly basis by fax. Failure to reply will be acknowledged as an agreement.

Receivers Copy - White

Return Copy - Pink

Hauliers Copy - Blue

Consignors Copy - Yellow

KARRO FOOD UK - Hugden Way Norton Grove Ind Est Norton Malton YO17 9HG

Weighbridge Ticket No <17\266\008957>

Vehicle Reg : YK17LUD
Haulier : Z150 - HAULAGE HOLDINGS
Haulier Ref : PN
Product Code : 400630WB
Product Desc : OFFAL (CAT 2)

1ST WEIGHING

Time : 16:57
Date : 23/09/2017
Gross wt : 16440 kg
RN : 008957

2ND WEIGHING

Time : 17:31
Date : 23/09/2017
Gross wt : 39820 kg
RN : 008958

Net Weight : 23380 kg

Signed Driver : ZEGILOWECZ

Signed on behalf of KARRO FOOD UK

An Electronic tally roll record of this transaction
is available for inspection for up to 6 months.

Report Ref: TS001, Requiem v9.29m.9861

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
Title: Carcass Correlation Procedure		Ref: FP-64	Page 1 of 1

DEFINITION:

This procedure details the requirements for the correlation of the carcass, pluck and guts for inspection.

SCOPE

All carcasses being presented to Meat Hygiene Inspectors as fit for human consumption.

RESPONSIBILITY:

- General Manager – Fresh Meat
- Slaughter line Manager
- Slaughter line Supervisor
- Slaughter line Charge hands
- Slaughter line Operatives

METHOD:

It is a legal requirement that the carcass, pluck and guts must be presented at the same time (in correlation) to the Meat Hygiene Inspectors in order for the carcass to be stamped and deemed fit for human consumption.

If any of the three components (carcass, pluck or guts) are missing at point of inspection then the Meat Hygiene Inspector or Slaughter line Operative will immediately stop the line. The location of the missing component must be located for inspection or the carcass will not be stamped and must be disposed of as not fit for human consumption into Category 2 waste.

If correlation goes out of sync for any of the 3 components then the line MUST be stopped immediately. Immediately contact the Slaughter line Manager.

If any guts come into contact with the floor then these must be placed back in the gut pan but must be marked with a red flag. If a pluck comes into contact with the floor then these must be placed back on the pluck line but must be marked with a red flag. ***NB*** The red flag shows that these products have come into contact with the floor and are no longer eligible for human consumption. Once any component with a red flag has been inspected to the meat hygiene inspectors then it must go into one of the category 2 waste bins provided.

Corrective Actions

Missing component - The location of the missing component must be located for inspection or the carcass will not be stamped and must be disposed of as not fit for human consumption into Category 2 waste.

Correlation - Correlation must be regained and then the line can restart.

Gut Pan Reject – Reject mechanism must be working at all times. The line can only run once the gut pan reject mechanism is fixed and working correctly. ***NB*** All guts which have gone to the gut room since the

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
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last positive check will be disposed of as Category 2 waste. This will be recorded as the corrective action on the correlation check sheet (SL-016-US).

Monitoring

Monitoring of the **correlation** takes place every 20 minutes during production. The charge hand checks the alignment of the slaughter line and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Monitoring that the **gut pan reject mechanism** is working correctly also takes place every 20 minutes during production. The charge hand checks the reject mechanism of the gut pan and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Correlation check sheet will be formally reviewed by the Slaughter line Manager/Supervisor daily.

Verification

The correlation and gut pan reject mechanism will be verified once daily by the QA department. The QA checks the alignment of the slaughter line and the reject mechanism of the gut pan. If either is not working then they must stop the line immediately and contact the Slaughter line Manager.

CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed: _____ Date: _____

Print Name: _____ Clock Number: _____

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

Reference No:
CG/2060/ADM/1701

Agreement to Destroy Meat



1 Name of Food Business Operator or representative in BLOCK letters: **IAN HUNT**

Position: **TECHNICAL MANAGER** Date: **22/09/17**
(Food Business Operator / manager)

Address of approved establishment: **KARRO FOODS LTD, HUGDEN WAY, NORTON, MALTON**
Postcode: **YO17 9HG**

2 Meat examined

Description: **PIG CARCASSES**

Quantity: **468 CARCASSES (KILL DATE 21/09/17. KILL No. 1845-2313)**

Identification marks: **UK 2060EC**

3 Stored at (address and location): **CARCASE CHILLS, HUGDEN WAY, NORTON**
Postcode: **YO17 9HG**

4 Accept the meat for destruction

Signature of Authorised Officer: **[Signature]** Designation: **OV**

Name in BLOCK letters: **CARLOS GAZARDON** Date: **22/09/17**

Official address: **FSA York, Kings Pool, Peasholme Green, York** Postcode: **YO1 7PR**

Email address: **Business.Support@foodstandards.gsi.gov.uk**

Telephone number: **01904 232177** Fax Number: **01904 232184**

Declaration on behalf of the person in charge of the meat

Name of person making declaration: **IAN HUNT**

Position: **Head of Technical** Date: **22/09/17**
(FBO / manager)

Full address: **KARRO FOODS LTD, HUGDEN WAY, NORTON, MALTON**
Postcode **YO17 9HG**

Authorised by the person in charge of the meat listed in paragraph 2 above and stored at the location in paragraph 3, I agree to destroy the meat described above and agree to pay the full cost of any inspection, supervision and disposal. I am aware and on behalf of the owner, confirm the FSA cannot be held responsible for loss incurred in ensuring the meat is destroyed.

Signature: **[Signature]** Date: **22/09/17**

Witness signature: **[Signature]** Date: **22/09/17**

Witness position: **Official Veterinarian**

Witness address: **HUGDEN WAY, NORTON, MALTON**
Postcode: **YO17 9HG**

Note for Authorised Officer – General
Checks must be made to ensure that all products specified in this notice have been stained* and / or disposed of* in the appropriate manner. [*Tick as applicable]

Retain copy of completed form at plant for 6 years and then destroy

Ian Hunt

From: Ian Hunt
Sent: 22 September 2017 17:21
To: carlos gabaldon (carlos.gabaldon@eandj.co.uk); Nikolaos Armaos
Cc: Stuart Hawkshaw; Mike Carr; Mike Roberts; Adrian Stockill; Steve Field; Darren James
Subject: Actions taken today as a result of USDA Audit/Gut Correlation Issue
Attachments: MAL-OB-1st 5250-JMN06308_0906_001.pdf

Carlos/Niko,

As promised below is a summary of actions taken today, we will revert by close of play Monday with a further report of Root Cause and appropriate further corrective and preventative actions.

Issue

- At 1145h on 21/9/17 the following issues presented themselves in quick succession on the slaughter line at the MHI point in the line
 - The gut reject pan failed to operate as expected (in that the Guts did not reject when placed under challenge to do to)
 - It was observed that more than 1 carcass passed the inspection point with no guts in the pans to correlate to the carcass
 - It was observed that the carcass line was out of correlation in terms of presentation of Guts/Red Offal and Carcass to the inspection point

Immediate Corrective Actions Taken

We have taken the below immediate corrective actions and are currently carrying out a further investigation and appropriate RCA into the issues so that we may develop and implement effective preventative actions.

- *Gut Pan Rejection Failure*
 - All materials produced from Guts during the production day 21/9/17 up until the time 11:45 were isolated and sent to disposal (this was a total of 14 dolavs)
 - The Gut Room was cleaned of all material and production was recommenced only at 12:10 once the reject mechanism was confirmed as working
 - We have implemented an additional check (every 20 minutes) on the efficacy of the gut pan rejection as of next slaughter day (25/9 – Note we do not slaughter on Friday) (This will be briefed on Monday am)
- *Carcass correlation issue and misrepresentation of carcasses with no Guts*
 - Production was stopped, the line was brought back into correlation and checked for correct correlation by the FBO and MHI prior to restarting

Ian Hunt

From: Ian Hunt
Sent: 25 September 2017 12:38
To: carlos gabaldon (carlos.gabaldon@eandj.co.uk); 'Nikolaos Armaos'
Cc: Stuart Hawkshaw; Mike Carr; Mike Roberts; Adrian Stockill; Steve Field; Darren James; Stuart Holroyd; Andrew Mitchell
Subject: RE: Actions taken today as a result of USDA Audit/Gut Correlation Issue
Attachments: Photographic Evidence of 468 Condemned Carcass Disposal.pptx; MAL-OB-1st 5250-JMN06308_0938_001.pdf; MAL-OB-1st 5250-JMN06308_0926_001.pdf

Carlos/Niko,

Please see attached disposal notes and photographic evidence of the disposal that took place on Saturday

Kind Regards

Ian

Ian Hunt
Head of Technical

+44 (0) 1653 602426 or 01653 693031 xtn 794
+44 (0) 7971 179 113
Ian.Hunt@Karro.co.uk

KARRO FOOD GROUP Ltd
Hugden Way, Malton, YO17 9HG



From: Ian Hunt
Sent: 25 September 2017 08:48
To: carlos gabaldon (carlos.gabaldon@eandj.co.uk); 'Nikolaos Armaos'

Photographic Evidence of 468 Condemned Carcass Disposal

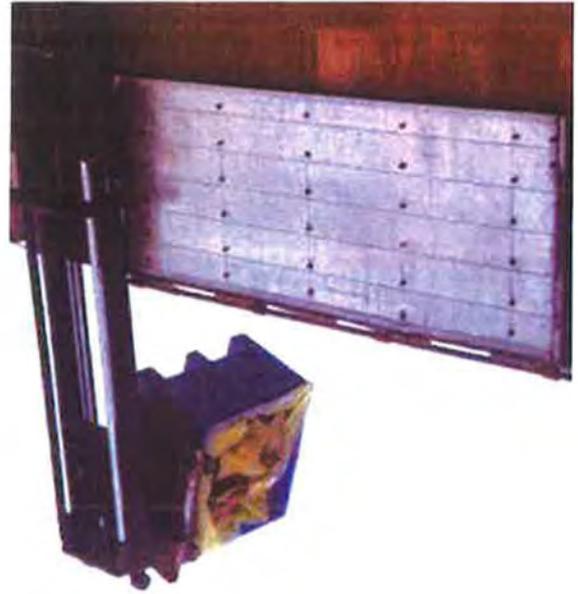
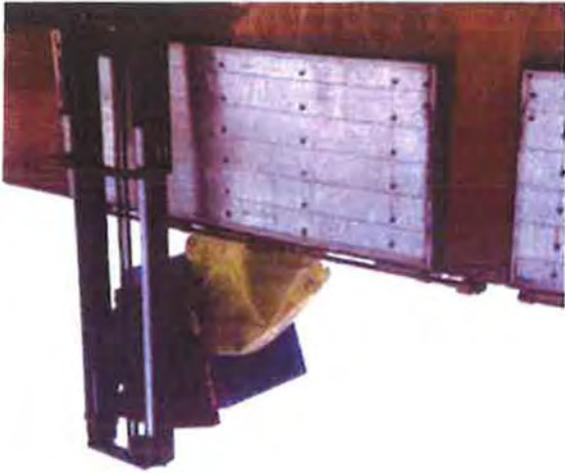
23rd September 2017

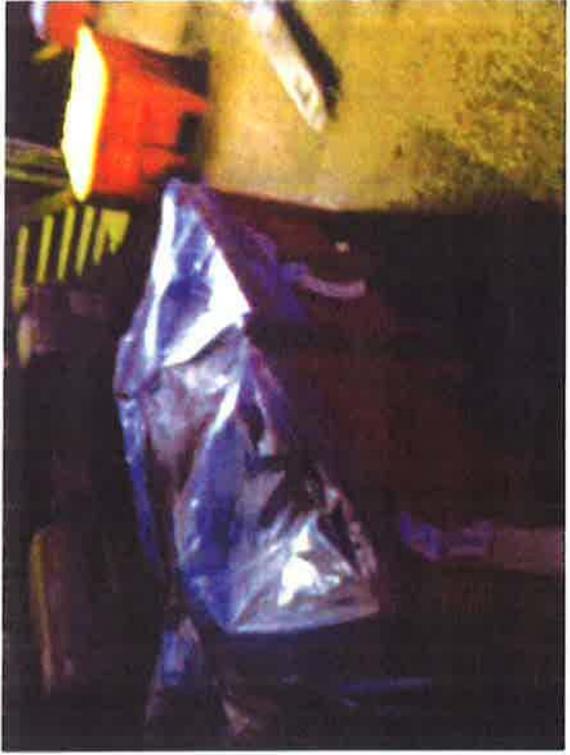


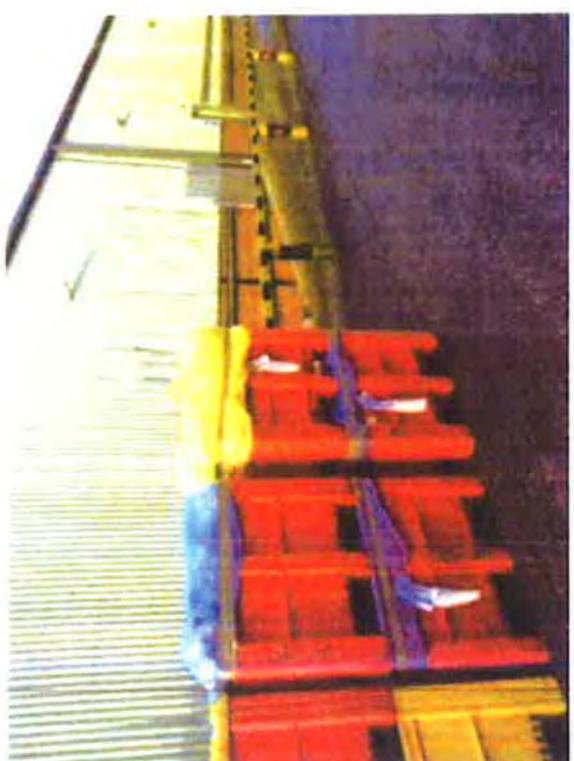


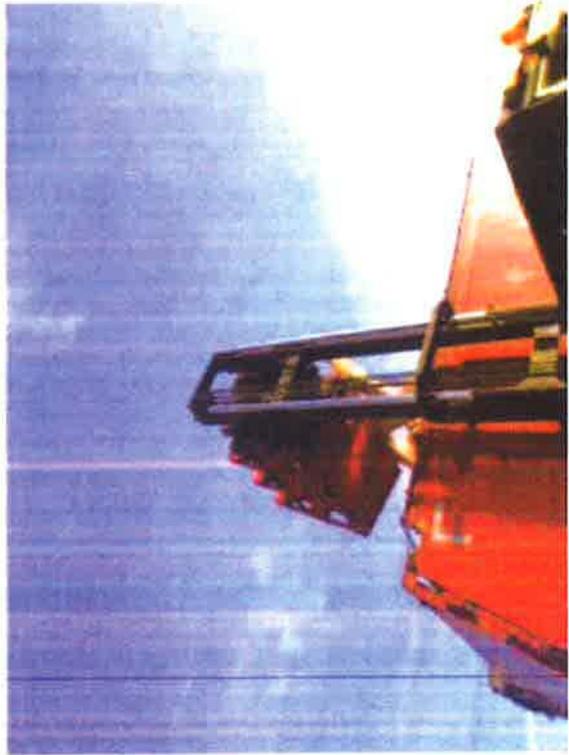




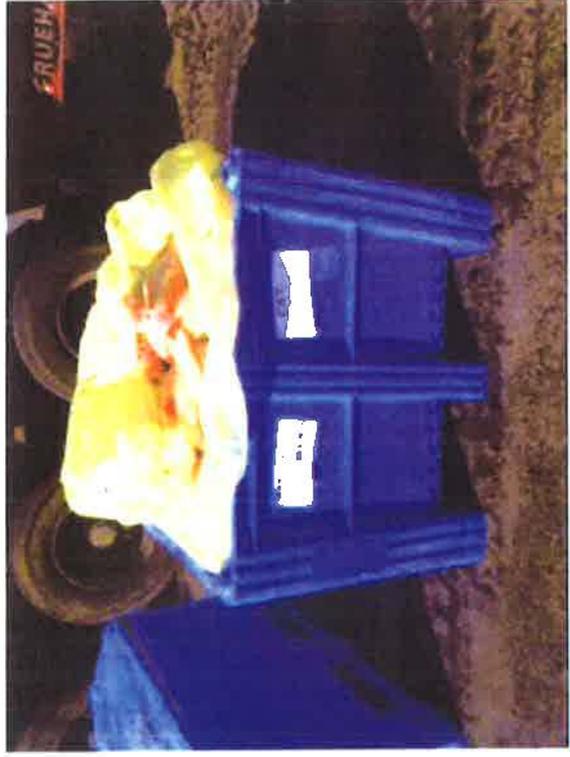






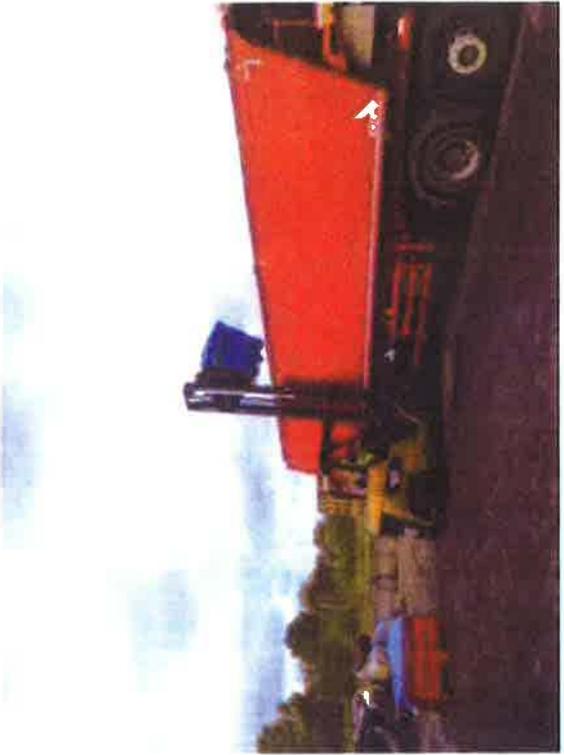


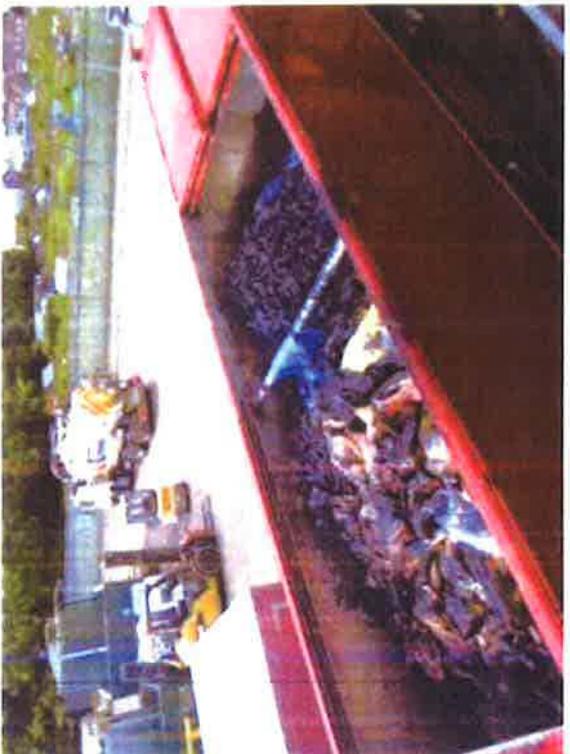
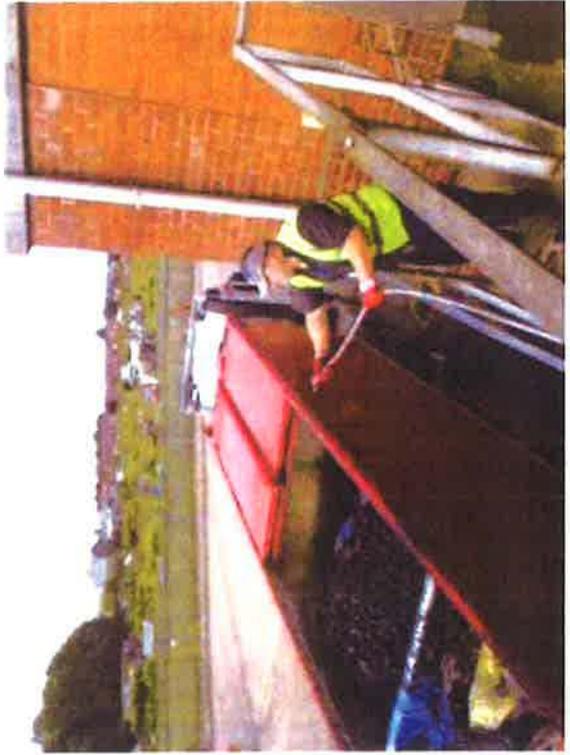






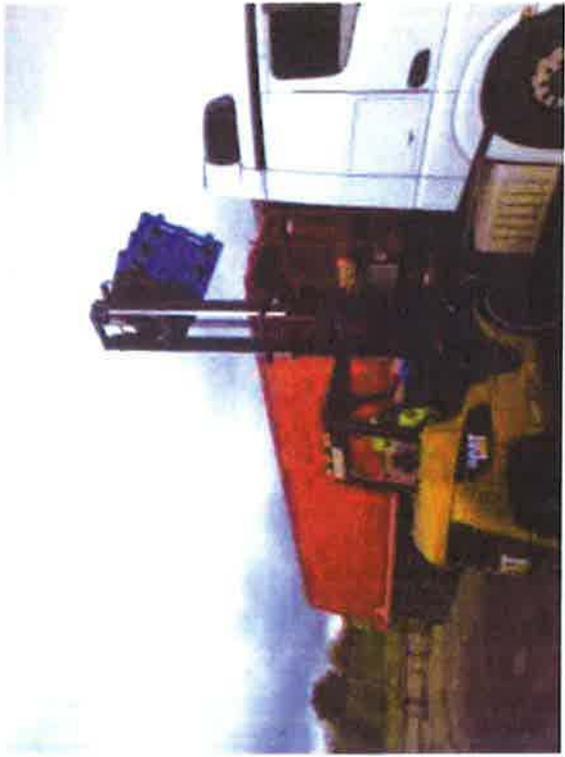


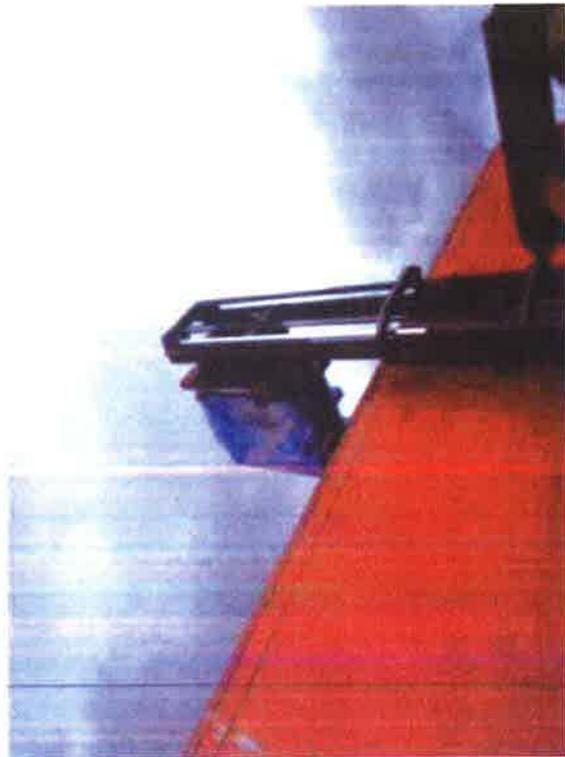


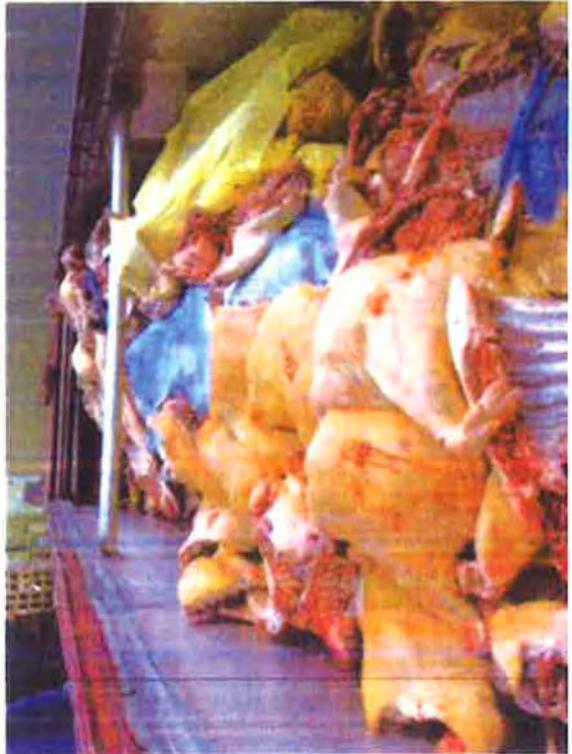
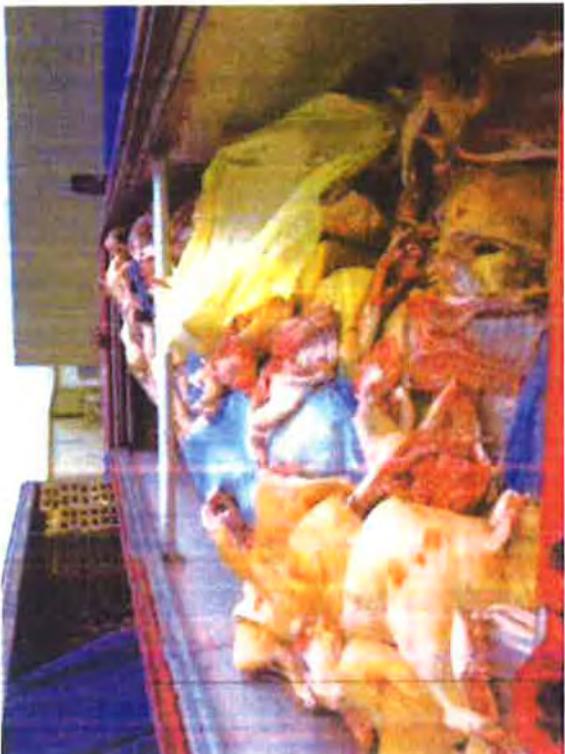


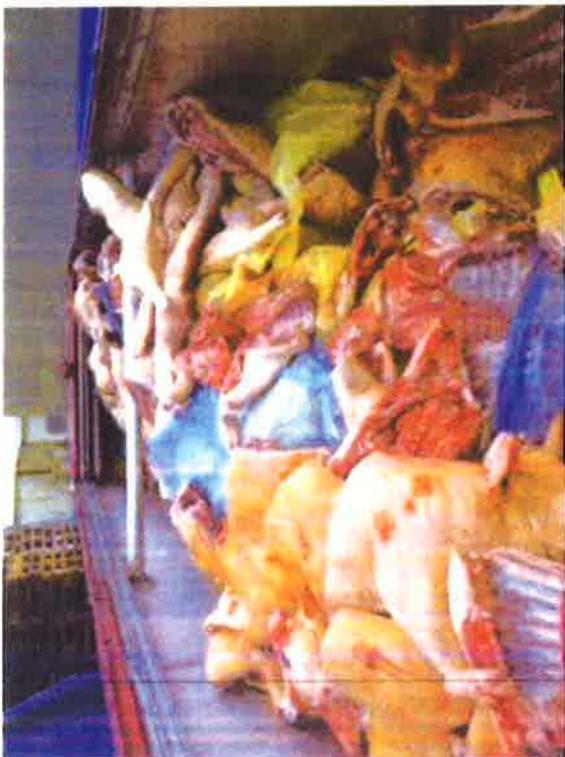










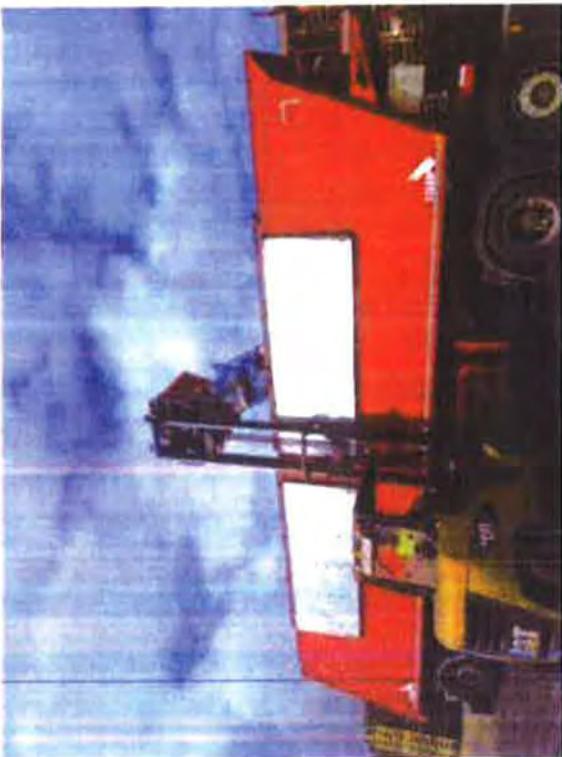


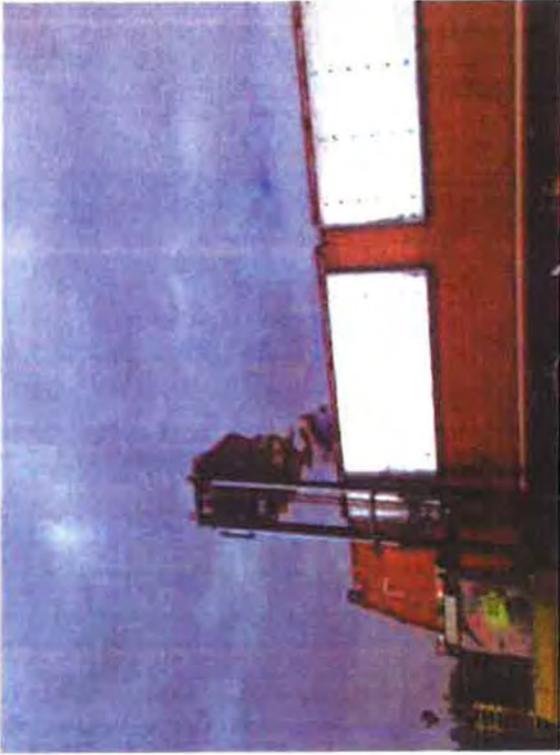


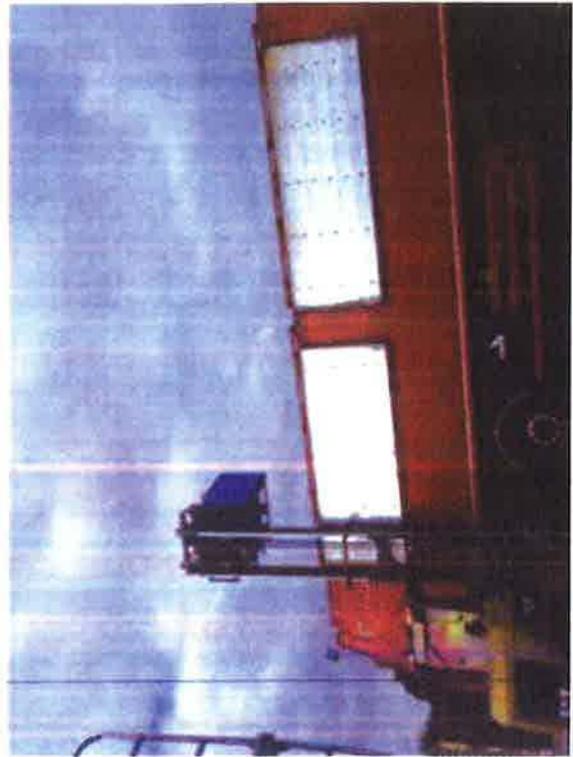
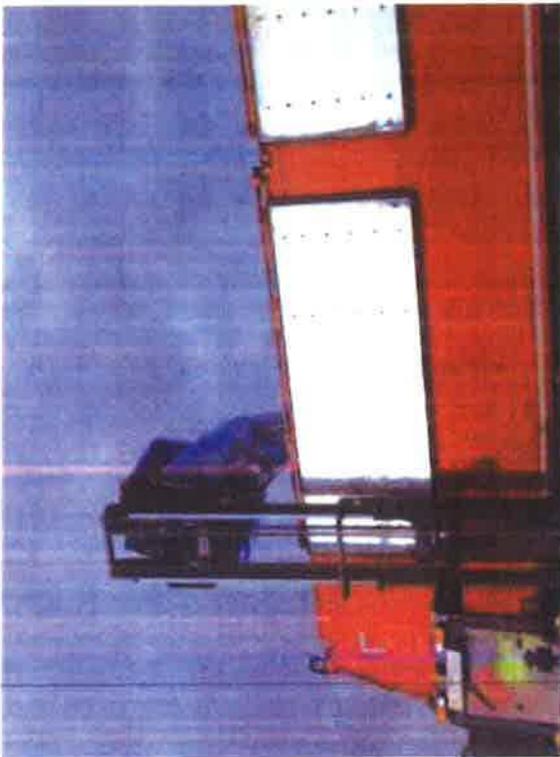


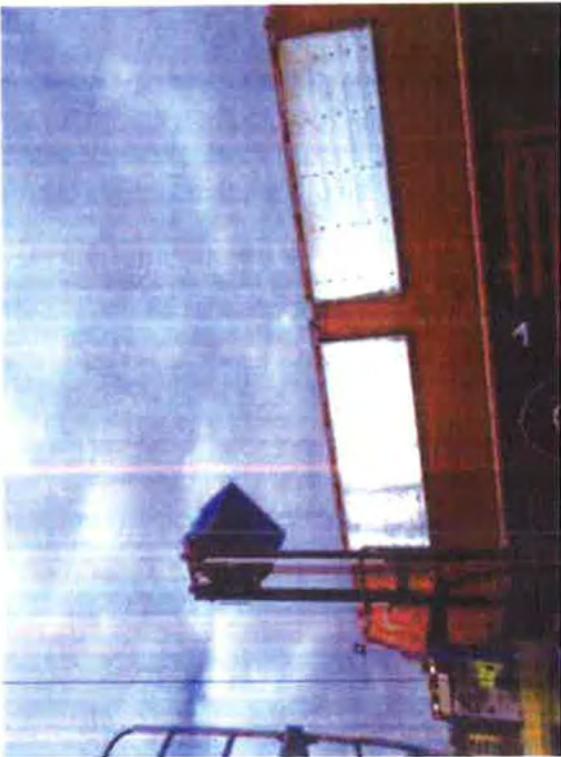


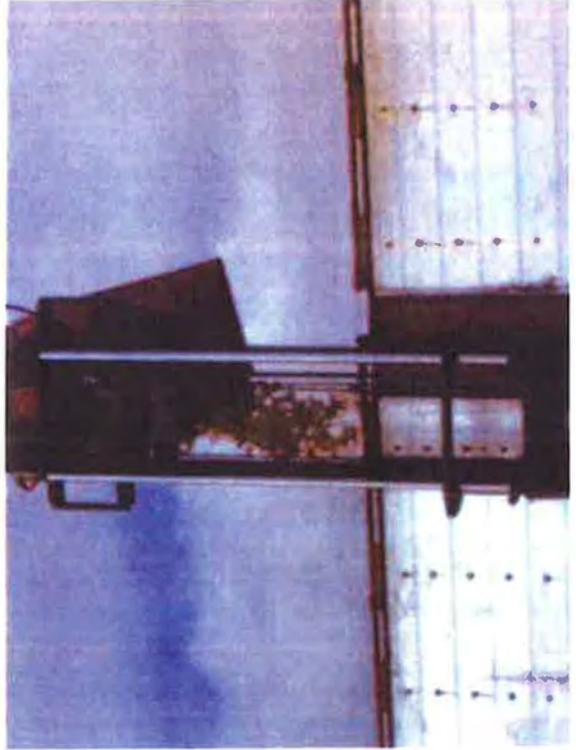


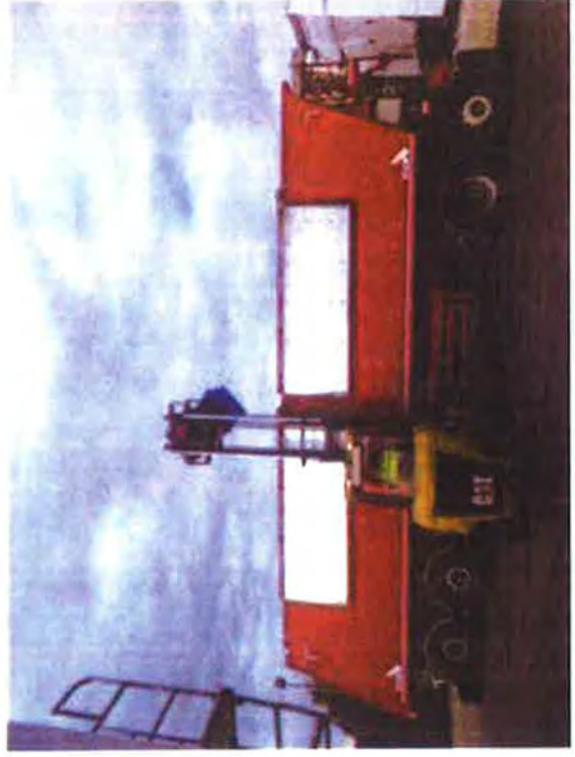


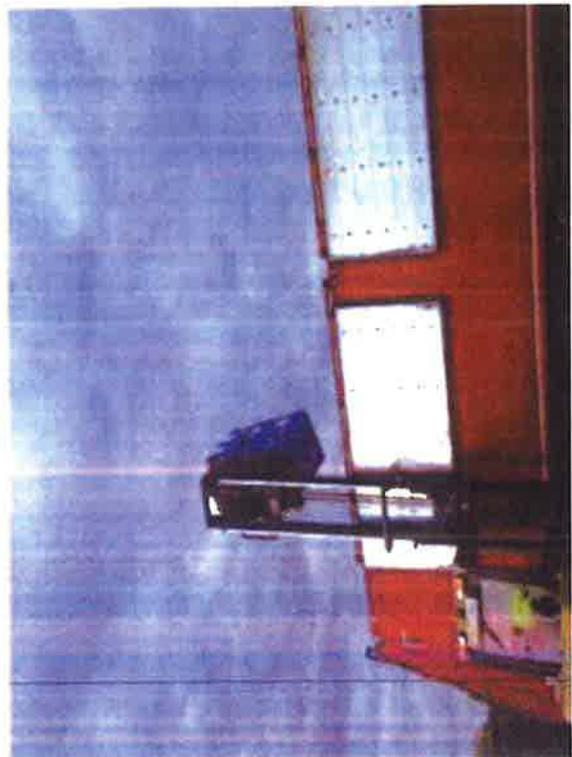
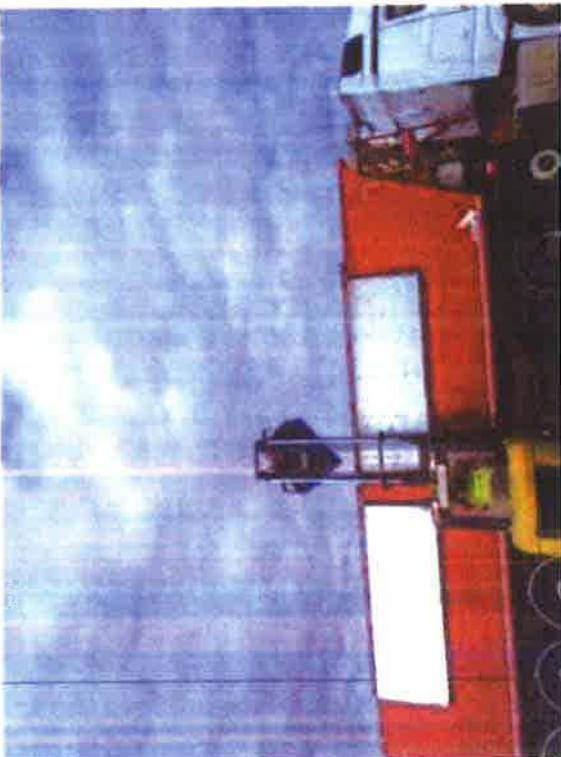
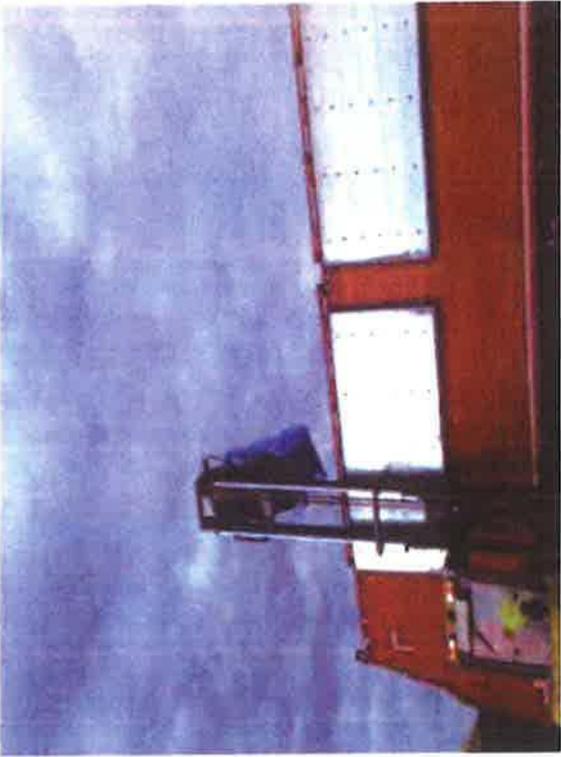


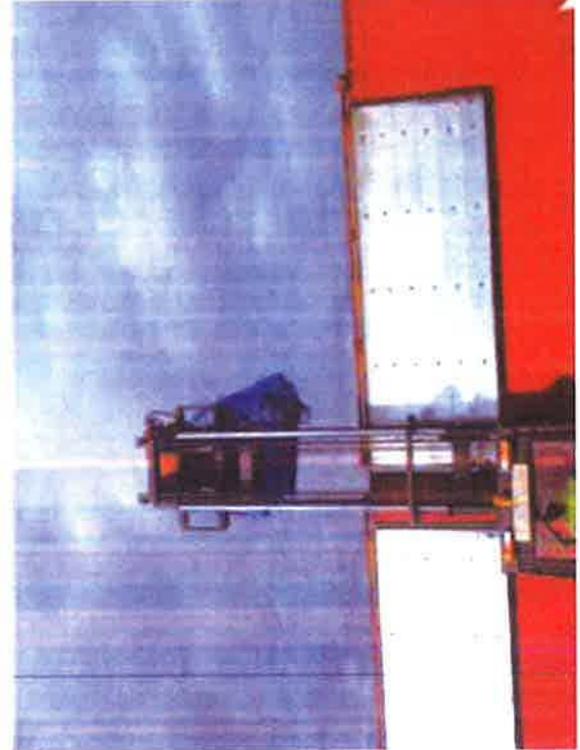
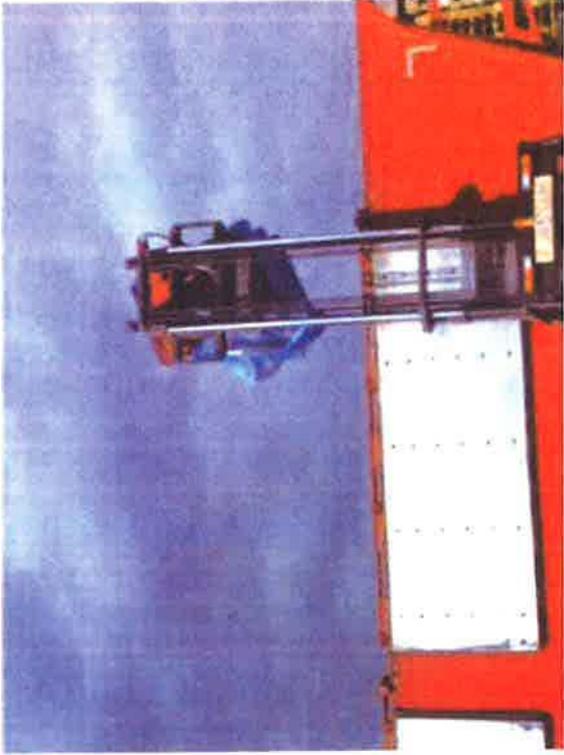






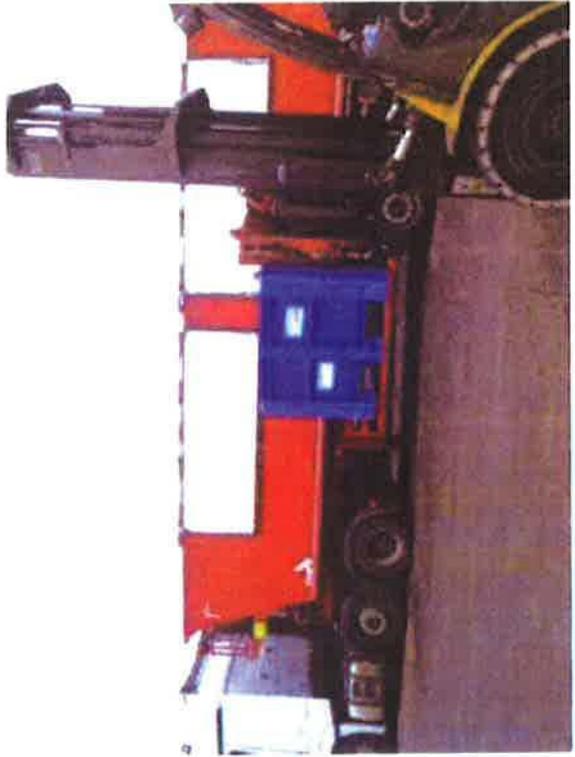














	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
Title: Carcass Correlation Procedure		Ref: FP-64	Page 2 of 1

last positive check will be disposed of as Category 2 waste. This will be recorded as the corrective action on the correlation check sheet (SL-016-US).

Monitoring

Monitoring of the **correlation** takes place every 20 minutes during production. The charge hand checks the alignment of the slaughter line and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Monitoring that the **gut pan reject mechanism** is working correctly also takes place every 20 minutes during production. The charge hand checks the reject mechanism of the gut pan and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Correlation check sheet will be formally reviewed by the Slaughter line Manager/Supervisor daily.

Verification

The correlation and gut pan reject mechanism will be verified once daily by the QA department. The QA checks the alignment of the slaughter line and the reject mechanism of the gut pan. If either is not working then they must stop the line immediately and contact the Slaughter line Manager.

CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed:  _____

Date: 3-9-17 _____

Print Name: SMILLS _____

Clock Number: 95007424 _____

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
	Title: Carcass Correlation Procedure	Ref: FP-64	Page 2 of 1

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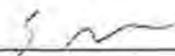
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CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed:  Date: 3.10.17

Print Name: S. H. H. H. H. Clock Number: 60033274

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
		Title: Carcass Correlation Procedure	Ref: FP-64

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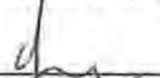
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CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed: 

Date: 5/10/17

Print Name: N.D. Jackson

Clock Number: 95007425

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
Title: Carcass Correlation Procedure		Ref: FP-64	Page 2 of 1

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The correlation and gut pan reject mechanism will be verified once daily by the QA department. The QA checks the alignment of the slaughter line and the reject mechanism of the gut pan. If either is not working then they must stop the line immediately and contact the Slaughter line Manager.

CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed: G. Urbanowski Date: 5/10/17
 Print Name: G. URBANOWSKI Clock Number: 60080186

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
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CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed: *N Temple*

Date: 5/10/17

Print Name: N TEMPLE

Clock Number: 60074622

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

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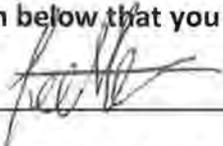
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CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed: 

Date: 5/10/17

Print Name: J. TATTERSALL

Clock Number: 60080920

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

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CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed: M. peggs

Date: 3-10-17

Print Name: M. peggs

Clock Number: 60042384

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
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CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed:  Date: 3/10/17

Print Name: A. BROOKSHAW Clock Number: 60000921

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
		Title: Carcass Correlation Procedure	Ref: FP-64

last positive check will be disposed of as Category 2 waste. This will be recorded as the corrective action on the correlation check sheet (SL-016-US).

Monitoring

Monitoring of the **correlation** takes place every 20 minutes during production. The charge hand checks the alignment of the slaughter line and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Monitoring that the **gut pan reject mechanism** is working correctly also takes place every 20 minutes during production. The charge hand checks the reject mechanism of the gut pan and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Correlation check sheet will be formally reviewed by the Slaughter line Manager/Supervisor daily.

Verification

The correlation and gut pan reject mechanism will be verified once daily by the QA department. The QA checks the alignment of the slaughter line and the reject mechanism of the gut pan. If either is not working then they must stop the line immediately and contact the Slaughter line Manager.

CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed:  Date: 3-9-17

Print Name: SMILLS Clock Number: 95007424

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
Title: Carcass Correlation Procedure		Ref: FP-64	Page 2 of 1

last positive check will be disposed of as Category 2 waste. This will be recorded as the corrective action on the correlation check sheet (SL-016-US).

Monitoring

Monitoring of the **correlation** takes place every 20 minutes during production. The charge hand checks the alignment of the slaughter line and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Monitoring that the **gut pan reject mechanism** is working correctly also takes place every 20 minutes during production. The charge hand checks the reject mechanism of the gut pan and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Correlation check sheet will be formally reviewed by the Slaughter line Manager/Supervisor daily.

Verification

The correlation and gut pan reject mechanism will be verified once daily by the QA department. The QA checks the alignment of the slaughter line and the reject mechanism of the gut pan. If either is not working then they must stop the line immediately and contact the Slaughter line Manager.

CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed: D Vickers Date: 3-10-17

Print Name: D VICKERS Clock Number: 60001344

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
Title: Carcass Correlation Procedure		Ref: FP-64	Page 2 of 1

last positive check will be disposed of as Category 2 waste. This will be recorded as the corrective action on the correlation check sheet (SL-016-US).

Monitoring

Monitoring of the **correlation** takes place every 20 minutes during production. The charge hand checks the alignment of the slaughter line and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Monitoring that the **gut pan reject mechanism** is working correctly also takes place every 20 minutes during production. The charge hand checks the reject mechanism of the gut pan and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Correlation check sheet will be formally reviewed by the Slaughter line Manager/Supervisor daily.

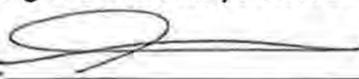
Verification

The correlation and gut pan reject mechanism will be verified once daily by the QA department. The QA checks the alignment of the slaughter line and the reject mechanism of the gut pan. If either is not working then they must stop the line immediately and contact the Slaughter line Manager.

CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed:  Date: 3/10/17

Print Name: N. BIROU Clock Number: 60013116

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical

	Food Safety and Quality Management System Procedure	Date: 26/09/2017	Issue: 1
		Title: Carcass Correlation Procedure	Ref: FP-64

last positive check will be disposed of as Category 2 waste. This will be recorded as the corrective action on the correlation check sheet (SL-016-US).

Monitoring

Monitoring of the **correlation** takes place every 20 minutes during production. The charge hand checks the alignment of the slaughter line and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Monitoring that the **gut pan reject mechanism** is working correctly also takes place every 20 minutes during production. The charge hand checks the reject mechanism of the gut pan and if it is not working then they must stop the line immediately and contact the Slaughter line Manager.

Correlation check sheet will be formally reviewed by the Slaughter line Manager/Supervisor daily.

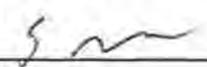
Verification

The correlation and gut pan reject mechanism will be verified once daily by the QA department. The QA checks the alignment of the slaughter line and the reject mechanism of the gut pan. If either is not working then they must stop the line immediately and contact the Slaughter line Manager.

CROSS REFERENCE:

SL-016-US - Slaughter Line Correlation Sheet

Please sign below that you have read, understood and agree to comply with all of the above procedure:

Signed:  Date: 3.10.17

Print Name: S. Harvey Clock Number: 60035274

AMENDMENT LOG

DATE:	ISSUE NUMBER:	DETAILS OF AMENDMENT:	ISSUED BY:
27/09/2017	01	New Procedure	D James

Issued by	Quality Systems Manager
Approved by	Head of Technical



Quality Management System Check Sheet

Date:
08/09/2015

Issue:
7

Title: Staff Briefing Sign Off Sheet

Ref:
GEN - 021

Ref:
Page 1

Briefing by	Darren James – Quality Systems Manager		Date	09/10/2017
Reason for Briefing	If any guts come into contact with the floor then these must be placed back in the gut pan but must be marked with a red flag.			
	If a pluck comes into contact with the floor then these must be placed back on the pluck line but must be marked with a red flag.			
	NB The red flag shows that these products have come into contact with the floor and are no longer eligible for human consumption. Once any component with a red flag has been inspected to the meat hygiene inspectors then it must go into one of the category 2 waste bins provided			
Area/Dept.	All areas	Customer	FSA	
Material Code	N/A	UB/KD/Batch	N/A	
Picture Shown	N/A			

I have understood the above briefing:

Name	Signature	Name	Signature
A LOWIE	<i>A Lowie</i>	S MILLS	<i>S Mills</i>
W BRZEZOWSKI	<i>W Brzezowski</i>	N JACKSON	<i>N Jackson</i>
S STEPNIAK	<i>S Stepniak</i>		
P HODULA	<i>P Hodula</i>		
S RHODES	<i>S Rhodes</i>		
M KUNAPILC	<i>M Kunapilc</i>		
D KROPIWNIK	<i>D Kropiwnik</i>		
A BOZOVAN	<i>A Bozovan</i>		
N TEMPLE	<i>N Temple</i>		
M PEGGS	<i>M Peggs</i>		
G URBANSKI	<i>G Urbanski</i>		
P TARDON	<i>P Tardon</i>		
T CZYZ	<i>T Czyn</i>		
Z STEFANSKI	<i>Z Stefanski</i>		
Z SZLOPIALC	<i>Z Szlopialc</i>		
S TATTERSALL	<i>S Tattersall</i>		
G OLONCZAK	<i>G Olonczak</i>		
P. PISARSKI	<i>P. Piskarski</i>		

Issued by	Quality Systems Manager
Approved by	Technical Manager

ROOT CAUSE ANALYSIS

- At 1145h on 21/9/17 the following issues presented themselves in quick succession on the slaughter line at the MHI point in the line
- The gut reject pan failed to operate as expected (in that the Guts did not reject when placed under challenge to do so)
- It was observed that more than 1 carcass passed the inspection point with no guts in the pans to correlate to the carcass
- It was observed that the carcass line was out of correlation in terms of presentation of Guts/Red Offal and Carcass to the inspection point

Why is this happening?

The carcass/Guts/Plucks were not presented all together and when the guts were not rejected by the Gut Pan reject no action was taken by the FBO.

Why is this that?

There is a lack of understanding and knowledge of the requirements to present guts/plucks/carcasses for inspection

Why is this that?

There is a lack of training to guide managers and operatives what to do if there is an issue with the presentation of these items for inspection or with the rejection of non acceptable items.

Why is this that?

There is not a procedure in place for the correlation of all items and verification of the systems in place to control and maintain it.

Corrective action:

• **Gut Pan Rejection Failure**

- All materials produced from Guts during the production day 21/9/17 up until the time 11:45 were isolated and sent to disposal (this was a total of 14 dolavs)
- The Gut Room was cleaned of all material and production was recommenced only at 12:10 once the reject mechanism was confirmed as working
- We have implemented an additional check (every 20 minutes) on the efficacy of the gut pan rejection as of next slaughter day (25/9 – Note we do not slaughter on Friday) (This will be briefed on Monday am)
- **Carcass correlation issue and misrepresentation of carcasses with no Guts**
- Production was stopped, the line was brought back into correlation and checked for correct correlation by the FBO and MHI prior to restarting
- All carcasses that had been produced since the last documented check of correct line correlation (this was at 1100h) were identified (these were carcass numbers 1845-2313 – 468 in total), located and placed on hold
- Karro Foods made the decision to dispose of all carcasses to Category 2 disposal (voluntary agreement to dispose documentation attached). These carcasses will be disposed of at the business cost on 23/9/17 (evidence as attached)

Preventative Action:

- Procedure FP-64 Implemented to address the issue of non presentation to include what happens if Guts fall on the floor during evisceration.
- Monitoring and verification is captured on Check Sheet SL-016-US

• **LT Corrective action:**

- Investigate/Review if the above controls have addressed this issue and assess if further mechanical controls/interventions are required.

	Food Safety and Quality Management System Check Sheet	Date: 20/09/2017	Issue: 31
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KARRO Food Group Ltd.

Malton

SANITATION STANDARD OPERATING PROCEDURES

UK 2060

Sanitation Standard Operating Procedures

**Revision 31
20th September 2017**

Stuart Hawkshaw



Technical Manager

Enclosed in this notebook is the Sanitation Standard Operating Procedures
for – KARRO Food Group

Issued by	Quality Systems Manager
Approved by	Technical Manager

	Food Safety and Quality Management System Check Sheet	Date: 20/09/2017	Issue: 31
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Standard Sanitation Operation Procedures define the essential elements necessary to maintain sanitary conditions throughout the plant. The SSOP covers the daily pre-operational and operational sanitation requirements, which are required to prevent direct product contamination. each task has a defined monitoring arrangement.

In determining these procedures we have carefully reviewed and modified our existing arrangements to develop a system, which will control and monitor sanitation procedures at all times.

These revised requirements have been implemented in such a way that all personnel involved fully understand the procedures (or the part relevant to their duties) Ongoing review of the overall performance of the SSOP is assigned to the Technical Manager/Head of Technical.

Reviewed By;
Quality Systems Manager: Darren James

Date 20/09/2017

Authorised by;
Stuart Hawkshaw - Technical Manager



Date 20/09/2017

Issued by	Quality Systems Manager
Approved by	Technical Manager

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PROCEDURE FOR THE OPERATIONAL HYGIENE AND HANDLING OF DOLAVS, TRAYS, XMAS TREES AND FOOD CONTACT PACKAGING.

Issued by	Quality Systems Manager
Approved by	Technical Manager

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SANITATION FORMS

PRE-OPERATIONAL SSOP INSPECTION FORMS

Daily Pre-Operational Inspection Sheet- Fresh Meat Despatch	FMD - 001
Daily Pre-Operational Inspection Sheet – Retail Pork	RP - 001
Daily Pre-Operational Inspection Sheet – Primal Cutting	PC - 001 - US
Daily Pre-Operational Inspection Sheet – Slaughter Line Evisceration	SL - 011 - US
Daily Pre-Operational Inspection Sheet – Butchery	BU - 001
Daily Pre-Operational Inspection Sheet – Shoulder De-Bone	SH - 001
Daily Pre-Operational Inspection Sheet – Middle De-Bone	MI - 001 - US
Daily Pre-Operational Inspection Sheet – Protocon	PRO - 003
Daily Pre-Operational Inspection Sheet – Gut Room	SL - 012 - US
Daily Pre-Operational Inspection Sheet – Plate Freeze	SL - 013 - US
Daily Pre-Operational Inspection Sheet – Slaughter	SL - 001 - US
Daily Pre-Operational Inspection Sheet – Export	EXP-003
Daily Pre-Operational Inspection Sheet – Export Boxing	EXP-002
Steriliser Temperature Monitoring	GEN - 017
Steriliser Temperature Monitoring - Slaughter	SL - 003 - US
Slaughter Line Steriliser Temperature Monitoring	SL - 014 - US
Primal Steriliser Temperature Monitoring	PC-002
Daily cleaning task Sheet	HSA's

CORRECTIVE ACTION FORMS

Corrective Action Report - Hygiene	TE - 062
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Issued by	Quality Systems Manager
Approved by	Technical Manager

	Food Safety and Quality Management System Check Sheet	Date: 20/09/2017	Issue: 31
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OPERATIONAL SSOP INSPECTION FORMS

Operational Sanitation Operating Procedures Monitoring	TA – 054/TA-094
Steriliser Temperature Monitoring	PC-002
Steriliser Temperature Monitoring	GEN-017
Slaughter line steriliser monitoring sheet	SL - 003 - US, SL - 014 – US
Knife issue record	GEN-036
Contamination Rectification Record - Slaughter Line	SL - 019 - US
Contamination Rectification Record - Butchery	BU - 004
Carcass Contamination Monitoring Pre FSA Inspection	SL - 018 - US
Carcass Evisceration Procedure Monitoring	SL - 021 - US
Carcass Contamination Record	SL - 020 - US

Issued by	Quality Systems Manager
Approved by	Technical Manager

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SSOP-1

PROCEDURE FOR PRE OPERATIONAL HYGIENE OF PRODUCTION AREAS

OBJECTIVE:

To define the basic procedure for the daily cleaning and sanitation of the Slaughter line and Fresh Meat Areas.

SPECIFIC DETAILS FOR THE CLEANING OF EACH AREA AND THE INDIVIDUAL ITEMS OF EQUIPMENT WITHIN IT ARE HELD IN THE HYGIENE SCHEDULES MANUALS.

FREQUENCY:

Daily - prior to the start of production and to the OV pre-operational checks.

PERSONS RESPONSIBLE:

Implementation: Hygiene Charge hands /Supervisors.
Monitoring: Production Charge hands /Supervisors/Managers.
Corrective Action: Hygiene Supervisors.

DOCUMENTATION:

Daily Pre Operational Inspection Sheets – **see reference table on page 4**
Hygiene Procedure Monitoring Sheet – **HSA Daily Cleaning Task Sheet**
Corrective Action Reports – **TE-062 Hygiene Department Corrective Action Report**
TE060 Environmental Swab Failure Investigation Form

PROCEDURE:

1. Cover any electrical equipment with a plastic liner.
2. Pick up any parts and/or large debris and dispose of in designated unfit bins.
3. Disassemble equipment in accordance with the hygiene schedules and place parts in designated receptacles, racks etc (where applicable).
4. Pre-rinse soiled areas with potable water. This includes all equipment, stands, carts, and utensils. Pre-rinse should be performed starting at the top and moving towards the bottom.
5. Foam area to be cleaned from top to bottom with an approved cleaner mixed according to manufacturer specifications. Allow adequate time for the cleanser to loosen soil, contact time of 15-20mins
6. Rinse all equipment thoroughly with potable water using the top to bottom method.
7. Inspect and spot scrub area as needed. In any areas that require extra cleaning, repeat rinse after scrubbing is completed.
8. Apply sanitiser liberally to all surfaces according to manufacturer's specifications. Reassemble equipment (where applicable).
9. Remove plastic liner or cover them up and hand clean any electrical equipment.
10. Re-inspect and document that the area is clean and ready to be released to production for Pre-Operational inspection.

MONITORING AND RECORD KEEPING:

The nominated trained person carries out the Daily Pre-Operational Inspection in each department. The results are recorded on the relevant pre-operational form related to the department as above. If no deficiencies are found, the Acceptable box is marked "Pass". If a deficiency is found, the Acceptable box is marked "Fail". The details of any deficiencies of SSOP's are documented on the sheet and the immediate corrective action taken to restore sanitary conditions is recorded in each instance.

In cases which are serious in nature or repetitive a formal investigation and corrective action plan will be undertaken by the hygiene manager/supervisor using the hygiene department corrective action report (TE-062). Corrective actions will be agreed with the Head of Technical/Technical Manager and put in place immediately.

The pre-operational forms are completed with the time, date and signature of the checker, and forwarded to the Departmental Manager / Supervisor for documentation review and signature. Copies are passed to the Official Veterinarian, Hygiene Supervisor and the Technical Manager.

Issued by	Quality Systems Manager
Approved by	Technical Manager

	Food Safety and Quality Management System Check Sheet	Date: 20/09/2017	Issue: 31
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Food contact surfaces are swabbed as part of the routine microbiological monitoring process.

Adherence to the Hygiene Schedules is subject to monitoring by the Hygiene Supervisor. The observations are recorded on the HSA sheets.

CORRECTIVE ACTIONS:

All unsatisfactory food contact areas are re-cleaned, re-sanitised, re-inspected and released prior to start of production. The immediate corrective action taken to restore sanitary conditions is recorded on the Daily Pre Operational Inspection Sheet.

Any unsatisfactory non-food contact areas will be re-cleaned, re-sanitised, re-inspected and released within a suitable timescale

Any unacceptable micro swab results are reported to the Hygiene Supervisor, who ensures that the area is properly cleaned and a re-test carried out as soon as possible.

The Hygiene Supervisor carries out an investigation on serious in nature or repetitive issues to identify the root cause of the deficiency and completes a Corrective Action Report Form, stating the action taken to prevent a re-occurrence.

VERIFICATION

Verification is carried out on a random basis by Technical and recorded on the departmental pre-operational form.

Issued by	Quality Systems Manager
Approved by	Technical Manager

	Food Safety and Quality Management System Check Sheet	Date: 20/09/2017	Issue: 31
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SSOP-2

PRE OPERATIONAL CLEANING OF DOLAVS AND TRAYS

OBJECTIVE:

Dolav's and Trays to be used in production will be washed / sanitised prior to use.

FREQUENCY:

All dolav's and trays placed within a department are checked prior to start up of production.

PERSON RESPONSIBLE:

Implementation: Hygiene Charge hands/Supervisors.

Monitoring: Production Charge hands/Supervisors/Managers.

DOCUMENTATION:

Daily Pre Operational Inspection Sheets –

see reference table on page 4.

Corrective Action Reports –

TE-062 Hygiene Department Corrective Action Report

PROCEDURE: DOLAVS

1. Used dolav's are removed from production areas and transported to the dolav wash area for cleaning. Exceptionally, due to the health and safety implications of removing the dolavs from the department, Middle De Bone (MDB) dolavs will be cleaned and disinfected in the production area avoiding any cross contamination of products.
2. The dolav's are passed through the dolav wash machine, as per the Hygiene Schedule (**HYGOM1**) for dolav washing.
3. All dolav's are to be inspected for signs of damage. If dolav's are damaged they are to be removed and placed in designated area and labelled.
4. Dolav's are asided to the clean dolav storage area to await collection.

NB: Dolav's are not to be used without first placing a clean new dolav liner in the dolav, except when they are used to collect cardboard waste.

PROCEDURE: TRAYS

1. Used trays are removed from production areas and transported to the tray wash area for cleaning.
2. Major portions of meat scraps and/or debris are removed from tray prior to placing into washing machine.
3. Trays are placed one at a time on machine conveyor. Trays enter machine and is washed with detergent solution, as per the Hygiene Schedule for tray washing (**HYGOM2**).
4. Trays are inspected at machine exit for cleanliness and label residue and stacked on a pallet in a sanitary manner.
5. Trays must not be placed in direct contact with the floor. White trays are to be placed inside red/blue or nominated floor trays, which can come into direct contact with the floor.

MONITORING AND RECORD KEEPING:

The Production Charge hand/Supervisor or nominated trained person carries out a Daily Pre Operational Inspection in each department. This check includes a check on all trays on each line to ensure they are visibly clean and free of any debris. The results are recorded on the respective pre-operational inspection. If no deficiencies are found, the Acceptable box is marked "Pass". If a deficiency is found, the Acceptable box is marked "Fail". The details of any deficiencies are documented on the sheet and the immediate corrective action taken to restore sanitary conditions is recorded in each instance.

In cases which are serious in nature or repetitive a formal investigation and corrective action plan will be undertaken by the hygiene manager/supervisor using the hygiene department corrective action report (TE-062). Corrective actions will be agreed with the Head of Technical/Technical Manager and put in place immediately.

The sheet is completed with the time, date and signature of the checker, and forwarded to the Departmental Manager / Supervisor for documentation review and signature.

Copies are passed to the Hygiene Supervisor and the Technical Manager.

Issued by	Quality Systems Manager
Approved by	Technical Manager

	Food Safety and Quality Management System Check Sheet	Date: 20/09/2017	Issue: 31
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The trays are swabbed as part of the routine microbiological monitoring process.

CORRECTIVE ACTIONS:

All unsatisfactory trays and dolav's are returned to the tray wash department for re-cleaning prior to the start of production, with the exception of MDB as described above.

The immediate corrective action taken to restore sanitary conditions is recorded on the Daily Pre Operational Inspection Sheet.

The Hygiene Supervisor carries out an investigation on serious in nature or repetitive issues to identify the root cause of the deficiency and completes a Corrective Action Report Form, stating the action taken to prevent a re-occurrence.

All unsatisfactory trays and dolav's that are damaged are removed from circulation prior to the start of production.

VERIFICATION

Verification is carried out on a random basis by Technical and recorded on the departmental pre-operational form.

Issued by	Quality Systems Manager
Approved by	Technical Manager

	Food Safety and Quality Management System Check Sheet	Date: 20/09/2017	Issue: 31
Title: Sanitation Standard Operating Procedures		Ref: SSOP	Page 10 of 24

SSOP- 3

PROCEDURE FOR PRE OPERATIONAL CLEANING OF HANDS AND PERSONAL EQUIPMENT

OBJECTIVE:

All personal equipment, i.e. Hands and gloves, aprons, scabbards, arm guards, etc. will be clean before start of production.

FREQUENCY:

Daily.

PERSON RESPONSIBLE:

Implementation: Production Charge hands

Monitoring: Production Supervisors, or other appointed trained person.

DOCUMENTATION:

Daily Pre Operational Inspection Sheets - **see reference table on page 4.**

PROCEDURE:

1. All operators must ensure that their chain mail gloves, aprons, rubber gloves, scabbards, steels, meat hooks and arm guards are clean prior to start of production.
2. These items are to be cleaned in the washrooms available.
3. The equipment will be hand scrubbed.
4. The equipment will be rinsed with potable water.
5. The equipment is to be made available for inspection at any time.
6. All operators must wash their hands in the sluice rooms (or gloved hands) prior to entering the production areas with the exception of operatives working in the middle de-bone who need to wash secondary in the actual production room.

MONITORING AND RECORD KEEPING:

The Production Charge hand or nominated trained person carries out a Daily Pre-Operational Inspection in each department. This check includes a check on 5 operatives at random to ensure their personal equipment is clean. The results are recorded on the respective pre-operational inspection form. If no deficiencies are found, the Acceptable box is marked "Pass". If a deficiency is found, the Acceptable box is marked "Fail". The details of any deficiencies are documented on the sheet and the immediate corrective action taken to restore sanitary conditions is recorded in each instance.

The sheet is completed with the time, date and signature of the checker. Copies are passed to the Hygiene Supervisor, on site OV and the Technical Manager.

CORRECTIVE ACTIONS:

Any person found reporting to the workstation with unclean personal equipment is returned to the wash facilities to re-clean their equipment as necessary prior to the start of production.

The root cause of the deficiency is identified and appropriate preventative measures are implemented. These may include, but not limited to training, or retraining of the employee or disciplinary action.

VERIFICATION

Verification is carried out on a random basis by Technical and recorded on the departmental pre-operational form.

Issued by	Quality Systems Manager
Approved by	Technical Manager

	Food Safety and Quality Management System Check Sheet	Date: 20/09/2017	Issue: 31
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SSOP-4

PROCEDURE FOR PRE OPERATIONAL KNIFE & KNIFE SHARPENING EQUIPMENT CLEANING AND STERILISATION

OBJECTIVE:

To define the procedure for Pre Operational Knife & knife Sharpening Equipment Cleaning and Sterilisation.

FREQUENCY:

Daily-prior to the start of production.

PERSON RESPONSIBLE:

Responsibility: All operatives who use a knife and sharpening equipment as part of their role

Implementation: Production Charge hands.

Monitoring: Production Supervisors or other appointed trained person.

RECORD/DOCUMENTATION:

Steriliser Temperature Monitoring - **GEN – 017**

Slaughterline Steriliser Temperature Check Sheet – **SL - 003 - US, SL – 014 - US**

Primal Cutting Steriliser Temperature Monitoring – **PC - 002**

Daily Pre Operational Inspection Sheets – **see reference table on page 4.**

Knife issue record – **BU-025, GEN-036**

PROCEDURE:

Sterilisers are switched on sufficiently early to ensure that the water temperature achieves a minimum of 83°C prior to the start of production. (Adhering to EU Legislation and RoK authorities). Knives will not be placed in the sterilisers unless they comply with the temperature requirement. Knife integrity checks are carried out in all departments at the start and end of shift reference documents PC002, GEN017a & BU025.

Note: All equipment must be checked prior to use and under no circumstances must any damaged equipment be used.

Slaughter line Procedure

On arrival at the work station operators place both colour-coded knives in the Steriliser.

All Knife sharpening equipment must be sterilised first thing prior to use by submerging into a 1% solution of terminol.

Primal Cut

On arrival at the work station operators place both colour-coded knives in the Steriliser.

All Knife sharpening equipment must be sterilised first thing prior to use by submerging into a 1% solution of terminol.

Leg Butchery, Middle and Shoulder Debone Area Procedure

Before operations the operative in charge of knives will place the knives for the day in the sterilisers and then issue one knife per operative as necessary.

All Knife sharpening equipment must be sterilised prior to use by submerging into a 1% solution of terminol.

One colour will be issued for the days production:

- Monday – Black
- Tuesday – Red
- Wednesday – Black
- Thursday – Red
- Friday – Black

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Approved by	Technical Manager

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Retail Pork

On arrival at the work station operators place knives in the steriliser. The area operates with a 2-knife colour coded system starting the day on black, after break red and after second break black again.

All Knife sharpening equipment must be sterilised prior to use by submerging into a 1% solution of terminol.

All Fresh Meat Areas

Whizzard blades are placed in sanitiser solution before assembly.

Scissors are washed and sterilised prior to use.

Templates are washed and sterilised prior to use

All Knife sharpening equipment must be sterilised prior to use by submerging into a 1% solution of terminol.

°MONITORING AND RECORD KEEPING:

Steriliser temperatures are recorded prior to start of production and monitored throughout production using form **GEN 017** Fresh Meat Areas, **SL - 003 - US, SL - 014 - US** for the Slaughter line and **PC-002** for Primal Cut.

The Production Charge hand/Supervisor or nominated trained person carries out a Daily Pre Operational Inspection in each department. This check includes a check on 5 persons at random to ensure they adhere to the procedure. The results are recorded on the respective inspection form. If no deficiencies are found, the Acceptable box is marked "Pass". If a deficiency is found, the Acceptable box is marked "Fail". The details of any deficiencies are documented on the sheet and the immediate corrective action taken to restore sanitary conditions is recorded in each instance.

The sheet is completed with the time, date and signature of the checker, and forwarded to the Departmental Manager/Supervisor for documentation review and signature.

Copies are passed to the Hygiene Supervisor and the Technical Manager.

CORRECTIVE ACTIONS:

In the event of a steriliser temperature being recorded <83°C, The steriliser is labelled "Engineers in attendance" until the temperature achieves >83°C. The individual steriliser is re-checked after 30 minutes. If the temperature is still <83°C the sign "Engineers in attendance" will not be removed and Engineering and the Supervisor are informed.

If any unit goes down whilst in production the corrective action scenario should be followed as stated above. Alternative sterilisers might need to be used until function is restored.

In the event of an operator being observed not to follow the correct procedure, they are instructed by the departmental management to immediately carry out the correct procedure prior to commencement of work.

The root cause of the deficiency is identified and appropriate preventative measures are implemented. These may include, but not limited to training of the employee or disciplinary action.

VERIFICATION

Monitoring records are verified by Technical on a random basis.

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SSOP-5

PROCEDURE FOR OPERATIONAL CLEANING OF HANDS AND PERSONAL EQUIPMENT

OBJECTIVE:

To define the procedure for ensuring that all personal equipment is cleaned and stored correctly throughout the production day and that hands and gloves are washed regularly.

FREQUENCY:

At break times.

PERSON RESPONSIBLE:

Production Management to ensure this procedure is followed.
Technical Supervisor to monitor this procedure.

RECORD/DOCUMENTATION:

SSOP Monitoring Sheet - **TA - 054**

PROCEDURE:

All operatives must wash their hands every time they enter a production area.

All personal equipment must be kept clean and in a sanitary condition at all times and be visibly clean.

Steels must be kept in clean scabbards and not hung on chains.

At break times operatives hand over their knives to the operative in charge of knife cleaning who will then wash and sterilise them. The operatives must remove their chain mail gloves, arm guards, aprons, steels and scabbards and take them to the sluice areas for cleaning and then to the changing rooms to storage.

The equipment is to be hand scrubbed and rinsed with potable water in the sluice room facilities and hung on the hangers in the changing rooms during breaks and at the end of the shift. Kevlar gloves are disposed of in the allocated bins in the sluice room and must not be taken to the changing rooms. Clean kevlar gloves are available on return to the work stations before entering the department and after washing hands in the sluice room.

MONITORING AND RECORD KEEPING:

The Technical Supervisor or nominated trained person carries out an inspection on a daily basis in each department to ensure the above procedure is followed. The results are recorded on form **TA – 054**.

Five operatives in each department are selected at random and their equipment is checked. The time and the operatives name are written on the sheet. If no deficiencies are found, the Acceptable box is marked "Pass". If a deficiency is found, the Acceptable box is marked "Fail".

The details of any deficiencies are documented on the sheet and the immediate corrective action taken to ensure compliance with the procedure is recorded on the back of the sheet.

The sheet is completed with the time, date and signature of the checker, and forwarded to the Departmental Production Managers.

CORRECTIVE ACTIONS:

In the event of an operator being observed not to follow the correct procedure, they are instructed by the departmental management to immediately return to the sluice room and carry out the correct hygiene procedure as detailed in FP-3.(Hand wash) or as above if PPE. This needs to be documented on **TA-054**.The root cause of the deficiency is established and measures to prevent a re-occurrence are implemented. These may include, but not limited to training or retraining of the employee or disciplinary action.

VERIFICATION:

SSOP 5 is verified daily by Technical using form TA-054 "Operational Sanitation Procedures Monitoring"

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Approved by	Technical Manager

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SSOP-6

PROCEDURE FOR OPERATIONAL KNIFE & SHARPENING EQUIPMENT CLEANING AND STERILISATION

OBJECTIVE:

To define the procedure for operational Knife & Sharpening equipment, Cleaning and Sterilisation.

FREQUENCY:

Slaughter line - Dressing Line up to FSA Inspection (including rectification room)

Between each carcass (STEEL, WASH, STERILISE)

Slaughter line – Other Areas

At least every hour and at every break.

Fresh Meat Butchery Areas

Every break

This same procedure will be followed in all areas if the knife or sharpening equipment is contaminated as a result of falling on the floor, touching contaminated meat or any other source of contamination.

PERSON RESPONSIBLE:

Responsibility: All operatives who use a knife and sharpening equipment as part of their role

Implementation: Production Charge hands

Monitoring: Technical Department Supervisor/Auditor

DOCUMENTATION:

Steriliser temperature monitoring check sheet **GEN - 017**

Slaughter line Steriliser Temperature Check Sheet- **SL - 003 - US, SL - 014 – US**

Steriliser Temperature Monitoring – **PC-002**

SSOP Monitoring sheet-**TA-054**

PROCEDURE:

Slaughter line

Temperature of sterilisers are checked and recorded every 2 hours during production.

Any malfunctions are to be reported to the engineers and steriliser labelled with the 'Engineers in attendance sign', which will be removed once the steriliser is fully working (83°C).

Dressing Line to FSA Inspection Point (including rectification room): 2-knife colour coded system is used to ensure that a clean and sterilised knife is used for each carcass.

After use, knife is washed and placed in the steriliser and replaced with the other colour-coded knife, which is stored in the steriliser ready for use.

At the end of production, all slaughter line operators clean and sterilise their knives before leaving the work station, and place them in a clean scabbard.

After use, scissors are cleaned and placed in the steriliser at least hourly and at break times.

All Knife sharpening equipment must be cleaned and sanitised at each break time during the day.

Primal Cut/Retail Pork

This area operates with a 2-knife colour coded system starting the day on black, after break red and after second break black again.

At the end of production all operatives hand in their knives which are washed and placed in the knife cabinet.

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All Knife sharpening equipment must be sanitised at each break time during the day.

Fresh Meat Areas

One colour will be issued for the days production.

- Monday – Black
- Tuesday – Red
- Wednesday – Black
- Thursday – Red
- Friday – Black

Knives are cleaned and sterilised prior to production start and at every break.

Temperature of sterilisers are checked and recorded before production and every 2 hours during production.

Any dropped knives or knife sharpening equipment must be washed and sterilised before re-use.

All Knife sharpening equipment must be cleaned and sanitised at each break time during the day.

At the end of production all operatives hand in their knives which are washed and placed in the knife cabinet.

Break time/Overtime

At break time and if working overtime all knives and sharpening equipment are to be cleaned and sterilised before re-use.

General

If during production the operator drops a knife or any sharpening equipment, it must be cleaned and sterilised immediately.

If during production the operator damages a knife or any sharpening equipment, it must be reported to the charge hand and replaced immediately. **No damaged equipment must be used.**

Whizzards

These are removed from the drive heads, washed and sterilised at each break time during the day.

Blade Pullers

These are sanitised at each break time during the day.

Templates

These are cleaned and sanitised at each break time during the day.

Knife Sharpening equipment

These are cleaned and sanitised at each break time during the day.

MONITORING AND RECORD KEEPING:

The Production Supervisor or nominated trained person carries out a Butchery Knife Sterilisation Check in each department. This check includes a check on all lines to ensure the above procedure is followed. The results are recorded on the respective knife sterilisation sheet. If no deficiencies are found, the Acceptable box is marked "Pass". If a deficiency is found, the Acceptable box is marked "Fail". The details of any deficiencies are documented on the sheet and the immediate corrective action taken to ensure compliance with the procedure is recorded.

The sheet is completed with the time, date and signature of the checker, and forwarded to the Departmental Manager.

CORRECTIVE ACTIONS:

In the event of an operator being observed not to follow the correct procedure, they are instructed by the departmental management to immediately carry out the correct procedure. This is documented in the TA-054

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Any product, which has been contaminated as a result of a failure to carry out this procedure, is to be asided to the unfit meat containers for disposal.

The root cause of the deficiency is established and measures to prevent a re-occurrence are implemented. These may include, but not limited to training or retraining of the employee or disciplinary action.

VERIFICATION

SSOP 6 is verified daily by Technical using form TA-054 “Operational Sanitation Procedures Monitoring”

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SSOP-7

PROCEDURE FOR HANDLING MEAT AFTER COMING INTO CONTACT WITH THE FLOOR

OBJECTIVE:

To ensure that products which have inadvertently come into contact with the floor are handled in such a way as to prevent contamination and adulteration of product.

FREQUENCY:

All meat that comes into contact with the floor.

PERSON RESPONSIBLE:

Implementation: Production Manager/Supervisor/Charge hands/Operatives.

Monitoring: Technical Department Supervisor/Auditor.

RECORD/DOCUMENTATION:

Operational SSOP Monitoring Sheet - **TA - 094**

PROCEDURE:

Carcass Procedure for the Slaughter line.

Slaughter line Pre Evisceration

- Any carcass, which comes into contact with the floor, must be picked up as soon as possible, rinsed and passed through the singer before evisceration.

Pre and Post FSA Inspection

- Any carcass, which comes into contact with the floor after opening, must be picked up immediately. Inspection and trimming shall be done under FSA supervision.

Carcass Procedure for Chills and Fresh Meat Areas

- Any carcass, which comes into contact with the floor, must be picked up immediately, and placed dirty side up on an inspection table. That person must then immediately wash their hands.
- A supervisor or charge hand must be informed in order that an inspection can be carried out. Any contaminated meat must be trimmed off with a clean, sterilised knife. The carcass can then be returned to the line.
- All trimming must be placed in the CAT 3 bin or CAT 2 if contaminated with abscesses, faecal material or machinery oil.
- The inspection table must be cleaned and sanitised using the spray sanitiser provided.
- Before returning to production, the operator must wash and sterilise his knife and wash his hands and apron.

Primals and Sub Primals

- Any primal or sub primal cut which comes into contact with the floor must be picked up and placed dirty side up onto the inspection table (should the meat roll on the floor then this must be fully trimmed). This person must then immediately wash their hands. ***NB* Under no circumstances can materials which have come into contact with the floor be used for OSI Food Solutions.**
- A supervisor or charge hand must be informed in order that an inspection can be carried out. Any contaminated meat must be trimmed off with a clean, sterilised knife. The primal can then be returned to the line.
- All trimming must be placed in the CAT 3 bin or CAT 2 if contaminated with abscesses, faecal material or machinery oil.
- The inspection table must be cleaned and sanitised using the spray sanitiser provided. In the primal cut area, the tables are cleaned with water before sanitising. Special care must be taken in order to avoid

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splashing or spraying of carcasses or meat cuts when cleaning tables (pouring of water and spraying should be done from a short distance).

5. Before returning to production, the operator must wash and sterilise his knife and wash his hands and apron.

Off cuts/ribs/jowl/fillets/trim.

1. Any of the above cuts coming in contact with the floor must be picked up and placed All trimming must be placed in the CAT 3 bin or CAT 2 if contaminated with abscesses, faecal material or machinery oil.
2. Before returning to production, the operator must wash their hands.

Dolav's

1. If dolav's are used for transferring floor contaminated primals. The dolav must be lined and labelled 'Floor contaminated primals' with the current batch information. All primals are to be transferred to a inspection table. That person must then immediately wash their hands.
2. A supervisor or charge hand must be informed in order that an inspection can be carried out. The whole primal must be trimmed off as if all the external surface has been contaminated. Meat must be trimmed off with a clean, sterilised knife. The primal can then be returned to the line.
3. The inspection table must be cleaned and sanitised using the spray sanitiser provided after each primal has been trimmed.
4. All trimmings must be placed in the CAT 3 bin or CAT 2 if contaminated with abscesses, faecal material or machinery oil.
5. Before returning to production, the operator must wash and sterilise his knife and wash his hands and apron.

MONITORING AND RECORD KEEPING:

The QA Supervisor or nominated trained person carries out a check in each department to ensure adherence to this procedure. The results are recorded on T-94. If no deficiencies are found, the Acceptable box is marked 'Yes'. If a deficiency is found, the Acceptable box is marked 'No'. The details of any deficiencies are documented on the sheet and the immediate corrective action taken to ensure compliance with the procedure is recorded.

The Sheet is completed with the time, date and signature of the checker, and forwarded to the Technical Manager and Departmental Managers.

CORRECTIVE ACTIONS:

In the event of an operator being observed not to follow the correct procedure, they are instructed by the departmental management to immediately carry out the correct procedure. This needs to be documented on T-94

Any product, which has been contaminated as a result of a failure to carry out this procedure, is to be asided to the unfit meat containers for disposal.

The root cause of the deficiency is established and measures to prevent a re-occurrence are implemented. These may include, but not limited to training or retraining of the employee or disciplinary action.

VERIFICATION

SSOP 7 is verified daily by Technical using form TA-094 "Operational Sanitation Procedures Monitoring"

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Approved by	Technical Manager

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SSOP- 8

PROCEDURE FOR THE OPERATIONAL PREVENTION OF CONTAMINATION BY FAECAL/INGESTA AND ABSCESSSES

OBJECTIVE:

To define the procedures carried out to prevent contamination by faecal/ingesta and abscesses.

FREQUENCY:

Ongoing as required.

PERSON RESPONSIBLE:

The Slaughter line Management is responsible for the implementation and monitoring of this procedure. The Butchery Management teams are responsible for the implementation of the abscess controls within their departments. The Technical Supervisor is responsible for monitoring this procedure on a daily basis.

RECORD/DOCUMENTATION:

Evisceration Procedure Monitoring Sheet – **SL – 021 – US**

Faecal Contamination Record Sheet – **SL – 019 – US**

Carcass Contamination Record Sheet – **SL – 020 – US**

Charge hands Monitoring of Carcass Contamination at FSA Stand Sheet – **SL – 018 – US**

RECORD/DOCUMENTATION:

SSOP Monitoring Sheet **TA – 094**

PROCEDURE: Faecal/Ingesta Contamination

Evisceration

1. Viscera are removed in accordance with Work Instruction Sline **WI28**
2. As the carcass arrives at opening the operatives open the carcass, if the intestine is burst, the operative will then attach a square red flag to the contaminated carcass. This will identify faecal contamination. The contaminated carcass will then be moved & monitored, by a production charge hand, to the rectification room, where rectification procedures can be carried out.
3. The operative must wash their apron, rinse then sterilise their knife. Ready to recommence duties on the next carcass.
4. If during evisceration the operator bursts a stomach or causes any type of faecal or ingesta contamination, they must immediately stop work on the carcasses and inform the charge hand.
5. The charge hand must check all immediate carcasses either side of the affected carcass for signs of cross contamination. A square red flag must be placed on each gambrel that contains a contaminated carcass. The top line charge hand must be informed & escort the carcasses to the rectification room.

Pelvic Cavity Inspection

1. The pelvic cavity inspection is specifically in place to identify any faecal contamination.
2. If any faecal contamination is observed, the operator places a square red semi-circle on the gambrel.
3. The carcass is then transferred to the rectification room, where it is carefully trimmed and corrected to remove any faecal contamination.
4. The pelvic cavity inspector can alert the bung gun operator of any abnormal levels of contamination by the use of amber and red lights situated at the corner at the top of the line.
5. If the bung gun operator is alerted of an abnormal level of faecal contamination by means of the lights, he then inspects the gun for correct operation cleaned and sharpened as necessary to correct the problem. If necessary, the bung gun is replaced and asided for repair.

Heads

Heads contaminated with digestive content/faecal are marked by the operator with a red triangle.

Rectification Room

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1. The operator carefully trims out the affected carcasses to complete the removal of the intestines and pluck and carries out the remaining pre-FSA dressing operations. Any faecal or ingesta contamination is carefully removed so as not to cause any further contamination. A green plastic tag is then placed over the hind foot to identify this as a Non-OSI / M&S product. The carcass is then presented to the FSA for inspection.

Abscesses Slaughter line

6. If during carcass dressing operations an operator cuts through or identifies an abscess, they must immediately stop work on the carcass, wash and sterilise the knife.
2. The operator must inform the line charge hand who places a yellow semicircle on the gambrel and escorts the carcass down the line to the rectification room.
7. The operator in the rectification room carefully carries out the remaining pre-FSA dressing operations, and trims out the affected area so as not to cause any further contamination of the carcass.
4. Any contaminated parts of the carcass are placed in the CAT 2 bins.
5. The carcass is then presented to the FSA for inspection.

Butchery

8. If during butchery operations an operator cuts through or identifies an abscess, they immediately stop work on the piece of meat affected and inform the line charge hand.
9. If any work surfaces have been contaminated, then the line is stopped immediately. All affected surfaces are washed and sanitised before re-starting operations.
10. Any sub primal cuts are placed in the CAT 2 bin. Any whole primals are taken to the inspection table and carefully trimmed to remove any contamination.
5. Any affected meat is placed in the CAT 2 bins. Any fit meat is returned to the line.
5. All operators wash and sterilise their knives and any other affected parts of their equipment and washes their hands before re-starting work.

MONITORING AND RECORD KEEPING:

Slaughter line

The evisceration procedure is monitored by the line charge hand. Each operator is checked 4 times a day for compliance with the evisceration and wash down procedure. The results are recorded on Sheet **SL – 021 – US**.

All contamination occurrences are monitored by the line charge hand. All instances of carcass contamination on a daily basis is recorded using sheet **SL – 020 – US**

A carcass contamination check is carried out by the line charge hand. 20 carcasses per 30 minutes are checked for contamination to ensure that flag systems are operating correctly. The results are recorded on sheet **SL – 018 – US**.

The number of flagged carcasses of each type referred for rectification is monitored and recorded by the rectification room operator using sheet **SL – 019 – US**

CORRECTIVE ACTIONS:

In the event of an operator being observed not to follow the correct procedure, they are instructed by the departmental management to immediately carry out the correct procedure. This needs to be documented on SSOP Corrective Action Report **TA-094**

Any product which has been contaminated as a result of a failure to carry out this procedure is to be asided to the unfit meat containers for disposal.

The root cause of the deficiency is established and measures to prevent a re-occurrence are implemented. These may include, but not limited to training or retraining of the employee or disciplinary action.

VERIFICATION

SSOP 8 is verified daily by Technical using form TA-094 “Operational Sanitation Procedures Monitoring”
SL-019 is verified by Technical on a daily basis.

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Approved by	Technical Manager

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SSOP- 9

OPERATIONAL HYGIENE AND HANDLING OF DOLAVS, TRAYS, XMAS TREES AND FOOD CONTACT PACKAGING.

OBJECTIVE:

Dolav's, trays, xmas trees and food contact packaging used in production are cleaned and handled in such a way as to prevent contamination of product.

FREQUENCY:

On going

PERSON RESPONSIBLE:

Production Management is responsible for implementing this procedure.
Technical Supervisor is responsible for monitoring this procedure on a daily basis.

RECORD/DOCUMENTATION:

SSOP Monitoring Sheet **TA – 094**

PROCEDURE:

Dolav's

- During production dolav's must be washed as per the hygiene schedule for dolav's and stored in the collection area to await collection.
- Dolavs must always be used with a clean new dolav liner, correctly positioned such that the content of the dolav can be fully covered over (no liners need to be used when the dolav is going to hold only cardboard waste).
- Dolav liner must always be used in a manner, ensuring that the liner is positioned such that the liner in the dolav does not over hang so as to be in contact with footwear or the floor.
- Dolav's must never be sited such that they can obstruct the passage Xmas trees of primals, causing the primals to contact the outside of the dolav.
- Dolav's used for the collection of packaging waste must be clearly distinguished from those for meat use by using a black dolav liner. Dolavs for the collection of cardboard waste can be used without liners.

Trays

- During production trays will be washed as per the hygiene schedule for trays and stored in the collection area to await collection.
- Trays used for direct contact are checked by the hygiene team as per 16 trays/pallet on a daily basis.
- Any trays found to be not clean once in the production departments must be returned to the tray wash area for re washing.
- Trays used for unfit meat must be clearly marked "Category 2 Material – Not for Animal Consumption" (red trays) or "Category 3 Material-Not for Human Consumption" (yellow trays)
- Tray liner must always be used in a manner, ensuring that the liner is positioned such that the liner in the tray does not over hang so as to be in contact with footwear or the floor.
- All trays used for direct contact with unwrapped meat must be free of remnants of label adhesive.

Xmas Trees.

- Xmas Trees must be washed and sanitised. Prior to use. They must be checked for cleanliness immediately before use. Any trees found not to be clean must be returned to the tree wash for re-washing or wash in the department if they can't be returned avoiding any contamination of meat or work surfaces.

Packaging

- All food contact packaging, such as tray liners, dolav liners, tubing, must be stored and handled in a manner such as to eliminate the possibility of contamination.
- Such items must be kept in the outer wrapping until required. They must then be placed into clean receptacles or on to suitable racks or other storage equipment to await use.

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- After production all packaging items must be either removed from the production areas or wrapped to prevent cross contamination.

MONITORING AND RECORD KEEPING:

The QA Supervisor or nominated trained person carries out a check in each department to ensure adherence to this procedure. The results are recorded on Form **TA – 094**. If no deficiencies are found, the Acceptable box is marked “Yes”. If a deficiency is found, the Acceptable box is marked “No”. The details of any deficiencies are documented on the sheet and the immediate corrective action taken to ensure compliance with the procedure is recorded.

The Sheet is completed with the time, date and signature of the checker, and forwarded to the Technical Manager and Departmental Managers.

CORRECTIVE ACTIONS:

All unsatisfactory trays and dolav’s are returned for re washing as necessary.
Any contaminated packaging is discarded.
Any actions need to be documented on SSOP Corrective Action Report **TA-060**

Any product, which has been contaminated as a result of a failure to carry out this procedure, is to be asided to the CAT 2 disposal.

The root cause of the deficiency is established and measures to prevent a re-occurrence are implemented. These may include, but not limited to training or retraining of the employee or disciplinary action.

VERIFICATION

SSOP 9 is verified daily by Technical using form TA-094 “Operational Sanitation Procedures Monitoring”

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Amendment Log

Date	Version	Amendment Reason	Name
25/11/2009	12	New Technical Manager	Clive Parry
03/06/2010	13	Document details updated to comply with Quality Management System Review amendments.	Jon Hayton
03/10/2011	14	Document details updated to comply with Quality Management System Review amendments	Siobhán Houldershaw
16/05/2012	15	Details amended to reflect changes in documentation and knife control	Ian Lumley
13/07/2012	16	Addition of Primal Cut Steriliser Temperature Monitoring checksheet PC-002	Siobhán Houldershaw
05/04/2013	17	Change of Company Logo and Name, new QA Manager and Technical Manager	Malton Technical
09/09/2013	18	Word change and re-format. Change MHS to FSA	Bren Harrington
18/11/2013	19	Knife hygiene policy change from every hour to each break	Bren Harrington
19/05/2014	20	Update knife issue and sterilisers in butchery	Bren Harrington
10/09/2014	21	Update SSOP-4 steriliser temp to 83°C to come in line with RoK authorities	Karan Wilson
24/03/2014	22	Amendment to SSOP -7 handling of meat been in contact with floor	Karan Wilson
26/04/2015	23	Annual review	Karan Wilson
29/09/2015	24	Amendment to SSOP -7 corrective action added should meat roll after coming into contact with the floor. SSOP – 6 knife control	Karan Wilson
04/11/2015	25	Amendments to SSOP4 & 6 knife control and sharpening equipment added	Karan Wilson/ Stuart Hawkshaw
29/03/2016	26	Primal cuts that comes into contact with floor cannot be used for OSI Food Solutions.	Darren James/Stuart Hawkshaw

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07/07/2016	27	PPE stored in changing rooms instead of sluice room	Julia Rodriguez
23/05/2017	28	Cardboard waste dolavs don't need to be covered with a liner	Julia Rodriguez
23/05/2017	28	MDB dolavs washed in production area	Julia Rodriguez
23/05/2017	28	Amendment to SSOP 4 and SSOP 6 regarding all knives sterilised on site	Julia Rodriguez
01/06/2017	29	SSOP 7 amended regarding inspection table C&D	Julia Rodriguez
31/08/2017	30	Review	Julia Rodriguez
20/09/2017	31	Review as requested by site OV's	Darren James

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Approved by	Technical Manager



Food Safety and Quality Management System Checksheet

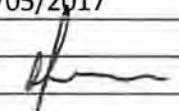
Date:
20/04/2015

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Title: HACCP Review

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Date:	05/07/2017	HACCP study being reviewed:	New by product process (bladders)
Attendees:	DJ, NM, AM, JR	Date of last HACCP review:	09/05/2017
Apologies:	MC, SH	Outstanding actions from last review:	0
Signed as verified by HACCP Team Leader:			

Question	Review	YES/NO	Comments
1	Have any complaints relating to food safety been received?	No	
2	Have any new raw materials been brought into the factory?	No	
3	Has there been any change to ingredient formulation?	No	
4	Has the production process or equipment changed?	Yes	New Teeuwissen business utilising bladders
5	Are cleaning instructions in place for new equipment?	Yes	
6	Are new items of equipment on the maintenance plan?	No	
7	Have any new packaging materials been brought into the factory?	No	
8	Have there been any changes to the storage or distribution conditions of the products?	No	
9	Have there been any changes in staff or management responsibilities?	No	
10	Has there been a change in consumer use of product?	No	
11	Have there been any changes in scientific information associated with ingredients, process or product?	No	

Number	Action Point	Who	Date	Completed
1	Review process flow	DJ	14/07/2017	14/07/2017
2	Review risk assessment	DJ	14/07/2017	14/07/2017

Issued By	Quality Systems Manager
Approved By	Technical Manager



Food Safety and Quality Management System Checksheet

Date:
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CCP's:

CCP 1 - Contamination with Digesta During Slaughter

CCP2 – Cooking

CCP3 – Cooling of cooked meats

All operatives responsible for monitoring the CCP's have a very good understanding of what is required. All CCP training (new and refresher) is being carried out as part of the transition to the new KARRO HACCP.

HACCP Review

Responsibility – No Change

Product description – No change

HACCP Team – No change

Scope – **Updated to now include the new process for Teeuwissen**

Hazard Overview(s) – No change

Terms of reference – No change

Pre-requisites – No change

The Karro HACCP study is in accordance with codex Alimentarius

Risk analysis – **Updated process flow and hazard analysis for by products**

Decision tree – No change

Validation – No change

Verification - still to be carried out by Internal audits as CCP audits... numbers 18, 33 & 1

Flow diagram – **By product process flow updated and to be signed off by team**

Summary from the HACCP Team

This HACCP review has shown the current HACCP is a good food safety system. The HACCP covers all aspects of the food production from raw materials coming on site to despatch. The HACCP is well supported with company pre-requisites and procedures which have been trained out to the relevant people.

NB No complaints relating to serious food safety issues have been received, and complaints are being trended monthly through customer KPI reports with no adverse trends.

Issued By

Quality Systems Manager

Approved By

Technical Manager



Food Safety and Quality Management System Checksheet

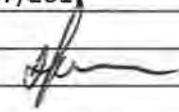
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Date:	25/08/2017	HACCP study being reviewed:	Request by Site OV's to review the process flows (Fresh Meat Areas).
Attendees:	DJ, NM, SH, LS, JR	Date of last HACCP review:	05/07/2017
Apologies:	MC, AM	Outstanding actions from last review:	0
Signed as verified by HACCP Team leader:			

Question	Review	YES/NO	Comments
1	Have any complaints relating to food safety been received?	No	
2	Have any new raw materials been brought into the factory?	Yes	New packaging materials (alternative supplier).
3	Has there been any change to ingredient formulation?	No	
4	Has the production process or equipment changed?	No	
5	Are cleaning instructions in place for new equipment?	N/A	
6	Are new items of equipment on the maintenance plan?	N/A	
7	Have any new packaging materials been brought into the factory?	Yes	Alternative supplier.
8	Have there been any changes to the storage or distribution conditions of the products?	No	
9	Have there been any changes in staff or management responsibilities?	No	
10	Has there been a change in consumer use of product?	No	
11	Have there been any changes in scientific information associated with ingredients, process or product?	No	

Number	Action Point	Who	Date	Completed
1	Review process flows – Fresh Meat	NM/JR	05/09/2017	05/09/2017
2	Review risk assessments (if process flows need changing)	DJ	12/09/2017	12/09/2017
3	Update process flows – Fresh Meat	DJ	20/09/2017	20/09/2017
4	Update risk assessments (if process flows need changing)	DJ	20/09/2017	20/09/2017

Issued By	Quality Systems Manager
Approved By	Technical Manager



Food Safety and Quality Management System Checksheet

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CCP's:

CCP 1 - Contamination with Digesta During Slaughter

CCP2 – Cooking

CCP3 – Cooling of cooked meats

All operatives responsible for monitoring the CCP's have a very good understanding of what is required. All CCP training (new and refresher) is being carried out as part of the transition to the new KARRO HACCP.

HACCP Review

Responsibility – No Change

Product description – No change

HACCP Team – No change

Scope – No change

Hazard Overview(s) – No change

Terms of reference – No change

Pre-requisites – No change

The Karro HACCP study is in accordance with codex Alimentarius

Risk analysis – **Review and update (fresh meat areas)**

Decision tree – No change

Validation – No change

Verification - to be carried out by Internal audits as CCP audits... numbers 18, 33 & 1 (up to date).

Flow diagram – **Review and update (fresh meat areas)**

Summary from the HACCP Team

This HACCP review has shown the current HACCP is a good food safety system. The HACCP covers all aspects of the food production from raw materials coming on site to despatch. The HACCP is well supported with company pre-requisites and procedures which have been trained out to the relevant people.

NB No complaints relating to serious food safety issues have been received, and complaints are being trended monthly through customer KPI reports with no adverse trends.

Issued By

Quality Systems Manager

Approved By

Technical Manager



**Food Safety and Quality Management System
Checksheet**

Date:
20/04/2015

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Issued By

Quality Systems Manager

Approved By

Technical Manager

CORRECTIVE AND PREVENTIVE ACTION PLAN

Name of Establishment: Dalehead Foods Ltd	Establishment Address: Fulney Lane, Spalding, PE12 6EP
Plant number :UK 5091	Audit date: 26 /09/2017
Date prepared (dd/mm/yyyy): 26/03/2018	
Prepared by: Ricky Chapman (Technical Manager) QC Supervisor / Production Supervisor / Production Manager (Name & Designation of establishment's authorized representative)	Approved by : Martin Luke (Site Director) Owner/Management Representative (Name & Designation of establishment's authorized representative)

Deficiency number (1)	Description of deficiency (Please affix picture if possible) (2)	Corrective Action and Preventive Actions (3)	Evidence of compliance (please take a picture/photo after the institution of Corrective Action) (4)	Completion or proposed completion date dd/mm/yyyy (5)	Person Responsible (6)	Verified by the on-site OV OV (7)
1	During pre-op sanitation verification at UK5091, inspection personnel observed multiple particles of fat or blood, from previous day's production on conveyor belts of cutting raw pork area. Also, two spots of chipping paint and one area of rust (approx. 60cm x 3cm) were observed on overhead structure. These deficiencies were corrected before the start of operation.	All cleaning instruction cards (CIC's) were reviewed and re-issued with focus on pictorial standards for compliance.	Example of cutting belt CIC and training records is attached.  Overhead area in cutting. (26/03/18)	CIC's were re-issued and re-trained by 31-01-2018. The overheads are now routinely monitored as part of pre-op checks. Photo of the current state (26/03/2018) is attached.	Ricky Chapman Konrad Pacholski	The reviewed CIC's were shown to OV during the Weekly Meeting (WC 05-02-18). CIC's were found to be improved, satisfactory; OV's routine pre-operational inspections of random conveyors belts in cutting areas from 25-01-18

CORRECTIVE AND PREVENTIVE ACTION PLAN

Deficiency number (1)	Description of deficiency (Please affix picture if possible) (2)	Corrective Action and Preventive Actions (3)	Evidence of compliance (please take a picture/photo after the institution of Corrective Action) (4)	Completion or proposed completion date dd/mm/yyyy (5)	Person Responsible (6)	Verified by the on-site OV OV (7)
						<p>to 28-03-18 have been varied and the cleaning standards fluctuating, with lapses in cleaning occurring on 26-02-18 and 28-03-18 (today), where appropriate corrective actions were taken by FBO prior operating and enforcement has been applied by OV (written advise) Overhead area in cutting is currently free of rust (28-03-18)</p>

CORRECTIVE AND PREVENTIVE ACTION PLAN

Deficiency number (1)	Description of deficiency (Please affix picture if possible) (2)	Corrective Action and Preventive Actions (3)	Evidence of compliance (please take a picture/photo after the institution of Corrective Action) (4)	Completion or proposed completion date dd/mm/yyyy (5)	Person Responsible (6)	Verified by the on-site OV (7)
2						
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HYGIENE CLEANING INSTRUCTION CARD



DALEHEAD FOODS - SPALDING		Ref No.	CAP 02
AREA	Cutting & Pace Lines		
ITEM	Leg Line Conveyor (L1)		
RESPONSIBILITY	Hygiene Operative	FREQUENCY	Daily
ENGINEERING ASSISTANCE REQUIRED YES/NO	No		

PRODUCTS	CONCENTRATION	TEMP.	COLOUR CODE/HAZARD
CHLORFOAM PLUS Signal Word - Danger	3-5%	Ambient 18-25°C	
ACTIVE Signal Word - Danger	1 - 2%	Ambient 18-25°C	
MAXIFOAM ACID Signal Word - Danger	3 - 5%	Ambient 18-25°C	

PERSONAL PROTECTIVE EQUIPMENT (PPE) Ensure full PPE is worn at all times

<input checked="" type="checkbox"/>									
EN166-3	EN345	EN166	EN14605	EN143	EN465/6	EN374	EN397		

EQUIPMENT REQUIRED



SPECIAL INSTRUCTIONS

Ensure that all signs are in place (caution wet & slippery floors) before you start your task

Do not use any chemicals or equipment you are not authorised or trained to use.

Never attempt any task you are unsure about/or not trained, always inform your Supervisor/Manager of any problems.

DO NOT CARRY OUT ACID CLEANING IF CHLORINATED PRODUCTS ARE BEING USED.



Cover any electrical points with plastic sheeting and isolate power supply



All areas covered with sheeting to be wiped pre- coverage using a anti microbial wipe then repeat this process when removing sheeting

Report any faulty equipment and Health & Safety issues to an Engineer /Engineering Supervisor immediately.

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HYGIENE CLEANING INSTRUCTION CARD



DALEHEAD FOODS - SPALDING

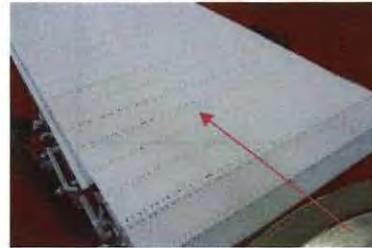
Ref No.

CAP 02

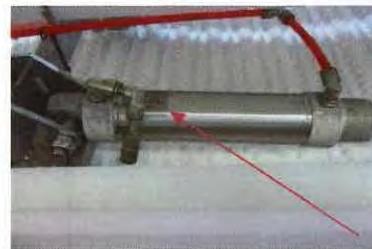
1. Isolate the power supply and cover with plastic sheeting to avoid any water ingress



2. Using fresh clean water to remove any gross debris, rinse over the main surface of the leg line conveyor



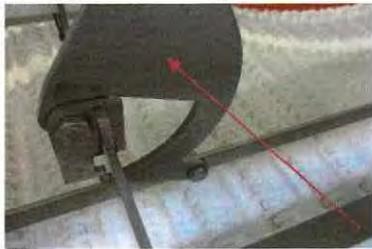
3. Using the handle on the side of the leg line conveyor, push upwards this will raise the belt to allow you internal access



4. Using fresh clean water to remove any gross debris, rinse over the lifting wheels



5. Using fresh clean water to remove any gross debris, rinse over the internal framework and guides



6. Using fresh clean water to remove any gross debris, rinse over the internal roller and cogs



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HYGIENE CLEANING INSTRUCTION CARD



DALEHEAD FOODS - SPALDING

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CAP 02

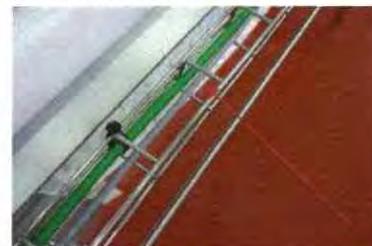
7. Using fresh clean water to remove any gross debris, rinse down the internal conveyor belt and the side guarding



8. Using fresh clean water to remove any gross debris, rinse down the draft shaft housing and under guides



9. Using fresh clean water to remove any gross debris, rinse over the supporting framework and conduit meshing



10. Apply foam to all surfaces using a solution of **Chlorfoam Plus** @ 3-5% ensuring an even coverage. following **DHSSOW 09 Chemical Application**

11. Allow at least 20 minutes contact time.

12. Remove any stubborn deposits with a green scouring pad paying particular attention to all internals ensure you are wearing **anti - cut gloves** when working on the internals

13. Rinse all surfaces thoroughly with clean water to remove all detergent residues.

14. Visually inspect all surfaces and if any debris persists, re-clean, then using **Chlorfoam Plus** @ 3-5% and a green scouring pad and allow a further 20 minutes contact time then rinse with fresh water.

15. Spray with a solution of **Active** @ 1% to disinfect all surfaces **DHSSOW 09 Chemical**

Application

16. If there is a production of organic material post hygiene, then ensure that you allow 15 minutes contact time of **Active** @ 1% then rinse all areas with fresh clean water

17. Ensure that you follow **HYG 09 Residual Chemical Removal Procedure**

18. Allow to air dry.

19. Using the lever, press downwards to close the access to the internals



For an Acid Clean

Follow the very same process as stages 1 -19 inclusive using **Maxifoam Acid** @ 3-5% with a contact time of 20 minutes

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HYGIENE CLEANING INSTRUCTION CARD



DALEHEAD FOODS - SPALDING

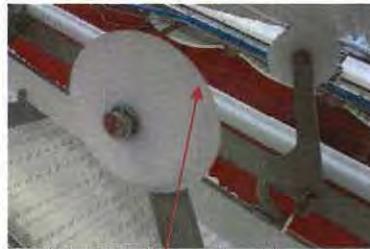
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CAP 02

KEY INSPECTION POINTS - TOTAL 8



Main Conveyor Surface



Wheels



Guides



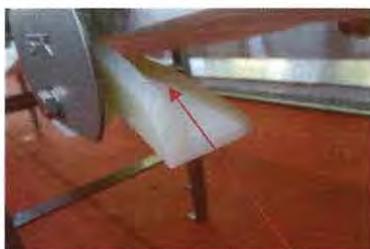
Rollers/Cogs



Internal Belt



Guide Break



Underside Support Bars



Drive Shaft

Key Inspection Points Detail:-

Main Conveyor Surface - Food Contact Point /Food harbourage points, possible entry for food debris

Guide Break - Food harbourage point as debris could fall through

Internal Surface of belt - Food harbourage point possible entry for food debris

Roller/Cogs - Food harbourage points, possible entry for food debris around surface edge of wheel housing

Drift Shaft - Outlet housing - possible food harbourage point

Wheels - Food harbourage points, possible entry for food debris around surface edge of wheel housing

Guides - Food Contact Point, Food Harbourage point where guide meets the conveyor belt - Attention to detail

Underside Support Bars - Food Contact Point / Food harbourage points possible entry for food debris

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CUTTING & PACE LINES - SPALDING

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