

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN221603 5306N-1	03/06/2014	03J02	Slaughter HACCP	O	<p>(B)(4) Monitoring Records- NY Wash, Pickers, IOBW: On February 27, 2014, the EIAO reviewed "Process Control Sheet" records from January 13, 2014 through February 13, 2014. The (B)(4) Evaluation Program states that supervision or maintenance will be informed if (B)(4) concentration is outside the target and range; and rechecks will be conducted if the (B)(4) concentration is outside the range. The range is (B)(4) ppm (B)(4) and the target is (B)(4) ppm (B)(4). The following dates had values outside of the range with no rechecks and no notification of supervision or maintenance: 2/13/14 in New York Wash; and 2/11/14 in New York Wash. The dates had (B)(4) values outside the target with no notification of supervision or maintenance: 1/14-15/14 in New York Wash and IOBW Reprocessing, 1/16-17/14 in New York Wash and IOBW; 1/18-19/14 in New York Wash, and IOBW Line 2; 1/19-20/14 in IOBW Reprocessing and IOBW 1 and 2 Line A and B; 2/4-5/14 in New York Wash and IOBW 1 and 2 Lines A and B; and 2/13/14 in New York Wash and IOBW 1 and 2 Lines A and B. The establishment failed to implement their (B)(4) Evaluation Program, which is used to support that "Pathogens (example Salmonella)" are not reasonably likely to occur in the Slaughter hazard analysis at the "NY Wash", "Inside Outside Bird Washer #1" and "Inside Outside Bird Washer #2" steps. This is a regulatory noncompliance under 9 CFR 417.5(a)(1) and Notice of Deferral Verification Plan point 7(a).</p>
5309	P6137A	NJN291603 2406N-1	03/06/2014	01C01	Operational SSOP Record Review	O	<p>Enterobacteriaceae: The establishment implemented the "Sanitary Operation Verification Program" to evaluate the effectiveness of operational sanitation practices by monitoring the log values of product contact surfaces with acceptable limits of < (B)(4) logs. The program indicates, (B)(4) . The EIAO reviewed "Sanitary Operation Verification Program" records from 1/15/14-2/15/14 and determined that on the date of 2/3/14, a food contact surface in Zone 14, Site 33, had a value of (B)(4) logs, however, no corrective actions and no re-sampling for 2 consecutive days were documented. This is a regulatory noncompliance under 9 CFR 416.14 and Notice of Deferral Verification Plan point 19.</p>

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5309	P6137A	NJN441403 4306N-1	03/06/2014	03C02	Raw Intact HACCP	O	<p>(B)(4) Parts SOP: The establishment's "Parts (B)(4) Monitoring SOP" indicates, "QC will evaluate concentration and dwell times at start of the process, hourly and/or at the end of the process. Results will be recorded on (B)(4)® Salvaged Parts Monitoring Log". However, on February 24, 2014 at approximately 1430, the EIAO observed a QC employee monitoring (B)(4) concentrations for Fillet dips. The EIAO reviewed the current (B)(4) monitoring record for the Fillet dip, which had initials and time documented for dwell time, however the value for dwell time was not documented. In discussion with the QC employee, she stated that the dwell time was monitored, however it was not documented. The establishment failed to implement their "Parts (B)(4) Monitoring SOP", which is used to support that "Pathogens (example Salmonella)" are not reasonably likely to occur in the Raw Not Ground hazard analyses at the "(B)(4) Dip" steps. This is a regulatory noncompliance under 9 CFR 417.5(a)(1) and Notice of Deferral Verification Plan point # 11. CCP 3B (B)(4)</p> <p>(B)(4): On February 25, 2014 during night shift, the EIAO observed the monitoring of CCP 3B, (B)(4). The critical limit for CCP 3B is (B)(4). The EIAO observed a QC employee monitor the concentration of (B)(4) using a test strip on a cone located on the cone line. The test strip indicated that the concentration was approximately (B)(4), however, this value was not documented and no corrective actions were taken for this deviation. The QC employee then monitored a conveyor belt on the cone line and documented this value in lieu of the previous value for the cone. The establishment failed to document the actual value and failed to take corrective actions in response to a deviation. This is a regulatory noncompliance under 9 CFR 417.5(a)(3) and Notice of Deferral Verification Plan point 10(b).</p>

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5310	M6137B	FFA2001031 606N-1	03/06/2014	01B02	Pre-Op SSOP Review and Observation	O	<p>On 3-5-2014, at approximately 1:45am during a Pre-Operational review and observation task I began my inspection in the time after the establishment's Quality Control personnel had finished with their inspection, I observed in the Raw side of production excess amounts of product left on numerous hanging racks(13) left from the day prior. U.S. Retain tag no.B38 937057 was applied to the racks affected. (B)(6) was notified immediately of the discrepancy and of the noncompliance. Establishment's SSOP's states in section 1; (B)(4)</p> <p>. This is a noncompliance with Regulatory Requirements of 9CFR 416.13(c) and 416.14. Corrective actions were implemented and the retain tag was removed at 2:30am. A similar noncompliance with the same root cause was observed on 2-26-14 and documented on Record No. FFA0600021027 N/1. To date Plant Management has not provided a written response to this NR. This linkage serves to demonstrate that the establishment's SSOP regulatory requirements are in need of revision to become effective. This document serves as written notification that failure to comply with regulatory requirements could result in additional regulatory or administrative actions as described in 9CFR Part 500.4.</p>
5568	M20923	XUM192203 4206N-1	03/06/2014	01D01	SPS Verification	C	<p>On 3/6/2014, at approximately 1955 hours, while performing a routine scheduled Sanitation Performance Standards (SPS) inspection task on the Cook Area Line #2 Oven Room, I observed the following noncompliance: standing water flooded along the southwest portion of the oven creating insanitary conditions, a noncompliance per 9 CFR 416.1, 416.(b)(2), and 416.(e)(3). The water fluid was coming from the belt wash area and some pipe connections to the belt wash. This type of condition is an ideal environment for the growth and spreading of Listeria Monocytogenes in a Post Lethality processing environment. I took regulatory control by rejecting the area with US Tag # 148126. I showed and informed Mr. (B)(6) of the forthcoming noncompliance. After corrective actions were performed by production and sanitary conditions were restored, I relinquished the US Tag at 2031 hours. The requirement(s) of Title 9 CFR 461.1, 416.2(b)(2), and 416.2(e)(3) were not met.</p>

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5568	M20923	XUM591403 3806N-1	03/06/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	<p>At approximately 1115 hours while performing HACCP task (the record review component of procedure for fully cooked-not shelf stable process), I observed the following noncompliance: While review the records in the QC office dated 3/3/14 CCP (B)(4) (CCP-2B), QC Verification Record review check made at 2035 QC auditor documented time, initial but the acc/unacc check was missing. Establishment HACCP Plan states- Record review indicates the specific verification check was made according to the HACCP plan and that the verification check was acceptable/ unacceptable. Records were reviewed on 3/4/14 by (B)(6). There was no corrective action documented for deficiency. Also reviewing the HACCP & General Temperature Monitoring Log dated 3/5/14 the records were reviewed by (B)(6) on 3/5/14 at 1746 with initial but the acc/unacc check was missing. I notified the (B)(6) about the non-compliance. This does not meet the requirement of 9 CFR 417.5(a)(3) which states: "The establishment shall maintain: Records documenting the monitoring of CCPs and their critical limits, including the recording of the actual times, temperature, or other quantifiable values, as prescribed in the establishment's HACCP plan; the calibration of process-monitoring instruments; corrective actions, including all actions taken in response to a deviation; verification procedure and results; product code(s), product name or identity. Each of these records shall include the date the record was made". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

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1325 7	P33900	NHH090003 4006N-1	03/06/2014	01C02	Operational SSOP Review and Observation	C	<p>On the night shift that began on 03/03/2014 at approximately 2138 I was in the Evisceration Room at Establishment 33900 P to perform a Zero tolerance procedure on Evisceration line #2. When I finished this procedure I started to another area of the plant. As I walked past the final rinse cabinet I observed water spraying from a nozzle on the inside of the cabinet. This spray was splashing on the carcass rail and turn wheels and then dripping onto the carcasses and shackles below. I had Inspector (B)(7)(C) stop the line immediately. Approximately 25 carcasses were affected. The (B)(6), had the carcasses reconditioned with (B)(4) water. I then had Inspector (B)(7)(C) re-start the line. The Preventive Measure given by Mr (B)(6) was that the water pressure in the cabinet was turned down and would be maintained at that pressure. Also, new plastic curtains would be installed on the outside of the cabinet to help keep the water inside the cabinet. Mr. (B)(6) was informed that a Noncompliance Record would be issued documenting the noncompliance. The requirements of Regulations 416.1 and 416.13(c) were not being met. The Establishments SSOP plan objective is, (B)(4)</p> <p>(B)(6)</p> <p>(B)(6) For an NR with the same deviation, refer to #NHH1704035104 N/ 1, dated 03/04/2014. The cited NR has not been answered at this time.</p>
5308	M6137	BXL0618034 805N-1	03/05/2014	01D01	SPS Verification	O	<p>At approximately 1404 hours While I was walking past the Sorting/Sizing belts in Plant #2 Packaging Rehang area I observed the following noncompliance. I observed heavy beaded condensation on the drip pan that is directly above the belt for Drop #4 and along the entire drip pan that runs along the back of the belts from Drop #1 through Drop #4. I immediately notified (B)(6) of the noncompliance. He immediately had the lines stopped and notified QC to put a hold on 2 tanks of product that were at the end of Drop #1 and Drop #4. (B)(6) then had a company employee wipe down the drip pans restoring sanitary conditions by approximately 1415 hours. My finding indicate a noncompliance with the regulatory regulations of regulations 9CFR416.1, 9CFR 416.2(d), 9CFR 416.4(b) and 9CFR 416.4(d).</p>

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5308	M6137	BXL1102035 005N-1	03/05/2014	04A06	Poultry Finished Product Standards	O	On 03/04/2014 at approximately 2336 hours while monitoring the Establishment's Reprocessing Procedures on Line ^(B) in Evisceration Area 1, I observed the following. After taking a random 10 bird sample I found 1 split tail bird with airsacculitis exudates remaining inside the cavity. I informed the leadperson and at approximately 2345 hours I took a 10 bird sample for the recheck. I found 1 bird with kidneys and 1 bird with airsacculitis exudates remaining inside the bird. I immediately took regulatory control action by stopping the line, and I informed ^{(B)(6)} of the noncompliance and showed him my findings. The line was started and all birds with split tails or missing tails were retained while corrective actions were implemented. Quality Control tagged the tank of retained birds pending rework of the product. At approximately 0001 hours I took a 10 bird sample for my recheck and passed, bringing the process back into control. At approximately 0049 hours, Quality Control performed a recheck on the retained tank of birds and passed, the birds were released back to production. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 381.76(b) and 9CFR 381.84.
1325 7	P33900	NHH460203 4805N-1	03/05/2014	06D02	Other Inspection Requirements	C	On the night of production that began on February 26, 2014 at approximately 2135 hours a presentation check was performed on line 2. When the no viscera portion of the presentation check was performed 16 carcasses with no viscera were observed over a 3 minute period at a line speed of ^{(B)(4)} carcasses per minute. Mr. ^{(B)(6)} , was notified and stated the plant had not performed no viscera checks at that point in the shift. When a second no viscera check was performed, 18 carcasses with no viscera were identified. Both checks resulted in error rates greater than the ^{(B)(4)} allowed at ^{(B)(4)} carcasses per minute for the ^{(B)(4)} evisceration system. The line speed was reduced by 10% to ^{(B)(4)} carcasses per minute and at that line speed 11 carcasses with no viscera were identified. This result was within the ^{(B)(4)} error rate allowed for the ^{(B)(4)} evisceration system. After the establishment had completed corrective actions, a missing viscera check was performed at 0520 hours. The number of missing viscera at line speeds of ^{(B)(4)} and ^{(B)(4)} carcasses per minute was 7 and 12, respectively. These values were within the allowed ^{(B)(4)} error rate.

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5568	M20923	XUM191203 3704N-1	03/04/2014	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 0715 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Cook side of the establishment: I found few small pieces of food particles on (B)(4) conveyor belt from the previous day of production. Upon continuing my inspection Line 2, I found whole piece of chicken wing stuck on (B)(4) exit belt from the last run date 2-28-14 Friday, because yesterday on 3-3-14 they run the meatballs on line 2. I took a regulatory control action and applied USDA retain/rejected tag# B24829892. I informed and showed to (B)(6) and (B)(6) of the non-compliance. The finding described in the non-compliance was on the food contact surface and very close to the food contact areas, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0750 hours. Plant SSOP Section1, page1, states: "(B)(4)". 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

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1325 7	P33900	NHH170403 5104N-1	03/04/2014	01C02	Operational SSOP Review and Observation	C	<p>On the night shift that began on 03/03/2014 at approximately 0338 I was in the Evisceration Room at Establishment 33900&nbsp;P to perform a Zero tolerance procedure on Evisceration line #2.&nbsp;As I started to collect the 10 carcasses needed to perform the procedure a carcass hit a water nozzle on the inside of the rinse cabinet.&nbsp;Water from this nozzle sprayed upward and outward, spraying the rail and the turn wheels on the shackle line.&nbsp;This water then fell onto the carcasses below.&nbsp;I had Inspector (B)(7)(C) stop the line immediately.&nbsp;&nbsp;Approximately 15 carcasses were affected, which the (B)(6) chose to condemn.&nbsp;&nbsp;I then had (B)(7)(C) re-start the line. &nbsp;The Preventive Measure given by Mr (B)(6) was that Maintenance personnel would tighten the nozzle to prevent it from spraying water outside the cabinet. &nbsp;Mr. (B)(6) was informed that a Noncompliance Record would be issued documenting the noncompliance. &nbsp;The requirements of Regulations 416.1 and 416.13(c) were not being met. &nbsp;The Establishments SSOP plan objective is, (B)(4)</p> <p>(B)(6)</p>
5112	M18909	JDD1810032 003N-1	03/03/2014	01C02	Operational SSOP Review and Observation	O	<p>In Evisceration this date 03/03/2014&nbsp;at 0210 H PST, I observed plant employee ready to place a reprocessed bird&nbsp;into a (Supposed To Be&nbsp;Clean Stainless Steel Vat), only the vat wasn't clean, it had a dime size piece of UFM, black in color,&nbsp;in it. This is a violation of the Establishment's written SSOP Program and the above 9 CFR's. Mr. (B)(6) and Ms (B)(6) were shown the noncompliance and were in concurrence with it.Ms. (B)(6) paperwork did not reflect this prior to my notification.</p>

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5308	M6137	BXL1808030 703N-1	03/03/2014	01B02	Pre-Op SSOP Review and Observation	O	<p>On 03/03/2014 at approximately 0006 hours while performing Pre-Operational Sanitation procedures on the Tub Wash Machine, I observed the following. There was a dried residue film around the bolts located on the metal sides where the tubs enter the machine, that came off easily when I scratched it with my fingernail. I also observed fat and meat particles approximately towards the middle section of the machine that were located close to the top inside of the machine that ran from one side to the other. I applied U.S. Rejected/U.S. Retained tag #B31406475 to the machine and I informed (B)(6) of the noncompliance and showed him my findings. At approximately 0156 hours while performing a recheck on the tub wash machine, I observed the following. There was still some dried residue film around the bolts, and inside the machine were several pieces of fat between the metal links of the belt that are on the edges of the white plastic that runs along the sides of the inside of the machine. I informed (B)(6) and showed him my findings. At approximately 0324 hours after the tub wash machine had been washed and sanitized restoring sanitary conditions, I removed my tag and released the machine. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.13(c), and 416.4(b).</p>
5308	M6137	BXL5204035 303N-1	03/03/2014	01B02	Pre-Op SSOP Review and Observation	O	<p>On 03/02/2014 at approximately 2129 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Plant 2, I observed the following. There is an exhaust fan directly over Scalding #3. There was a clear fluid dripping profusely from the opening directly into the scalding causing an insanitary condition. The fluid appeared to be rain water flowing from the roof. (B)(6) was shown the noncompliance. A mechanic was called and placed a sheet of plastic to direct the fluid away from the scalding. The affected section of the scalding is located adjacent to the access door to the Stunning Area. The scalding was emptied and recleaned restoring sanitary conditions by approximately 2230 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 13(c), and 9 CFR 416.14.</p>

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1325 7	P33900	NHH280302 0528N-1	02/28/2014	06D02	Other Inspection Requirements	C	<p>On the night of production that began on February 26, 2014 at approximately 2145 hours a presentation check was performed on line 2.&nbsp;When the no viscera portion of the presentation check was performed 16 carcasses with no viscera were observed over a 3 minute period at a line speed of (B)(4) carcasses per minute.&nbsp;Mr. (B)(6), was notified and stated the plant had not performed no viscera checks at that point in the shift.&nbsp;When a second no viscera check was performed, 16 carcasses with no viscera were identified.&nbsp;Both checks resulted in error rates greater than the (B)(4) allowed at (B)(4) carcasses per minute for the (B)(4) evisceration system.&nbsp;The line speed was reduced by 10% to (B)(4) carcasses per minute and at that line speed 11 carcasses with no viscera were identified.&nbsp;This result was within the (B)(4) error rate allowed for the (B)(4) evisceration system. A presentation heck was then performed on line 1 at 2220 hours.&nbsp;When the no viscera check was performed 27 carcasses with no viscera were observed over a 3 minute period at a line speed of (B)(4) carcasses per minute.&nbsp;Mr. (B)(6), was again notified and stated the plant had not performed no viscera checks at that point in the shift.&nbsp;A second no viscera check resulted in 24 carcasses no viscera.&nbsp;The line speed was reduced by 10% to (B)(4) carcasses per minute and at that line speed 11 carcasses with no viscera were identified.&nbsp;This result was within the (B)(4) error rate allowed for the (B)(4) evisceration system. The establishment was unable to correct the issue on either line before the end of the night's production; therefore, both lines were checked at the beginning of the shift on February 27, 2014.&nbsp;The no viscera check on line 2 at (B)(4) carcasses per minute resulted in 7 carcasses with no viscera.&nbsp;This value is within the allowed error rate of (B)(4) so the line speed was increased to (B)(4) carcasses per minute.&nbsp;Four carcasses with no viscera were obtained at this line speed.&nbsp;No viscera checks on line 1 resulted in 8 and 10 carcasses with no viscera at line speeds of (B)(4) and (B)(4) carcasses per minute, respectively.&nbsp;These results were within the (B)(4) error rate allowed for the (B)(4) evisceration system at the line speeds stated.The requirements of 9 CFR 381.76(a) and 381.76(b) were not met.</p>

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5112	M18909	JDD3622025 727N-1	02/27/2014	01D01	SPS Verification	C	On 02/27/2014 at approximately 1957 hours I observed the following noncompliance to 9 CFR 416.1, 9CFR 416.2(d) and 9 CFR 416.4(d) in the Weigh and Price Room. While doing my verification checks in the Weigh and Price room I observed water dripping from the ceiling next to refrigeration unit in the Weigh and Price Room onto a pallet of sealed cases of Turkey Breast Roast. I immediately took regulatory control action by applying U.S. Retain Tag # B43241090 to the pallet and informing (B)(6) of my observation and noncompliance. Mr. (B)(6) took immediate corrective action in my presence by removing the pallet from underneath the dripping water and informing maintenance. Mr. (B)(6) removed the cases of effected product and reworked the product inside. The dripping was on the outside of the sealed case's so no product was effected by the dripping. Regulatory control was relinquished at approximately 2020 hours after sanitary conditions were restored.
5308	M6137	BXL4707024 127N-1	02/27/2014	01B02	Pre-Op SSOP Review and Observation	O	On 02/27/2014 at approximately 0010 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Packaging, I observed the following. There were patches of semi-dried fat and tissue measuring to approximately 3/4" by 3" by 1/16" on the small cutting wheels on all three breast processors checked. The cutting wheels are used to make the final cut on the front halves before the breast halves and back bone are dropped onto the product belts. There were also two large pieces of tissue to approximately 3" between the chain and the upper nylon support bracket on processor #9. I contacted (B)(6) and showed him my findings. Breast processors 8-10 were recleaned and returned to service by approximately 0020 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) and 9 CFR 416.13(c).
5308	M6137	BXL5203024 027N-1	02/27/2014	01C02	Operational SSOP Review and Observation	O	On 02/26/2014 at approximately 2307 hours while monitoring Operational Sanitation in the Plant 2 Paw Room, I observed the following. Water was dripping from an air vent above the grey plastic bin that is used to collect the paws. A piece of plastic had been put up under the air vent and the water that was dripping from the air vent was collecting in the plastic and then dripping directly into the bin of paws that was approximately 3/4 full. I immediately tagged the bin of paws with U.S. Rejected/U.S. Retained tag #B31406626, and I informed (B)(6) of the noncompliance. The bin of paws were taken to the PC Plant where I removed the tag at approximately 2320 hours and the paws were condemned. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.13(c), 9CFR 416.2(b)(1), 9CFR 416.2(b)(2), 9CFR 416.4(a), and 9CFR 416.4(d).

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5310	M6137B	FFA0600021 027N-1	02/27/2014	01B02	Pre-Op SSOP Review and Observation	O	<p>On 2-26-14 at approximately 01:30 hrs while performing a preoperational inspection, after the establishment's Quality Control personnel finished with their inspection I observed the following deficiencies in the Raw side production area (Zone A); the rework table with product left from the day before on the side rims around the table and underneath, including the framework. Product was also found on the small blender's dumper/crossbar (product contact), and roller guides for raising and lowering dumper. Excessive product left on the lid of the large blender, hoses, and framework of the catwalks of this machine. These are in noncompliance to the Establishments SSOP's. Regulatory requirements of 9 CFR 416.13(2) and 416.14(2). As stated in your SSOP, section 1/Pre-operational Sanitation, (B)(4)</p> <p>(B)(4)</p> <p>ith (B)(6) accompanying me during my inspection, he was taking immediate corrective actions on all of these items mentioned and also notified of this N.R. This noncompliance serves as written notification that failure to comply with regulatory requirements listed could result in additional regulatory or administrative actions.</p>
1325 7	P33900	NHH040402 0727N-1	02/27/2014	04A06	Poultry Finished Product Standards	C	<p>On the night shift that began on 02/26/2014 at approximately 235 Hours, I was in the Evisceration room at Establishment 33900 P. I was in the area to give relief breaks to the line inspectors. At the reprocessing cut-up station I observed an employee pick up six carcasses that was marked with a long straight cut on the back of the carcass. This cut then had a small cut across the long cut close to the tail of the carcass. The plant employees had reprocessed these carcasses by removing part of the breast that had been mutilated by the picker fingers in the picking room of the establishment. This employee then took the carcasses to the Inflamatory Process area and put them into the (B)(4). The Establishment has a cut-up reprocessing procedure and an Inflamatory process procedure. Neither of these procedures were fully followed. Regulatory Control Action was taken by applying USDA Reject tag number B38075852 to the (B)(4). The requirements of Regulation 381.91(c)(2) were not being met.</p>

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1325 7	P33900	NHH550302 4527N-1	02/27/2014	01C02	Operational SSOP Review and Observation	C	<p>On the morning of February 26, 2014 at approximately 0540 hours while touring room 1 Further Processing the following noncompliance was observed.&nbsp; Approximately one-third tote of down-grade wings was observed under the catwalk for the breast processors.&nbsp; At the time, plant employees were standing on the catwalk and water was dripping from the catwalk into the tote contaminating the product.&nbsp; Mr. (B)(6) immediately removed the product and condemned it and sent the tote to be washed.&nbsp; To prevent recurrence, Mr. (B)(6) stated the responsible employee would be retrained.&nbsp; Mr.(B)(6) was informed the noncompliance would be documented on a noncompliance record.&nbsp; The establishment's SSOP plan states (B)(4)</p> <p>(B)(4) The requirements of 9 CFR 416.1 and 416.13(c) were not met.&nbsp; For a similar noncompliance refer to NR NHH0101014504N/1 dated January 4, 2014.&nbsp; The preventive measure for this noncompliance was (B)(4)</p> <p>(B)(4) These measures may have been implemented incorrectly or may have been ineffective at preventing recurrence.&nbsp;</p>
1326 1	M33901	HAY400202 1827N-1	02/27/2014	01D01	SPS Verification	C	<p>On the calendar date of February 27, 2014 at approximately 0042 hours while performing the Operational SSOP Review and Observation task, the following facility noncompliance was observed in the RTE Clean Room: Part 2 of the establishment's SSOP's under "Facilities" states that (B)(4)</p> <p>(B)(4).I, CS(B)(7)(C), observed multiple beads of condensation on the underside of the white pipe adjacent to the oven conveyor. Beaded condensation was also located on the underside of the stainless conduits above the oven conveyor.&nbsp;At the time of the findings, exposed grilled chicken breast were being processed and conveyed from the oven&nbsp;into the freezer.Please be advised that no product contamination was observed, as the condensation was non-dripping (B)(6)</p> <p>(B)(6), was shown the noncompliance and she confirmed the findings. Production was stopped and corrective actions were immediately initiated. Ms.(B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting.A similar noncompliance record was documented on February 26, 2014; please reference NR # HAY2413025426N-1. The establishment's response to NR # HAY2413025426N-1 is pending.</p>

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5112	M18909	JDD5606024 726N-1	02/26/2014	01802	Pre-Op SSOP Review and Observation	O	EVISCERATION: 1) UFM in the Gizzard Defatter, 2) UFM in I/O Wash Line Two, 3) Inedible Hooks with UFM on them and RED ID TAPE loose and insanitary condition, 4) UFM on Framework of the Quill Puller. Boning: 1) Multiple residues on the Tendon/Strap Puller, 2) Product Residue in Right Drive Cog on Overhead Belt feeding hanging, 3) Production residue on Wall/Ceiling left side of Contherms. 4) Sprinkler Shrouds are rust, loose paint ceiling by the MAIN BONING WASH STATIONS, 5) Product residue on Belts Feeding MDP and Drum machines, 6) Brown strips on bottom of Breast Sorter, one is badly stained and pieces have chipped out of it, the other has residue on it, RAW FAB: Discussed with Mr. (B)(6), the conditions of the CASING BOXES. This is violation of the above 9 CFR's and the Establishment's written SSOP Program. This is Linked to NR 020-2014, Dated 02-24-2014, JDD1608021224N/1 and its associated JDD number.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ4520025 726N-1	02/26/2014	03J04	Poultry Zero Tolerance Verification	O	<p>On February 26, 2014 at 1555 I, CS (B)(7)(C) observed visible fecal material on one bird at the chiller exit area while performing a Post chill FPS test. PHV (B)(7)(C) verified my finding. The fecal material was found on the partial tail and on the cut surface area of the pelvic bone next to the partial tail. The dark brown creamy fecal material with ureate covered half of the partial tail and the entire cut surface of pelvic area. A cloaca with intestine approximately 1 1/2" long was attached to the partial tail. All birds exiting the chill system were toted off and retained for rework. QC performed Postchill fecal checks resulting in no fecal found. Birds exiting the chill system were allowed to return to the normal process flow. A total of five totes were retained, reworked and reinspected by QC. Additional checks were performed in the Packaging Dept on all lines receiving product from the chiller. No fecal was found. I verbally notified (B)(6) and (B)(6) that a NR would be issued. The verbal response given was that the failure was due to employees failed to remove attached cloaca and intestine from the bird prior to entering the chiller. All Evisceration Department employees on duty at the time of the failure were counseled individually by the Evis Supervisor of the importance to remove all cloacae and intestines from the birds or hang them on the reprocess line for rework. The verbal preventative measure given was that all Inspector helpers will be retrained on the importance of removing the cloacae and intestines from the bird or remove the bird to the reprocess line. On December 26, 2013 NR # OIJ4509121326N (#86) was written for fecal found while performing a prechill Poultry Zero Tolerance Verification test. The cause was determined to be a malfunctioning spray nozzle in the New York bird wash. The written preventative measure given was that Maintenance will check the NY Wash at breaks and lunch. On December 4, 2013 NR # OIJ0908123505N (#84) was written for fecal found while performing a prechill Poultry Zero Tolerance Verification test. The cause was determined to be a malfunctioning spray nozzle in the New York bird wash. The written preventative measure given was that Production will check the water nozzles every half hour until 12/13/13. The preventative measures given have been ineffective in preventing further occurrence of visible fecal being found in the chiller system. The establishment Awareness meeting notes show the last time fecal noncompliances were discussed was on December 26, 2013. This NR is linked to NR # OIJ4509121326N (#86) and NR # OIJ0908123505N (#84) for the same root cause of not preventing visible fecal material from entering the chiller system.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY241302 5426N-1	02/26/2014	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of February 26, 2014 (Wednesday) at approximately 0720 hours, I received a visit from Dr. (B)(7)(C), Dr. (B)(7)(C) and Dr. (B)(7)(C) to conduct a tour through the establishment. This tour was conducted during scheduled operations although product was not being processed at the time. As we walked through the processing areas the following noncompliances were observed: (1) Raw processing side of lines #1 and #2, a white shovel that is used for edible product was hanging on the side of the large marinating tumbler for line #1 and was observed to have two tissue/fat particles on the inside surface. The particles had a brown color and ranged between 1/16" and 2/16" in size. U.S Rejected tag B38464356 was applied to the white shovel. Also observed was a long trail of a white product ingredient that had been spilled onto the floor where the ingredients are set up at the mixing tanks. The spilled ingredient covered an area approximately 6' long. (2) Raw processing side #3 and #4, three stacks of white barrels (four barrels in each stack) labeled for edible product were observed with the presence of fat particles on the outside and inside surfaces. The barrels were staged on a stainless steel table and were turned down on the table. The fat particles had a black color and ranged between 1/16" to 2/16" in size. Also observed on the white barrels were rough edges all around the top surfaces. U.S. Rejected tags B38464357, B38464358 and B38464359 were applied to white barrels. A stainless steel (B)(4) was observed to have the presence of fat particles/tissue on the inside surface. The particles/tissue ranged approximately 2/16" in size. U.S. Rejected B38464360 was applied to the (B)(4) Mr. (B)(6) was shown the conditions and informed that there were SSOP noncompliances. Mr. (B)(6) also informed Mr. (B)(6) of the SSOP noncompliances. (3) In the middle cooler, a drip pan underneath a cooling unit near the entrance to the MSC department had beaded condensation present. Beaded condensation was also present on the ceiling of the hallway near the MSC department. No product was on the production lines during this time. All insanitary equipment was immediately removed from the raw processing areas and taken to the equipment wash room. As, a preventative measure, the S3 Sanitation Cleaning assistant site manager, Mr. (B)(6), was informed of conditions and followed up on the cleaning of equipment. (No product was contaminated). The establishment's Standard Operating Procedures for Sanitation (Part 2; section 1 states: (B)(4)". Equipment was not maintained in a sanitary manner and ineffective SOP monitoring failed to prevent equipment contamination. The Regulatory requirements for 9CFR 416.13(c), 416.1 and 416.4(d) were not met.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN501802 1525N-1	02/25/2014	01D01	SPS Verification	O	<p>On February 25, 2014 while performing my schedule SPS Procedure in Raw Side and Cook Side Coolers I observed noncompliance with SPS regulatory requirement(s) 416.4(b)(1), 416.4(b), 416.2(b)(2). Raw Side Cooler Number Two: Inside Cooler #2, I observed a section of the floor that was damaged. Two tanks of product was stored on top of the damaged floor. Several loose large and small piece of the floor was scatter in different directions. U.S. Reject Tag NO. B38937062 was applied to this section of the cooler (product traffic area). Mr. (B)(6), was informed and showed the noncompliance. Raw Side Cooler Number One: Inside Cooler #1, I observed that behind the Ice Machine the ceiling has a couple of areas that has gaps and has black UFM along the gaps. I observed that the Product Thawing Area has several rusty beams and rails (product staging area). Mr. (B)(6), was informed and showed the noncompliance. Cook Side Cooler #2: I observed that the doorway as you enter into Cooler #2, has rust and chip paint also at the bottom of the doorway I observed a hole with broken pieces of concrete. I observed rust along the rail where the product is staged prior to entering Cooler #2. I observed rust on the small pole before enter the hallway. I observed prior to enter the handwash area for the slice pack department the overhead trim on the door is loose and hanging down exposing rust (product traffic areas). Mr. (B)(6) was informed and showed the noncompliance. This NR is linked to NR#LQN4218025504N/1 dated 2/4/14, for a similar noncompliance. This NR serves as written notification that failure to comply with regulatory requirement(s) may result in additional or administrative actions as described in 9 CFR 500.4.</p>
5308	M6137	BXL1813024 725N-1	02/25/2014	04C05	Poultry Good Commercial Practices	O	<p>At approximately 0845 hours while monitoring the Establishments' Good Commercial Practices procedures, I observed the following noncompliance. When I walked into the Line #2 Live Hang area I observed a grey barrel marked Inedible on a dolly that it is used to transport DOA's from the Live Hang area to the USDA Condemn tank that is now kept outside. When I looked inside the barrel it was approximately 3/4 full of DOA's and I observed one bird still breathing on the top layer of DOA's in the barrel. I turned on my flashlight to get a closer look at the bird and it lifted up it's head, was blinking it's eyes and was moving it's wings. I was concerned about additional DOA's being placed on top of the live bird, as the bird could suffocate. I immediately informed (B)(6) of the noncompliance. The Company elected to humanely euthanize the bird. The Establishments SSOP's state that grey barrels are used for Inedible product. My findings indicate a noncompliance with 9 CFR 381.65(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN510902 4625N-1	02/25/2014	04C05	Poultry Good Commercial Practices	O	<p>At approximately 0700 on February 25, 2014 during the night shift at Est. P 6137A, I observed the following non compliance: Two carcasses, which clearly showed signs of having died by means other than slaughter, were found by the line inspector and held for the veterinarian. The carcasses were congested on one side, and one showed an additional 3" line of hemorrhage of the keel. The viscera of both carcasses were congested and livers were friable. This indicates an incomplete bleed, most often caused by dead or dying birds being hung on the line. Mr. (B)(6) was informed and also inspected the carcasses. Carcasses were subsequently condemned, and I informed Mr. (B)(6) that an NR would be issued. Poultry must be slaughtered in accordance with good commercial practices in a manner that will result in thorough bleeding of the carcasses (9 CFR 381.65(b)) and birds plainly showing on ante mortem inspection any disease or condition... would cause condemnation of their carcasses on post mortem inspection, shall be condemned. Birds which on ante mortem inspection are condemned shall not be dressed, nor shall they be conveyed into any department of the official establishment where poultry products are prepared or held. Poultry which has been condemned on ante mortem inspection and has been killed or died otherwise shall under the supervision of an inspector of the Inspection Service, be disposed of as provided in § 381.95. (9 CFR 381.71(a)).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM251202 4025N-1	02/25/2014	01B02	Pre-Op SSOP Review and Observation	C	At approximately 620 hours, while performing a PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Raw side of the establishment: I found piece of chicken approximately 1 ½ inch long stuck in chicken Flatteners machine, from the previous day of production. Upon continuing my inspection: Line 2, I found food particles on one of the conveyor belt, also from the previous day of production. All finding described in the non-compliance were on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. I took a regulatory control action and applied USDA retain/rejected tag# B24829887. I informed (B)(6) and (B)(6) of the non-compliance. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0655 hours. Plant SSOP Section1, page1, states: (B)(4). 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
4630	M7322	AOA330502 0424N-1	02/24/2014	01B02	Pre-Op SSOP Review and Observation	O	At approximately 0415 hours while performing Pre-operational Sanitation Standard Operation Inspection in the establishment's Raw Processing Area Freezer there were "2 Season Ingredient Mixing Bins" stored with a plate of whitish cloudy looking ice (approximately 1 ½ inch thick and 2 ½ square feet wide) in the inside bottom area of the bins. The Season Ingredient Mixing Bins have been observed in use to contain the season ingredients that are use in the formulation of the edible frank product. The condition of the Season Ingredient Mixing Bins did not meet the minimum requirements of 9 CFR 416.13(c), 416.4(a), 416.2(d), and 416.1. USDA retain tag #B40007620 was applied. (B)(6) and (B)(6) was notified. The area was released at approximately 0426 hours when the corrective actions were verified by FSIS. -This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1608021 224N-1	02/24/2014	01802	Pre-Op SSOP Review and Observation	O	<p>In Evisceration I observed the following:1)The Gizzard Defatting Machine has another new crack in it one inch long in the back. This was shown to and concurred upon by Mr. (B)(6) and Mr. (B)(6) who sets the machine up, 2) I/O Wash Line Two, Red Rubber Hose fraying rubber off, Mr. (B)(6) notified of this issue, 3)Overhead screen in ceiling in the Picking Room has feathers in it, 4) Both Knife Sanitizers in the OSTEO ROOM were not cleaned, they are bolted down and can't be easily dumped for cleaning, 5)Nails in ceiling are rusting though the paint over, 6) Overhead Industrial Air Moving Unit is getting rusty, 7) Ammonia Lines feeding GIB Chiller are rusty. Ms. (B)(6) was advised of these issues and they were not reflected in her paperwork prior to my notification of the same Boning: 1)Overheads holding shackles at wing trim has UFM on it, 2) Belt for WishBone line is peeling it's surface and was removed from service. 3)End chute off Breast Trim Sorting Belt is cracked again, a one inch crack on the interior of both sides of the Chute. Mr. (B)(6) was shown the Issue as was Mr. (B)(6) 4) Four Stainless Steel Vats with Poultry residue in them. This is a violation of the above 9 CFR's and the Establishment's written program. This NR is Linked to the following NR 15-2014, Dated 02/18/2014, JDD3010025118N/1 and associated linkage.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN550102 0124N-1	02/24/2014	03J04	Poultry Zero Tolerance Verification	O	At 2334 hrs I performed a Poultry Fecal Zero Tolerance Verification Task at the FPS station, a point in the process after the last intervention before carcasses enter the chilling system. I noted the following non compliance: On slaughter line A, I randomly selected 10 carcasses for visual observation. I noted that the seventh of the ten carcasses exhibited a smear, approximately a 1/2 inch by one inch on the leaf fat inside the left side of the carcass that was yellow/brown in color, pasty in consistency. This material is consistent with the characteristics of fecal material. I stopped the line, informed and showed the finding to (B)(6) and (B)(6). I then released control of the line so the establishment could initiate their corrective actions, including a recheck and marking the chiller with a red netted carcass. Further corrective actions included increasing the chiller water by 1/4 gallon per bird. Three post chill checks performed ten minutes apart indicated that there were no further findings of fecal material. The red netted carcass exited the chiller at 0109 hrs. All corrective actions were documented by the establishment in accordance with the establishment's corrective action for a CCP 3B(B)(4)) failure indicating that the CCP was under control.The finding of fecal material on or in a carcass at this point of the production line constitutes a non compliance according to 9 CFR 381.65(e) which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank".
1325 7	P33900	NHH401602 3124N-1	02/24/2014	01D01	SPS Verification	C	At 1400 hours while touring the box storage area I also checked the outside premises just below the room. I observed that the inedible product dumpster near dock was over half filled with product that had not been denatured. After returning downstairs to determine why denaturant was not being applied and I was told that the denaturant dispensing equipment was inoperable. CFR 381.95 states that all condemned parts of carcasses, or other condemned poultry products, except those condemned for biological residues shall be disposed of by either of the approved method listed therein. Chemical denaturing in liberal amounts, as elected by the plant, was not being applied at all; therefore this requirement was not met.Management was notified and the dumping area was rejected until denaturant was applied.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH470002 3224N-1	02/24/2014	01C02	Operational SSOP Review and Observation	C	<p>On the night shift that began on 02/23/2014 at approximately 2140 I was in the Evisceration Room at Establishment 33900&nbsp;P to perform a finished product standards procedure on Evisceration line #2.&nbsp;As I walked away from the station on my way back to the USDA office, I saw a band from the inside of the inside/outside bird washer that had come loose from the bracket that holds it in place.&nbsp;A maintenance man was instructed to replace the band on the bracket and as he attempted to accomplish this, the sleeve of his shirt came in contact with the carcasses exiting the unit.&nbsp;&nbsp;Approximately 30 carcasses were affected.&nbsp;&nbsp;&nbsp;Regulatory Control Action was taken by stopping the line, removing the affected carcasses for reconditioning. &nbsp;I then released the line to production. &nbsp;The Preventive Measure given by Mr. (B)(6) was that the Maintenance personell involved would be retrained in sanitary operations during production. &nbsp;Mr.(B)(6) was informed that a Noncompliance Record would be issued documenting the noncompliance. &nbsp;The requirements of Regulations 416.1 and 416.13(c) were not being met. &nbsp;The Establishments SSOP plan objective is, '(B)(4)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA050902 2722N-1	02/22/2014	01D01	SPS Verification	O	<p>On Feb. 20 2014 while performing a Sanitation Standard Operation Procedure Inspection in the establishment cook processing areas, FSIS FLS/Dr.(B)(7)(C) and I observed the following deficiencies: 1. At approximately 1308 hours at the #1 retail batter tank area of the establishment's batter room, we observed a plastic bag that was partially taped to the ceiling panel. The bag contained approx. 6-8 ounces of clear liquid that appeared to be water. The bag was swiftly moving back and forth in response to the air from an air unit. We observed some clear liquid from the ceiling and from the swiftly moving plastic bag, dripping down (to numerous to count approx. 25-30 visible drops) on the cardboard spacer that were partially covering a pallet of approximately 9 bags of open dry batter product. Small portions of 3 bags of the open dry batter product were not covered by the cardboard spacer but close investigation reveal that there were no product contamination or adulteration. Official control action was taken. USDA reject tag #B40017692 was applied to the area and (B)(6), and (B)(6) was notified. The area was released at approx. 1328 hours when corrective measures were observed.&nbsp;- A similar noncompliance was observed on 12/06/13 and documented on NR#AOA3014121006N/1. The preventive measure (further planned action) provided by the establishment that states, "The maintenance department inspected the attic area over the fryer room.&nbsp;The attic area was found to have a water leak from the rain.&nbsp;A panel from the roof had separated at the seam, creating a gap for the rain to enter the attic area and leak through, to the production area.&nbsp;The panel in the roof was resealed and the water was removed from the attic area", appears to be ineffective in preventing this noncompliance. -This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s). -Continued failure to meet regulatory requirements can lead to enforcement actions described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA580902 3322N-1	02/22/2014	01C02	Operational SSOP Review and Observation	C	On Feb. 20 2014 while performing a Sanitation Standard Operation Procedure Inspection in the establishment cook processing areas, FSIS FLS/Dr.(B)(7)(C) and I observed the following noncompliance: 1. At approximately 1315 hours while observing the bulk line fryer areas we observed the frank wash sinks and noticed that the product contact surfaces of the frank wash sinks had a heavy build up of a white, dry, lumpy and crusty looking substance that appeared to be an accumulation of previously wet batter that had dried up. The fryer #2 frank wash sink did not have any written information to declare the intended use (e.g. Frank Wash, Hand Wash, Equipment Wash). The frank wash sinks are used to rewash edible frank product that could be place back into the ready to eat corndog production process. (B)(6) and (B)(6) were notified. No retain tag was applied because immediate corrective measure were taken by the establishment. -This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).
1326 1	M33901	HAY330202 0725N-1	02/22/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On the calendar date of February 22, 2014 at approximately 2257 hours while performing the Fully Cook -Not Shelf Stable HACCP task, the following noncompliance was observed: On, Thursday February 20, 2014 at approximately 0114 hours I, CSI (B)(7)(C), reviewed the CCP-4 (B)(4) for the date of February 19- February 20, 2014 while inside the RTE clean room. At the time, the log showed that the temperature of Orange Chicken was monitored at "9:15 pm" and that a direct observation of the monitoring was recorded at "9:16pm". "9:17pm" was the time recorded in the record review section of the record. On today's date, I reviewed the log along with the written corrective actions that were performed after a deviation from the critical limit occurred (please reference NR # HAY0118020620N/1) at CCP-4. The log now shows a line marked through the time of "9:16 pm" (initials included) in the direct observation section of the record and the time of "9:15 pm" recorded underneath the original time. No determination can be made as to when the entry of "9:15 pm" was recorded in the direct observation section of the record, as neither the date nor the time was recorded next to the entry. In addition, "acceptable" was recorded in the results column during the Records Review verification at 9:17 pm on 2/19/14 (B)(6), was shown the noncompliance and informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0813025 621N-1	02/21/2014	01C02	Operational SSOP Review and Observation	C	On 02/21/2014 at approximately 1012 hours while performing my inspection duties in the Tray Pack room I observed a stainless steel tank containing approximately 1694 lbs of Turkey Split Half Breast with Scap being brought in from cooler # 3 to be packaged, I observed numerous black flakes of UFM on the product. I immediately took regulatory control action by applying U.S. Retain tag # B43241093 to the tank of Split Breast and informing (B)(6) of my observation and the noncompliance. Upon further inspection in cooler # 3 at approximately 1018 hours, I observed a stainless steel tank containing approximately 1676 lbs of Turkey Necks also with black flakes of UFM on top of the ice covering the necks. Regulatory control action was also enforced on the tank of necks by applying U.S. Retain tag # B43241094 to the tank of necks. Mr. (B)(6) was also informed of the UFM on the tank of necks. Mr. (B)(6) took immediate corrective action in my presence by having the top layers of the product in both tanks reconditioned and washed with (B)(4) ppm (B)(4) water. Regulatory control was relinquished and product released at approximately 1130 hours after the completion of all corrective actions. This is a noncompliance of 9 CFR 416.1 and 9 cfr 416.4(d).
5112	M18909	JDD1307021 721N-1	02/21/2014	01D03	Poultry Sanitary Dressing	O	In last Exit meeting dated 02/14/2014, it was brought to the attention of all parties in the meeting that the Establishment is not taking the rusty conditions in the Rosier Area seriously and no corrective action has taken place to prevent rust from getting in or on the unit. And on this date 02/14/2014, Mr. (B)(6) requested to Mr. (B)(6) follow up and take care of temporary fixes. Today 02/21/2014 at 0915 H PST I went to check if any temporary fixes had been instituted on rusty conditions. There was interventions to be observed and rust observed on the the unit. Mr. (B)(6) and Ms. (B)(6) shown the issues. Mr. (B)(6) and Mr. (B)(6) were verbally on the phone. This is a violation of the above 9 CFR's and is LINKED to NR 014/2014, Dated 02/14/2014, JDD2017023014N/1 and JDD1613020406N/1 dated 02/06/2014.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0719020 921N-1	02/21/2014	03J02	Slaughter HACCP	O	<p>While performing Pre-Chill Finished Product Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 1245 hours, I randomly removed a 10 bird sample from Line 1 in Evisceration Area #1. I found one out of the birds with visible fecal contamination inside the bird at the right side under the leaf fat area. The fecal material was dark green in color, pasty in texture and measured approximately 1/4" diameter in size. This exceeded the limit of Zero Tolerance for the process to be in control. I informed (B)(6), (B)(6) and (B)(6) of the noncompliance. Dr. (B)(7)(C) verified the fecal finding. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1315 hours and it passed. This is a violation of the critical limits of CCP-2B Zero Contamination of the Plant's HACCP Plan for Slaughter.</p>
5308	M6137	BXL4409024 620N-1	02/20/2014	01C02	Operational SSOP Review and Observation	C	<p>On 02/18/2014 at approximately 1328 hours, while performing direct observation of the Second Processing Rinse at lunch break at the Rehang 2 Area, I observed the following. The kick outs and sorting belts had been rinsed and an employee had started applying sanitizer (Quat) to that area. I observed Quality Control check the (B)(4) concentration at approximately 1332 hours. The SSOP Plan states in part under procedure, that (B)(4). The employee that was applying the (B)(4) sanitizer had already begun sanitizing the area when Quality Control measured the concentration of the (B)(4). I informed (B)(6) of the noncompliance. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.13(b) and 9CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5519022 020N-1	02/20/2014	01C02	Operational SSOP Review and Observation	O	<p>At approximately 1315 hours, while monitoring the mid-shift rinse procedure at the (B)(4) Room, I observed production employees were rinsing the area with potable water. At approximately 1350 hours while they were rinsing the floor they over sprayed two stacks of clean product brown tubs, the brown tubs were located next to the sink on the back of the cone lines. I immediately tag the tubs with U.S. Retained/Rejected Tag # B31 406455 and B31 406436 and informed (B)(6) and (B)(6) of the noncompliance.</p> <p>(B)(6) sent the tubs to the tub wash room, I then removed my tags. At approximately 1405 hours, I observed when Quality Control finished her checks in the (B)(4) Room and sanitation personnel were also finished with the rinsed and the application of the sanitizer (B)(4). The belt that it is over the chute by the Cone Line (B)(4) was not rinsed and sanitized with (B)(4)). The belt that transfers the halves to the cones (line 1 to line (B)(4)) was not rinsed and sanitized with (B)(4) either. I informed (B)(6) of the noncompliance. The SSOP Plan states in part under procedure (B)(4)</p> <p>(B)(4)</p> <p>. At approximately 1420 hours the belts were rinsed and sanitized, then the Area was released. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.13 (b) and 9CFR 416.13 (c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM561202 5220N-1	02/20/2014	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 0650 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Cook side of the establishment: I found piece of chicken stuck on blue incline belt from the previous day of production. Upon continuing my inspection Line 1, I observed lots of bulid up underneath frame and the pipes around the C-49 blue conveyor belt also from previous day of production. I took a regulatory control action and applied USDA retain/rejected tag# B24829882. I informed sanitation (B)(6) and (B)(6) and (B)(6) of the non-compliance. The finding described in the non-compliance was on the food contact surface and very close to the food contact areas, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0730 hours. Plant SSOP Section1, page1, states: (B)(4)</p> <p>. 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". 9CFR 416.4 (b) states: "Non food-contact surfaces of facilities, equipment, and utensils used in the operation of establishment must be cleaned and sanitized as frequently as necessary to prevent the creation and the adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH390002 0720N-1	02/20/2014	01802	Pre-Op SSOP Review and Observation	C	On the production shift that began on 02/19/2014, I performed pre-operational sanitation review and observation at Est. 33900 P. This Pre-Op was performed in the further processing department of the Establishment, in room #2(on schematics for pre-op inspection). This was after sanitation had completed cleaning the equipment and the establishment had completed pre-operational sanitation inspection of the equipment and released the area for USDA inspection. There are no additional sanitation or inspection steps prior to the start of production. This procedure was completed before product reached the areas inspected. The following non-compliance was observed on the line 1 marination injector. Fat and a brown protein residue was on the under side of the unit and on product contact portions of the stainless steel plate that houses the injector needles. This residue ranged in size from 1/8 inch to 1/2 inch in size and numbered fourteen pieces on the under side of the plate. A greasy yellow to brown residue was on the top of the UHMW and the bottom side of the stainless steel plate that holds the needles in place. The line #2 injector was then broken down and the same conditions were observed in the same places of this injector. The units were re-cleaned by Sanitation and re-sanitized. I then re-inspected and released the units to Production. The requirements of Regulations 416.4(a) and 416.13(c) were not being met.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY011802 0620N-1	02/20/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	<p>On the calendar date of February 20, 2014 at approximately 0114 hours while performing the review and observation component of the Fully Cooked -Not Shelf Stable HACCP task, the following noncompliance was observed: Cooling finished product to <31.3F is the critical limit prescribed at CCP 4 -after the freezer & metal detector step- in the establishment's HACCP plan. I, CSI (B)(7)(C), measured the temperature of Orange Chicken at CCP 4 by inserting the probe of the thermometer (calibrated and provided by the establishment) inside 2 pieces of product. After equilibrating, the thermometer read: 34.4F. I proceeded to take additional temperatures from different pieces of product from the bag and obtained temperatures of 33.8F, and 34.7F, respectively. At this time, I notified Lernetha (B)(6), QA Technician, of my results and requested that she also monitor the temperature of the product from a different bag. Ms. (B)(6) monitored the temperature of the product at CCP 4 (from a different bag) in my presence, and once the thermometer equilibrated, the results read 33.9F. I reviewed the CCP 4 HACCP Record and noted that the last acceptable temperature was recorded at 1212 hours. Production was stopped, and all product since the last acceptable check (8 combos and 4 pallets of packaged and labeled product) were retained with U.S. RETAINED tag # B40172385. (B)(6), was notified of the noncompliance and informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2505024 119N-1	02/19/2014	01C02	Operational SSOP Review and Observation	O	On 02/19/2014 at approximately 0100 hours while monitoring Post-Chill Finished Product Standards from product exiting Chiller #3, I observed the following. After taking a standard 10 bird random sample, I observed two birds with medium gray flakes of UFM(Unidentified Foreign Material) that appeared to be paint. I contacted (B)(6). The birds were already being hung going to the Weight/Check line. One of the first birds dropped at the first collection tank on the Weight/Check line had a similar gray flake measuring approximately 1/8" by 1/8"on the left side exterior of the carcass near the abdominal opening. A partial tank of the birds collecting at the Check/Weight location was retained under QC hold for reinspection. I contacted (B)(6), showed him the flakes and informed him of the noncompliance. The flakes on the carcasses measured approximately 1/8"by 1/8" located on the outside of the carcass on the left side near the abdominal opening, approximately 1/8" by 1/8" located on the inside on the left leaf fat, and approximately 1/4" by 3/8" on the exterior of the carcass in the depression left by the oil gland removal. The UFM crumbled easily upon contact. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).
5308	M6137	BXL4117022 719N-1	02/19/2014	03J02	Slaughter HACCP	O	While performing Pre-Chill Finished Product Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4).At approximately 1053 hours, I randomly removed a 10 bird sample from Line 1 in Evisceration Area #1, I found one out of the ten birds with visible fecal contamination inside the bird at the right side under the leaf fat area. The fecal material was dark green in color and pasty in texture, measured approximately 3/16" diameter in size. This exceed the limit of Zero Tolerance for the process to be in control. I informed (B)(6), (B)(6) and (B)(6) of the noncompliance. Dr. Reza Hejazi verified the fecal finding. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1116 hours and it passed.This is a violation of the critical limits of CCP-2 (B)(4) the Plant's HACCP Plan for Slaughter.
5112	M18909	JDD0610021 318N-1	02/18/2014	01D01	SPS Verification	C	At 0125 H PST 02/18/2014 I observed a Female Employee unroll a Tank Liner (USED FOR PRODUCT SURFACES) from the Master Roll, and contaminate it upon the Evisceration Floor. She was not aware that her action contaminated the Liner. Mr. (B)(6) and (B)(6) was notified of the Situation and of the intent of documentation. This a violation of the above 9 CFR's. This is linked to NR 010-2014, Dated 01/24/2014, JDD2010010724N/1 and JDD1208013317N/1

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3010025 118N-1	02/18/2014	01802	Pre-Op SSOP Review and Observation	O	<p>At 2245 H PST, 02/17/2013 while performing PRE-OP on CHILLERS A&B the following was noted: 1) Ceiling has numerous nails in it that were painted over, nails rusted flaked off paint and now the rusty nails readily show up, also some rusty electrical conduit was observed. In Evisceration in general was observed Electrical Boxes that are extremely rusty. These issues showed to and or discussed with Mr. (B)(6) and Ms. (B)(6) was advised and her paperwork updated with my information. This also violates 9 CFR: This is also a violation of this CFR: 9 CFR: 416.4 Sanitary Operations. (a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. The following noted as follows BONING ROOM:: 1) Over head rails for Carcass' by the Ice/Carcass Separator has black UFM on it; 2) On the back side of the Contherms, the lift controls are extremely rusty; 3) The chute at the end of the Breast Sorter Belt has a 3 inch crack on the product side of the chute; 4) Black UFM on long belt feeding MDP; 5) Seven Stainless Steel vats observed with poultry residue in them; 6) Off conditioned wings in Cooler 5, had (B)(6) to tag the product; 7) Lines 1 & 2 Tray Pack shrink tunnels had UFM; Tape used to hold cutting board material Line One; Cooler Ten had blue tub with UFM in it and white tub setting upon a box and a lable stuck in the interior of this edible use container; 8) On Saddle Machine 2 on hose observed with UFM on it; 9) Fiberglass repairs on wall by SHOVEL HANGERS is broke and peeling paint. This all showed to and concurred upon by Mr. (B)(6) and Mr. (B)(6) no of these items were in his paperwork prior to my notification of the same. This is a violation of the above 9CFR's and the Establishments written SSOP program. This is Linked to the following NR 017-2014, Dated 02/10/2014, JDD5623023310N/1 and associated numbers JDD1405025803N/1+5</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0218022 118N-1	02/18/2014	03J02	Slaughter HACCP	O	<p>The establishment's Inside Outside Bird Wash program states, "(B)(4)"</p> <p>" However, on multiple occasions the establishment did not document some of the parameters. For example, on December 30, 2013 at 1259 hours, and December 26, 2013 at 1539 hours, the Timing, Alignment, and One-Leggers checks were not documented. On December 12, 2013 at 1455 hours, and December 26, 2013 at 0835 hours, the sprayer, shower heads and pumps operating check was not documented. On December 24, 2013, at 0430 hours, and December 29, 2013, at 2339 hours, no pressure was documented.&nbsp; On December 13, 2013, at 0629 hours, the records show that for the PSI "Error – wrong entry" was documented, but no other entry was made with the correct PSI. The establishment is not implementing CP 4 – Inside Outside Bird Wash Monitoring program as written. This is a regulatory noncompliance under Title 9 CFR 417.5(a)(1).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							being implemented as written. This is a regulatory noncompliance under 9 CFR 417.5(a)(1).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1214023 318N-1	02/18/2014	04A06	Poultry Finished Product Standards	C	On 02/18/2014 at approximately 1046 hours while performing a Pre-Chill Finished Product Standards Task in the Evisceration Area on Line (B)(4), I observed the following. After taking a standard random 10 bird sample, I accumulated 35 nonconformance points. I informed (B)(6) and Quality Control performed a recheck. At approximately 1051 hours, the recheck failed with 36 nonconformance points. At this point the process is judged to be out of control. I informed (B)(6) of the noncompliance. Quality Control performed a Post-Chill check at approximately 1102 and passed. At approximately 1108 hours, Quality Control performed a Pre-Chill check and passed, bringing the process back in control. Quality Control performed Post-Chill checks approximately every 30 minutes until the product under process control arrived. My findings indicate a noncompliance with 9CFR 381.76(b).
5308	M6137	BXL1518024 718N-1	02/18/2014	03C02	Raw Intact HACCP	O	The establishment's records indicate that on multiple occasions the establishment is not collecting samples as indicated in the program. For example on December 6, 2013, December 18, 2013, no breast samples were collected during the AM shift. On December 23 and 27, 2013, and January 6 and 25, 2013, no breast samples were collected during the PM shift. In addition, on December 4, 2013, and January 4, 2014, the establishment collected two breast samples instead of an extra leg sample as indicated in the program. The establishment is not implementing their program as written. These are regulatory noncompliances under Title 9 CFR 417.4(a)(1) and 417.5(a)(2).
5308	M6137	BXL2707023 118N-1	02/18/2014	01C02	Operational SSOP Review and Observation	O	On 02/18/2014 at approximately 0315 hours while monitoring Operational Sanitation in Plant 2, I observed the following. ABF (Anti-Biotic Free) birds were entering Chiller #4 after being treated with Cetylpyridinium Chloride, (B)(4)' antimicrobial. The antimicrobial treatment is rinsed off in the chiller adding an unknown amount of (B)(4) to the chiller water. Packaging was still packing 'Organics' from before lunch and birds were still exiting Chiller 4. 'Organics were being exposed to the Cetylpyridinium Chloride which is not an authorized antimicrobial for product labeled 'Organic'. I contacted (B)(6) and stated that 'Organics' were still being processed. I informed him of the (B)(4) treated birds entering Chiller #4. The birds on the rehang belt and birds exiting chiller #4 until approximately 0326 hours were downgraded from 'Organics' to ABF by production. I informed (B)(6) of the noncompliance. My findings indicated a noncompliance with 9 CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3908025 618N-1	02/18/2014	01C02	Operational SSOP Review and Observation	O	At approximately 0040 hours while monitoring Pre-Chill Finished Products Standards in Plant #1 on Line #1, I observed the following noncompliance. After taking a random 10 bird sample, when I opened up the neck area to inspect it I observed a shiny piece of metal approximately 5mm x 1mm on the fat on the left side of the neck area under the skin. I informed (B)(6) of the noncompliance. According to PDD, FSIS considers metal of any size on a carcass to be an unacceptable contaminant that should be addressed by the Establishments' Hazard Analysis. The issue of metal contamination has been discussed at previous weekly meetings with the Establishment. My findings indicate a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).
1325 7	P33900	NHH350202 1018N-1	02/18/2014	01D01	SPS Verification	C	On the night of production which began on 02/17/2014 in est. 33900 P, Inspection found the Main Hallway between the QA/HACCP Office and the Drydock in an unsanitary condition. A dried patch of dirty water at least 6 feet in length and 1 foot in width was present and Power Jacks which are used in the Further Processing Department to move Raw Edible Product were being driven through it and into the Further Processing Area where Floor Salvage is conducted. Inspection took Regulatory Control Action by taping off the Area and placing Us Reject Tags #B38075672 at 0039 Hours and #B38075667 at 0041 respectively. Sanitary conditions were restored to the Hallway at 0122 Hours at which the two tags were removed. The requirements of 9CFR 416.1, 416.2(b)(1) and 416.2(b)(2) were not being met and Night-shift Plant Superintendant Mr. (B)(6) was advised that a Non-compliance record would be generated. Refer to NR #NHH0503105231N/1 dated 10/30/2013 for a similar noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY040802 3718N-1	02/18/2014	01B02	Pre-Op SSOP Review and Observation	C	<p>On calendar date February 18, 2014 (Tuesday) at approximately 0655 hours while performing Pre-Op SSOP Review and Observation task in the IF Department (zone 10), the following noncompliance was observed: I, (B)(6), observed a brown, dusty residue all along the top surface of 2 two overhead Verifeeder pipes. These pipes are insulated with a white covering and are used to pump cold water to the (B)(4) Tanks on Line (B). These pipes are approximately 35' in length. I also observed that the overhead ammonia pipes had a similar brown, dusty residue present on the top surfaces. I showed Mr. (B)(6) (B)(6) and Ms. (B)(6) of the conditions and informed them that there was Sanitation Performance Standards noncompliance. The establishment's SSOP, states that (B)(4)</p> <p>(B)(4)</p> <p>" According to the S3 Sanitation Cleaning company schedule, the overhead equipment will be cleaned on a weekly basis. The establishment failed to meet the requirements for 9CFR 416.4(b) and 416.1.</p>
5308	M6137	BXL1116023 715N-1	02/15/2014	04A06	Poultry Finished Product Standards	O	<p>At approximately 1301 hours, I randomly removed a 10 bird sample from Line (B) A in Evisceration Area #2 for Pre-Chill Finished Product Standard Check, I documented 39 points in the Processing Nonconformances from the 10 bird sample. This exceed the subgroup absolute limit of (B)(6) points for the Processing Nonconformances to be in control. I informed Quality Control of the failure and at approximately 1310 hours she performed a recheck. Quality Control documented 27 points on the Processing Nonconformances, this exceed the limit of the (B)(6) points allowed for the recheck, at this point the process is considered out of control. I informed (B)(6) (B)(6) of the noncompliance. Corrective actions were implemented. Quality Control performed rechecks at Pre-Chill and Post-Chill. At approximately 1505 hours the process was back in control. This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2017023 014N-1	02/14/2014	01D03	Poultry Sanitary Dressing	C	<p>On 02/14/2014 I observed the following non-compliance's to 9 CFR 416.1, 9CFR 416.2(b)(2) and 9CFR 416.2(d). At approximately 0950 hours while passing through the hallway between the old Loading dock and Bagging Area I observed heavy beaded condensation on the drip pan above hallway in the Rosier Room. I immediately informed (B)(6) of my observation and non-compliance. Ms (B)(6) took immediate corrective action by having the condensation wiped off to restore sanitary conditions. No product was involved. At approximately 1312 hours while performing my inspection duties in the Boning Room I observed condensation dripping from between the ceiling panels next to the exhaust vent, I immediately took regulatory control action by applying U.S. Reject tag # B39554636 to the area underneath the drip and informing (B)(6) of the drip and non-compliance and that the area underneath had been tagged and rejected. Regulatory control was relinquished at approximately 1410 hours after sanitary conditions were restored. No product was involved. This NR is being linked to NR # JDD1613020406N dated 02/06/2014</p>
5308	M6137	BXL0504024 715N-1	02/14/2014	01C02	Operational SSOP Review and Observation	O	<p>At approximately 1737 to 1855 hours on February 14, 2014, while monitoring the establishment's Operational sanitation Standards in the Packaging, (B)(4) Room, and Rehang areas, I observed the following deficiencies:</p> <p>a) Plant 1 Rehang Conveyor Areas: Personnel still hanging product coming directly out of Chiller # 1 & 2 at 1735 hours. I observed Sanitation Personnel spraying down the Chillers while product was still in the chilling processing mode and be directly dumped onto the Rehang Conveyors to be sorted and re-hung for the further processing and packaging process. Retain Tag # B 31407539 issued to affected one bin of product. All above discrepancies were creating a food safety noncompliance. I informed (B)(6), (B)(6) of the noncompliance. Corrective actions were implemented immediately. Sanitation personnel was stopped from further cross contaminating remaining product and from raising temperature levels of the water that is chilling the product in Chiller # 1. Rehang Conveyors and Rehang Production was ceased for the day and product was condemned by 1811 hours per (B)(6). My findings indicate a non compliance with the regulatory regulations CFR 416.1 and 416.4(d).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ3517025 714N-1	02/14/2014	04A06	Poultry Finished Product Standards	O	On February 14, 2014 I, CSI (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for trim nonconformances is 10 points. My test at 1444 resulted in 27 points. At approximately 1504 a retest was performed by (B)(6) using a tighten criteria of 12 points which failed with 17 points. I verbally notified (B)(6) of the noncompliance and that I would be issuing a NR. The plant implemented the required procedures for FPS failure. Two passing Prechill tests were achieved at 1531. No failing tests at Postchill are documented. The Prechill nonconformances I observed at 1444 were: 3 bruises > 1" (6 pts), 8 scabs/IP < 1/2" (16 pts), and 1 IP > 1/2" (5 pts). On January 17, 2014, NR # OIJ4601011718N (#2) was issued for processing noncompliance which is the second part of FPS Prechill requirements. The written response given that Maintenance made adjustments to bring the process under control was not effective to prevent recurrence of Prechill FPS noncompliance. This noncompliance is linked to NR # OIJ4601011718N (#2) for the same root cause of Prechill FPS noncompliance. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the January 23, 2014 meeting.
5308	M6137	BXL0816025 913N-1	02/13/2014	01C02	Operational SSOP Review and Observation	O	On February 6th
5308	M6137	BXL3222022 413N-1	02/13/2014	01B02	Pre-Op SSOP Review and Observation	C	On 02/12/2014 at approximately 2200 hours while monitoring the establishments' Pre-Operational Sanitation procedures in Plant #2, I observed the following. There was heavy beaded condensation above Chiller #3 middle section near the giblet chillers. The condensation was on the PVC, metal and vinyl covered pipes, and concrete ceiling surfaces directly above the chiller. The ceiling and piping are treated as non-product contact surfaces. I informed (B)(6) of the noncompliance. I moved to the center walkway between the chillers to monitor the drying of the affected surfaces and observed the same beaded condensation condition on the pipes and ceiling surfaces over large areas above both Chillers 3 & 4. The condensation was removed restoring sanitary conditions by approximately 2210 hours. My findings indicated a noncompliance with 9 CFR 416.1, 416.2(d), 9 CFR 416.4(d), 9 CFR 416.13(c) and 9 CFR 416.14.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM412202 4713N-1	02/13/2014	01D01	SPS Verification	C	On 02/13/2014, at approximately 2000 hours, while performing a directed Sanitation Performance Standards (SPS) inspection task in response to a deficiency on the Cook Area Line (B)(4) Oven Room, I observed the following noncompliance: beaded and dripping condensation coming from a hanging gray electrical wire and electrical box to a panel cover sensor above the belt wash to the oven creating insanitary conditions, a noncompliance per 9 CFR 416.1 and 416.2(d). The condensation was dripping in close proximity to the oven belt. Also, the screw brackets to the electrical box were pitted and worn. I took regulatory control by rejecting the area with US Tag # 24829911. I showed and informed Mr. (B)(6) (B)(4) of the forthcoming noncompliance. Corrective actions were immediate performed by production restoring sanitary conditions, I relinquished the US Tag at 2010 hours. The requirements of Title 9 CFR 416.1 and 416.2(d) were not met.
5308	M6137	BXL2814025 712N-1	02/12/2014	03J02	Slaughter HACCP	O	On 02/12/2013, at approximately 0840 hours, I observed how the Establishment's employee performed the Salvage Parts Treatment Procedure on the evisceration parts in Plant #2. The procedure was acceptable. At approximately 0844 hours, I observed Quality Control performed CCP-1B (b) (4) (B)(4). At approximately 0930 hours, I went to and reviewed the records for (B)(4) Monitoring Log Plant #2" for Evis Parts. I noticed that the (B)(4) concentration was (B)(4) ppm at 0812 hours, (B)(4) ppm at 0843 hours and at 0904 hours the recheck passed with (B)(4) ppm. On the Product Hold and Release Form it was written Hold Tag # 58393, hoses retained released when (B)(4) in compliance. The hose of (B)(4) was retained at 0817 hours and released at 0904 hours. The Salvage Parts procedure was performed with concentration of (B)(4) ppm of (B)(4) HACCP Plan -Slaughter Plant 2- under step #36 states in part: Parts Salvage (B) Pathogens, i.e. Salmonella. Is the Hazard significant? No. Justification for decision (B)(4) (B)(4) Supplements 2,7,17,18,56. HACCP Supplement #56, Salvage Parts Treatment: CP-19 under procedure #2 states in part (B)(4) " (B)(4) water (B)(4) ppm and (B)(4) concentration (B)(4) ppm" (B)(6) was informed of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1013023 711N-1	02/11/2014	03J02	Slaughter HACCP	O	While performing Pre-Chill Finished Product Standards Task, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 9CFR 417.2 (c)(4).At approximately 0852 hours, I randomly removed a 10 bird sample from Evisceration Area #2, Line █, I found one out of the ten birds with visible fecal contamination inside of the bird between the tail and the kidneys, the bird had side cut tail. The Establishment marking system used the side cut tail to identify possible fecal contamination from the(B)(4) The fecal material was dark green in color and pasty in texture measured approximately 1/4" long by 3/8" wide in size. This exceed the limit of Zero Tolerance for the Process to be in control. I informed █ (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0920 hours and it passed.This is a violation of the critical limits of CCP-2B █ (B)(4) of the Plant's HACCP Plan for Slaughter.
5309	P6137A	NJN101802 3811N-1	02/11/2014	03J04	Poultry Zero Tolerance Verification	C	At approximately 1422 hours, while performing PHIS finished product standards task in the evisceration department on the reprocessing off-line, prior to the birds entering the chiller, I observed one carcass, out of the ten (10) carcasses random sample, contaminated with visible fecal material. The fecal material was approximately half inch long and quarter of inch wide, brown in color, pasty in consistency, and located on a broken back bone close to the tail of the carcass. I took regulatory control action by stopping the reprocessing line and applied a US retain tag, # B43303968, on the affected carcass. The finding was shown to Mr.(B)(6) █, and █ (B)(6) █. SPHV, Dr. (B)(7)(C) █, confirmed that my finding was indeed fecal material. The reprocessing line and the affected carcasses were released to the establishment, allowing QC representative to perform a re-check and the plant procedures for fecal failure. The findings of fecal material on a carcass passed the final wash cabinet en-route to the chilling system represents a zero tolerance failure, as outlined in the establishment's HACCP and in accordance with the regulations 9 CFR 381.65(e) which states: "poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." 9 CFR 417.2(c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits."A PHIS slaughter HACCP task was performed to verify that all corrective and preventative measures were completed.The plant took action to control CCP1B and turned up the chiller overflow to 1/4 of gallon per bird, marked the chiller to identify the end of the affected lot, and post chill checks were performed until the mark came out of the chiller.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN481102 2812N-1	02/11/2014	04A06	Poultry Finished Product Standards	C	While performing a finished product standards check on the reprocessing line, at approximately 1422 hours, prior to the birds entering the chiller, I observed the following noncompliance. In a sample of ten carcasses, there were five carcasses with split tail, which identifies that vacuuming is required to remove all affected tissues including the kidneys. One carcass had yellow gelatinous tissue on one side of the rib cage and a bruised wing, and another carcass had large amounts of yellow flacks and gelatinous tissue on the flap area as well as a bruised mutilated thigh. In addition, I found two other carcasses with cellulitis on the breast muscle and the stomach still inside the carcasses. Another three carcasses had partial crops; one of them had inesta on the crop area and the stomach inside the carcass. I immediately took regulatory control action by stopping the re-processing line and showed Mr. (B)(6), my findings and informed him of the forthcoming noncompliance. The presence of all these deviations and affected tissues in ten carcasses indicates that the re-processing line was not under control. The plant failed to effectively apply their procedures and comply with the federal regulations 9 CFR 381.84, 381.86, 381.89.
5112	M18909	JDD5623023 310N-1	02/10/2014	01B02	Pre-Op SSOP Review and Observation	O	On 02/10/2014 in Evisceration I observed the Gizzard Defatter Machine, interior product contact area to have a three inch crack. Mr. (B)(6) and Mr. (B)(6), in charge of setting up the Machine. Was to be welded prior to start up. Picking room had numerous feathers on overheads. Ms. (B)(6) was also advised of the issues. In (B)(4) room the floor is breaking up. Ms. (B)(6) and Mr. (B)(6) was advised This is a violation of the above CFR's and the Establishment's written program. This is linked to 012-2014, Dated 02/03/2014, JDD1405025803N/1 and Five other associated JDD Numbers.
5308	M6137	BXL1618025 410N-1	02/10/2014	01D01	SPS Verification	O	While walking through Plant #2 between evisceration lines at approximately 1500 hours, I observed numerous beads of condensation formed on the ceiling above the automatic drawers machines for Line (B)(6) and Line (B)(6). The condensation also was along the ceiling from the entrance of the condemned room through station #10, Line (B)(6). I informed (B)(6) and (B)(6) of the noncompliance. (B)(6) immediately started wiping down the condensation. I walked through the body opener area and observed more condensation above the back up body opener Area for the (b)(4) lines and the drip pan, also in the paw room was condensation on the ceiling. Establishment personnel wiped down the condensation. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2 (d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3320020 610N-1	02/10/2014	03J04	Poultry Zero Tolerance Verification	O	On 02/10/2014 at approximately 1040 hours, while performing a Zero Tolerance Task on Line #1 in Evisceration, I observed the following. After talking a random 10 bird sample, I found 2 birds with visible fecal contamination. The fecal on the first bird was located inside on the left under the leaf fat. The fecal material measured approximately 3/16" in size, olive green in color and slightly watery in texture. The fecal on the second bird was located inside on the right under the leaf fat. The fecal material measured approximately 5/16" in size, olive green in color and pasty in texture. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (B)(6) after I had found the first bird with fecal, of the noncompliance and the protocol for fecal failure was implemented. Quality Control performed the recheck at approximately 1055 hours and passed, bringing the process back into control. Quality Control performed post chill checks on the suspect lot, and all checks passed. My findings indicate a noncompliance with 9CFR 381.65(e) and 9CFR 417.(c)(4).
5308	M6137	BXL4520020 610N-1	02/10/2014	01C02	Operational SSOP Review and Observation	O	On 02/10/2014 at approximately 1315 hours, Line #1 in Plant 1 was stopped and there were no birds on the line. Maintenance was working on the plastic that was covering the leaks in the ceiling observed by plant personnel. I was informed by one of the USDA Inspectors that there was water dripping from the ceiling in another location. I shone my flashlight at the ceiling located towards the front and to the right side of the Inspectors Station #3. I observed the droplets of water that was falling from the ceiling and I informed (B)(6). Another USDA Inspector that was on Station #4, informed me that drops of water were falling on her at the Inspectors Station. I again shone my flashlight up at the ceiling and I observed that water was dripping from 2 bolts that were in the ceiling to the right side and towards the front of the station. I informed (B)(6) and I placed a U.S. Rejected/Retained tag #B31406631 on Line #1. I informed (B)(6) of the noncompliance. Maintenance placed plastic under the leaks and the line was washed restoring sanitary conditions. I removed the tag and released the line at approximately 1341 hours. The previous corrective actions were insufficient to prevent the reoccurrence. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.13(c), 9CFR 416.2(b)(1), 9CFR 416.2(b)(2), 9CFR 416.4(a), and 9CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4919021 410N-1	02/10/2014	01802	Pre-Op SSOP Review and Observation	O	<p>On 02/10/2014 at approximately 0740 hours while monitoring Pre-Operational Sanitation Procedures in Plant 1, I observed the following. On the Inspectors station #2, I shone my flashlight up at the ceiling and saw beaded water on a seam running along the ceiling. I informed (B)(6) and an employee came with a sponge mop and wiped the water off the ceiling. Upon further inspection I saw that there was more water, along the same seam on the ceiling in the middle of Line 1 and Line 2 that was dripping directly above the product area. While maintenance was taking corrective action by putting up plastic under the leaks in the ceiling, I continued with the pre-op in the evisceration department. At Chiller #2 I observed beaded condensation on a pipe directly over the chiller at approximately the middle section. I informed (B)(6), and a sanitation employee wiped off the pipe. I informed (B)(6) of the noncompliance. I tagged both Line 1 and Line 2 with U.S. Rejected/Retained tags #B31406636 and #31406641. After maintenance had finished putting up plastic and after the lines were washed restoring sanitary conditions, SCS (B)(7)(C) removed the tags and released the area at approximately 0910 hours. At approximately 0900 hours while performing Pre-Operational Sanitation Procedures in Packaging, I observed the following. A drip pan directly over Line 1 was covered with heavy beaded condensation. I informed (B)(6), and a sanitation employee wiped off the drip pan. I continued to Line 1 and I observed a drip pan directly over the line was also covered with heavy condensation. As I observed the employee wiping off the drip pan, drops of condensation fell onto the product belt. I informed (B)(6) and the belt was washed and sanitized restoring sanitary conditions. I informed (B)(6) and (B)(6) of the noncompliance. The previous corrective actions were insufficient to prevent the reoccurrence. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.13(c), 9CFR 416.2(b)(1), 9CFR 416.2(b)(2), 9CFR 416.4(a), and 9CFR 416.4(b)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN272102 5110N-1	02/10/2014	01C02	Operational SSOP Review and Observation	C	<p>On February 10, 2014 while walking through the Packaging department I, CSI (B)(7)(C) observed the following noncompliance. The drip pan directly above the (B)(4) product exit rollers was overflowing due to a clogged drain. The water was falling from the drip pan at a rapid and steady rate. The (B)(4) releases front halves of chickens by weight into a brown tub and an employee puts a clean lid on the tub as it exits the machine. I observed one tub with front halves in it exit the (B)(4) and water from the drip pan fell on to the product inside the brown tub. At approximately 1841 hours I took a regulatory action by tagging the affected product in the tub and informed (B)(6) (B)(6) of the forthcoming noncompliance. (B)(6) stopped production and restored sanitary conditions by unclogging the drip pan and removing all water from the overhead drip pan, as well as sanitizing the exit rollers. The affected product was reworked by the establishment and reinspected and released at approximately 1910 hours. These findings represent a noncompliance with the regulatory requirement of 9CFR 416.4(d) which states: Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments.</p>
5308	M6137	BXL0210023 507N-1	02/07/2014	03J02	Slaughter HACCP	C	<p>On 02/05/2014 at approximately 0946 hours while observing Quality Control performing a CP-1 Vent and Body Opening check in Plant 2, I observed the following. Line (B)(4) check was performed and documented, Line (B)(4) was documented as "No Product Available" even though there were birds on the line and the line was running, and Line (B)(4) check was performed and documented. This is a noncompliance with not verifying the operation of the (B)(4) and body opener on each line. The establishments' HACCP Plan-Slaughter Plant 2-Vent/Body Opener Step 12, under Potential Hazards Introduced, Controlled, or Reduced at this step, Is the hazard significant? No. Under 'Justification for Decision' it states in part, (B)(4) (B)(4). This is a noncompliance with 9CFR 417.5(a)(1). I informed (B)(6) of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0610025 407N-1	02/07/2014	01D01	SPS Verification	O	While going to performed Post-Chill Finished Product Standards Task, at approximately 0948 hours, I observed numerous beads of condensation formed on the ceiling above the dumper for Chiller #1 (B)(4) cabinet, the drip pan for the (B)(4) cabinet and the water rinse cabinet. These last areas are product contact surfaces, the dumper in front of Chiller #1 transfers the birds from stainless steel tanks to the rehang conveyors belts. I immediately informed (B)(6) of the noncompliance. He took immediate corrective action by wiping down the condensation. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2(d).
5308	M6137	BXL5102025 407N-1	02/07/2014	01B02	Pre-Op SSOP Review and Observation	C	On 02/06/2014 at approximately 2222 hours while monitoring Pre-Operational Sanitation procedures in Plant 1, I observed the following. There was a heavy layer of brown rust on the top chain driven sprocket for the Oil Gland Cutter for line 1. The rust coating had migrated down the shaft from the upper sprocket and was pooling on the lower sprocket that does the oil gland removal. Mechanics were called and the upper rusted chain was replaced on both lines with a stainless steel chain. After grinding and buffing was completed (B)(6) was called to remove the numerous specks and metal shards to approximately 1" left on the oil gland cutter, PMT machine and rehang belts. The items were rewashed restoring sanitary conditions by approximately 0115 hours. At approximately 2228 hours there was heavy beaded condensation on the ceiling above the Heart and Lung Remover on line 2. The condensation covered the ceiling from the wall on the line 2 side near station 8 to inspection station #4 on line 1, and from inspection station 8 to the line 2 Cropper. The condensation that was mopped with sponge mops and blown down with air. The use of air on the ceiling caused the entire area to be contaminated with specks and pieces of black and brown UFM (Unidentified Foreign Material) to approximately 1/2". Stations 4 & 8, Line 2 Liver Harvesting and the Giblet sorting belt were all rewashed to restore sanitary conditions by approximately 2300 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5404021 607N-1	02/07/2014	01802	Pre-Op SSOP Review and Observation	O	<p>At approximately 2414 hours on February 7, 2014, while monitoring the establishments Pre-Operational Sanitation Standards in the Packaging Department area, the (B)(4) Room, I observed the following deficiency:</p> <p>a) Wishbone Conveyor – grey and white support bars (entire length) – greyish to black coloring from mold growth on excessive yellowish product and thick slimy, textured fat buildup left under rim of support and on the guide bars. Black pipe running parallel to the conveyor had a buildup of sticky yellowish fat/residue full length of pipe area. b) Back Conveyor – stainless steel bar and white guide bar – full length of conveyor – excessive buildup of yellowish product and thickish slimy textured fat left under rims, guide bars, and the conveyor belting. All above discrepancies were creating food safety noncompliances. I informed (B)(6); and (B)(6) of the non compliances. Areas recleaned, sanitized and released at 2435 hours. My findings indicate a non compliance with the regulatory regulations 9 CFR 416.1, 9 CFR 416.13(a), 9 CFR 416.4(a) and (b).</p>
5568	M20923	XUM001402 5707N-1	02/07/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	<p>At approximately 1125 hours while performing HACCP task (the record review component of procedure for fully cooked-not shelf stable process), I observed the following noncompliance: While review the records in the QC office dated 2/6/14 Line 1 (b)(4) CCP-2B product Grilled chicken strips the check made at 21:57 temperature # 5 recorded (B)(4). Establishment HACCP Plan states- (B)(4) Records were reviewed on 2/7/14 at 7:29 am by (B)(6). There was no corrective action and deviation documented at temperature deficiency. I notified the (B)(6) about the non-compliance. This does not meet the requirement of 9 CFR 417.5(a)(3) which states: "The establishment shall maintain: Records documenting the monitoring of CCPs and their critical limits, including the recording of the actual times, temperature, or other quantifiable values, as prescribed in the establishment's HACCP plan; the calibration of process-monitoring instruments; corrective actions, including all actions taken in response to a deviation; verification procedure and results; product code(s), product name or identity. Each of these records shall include the date the record was made". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA462102 1206N-1	02/06/2014	01C02	Operational SSOP Review and Observation	C	At 2120 hours regulatory control action was taken when the following non compliances were observed as while performing an observation and review of the establishments operational sanitation and sanitary performance standards within the packaging department of Foster Farms in Demopolis Alabama. I observed water dripping from the end of a valve on a 3/4 inch water pipe along north east wall of the department, as the dripping was splatter off a concrete side extension of the wall and in the same vicinity next to employees packaging corn dogs along the conveyor line. No product was affected yet an insanitary condition was more than likely than not at all. Upon further observation I observed product boxes, plastic, gloves, wood sticks (used for the corn dogs), standing water, water in pans over flowing with grease and oil on the department floor. In addition, product over flow on the conveyor belt had corn dogs flowing onto the catch pans when packaging was backing up. Plant employees immediately removed in excess of 50 pounds of corn dogs to be discarded. Multiple trash receptacles and trash gondolas were over flowing. After corrective actions were taken and all sanitary requirements were met, the area was released officially back to the establishment for control of operations
5112	M18909	JDD1613020 406N-1	02/06/2014	01D01	SPS Verification	C	On 02/06/14 at approximately 0940 hours while performing my presentation check in evisceration I observed the following noncompliance to 9 CFR 416.1 and 9 CFR 417.2(d). I observed heavy beaded condensation on the main overhead water pipe crossing over Line 1 and Line 2 evisceration lines. I immediately informed (B)(6) of my observation and noncompliance. Mr. (B)(6) immediately took corrective action by having the condensation wiped off to restore sanitary conditions. No product was involved.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA2816024 910N-1	02/06/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	<p>During a routine patrol of the Cook Pack Department, I observed noncompliance with HACCP regulatory requirements 417.2(a)(1), 417.2(a)(2) and 417.4(a). On February 6, 2014 at approximately 1420 hrs. in the New Corndog Fryer Room I observed as 3 employees removed casing from cooked (RTE) franks that were located on the top of one stainless steel table. This table was located adjacent to one wall and in close proximity of Fryer #5. The Corndog Supervisor, Ms. (B)(6), was notified and asked if it was customary for this RTE frank product to be 'reworked' at this particular location. (B)(6) stated that she was unsure. (B)(6) accompanied me as I proceeded to the QA office in order to review the establishment's written 'Deli Plant Frank HACCP Fully Cooked - Not Shelf Stable Program'. Documentation in the Flow Chart demonstrated that the 'Rework' process step is only performed in the Raw Product Processing Department and is then incorporated into the 'Batching' process step. Documentation in the Hazard Analysis identified one biological food safety hazard, Listeria monocytogenes, as reasonably likely to occur at the 'Rework' process step. However, justification defined the probability of this biological food safety hazard occurring as 'low risk' as the process is designed through programs of product inspection and temperature control to reduce risk associated with the hazard. While reviewing the HACCP Program, Superintendent, Mr. (B)(6) joined us who was notified of IPP's concern with food safety for the RTE product taken out of the defined frank processing product flow. We returned to the New Corndog Fryer Room where the 3 employees were still in the process of removing the casing from the exposed RTE franks. Mr. (B)(6) confirmed that the RTE product was, in fact, undergoing the 'Rework' process at this alternate location in the post lethality environment. I asked Mr. (B)(6) to take random internal product temperatures of the franks on the table top as well as in the one edible product barrel that the 'Rework' product was being transferred to. The average RTE product temperature was (B)(4) F. As the 'Rework' process step was being performed in an alternate location and one that was not included in the Flow Chart of the above cited written HACCP Program is noncompliance with 417.2(a)(2). Also, a hazard analysis had not been performed for the alternate 'Rework' process step which is noncompliance with 417.2(a)(1) and 417.4(a). Official regulatory control action was taken and U.S. Retain Tag No. B31408287 was collectively used to retain the RTE post lethality exposed frank product located on the table top and in the edible product barrel. Mr. (B)(6) elected to condemn the U.S. Retained product and proceeded to transfer this product from the two sites into one condemn barrel (81 lbs). Upon appropriate product disposition official regulatory control action was relinquished and the above cited U.S. Retain Tag was removed (1445</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							hrs).This document serves as written notification that failure to comply with the regulatory requirements in 9 CFR Part 417 could result in adulteration of product and could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ2115025 607N-1	02/06/2014	01C02	Operational SSOP Review and Observation	C	<p>On February 6th 2014 at approximately 0826 hours I entered the packaging floor coming from the chiller area and as I passed rotisserie at the area of the thigh and leg belt lines along the outer perimeter I stumbled upon a scene where two tan totes of whole birds had fallen and spilled onto the floor and establishment employees were picking whole birds off of the floor and placing them back into the tan totes of which they originally spilled out. Whole potentially insanitary birds from the floor were being comingled with whole clean birds that did not spill out of the tan totes. In the immediate area where whole birds spilled onto the floor there was a grated floor trough style drain system, a pallet jack and a large black wheeled refuse container. It is reasonable to assume that establishment employees involved did not have a working understanding of the establishment's floor salvage program since comingling of sanitary product with insanitary product is unacceptable. It is further reasonable to assume that whole birds may have been rendered permanently insanitary and not eligible for the floor salvage program after coming in contact with an employee boot, the grate covering the trough style drain, the pallet jack or the refuse bin. I identified (B)(6) and asked her where those birds were being taken. She informed me they were going to a rinsing table in the chiller area to undergo floor salvage reprocessing. I immediately walked back to the chiller area and observed multiple tan totes with whole birds. The tan totes were not labeled with orange establishment hold tags. There was no way to visually distinguish the birds that had fallen onto the floor and been comingled with clean birds from another tan tote in the immediate vicinity containing whole birds which may or may not have been involved in the incident. I took a regulatory control action and I informed (B)(6) that I was retaining all the tan totes with whole birds in the chiller area near the reprocessing table until I could unequivocally determine their wholesomeness. (B)(6) became involved and I explained what I had observed and my concern that there was unaccounted and unidentifiable potentially permanently insanitary product present and comingling had occurred. He checked and counted birds in the red condemn barrel just to the side of the reprocessing table in the chiller area and the number of birds could not account for the total number of birds that spilled onto the floor. &nbsp; Mr. (B)(6) and I walked back to the scene where the initial incident had occurred and stumbled upon a second identical incident occurring where another two tan totes containing whole birds had spilled onto the floor and multiple establishment employees were again picking birds off of the floor and comingling them with clean whole birds that remained in their tan totes. None of the tan toes were labeled or marked in any way to distinguish them from the multiple covered tan totes containing wholesome product. Mr. (B)(6) immediately stepped in and told establishment employees to stop what they were doing and walk away from the scene. Mr. (B)(6)</p>

[illegible]

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3803022 005N-1	02/05/2014	01C02	Operational SSOP Review and Observation	C	On 02/05/2014 at approximately 0022 hours while monitoring Operational Sanitation in Packaging Area 1, I observed the following. There was black UFM(Unidentified Foreign Material) specks and smears to approximately 1/2" by 2" on the whole body carcasses on line 1916. The birds had received their final trim, final antimicrobial intervention and the giblets were being added back into the 'Organic' birds at the location where I was making my observations. After taking off several birds in a row the line was stopped and (B)(6) was called. An additional employee was placed at the final trim location to removed the affected birds. Approximately 30 carcasses were removed and held for reconditioning. The UFM was located on the drumstick and at the joint area with the thigh on the carcasses. (B)(6) held 2 partial racks of packaged product for reinspection. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).
5308	M6137	BXL4619020 805N-1	02/05/2014	03J04	Poultry Zero Tolerance Verification	O	While performing Zero Tolerance Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4).At approximately 1452 hours, (B)(6) randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination, inside of the bird at the right side between the tail and the leaf fat area. The fecal material was dark green in color and pasty in texture, measuring approximately 1/4" diameter in size. This exceed the limit of Zero Tolerance for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1545 hours and it passed.This is a violation of the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4723023 805N-1	02/05/2014	01C02	Operational SSOP Review and Observation	O	<p>At approximately 1815 hours to 1840 hours on February 5, 2014, while monitoring the establishments Operational Sanitation Standards in the Packaging Department and Rehang areas, I observed the following deficiencies:</p> <p>a) Plant 2 – Sanitation Personnel was washing down during production time at the Pre-chill/FPS tables, drip pans, pipes, and floor area. They were directly spraying the day's slaughter production debris from a non-product contact surfaces into Chiller # 3, a direct product contact surface and onto product while passing on shackles. b) Plant 1 – Sanitation Personnel was washing down during production time by the Chillers and washing the day's slaughter production debris from a non-product contact surface directly into the Chillers, which is a product contact surface and a hold orifice for the product while chilling. Plus they were washing down into the Chiller while the product was still in there chilling down to the correct temperature. c) Rotisserie Room – Sanitation Personnel was washing down before the completion of the task that was being performed. The wash down was creating heavy fog moisture which settles on pipes and ceiling, which are insanitary, non- product contact surfaces. The fog creates heavy moisture droplets coming from these insanitary areas, which falls onto the product and the boxes with the packing blue liners (ready for product and packing). Contaminating all product contact surfaces. All above discrepancies were creating food safety noncompliances. I informed (B)(6) and (B)(6), and (B)(6) of the non compliances. Corrective actions were implemented immediately. Inappropriate sanitation cleaning ceased until completion of production, product was removed, boxes and liners all condemned, and all the affected areas were restored to correct sanitary conditions by 1916 hours. My findings indicate a non compliance with the regulatory regulations 9 CFR 416.4(d) and 416.13(c). </p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN210302 0105N-1	02/05/2014	01B02	Pre-Op SSOP Review and Observation	C	<p>After QC had performed pre-operational sanitation and the area was released for USDA inspection,&nbsp;the following non compliances where noted in the respective areas:&nbsp;&nbsp;&nbsp;Food Service Area at approximately 0035 hrs.&nbsp;- The white product&nbsp;transfer belt of multi-cut #2 had black grease like material&nbsp;on the surface.&nbsp;This belt is a product contact surface used to convey the cut up pieces of chicken to the red mesh net hopper.&nbsp;Packaging&nbsp;Area at approximately 0047 hrs.&nbsp;- Leg Processor #1 had multiple pieces of fat and&nbsp;product residue on the frame along with&nbsp;numerous pieces of fat on the cutting board and frame of the cutting board located on the east side of the machine.&nbsp;The cutting board is also a product contact surface.&nbsp;&nbsp;I informed and showed&nbsp;(B)(6) these findings as he was present during the inspection and I&nbsp;informed him of the issuance of the non compliance report.&nbsp;A USDA retain tag was not issued since the areas where in control with the lock-out/tag out procedures.&nbsp;After the units where washed and sanitized the areas where released for production.These finding represent a non compliance&nbsp;with&nbsp;9 CFR 416.4(a) and 416.13(c).&nbsp;On 12/16/2013, Non Compliance report NJN3103121817N/1 was issued for&nbsp;similar findings on leg processor #2 in the packaging area.&nbsp;</p>
1326 1	M33901	HAY341602 5706N-1	02/05/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	<p>On the calendar date of February 5, 2014 at approximately 1543 hours while performing the recordkeeping component of the Fully Cooked -Not Shelf Stable&nbsp;HACCP task, the following noncompliance was observed: I, CSI (B)(7)(C), reviewed the HACCP record (CCP 3) from the previous day's operations; 2/4/2014. The record shows that the recorded temperatures met the critical limit prescribed in the HACCP plan, and that all monitoring and verification procedures were performed at the frequencies prescribed in the HACCP plan. "2/4/14" is the only date recorded in the "DATE" section of the record which indicates that all entries were made on 2/4/14. The record also shows that product temperatures were&nbsp;monitored&nbsp;and recorded past midnight on 2/4/14; however, the entries made after midnight do not include the date of 2/5/2014.&nbsp;&nbsp; (B)(6) , was shown the noncompliance and she confirmed the findings. Ms. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on January 8, 2014; please reference NR # HAY0703013909N/1. The establishments response to NR # HAY0703013909N/1 of - (B)(4) - failed to prevent recurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN421802 5504N-1	02/04/2014	01D01	SPS Verification	C	On February 4, 2014 while performing a routine patrol of the cook side departments I and FLS Dr. (B)(7)(C) observed noncompliance with SPS regulatory requirement(s) 416.4(d); 416.4(b) and 416.2(b)(1). At 15:35 hours I observed the east wall to have a hole in the white panel under the refrigeration unit above the pipe in the cook pack shipping dock; as well the metal frame of the door to the cook pack shipping dock cooler was broken;exposed wood and caulking was visible. As well on the east wall a white metal panel was broken and bent as well there was a large exposed gap on both sides of the ceiling refrigeration unit and black unidentifiable black material on the seams from the ceiling to the walls in the same cook pack shipping dock storage cooler.Also there were three sections on the ceiling in the hallway between the coolers and the (B)(4) chillers where loose caulking or sections of metal ceiling material were hanging down. Mr. (B)(6) was notified and shown the noncompliances. This NR serves as written notification of SPS noncompliance; as well as notification that failure to comply with regulatory requirement(s) may lead to additional regulatory or administrative actions as described in 9 CFR 500.4.
5129	M210	LQN421802 5504N-2	02/04/2014	01D01	SPS Verification	C	On February 4, 2014 while performing a routine patrol of the establishment's raw production areas I and FLS Dr. (B)(7)(C) observed noncompliance with SPS regulatory requirement(s) 416.4(d), 416.4(b) and 416.2(b)(1). At 16:10 hours I observed in the raw cooler to the left of the scale a gap between the stainless steel guard and the floor, the gap had pieces of concrete coming loose and on the floor as well the wall area behind the stainless steel water system tank had loose caulking and rust between the white wall panels and stainless steel guard in several locations on the west wall. As well the oven loading area had a CIP monitoring equipment machine that had a severely rusted motor on the bottom side as well as rusted conduit attachments and componets all over the machine parts and yellow gauges. Mr. (B)(6) was notified and shown the areas. This NR serves as written notification that failure to comply with regulatory requirement(s) may result in additional regulatory or administrative actions as described in 9 CFR 500.4.
5308	M6137	BXL5305022 404N-1	02/04/2014	01802	Pre-Op SSOP Review and Observation	O	At approximately 2400 hours

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM581502 4804N-1	02/04/2014	01D01	SPS Verification	C	This morning approximately at 1040 hours, while performing PHIS routine SPS task (Other Inspection Requirements/ Facilities and Equipment Standard), the following noncompliance was observed: Cook side of the establishment Line (B)(6) North side wall of the fryer room hand pallet jack charger has peeling paint and very rusty. I informed (B)(6) and (B)(6) of the non-compliance. Poorly maintained facilities and equipment can and do harbor food borne pathogens, which can then multiply and be dispersed throughout the food processing environment increasing the chances of product contamination which can render product adulterated. 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that the product is not adulterated". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
5112	M18909	JDD1405025 803N-1	02/03/2014	01B02	Pre-Op SSOP Review and Observation	C	On PRE-OP this date 02/03/2014 in Evisceration was noted the following: 1) 11/2 inch crack in the interior of the Gizzard Defatter by the Final Wash. 2) Above final wash, line two, the Overhead Fan is insanitary with Black UFM on Blades and supports for Fan are rusty. 3) I/O Wash Line Two has a Frayed Hose, 4) Picker Three has a Four Inch Weld that is Cracked. 5) Overheads in Picking Room has Feathers too numerous to count. 6) Plastic Strips insanitary with numerous Feathers from blood tunnel into first wash. 7) First Wash Spray Nozzles has UFM on both of them. 8) Pipes on Wall, Line One, near Head Pulling are black with UFM. 9) Evisceration Mens Restroom, the wall dividers between Urinals are insanitary and rusty. Mr. (B)(6) had been notified of this issue last week. Mr. (B)(6) , Ms. (B)(6) Mr.(B)(6) were notified of their respective issues. Issues were not previously documented in QC paperwork prior to notification of the same.In TRAY PACK, LINE ONE, SHRINK TUNNEL, the Exhaust Hose and related Piping has Black Grimy UFM inside them. Mr. (B)(6) and QC notified and it was not documented in (B)(6) (B)(6) paperwork prior to my notification of the same. These are violations of the Establishment written SSOP program and the above 9 CFRs. This is linked to NR 011-2014, Dated 01/31/2014, JDD1407012031N/1 and Six other related JDD numbers.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1407012 031N-1	01/31/2014	01802	Pre-Op SSOP Review and Observation	C	Pre-op this date 01/31/2014 at 0500 H PST in the (B)(4) Room off of Rosier Area, the Computer and Electrical Panel so dusty as to write your name in dust. This is a violation of the Establishment's written SSOP program and the above 9 CFRs. This is linked to NR 009-2014, Dated 01/23/2014, JDD3611015623N/1 and Five other associated JDD Numbers. Mr. (B)(6) was shown the Noncompliance and Q.C. Paperwork had no documentation of this prior to my notification of the same.
5568	M20923	XUM301101 4531N-1	01/31/2014	01802	Pre-Op SSOP Review and Observation	C	At approximately 0645 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Cook side of the establishment: I found lots of pieces of food particles on UHMW guide incline conveyor belt, few food particles under chute and also found food particles above (B)(4) belt bars from the previous day of production. Upon continuing my inspection Line 1, some of the batter pipes have food particles also from previous day of production. Found one of the batter mixer pipe rusty. I took a regulatory control action and applied USDA retain/rejected tag# B24829877. I informed (B)(6) and (B)(6) of the non-compliance. The finding described in the non-compliance was on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0735 hours. Plant SSOP Section1, page1, states: (B)(4). 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH050901 3531N-1	01/31/2014	03J02	Slaughter HACCP	C	<p>On Friday, January 31, 2014, at approximately 0801 hours, while performing Poultry Finished Product Standards (Prechill) on Evisceration Line #2, I observed fecal contamination on the outside of the first carcass randomly selected for the ten bird sample. The fecal material was located below the oil gland area. The fecal was approximately 1/4 inch in size and light brown in color. It had a watery texture to the touch. There were no plant employees between me and the chilling tanks when I performed this check. Therefore, It is reasonable to assume that the feces would have entered the chilling tanks in violation of Regulation 9 CFR 381.65(e). Mr. (B)(6) was notified of the deviation for the Critical Control Point CCP-1, (B)(6) at CCP-1, and he was shown the carcass. He immediately implemented the establishment's corrective action for visible feces at CCP-1. At 0815 hours, Mr. (B)(6) notified me that the cause of the noncompliance was equipment malfunction. Mr. (B)(6) stated, (B)(4) ". The preventative measure that was given was that a supervisor or leadperson will check the Bird Brush rotation everyday at start up. A similar noncompliance was documented on NR NHH0801014321N/1 dated 01-21-2014. The further planned action may not have been implemented or was ineffective in preventing the reoccurrence of this similar noncompliance.</p>
5308	M6137	BXL4318010 429N-1	01/29/2014	04A06	Poultry Finished Product Standards	C	<p>On 01/29/2014 at approximately 1517 hours while performing a Pre-Chill Finished Product Standards Task on Line #2 in Plant #1, I observed the following. After taking a standard random 10 bird sample, I accumulated 32 nonconformance points. There were 3 cloacas, 1 intestine, 3 whole lungs, 1 pin-feather, 1 feather, and 2 long hocks. This exceeds the subgroup absolute limit of (b)(6) points. I informed (B)(6) of the failure and Quality Control performed a recheck. At approximately 1527 hours, the recheck failed with 34 nonconformance points. At this point the process is judged to be out of control. I informed (B)(6) of the noncompliance. There were no other rechecks at pre-chill due to the shift finishing. Post-Chill checks were performed every 30 minutes until the birds finished coming out of the chiller. My findings indicate a noncompliance with 9CFR 381.76(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4716014 729N-1	01/29/2014	03C02	Raw Intact HACCP	C	<p>At approximately 1725 hours on 01/28/2014, while monitoring the (B)(4) dip on Line (B)(4) in Packaging, I observed the following noncompliance. There was one spray nozzle that was not working on the spray rinse that is required after the thighs go through the (B)(4) dip. The spray nozzle that was not working was located on the end of the spraying unit and I noticed that the thighs going under it were not being rinsed. The establishments' HACCP Plan -Raw Intact-Packaging Step 16 Parts Dip, under Potential Hazards Introduced, Controlled or Reduced at the step lists (C) Cetylpyridinium Chloride and Is the hazard significant? No. Under 'Justification for Decision' it states (b) (4) (B)(4).</p> <p>. A review of FSIS Directive 7120.1 Rev 16 dated 08/13/2013 under 'Antimicrobial lists "Cetylpyridinium Chloride used 'To treat the surface of raw poultry carcasses or parts (skin-on or skinless) and then 'Dip tank application' to treat poultry carcasses/parts "When application of the additive is not followed by immersion in a chiller, the treatment will be followed by a potable water rinse. I informed (B)(6) and she informed the employee that was dumping a tub of thighs into the (B)(4) dip to stop. The line was stopped and I informed (B)(6) of the noncompliance. Quality Control retained the racks of packaged thighs from the last acceptable check. On 01/29/2014, the packages of thighs were opened and the thighs were rinsed with potable water. My findings indicate a noncompliance with 9CFR 417.2(a)(1) and 9CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH271301 4029N-1	01/29/2014	06D02	Other Inspection Requirements	C	<p>On Wednesday, January 29, 2014, while performing an Other Inspection Requirement Task (Paw Diverter Check), on Evisceration Line #2 Station #2, I observed the following noncompliance. I asked the establishment to perform a Paw Diverter Verification Test; maintenance and production personnel performed the test. I observed when the paw diverter button for Inspection Station #2 was pushed, the paws did not divert into the condemn container; instead, they went into the paw chilling system where they were mixed with inspected paws. I immediately notified Mr. (B)(6), of the noncompliance and applied USDA Reject Tag # B 29 699848 to the system at 1134 hours. I checked the paw diverter paperwork that the establishment documents their checks on and the last acceptable check was made at 0930 hours. Mr. (B)(6), tagged and condemned 32 cases of Grade A paws and 2 cases of B Grade paws and 10 cases of C Grade paws that were produced between 0930 hours and 1134 hours.After lunch Mr.(B)(6) notified me that maintenance&nbsp;was ready for me to perform a retest. I performed a retest with production personnel on Evisceration Line #2 Station #2 and&nbsp;it failed at 1238 hours. I performed another retest with them at 1245 hours on Evisceration Line #2 Station #2 and it passed. I notified Mr.(B)(6) that he could resume saving paws; he had restored sanitary conditions to the chilling system during the lunch break. At this time the tagged was removed.There was a similar noncompliance documented on noncompliance report #NHH5500125412N/1 dated 12-12-2013. There was no further planned action given.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN421101 4128N-1	01/27/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On January 27, 2014 at approximately 1220 hours, while performing records review on HACCP records. I observed that the Pre-Shipment Review Log for Further Processed Product cook log CCP-1B was not verified for production date January 25, 2014. The Pre-Shipment page was filed with no signature a deviation was in the works for an oven failure but there was no exception report or other documentation filed along with the log. This is a Noncompliance of the verification activities of the HACCP Plan. This does not comply with establishment Verification Activities for CCP-1B and CCP-2B to be met prior to shipment. This does not comply with 9CFR 417.5(c) which states in part "Review prior to shipment", and 9CFR 417.4(a)(2)(iii) which states in part: Records review" (B)(6) was informed of the Noncompliance and (B)(6) was shown and informed of the noncompliance. This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions.
5308	M6137	BXL3109015 226N-1	01/26/2014	03J02	Slaughter HACCP	C	On 01/25/2014 at approximately 2350 hours while monitoring Pre-Chill Finished Product Standards on Line ^{(B)(6)} in Plant #2, I observed the following. After taking a standard 10 bird sample, I observed one carcass with visible fecal contamination. I contacted (B)(6) and an employee was stationed at the end of the line to wash carcasses per the establishments' protocol for fecal failure, however hanging was not stopped. The fecal material was on the inside of the carcass on the tissue under the left side fat flap. The fecal material was olive green in color, pasty in texture and measured approximately 1/2" by 1/4" by 1/8". (B)(6) directed (B)(6) to perform a recheck as it was near break time. The recheck passed at 0013 hours. The cause of the failure was determined to be the Inside Outside Bird Washer. A QC check of the Inside Outside Bird Washer on line ^{(B)(6)} at 2342 hours documented that the bird washer was working satisfactorily including timing, alignment, one leggers, spray valves, and pump with the water pressure at 77psi. The Pickup Sheet for the shift had the average bird weight at 7.0 pounds. The line was running at (B)(6) birds per minute at the time of the failure. The tail of the bird had been marked by the Establishments' procedure to identify birds that do not pass through the (B)(4) or Body Opener correctly. Issues with the fecal failure protocol (not stopping hanging), line speed, marked tail and bird size were all discussed with (B)(6) . The production line was moved to line ^{(B)(6)} after break. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5223012 926N-1	01/26/2014	01D01	SPS Verification	C	On 01/24/2013 at approximately 0300 hours while monitoring line functions at startup after lunch break, I observed the following. A pipe had split at a point just before where the rubber hose is attached. The hose supplies water to the shower heads located just before the (B)(4) (IOBW) Inside Outside Bird Washer on line (B)(6). The stream of water was spraying onto the chain, rail, the corner wheel that supports the chain and the supporting assembly for the blue corner wheel. These surfaces are treated as non-product contact surfaces. The fluids were dripping from the non-product contact surfaces onto the shackles, creating an insanitary condition. I contacted (B)(6) who was at the Rehang Area starting up line (B)(4). Upon returning a few birds had passed through the area before line (B)(6) was stopped and a mechanic was called. The pipe was replaced and the line was returned to service by approximate 0315 hours. I discussed the current water pressure which on occasion exceeds 100psi and the various types of piping installed with (B)(6). My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).
5309	P6137A	NJN421301 4425N-1	01/25/2014	03J04	Poultry Zero Tolerance Verification	C	On 1/25/14 in the Evisceration department on "A" line at approximately 1120 hours, I, CS (B)(7)(C), randomly selected ten carcasses for a zero-tolerance fecal check. One of the ten carcass sampled had a brownish green fecal smear on the center of the back of the carcass in the shape of a circle. The smear was approximately 1/4 of an inch in it's greatest diameter. I took a regulatory control action by retaining evisceration "A" line with the application of U.S. retain tag B38495207 and showed my findings to (B)(6). I released "A" line to (B)(6) who immediately implemented the establishment's corrective actions by conducting a ten bird recheck that passed. Both (B)(6) and (B)(6) were informed of the forthcoming noncompliance.
5112	M18909	JDD2010010 724N-1	01/24/2014	01D01	SPS Verification	O	On 01/23/2014 in the Old Shipping Dock Area near the Q.C. Inspection Station I observed a large floor patch loose. In the Rosier Area I observed OVERHEAD ELECTRICAL CONDUITS extremely rusty and this is direct over the open Rosier. Also observed a tool marked Inedible inside the Rosier and in (B)(4) solution. No notes of this in Q.C. Paperwork. This violates the above 9 CFR's and is linked to NR 003-2014, Dated 01/17/2014, JDDD1208013317N/1 Note: Kudos to the Establishment!!! The floor already repaired.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1304010 924N-1	01/24/2014	01802	Pre-Op SSOP Review and Observation	C	<p>On 01/23/2014 at approximately 2230 hours while performing Pre-Operational Sanitation verification after the establishments Pre-Operational checks, CSI (B)(7)(C) observed the following noncompliance to 9 CFR 416.4(b) in Plant 1 area 4 unit 13 line 2 liver harvester. CSI (B)(7)(C) observed blood and fat on the frame and sides of the liver harvester from the previous days production. Liver Harvester was cleaned and sanitized in my presence and (B)(6) and (B)(6) were notified of the noncompliance. In Plant 2 at approximately 2232 hours CSI (B)(7)(C) observed pasty fat on the inside of Chiller #3 above the water line covering an area measuring approximately 3 feet long to 6" wide and up to 1/4" thick. There was also numerous pieces of fat and tissue to approximately 1/2" splattered on approximately a 6' long section of a brace at the same location. There was also pasty fat covering approximately a 6" by 2" section of a bracket attached to the base of the kick out mechanism. The chiller was cleaned and released at approximately 2236 hours. At approximately 2233 hours the inside of the Finishing Chiller for line 1 had numerous pieces of fat and tissue to approximately 1/2". There was also a heavy layer of grease on the paddle associated with the unit that was at the top of its cycle and out of the water. The Finishing Chiller was dumped, recleaned and released by approximately 2239 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c) and 9 CFR 416.14.</p>
5309	P6137A	NJN560201 0724N-1	01/24/2014	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 00:10, the following noncompliance was noted. During the performance of a zero tolerance verification procedure on "B" line, I noted visible fecal material on the exterior of a poultry carcass. The affected area was located on the hock joint area of the right leg. The fecal matter measured approximately one eighth of an inch in diameter, was brown in color and of a paste like consistency. Upon noticing the affected carcass, I stopped the processing line and showed the fecal matter on the affected bird to Ms. (B)(6) and Mr. (B)(6). After notification, the establishment implemented corrective actions which included a subsequent recheck on "B" line. The recheck was conducted, completed and passed by Ms. (B)(6) at 00:18. The establishment did not meet the requirements of 9 CFR 381.65(e) which requires that the establishment prevent poultry carcasses contaminated with visible fecal material from entering the chilling system. In addition, the finding of visible fecal on a carcass after the final wash does not meet the establishment's critical limit for CCP 1B of "no visible fecal". Consequently, there is also noncompliance with 9 CFR 417.2(c)4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3611015 823N-1	01/23/2014	01B02	Pre-Op SSOP Review and Observation	O	Floor in OSD, Rosier OH, Inedible Hook
5112	M18909	JDD3611015 823N-2	01/23/2014	01B02	Pre-Op SSOP Review and Observation	O	In Tray Pack Shrink Tunnels Line one and (b)(4) were observed to be insanitary condition, Line One had a piece of styrofoam in it 1" x 6", feeding belt to tunnel is cracked and frayed and Line (b)(4) had UFM in the bottom Pan. This is a violation of the Establishment SSOP Program and the above 9 CFR's. Quality Control paperwork did not reflect these issues. This is linked to NR 002-2014, Dated 01/07/2014, JDD3010012407N/1 and four other associated JDD Numbers.
5308	M6137	BXL2804013 223N-1	01/23/2014	03J02	Slaughter HACCP	C	On 01/23/2014 at approximately 0000 hours while monitoring Pre-Chill Finished Product Standards on Line (b)(4) in Plant 2, I observed the following. After taking a standard 10 bird random sample I observed one carcass with visible fecal contamination. I contacted (B)(6) and the protocol for fecal failure was implemented. The fecal material was on the inside of the carcass on the tissue under the left side fat flap. The fecal material was olive green in color, pasty in texture and measured approximately 3/8" by 1/8" by 1/8". A QC recheck passed at 0035 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL4514011 323N-1	01/23/2014	01C02	Operational SSOP Review and Observation	O	At approximately 1050 hours while performing Post Chill Finished Products Standards task in Plant #1, I was walking past Drop #3 in the Plant #1 Packaging Rehang Area when I observed the following noncompliance. I stopped next to the bin staged for product at Drop #3 and observed a carcass on top of the pile already in the bin with black UFM (unidentified foreign material) on one of it's hocks. On further investigation I found 1 more carcass with black UFM on the hocks. I immediately informed (B)(6) of the noncompliance, as QC was walking past the area I informed QC of my findings and she applied a QC hold tag to the bin pending rework. I continued on to perform my Post Chill task on Chiller #2 where I took a random 10 bird sample and found 3 out of the 10 birds with black UFM on the hocks. I immediately informed (B)(6) and QC of my findings, (B)(6) and (B)(6) were also informed of the findings as well as (B)(6). My findings indicate a noncompliance with the regulatory regulations of regulations 9CFR 416.1 and 9CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5508014 823N-1	01/23/2014	06D02	Other Inspection Requirements	C	<p>On 01/23/2014 after receiving complaints from inspectors on line ^{(B)(6)} concerning Presentation&nbsp;I reviewed the Presentation Log for the shift and found no documentation concerning "Parts" inside the birds. I conducted a Presentation procedure on line ^{(B)(6)} with the line running at (B)(4) birds per minute)&nbsp;and&nbsp;on the first station observed (1) viscera on shackle, (1) membrane, (3) not reflective (2) parts inside and (1) contamination for a total of 24 nonconformance points. This exceeded the limit of ^{(B)(6)} points or ^{(B)(6)} occurrences for one error for the process to be in control. The third station had (1) viscera on shackle, (2) not reflective, (6) parts inside for a total of 18 nonconformance points. (B)(6) was informed of the failure. QC rechecks at 0401 hours failed. At this point the process is judged to be out of control. The line was slowed to (B)(4) A recheck at 0427 hours at (B)(4) passed at which time the&nbsp;evisceration process was&nbsp;moved to Line^(B) My findings indicated a noncompliance with 9 CFR 381.76(b).&nbsp;&nbsp;</p>
5308	M6137	BXL4208012 922N-1	01/22/2014	01C02	Operational SSOP Review and Observation	O	<p>On 01/21/2014 at approximately 2240 hours in Plant 1, Line # 2 , Inspection station 7, Inspector (B)(7)(C) observed a piece of shiny metal measuring approximately 2 inches by 1 inch and 1 cm thick&nbsp;attached to&nbsp;the viscera of a chicken on the evisceration line . Inspector (B)(7)(C) immediately stopped&nbsp;evisceration line # 2 and informed CSI (B)(7)(C) of the metal on the chicken viscera. CSI (B)(7)(C) notified (B)(6) of the metal . Production on line 2 was stopped and corrective action was done to find the source of the metal. Production was resumed at approximately 2330 hours after corrective actions were completed. According to PDD, FSIS considers metal of any size on a carcass to be an unacceptable contaminate that should be addressed by establishments Hazard Analysis. The issue of metal contamination has been discussed at previous weekly meets with the establishment. This noncompliance is being linked to NR BXL5704014912N dated 1/12/2014.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM061101 1222N-1	01/22/2014	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 625 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 2, Raw side of the establishment: I found few food particles on (B)(4) from the previous day of production. Upon continuing my inspection: Line 3, I found food particles on hopper 3A, also GCO in feed conveyor belt has lots of food particles and some build up on the bars, also from the previous day of production. All finding described in the non-compliance were on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. I took a regulatory control action and applied USDA retain/rejected tag# B24829888. I informed (B)(6) and (B)(6) and (B)(6) of the non-compliance. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0700 hours. Plant SSOP Section1, page1, states: (B)(4). 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH440501 3522N-1	01/22/2014	01C02	Operational SSOP Review and Observation	C	<p>On the night shift that began on 01/22/2014 at approximately 0225 I was in the Further Processing Room #1 at Establishment 33900&nbsp;P.&nbsp;I was in the area to perform a scheduled SSOP Operational Sanitation tour.&nbsp;As I walked through the room I observed a card board combo that contained inedible wing tips.&nbsp;&nbsp;The combo was not identified as containing inedible product.&nbsp;The requirements of 9CFR 416.3(c) were not being met. &nbsp;I walked approximately 20 feet further and saw a combo of back portions that were also inedible.&nbsp;This combo also did not display anything that would identify the product as inedible.&nbsp;The 2 combos were retained with USDA Retain tags #B38075849 and B38075850 respectively.&nbsp;&nbsp;Approximately 10 feet from this combo was a pallet of boxes with blue plastic liners that had been over sprayed during the floor wash down.&nbsp;These liners are product contact.&nbsp;&nbsp;Regulatory Control Action was taken by applying USDA Reject Tag #B38075851 to the pallet of boxes. Mr. (B)(6) and Mrs. (B)(6) were in the area and were shown the noncompliance. &nbsp;The Preventive Measure given by Mrs.(B)(6) was, "disciplinary action was taken against employee". &nbsp;(B)(6) and Mrs.(B)(6) were informed that a Noncompliance Record would be issued documenting the noncompliance. &nbsp;For similar noncompliance refer to NR # NHH5705015821N / 1, dated 1/21/2014.&nbsp;The requirements of Regulations 416.3(c) and 416.13(c) were not being met. &nbsp;The Establishments SSOP plan objective is (B)(4)</p> <p>"</p>
5129	M210	LQN461901 4821N-1	01/21/2014	04B01	Labeling - Product Standards	C	<p>On January 21, 2014 at 1500 hours while observing the operation in the Cook Side Dicing Department, I observed a Labeling/ Product Standard Noncompliance.&nbsp;I observed five barrels of edible product staged at the dicer ready to be diced without labels to identify the product.&nbsp;U.S. Retain Tag NO. B38937059 was applied to the five barrels of edible product.&nbsp;I informed and showed Ms. (B)(6) the noncompliance.&nbsp;This does not comply with Regulatory Requirement 381.117; which states in part: (B)(4), 381.122; which states in part:&nbsp;(B)(4), and 381.123; which states in part:&nbsp;(B)(4). Immediate corrective actions was implemented by management:&nbsp;U.S. Retain Tag was removed after &nbsp;Product was Identified with the proper label in my presence.&nbsp;This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN402101 0421N-1	01/21/2014	01D01	SPS Verification	O	While performing an anti-mortem and humane handling check, I noticed that the cage washer machine was not operating at all. The cages were passing through the washing machine and coming out the same, dry as well as dirty. I immediately informed Mr. (B)(6), of my observation and notified him of the forthcoming noncompliance. Mr. (B)(6) assigned an employee to manually wash all the cages that were not washed. The cages were soiled with heavy lodes of fecal material
1325 7	P33900	NHH080101 4321N-1	01/21/2014	03J04	Poultry Zero Tolerance Verification	C	At 2140 hours on the night of production which began on 01/20/2014, while performing required PHIS Poultry Zero-Tolerance task at the designated Line #2 Pre-chill station at est. 33900 P, after randomly selecting 10 slaughtered and eviscerated and chilled chicken carcasses for the subgroup test and having begun the test at 2139 hours, Inspection found fecal material on the 3rd bird in the set. The fecal material was a dark green color and of a pasty consistency which would easily smear to the touch. It consisted of one piece 1/4" in diameter and 1/8" in thickness, located on the inside of the breast area (B)(6). (B)(6) was shown the carcass and he concurred that the material in question was indeed feces. Upon investigation, it was found that the cause of the fecal find was (B)(4). (B)(4) Plant Management's Measure to prevent recurrence was (B)(4). (B)(6) The requirements of 9CFR381.65(e) and 417.2(c)(4) were not met and Mr. (B)(6) was advised that the incident would be documented on a Noncompliance Record. Refer to NR #NHH5405010808N/1 dated 01/08/2014 for a similar Noncompliance. Plant Management's measure to prevent recurrence was: (B)(4). (B)(6) To date all preventive measures may not have been implemented as described or were ineffective in preventing recurrence.
1325 7	P33900	NHH570501 5821N-1	01/21/2014	01D01	SPS Verification	C	On the night of production which began on 01/20/201 in est. 33900 P, Inspection was in Room 1 of Further Processing in est. 33900-P and found this Noncompliance: At 0359 Hours a 1/2-full Cardboard Combo of Wing Tips was found by the Leg Processor Machine with no identifying Label. The (B)(6) (B)(6) said that it was Inedible Product and was to be rendered. Inspection took Regulatory Control Action by applying US Retain Tag #B38075676 to the Combo until an Inedible Sticker was affixed. Inspection then released the Combo at 0407 Hours. Mr. (B)(6) was advised that a Non-compliance Record would be generated. The requirements of 9CFR416.3© were not met. Refer to NR #NHH2910114712N/1 dated 11/12/2013 for a similar noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH580001 4121N-1	01/21/2014	01B02	Pre-Op SSOP Review and Observation	C	On the production shift that began on 01/20/2014, I performed pre-operational sanitation review and observation at Est. 33900 P. This Pre-Op was performed in the further processing department of the Establishment, in room #1(on schematics for pre-op inspection). This was after sanitation had completed cleaning the equipment and the establishment had completed pre-operational sanitation inspection of the equipment and released the area for USDA inspection. There are no additional sanitation or inspection steps prior to the start of production. This procedure was completed before product reached the areas inspected. The following non-compliance was observed on the line 1 breast conveyor that brings the breast portions to the breast skinners. Fat and a brown protein residue was on the under side of the unit and on product contact portions of the belt. This residue ranged in size from 1/8 inch to 1/2 inch in size and numbered four pieces on the belt. A greasy yellow to brown residue was on the rails on the under side of the belt. Regulatory Control Action was taken by applying USDA Reject Tag #B38075848 to the belt until it was re-cleaned by Sanitation and re-sanitized. The drip pans on the line were dripping water on the product contact portions of the belt. Maintenance personnel straightened the drip pans as a temporary measure. I then re-inspected and released the units to Production. The requirements of Regulations 416.4(a) and 416.13(c) were not being met. The noncompliance was shown to Mr. (B)(6) and he was informed that it would be documented on a NR. For similar noncompliance refer to NR # NHH0303124510N / 1, dated 12/09/2013.
1326 1	M33901	HAY500001 5325N-1	01/21/2014	04B04	General Labeling	C	On the calendar date of January 22, 2013 at approximately 1657 hours while performing the Operational SSOP Review and Observation task, the following labeling noncompliances were observed: I, CSI (B)(7)(C), observed 2 combos of blocked product staged in front of lines (B)(4). At the time of the findings, there were no labels on or inside the combos to identify the contents within. The combos were retained with U.S. RETAINED tag #'s B43134431 & B43134432. At approximately 1701 hours I observed another combo, containing ground product, staged along side the wall adjacent to line (B)(4). The product could not be identified as there was no label to describe the contents within. The combo was retained with U.S. RETAINED tag # B43134434. (B)(6), was shown the noncompliance and he confirmed the findings. Once the product was correctly identified, the regulatory control action was relinquished. Mr. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1823015 920N-1	01/20/2014	03J02	Slaughter HACCP	C	<p>On 01/20/2014 at approximately 1254Hrs, I observed that the establishment failed to perform the required 10 bird WIP (work in process) sample check per container prior to putting the reprocessed birds into the chilling tank.&nbsp;I observed a plant employee taking reprocessed whole body turkeys from the tank when the plants HACCP monitor and I were at the Quality Control table documenting our task.&nbsp;He was putting the birds onto the incline conveyor which was taking the turkeys into the chilling tank.&nbsp;I had observed the attached&nbsp;WIP red tag prior going to the Quality Control table. The WIP tag had now been removed from the tank.&nbsp;&nbsp;(B)(6)&nbsp;when&nbsp;ask her if she had performed the CCP 1B check and released the birds she said she had not. (B)(6)&nbsp;also had not performed the task. U.S. Retain Tag NO:B43241031 was applied to the tank of whole body turkeys which had&nbsp;not been inspected per HACCP Plan. (B)(6)&nbsp;was notified of the noncompliance. She questioned the employee and found that the employee had misunderstood instruction regarding the WIP birds. She took immediate corrective actions. She had all of the birds in the tank reconditioned bird by bird with (B)(4)&nbsp;water spraying. The whole body reprocessed birds were released back to production flow at approximately 1450Hrs after verifying the plants appropriate corrective actions and reinspection by&nbsp;Ms.(B)(6). This observed incident of personnel not following the establishment's "Reprocessing Whole body Turkey's" WIP procedure is in violation to the Reprocessing Whole body turkeys HACCP Plan monitoring for CCP 1B. The in place CCP 1B is to comply with 9 CFR 381.65(e) zero tolerance for feces&nbsp;entering the chilling tank and also the plant's in place monitoring 9 CFR 417.2(c)(4). This noncompliance is being linked to noncompliance (#146) JDD4201114502N/1 dated 11/1/2013 for the same cause respectively.&nbsp;</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM001601 3220N-1	01/20/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	At approximately 1342 hours while performing HACCP task (the record review component of procedure for fully cooked-not shelf stable process), I observed the following noncompliance: Line ^{(B)(6)} while review the records of CCP-2B last check was made at 1338 hour all the entries were documented beside product description. I notified the ^{(B)(6)} and ^{(B)(6)} about the non-compliance. This does not meet the requirement of 9 CFR 417.5(a)(3) which states: "The establishment shall maintain: Records documenting the monitoring of CCPs and their critical limits, including the recording of the actual times, temperature, or other quantifiable values, as prescribed in the establishment's HACCP plan; the calibration of process-monitoring instruments; corrective actions, including all actions taken in response to a deviation; verification procedure and results; product code(s), product name or identity. Each of these records shall include the date the record was made". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
5568	M20923	XUM302201 3820N-1	01/20/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On 01/20/2014, at approximately 19:02 hours while performing a directed HACCP Review in response to a deficiency on the Palletizing Dept. Line ^{(B)(6)} , I observed the following noncompliance: the metal detector kick out was overfilled causing the kick out platform to be stuck and remain in the open position. This condition caused all product to flow over the metal detector and product could not be rejected for possible metal contamination. The palletizing line operator failed to monitor the kick out box that was overfilled and caused the "Metal Detection Verification Procedure" to fail, a noncompliance per 9 CFR 417.5(a)(1). The establishment identifies metal contamination as reasonably not likely occur and controls metal hazards with the "Metal Detection Verification Procedure", however this prerequisite program failed to identify possible metal detection due to the condition of the metal detectors kick out platform. This identified that the program is not effectively controlling the hazard and the establishment may not have adequate support for the decision made in its hazard analysis for that production lot. I took regulatory control by retaining two combo bins and 42 cases of Mini Corn Dogs product code 95038 with US Tag # 24829878. I showed and informed Mrs. ^{(B)(6)} of the forthcoming noncompliance. After corrective actions were performed by production, I relinquished the US Tag at 01:25 hours on 1/21/14. The requirements of 9 CFR 417.5(a)(1) and the establishment's Metal Detection Verification Procedure were not met.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN162101 4918N-1	01/18/2014	01D01	SPS Verification	C	On January 13, 2014, and January 16, 2014, during a recent follow-up visit, an ElAO observed insanitary conditions in the picking room. The drain below the paw cleaning/brush machine was clogged with skin and water was unable to drain. At the time of the observations, a pool of water filled with paw skins, bits of tissue and other debris was observed to be approximately 5' -6' in diameter and from 2-4" deep. At both occurrences, plant management was notified and corrective actions were immediately implemented. This is noncompliance with Title 9 CFR 416.1, 416.2(e)(4). QC was present at time of the observation and implemented immediate corrective actions. (B)(6) was informed of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN222201 0318N-1	01/18/2014	01802	Pre-Op SSOP Review and Observation	O	<p>An EIAO observed the establishment Quality Assurance employees conduct pre-operational inspection as per the establishments written SSOP. After the QC had completed their pre-operational inspection and released the area for product, the EIAO observed the following: Evisceration January 16, 2014 Fat on the door to the control panel where the QC applies their lock out tag out locks. Non food contact. A feather inside the control panel where the QC applies their lock out tag out locks. Non food contact &nbsp;A large piece of fat on the drain cover by the PAC machine. Non food contact Unidentifiable foreign material brownish green with the appearance of fecal on a small gray hose above the steps into Inspection station 1 (non food contact) and blood on the hydraulic hose to the station lift (incidental food contact) Unidentifiable foreign material small black and flaky in appearance on the A&B line evisceration machine drain pan Non food contact Feather, skin and cartilage on the paw conveyor (after the paw chiller) Food contact Fat and feathers on the Line B IOBW Food Contact Packaging January 16, 2014 Fat on the side of the (B)(4) dip tank. Non food contact. Pipe tape hanging from the junction of the hose to the tank non food contact. Tissue adhered to the plastic belt guide food contact. Fat on the tank exit frame non food contact. Fat and meat residue on the control panel/ electrical box non food contact A piece of fat on the roth line dark meat (b)(4) non food contact Fillet January 17, 2014 Fat and tissue dried to the side of the East Ice hopper non food contact. Meat residue on the bottom of the conveyor non food contact. Fat inside the Westside Incline Coveyor food contact Large piece of fat on the chute adjacent to the Westside Incline Conveyor Hard dark round piece of unidentifiable foreign material with the appearance of metal on Breast Processor 16, non food contact A piece of meat and fat on the Organic incline conveyor that is adjacent to the&nbsp; Front Half Delivery System Establishment had not run Organic material for "several months" according to plant manager. Fat on plastic 'cog' food contact. Large piece of meat in white buckets, food contact Unidentifiable Foreign Material with the appearance of black grease and fat on removable cutting boards. food contact. This describes noncompliance with Title 9 CFR 416.4(a), 416.4(b) and 416.13(c). The establishment took immediate corrective actions.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN262101 4418N-1	01/18/2014	01D01	SPS Verification	O	<p>On January 16, 2014, during a recent follow-up visit, an EIAO observed floors throughout the establishment in both production and non production areas exhibit pits, divots, holes, exposed aggregate, scratches and areas where steel rods are inserted through the floor, but are not readily cleanable. Holes range from approximately 1" to 2' in diameter and approximately 1/2" to 2" deep and contain dark water and solids at all times, including at pre-op. Sections of the floor in Fillet and Packaging have holes running under a layer of sealant, that when stepped on allow fluid that was trapped under the sealant to come out. The floor wall junctions throughout the facility exhibit cracks, standing water and are not readily cleanable. The walls throughout the establishment appear to have dirt and product residue adhered to the surface. The sections of wall constructed of white FRP are beige in appearance, and some areas exhibit black residue that is removable with gentle hand pressure. Further, there are numerous areas of the wall that exhibit rust. Throughout the establishment, there are areas of caulking that are peeling away from the wall, creating potential for pest harborage, and creating conditions that are not readily cleanable. Further, there is a section of the floor in evisceration that exhibits unidentified foreign material green in color with the appearance of algae. This is noncompliant with Title 9 CFR 416.2(b)(2). EIAO notified (B)(6) of the findings.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN452201 2818N-1	01/18/2014	01D01	SPS Verification	O	<p>On January 16, 2014, and January 17, 2014, an EIAO performed Employee / Employee Equipment Inspection (all items listed are food contact) with the QC representative present. 3 steels taken out of production due to rust, rough welds that are not readily cleanable with &nbsp;holes in the handles. 8 steels had loose blue plastic stuck at the point where the metal of the steel is encased on the plastic of the handle. Production Supervisor and QCs removed the plastic prior to production. 4 knives had tissue adhered to the blade, or between the blade and the pommel. 2 knives had loose blue plastic adhered between the blade and the pommel. 3 cut gloves had tissue and fat stuck in between the links. Additionally, the floor of the evisceration, Packaging and Fillet areas was littered with several pieces of fat, meat and sinew.&nbsp; This describes noncompliance with Title 9 CFR 416.1, 416.3(a). During a recent follow up visit from January 13, 2014, through January 18, 2014, an EIAO observed the following: A gap approximately 2-3" at the maintenance door Gaps at the base of the roll up door from 2-4" in the Picker room Gaps at the base of the doors leading into Live hang The doors to the outside in the auxiliary rooms off of the Fillet room are not maintained to prevent the entrance of vermin as they are locked open with a gap at the base of the doors Gaps at the base of the air vent in the boiler room ranging from 1" to 4" high and 2" to 1' long. This is noncompliant with Title 9 CFR 416.2(a) and 416.2(b)(3). Plant management was notified of the findings. On January 16, 2014, EIAO and FLS entered into the New Product Rooms and noted a foul putrid odor. The odor was identified as coming from the floor drain near the exit side of the Rotisserie area. Plant management including the Plant Manager, were present and observed the odor. Further, on January 15, 2014, EIAO entered into the Picking room to observe a QC check. The Picking room had a strong foul odor and was filled with steam to the extent that visibility was severely limited, creating potential safety concerns. Your establishment failed to provide ventilation adequate to control odors and vapors. This is noncompliant with Title 9 CFR 416.2(d). Plant management took immediate corrective actions.</p>
5112	M18909	JDD1208013 317N-1	01/17/2014	01D01	SPS Verification	C	<p>In Evisceration 01/09/2014, around 0845 I stopped both lines due to the water refuse drainage canal under the lines was full and overflowing into traffic pattern areas. Downtime about six minutes&nbsp;on the&nbsp;canal to drain and resanitize areas on both sides of the line.&nbsp;Ms. (B)(6), Mr. (B)(6), (B)(6), and Mr. (B)(6) were notified of the noncompliance. This is a violation of the above 9 CFR's.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2414012 218N-1	01/17/2014	03J02	Slaughter HACCP	C	<p>On 01/17/2014 at approximately 2013Hrs, I found the plant failed to meet the established Boning Room CCP 5B requirement of (b) (4). Using a company calibrated thermometer, I performed a physical verification check of the Heavy Tom Turkey Breast meat which was on the New Shipping dock. My findings were 50F, 48F, 50F & 48F, 46F, 40F. U.S. Retain Tag NO's: B43241029 & B43241030 were attached to the two tanks, containing Tom Turkey Brst 1, boneless, skinless without flt, with temperatures above 45F. The plant's Boning Room scan tags# T001913263 & T001912937 showed the tanks leaving the Boning Room at 14:01Hrs and 12:00Hrs on kill date 01/17/2014. (B)(6) was notified of the noncompliance and showed the temperatures above 45F. Mr. (B)(6) chose to add more CO2 and put the affected breast meat into the P-157 blast (B)(6). was notified and verified the temperatures above 45F. He also applied his Quality Control retain tags. The total affected product was 2918 pounds (B)(7)(C), CSI verified all sites of the product was below 45F at 0842Hrs on 01/18/2014. The establishment chose to run the University of Wisconsin PMP calculation and it showed no Salmonella outgrowth using the 1401Hrs & 1200Hrs found on 01/17/14 to 0030Hrs on 01/18/14 when product was 39F, per plant Q.C. record. The product was released back to shipping at 1620Hrs on 01/20/2014 after verifying the plant's corrective actions. The establishment has Salmonella Initiative Program (SIP), a waiver to 9 CFR 381.66(b). This waiver allows the establishment chill whole birds/parts to 45F in 8Hrs from slaughter. This observed incident of product temperatures above 45F exceeding the 8Hrs from slaughter is in violation to the plant's HACCP Plan at the Boning Department monitoring of CCP 5B which states in part; (B)(4)</p> <p>" The plants CCP 5B established company critical limit which states; (B)(4), was not sufficient in preventing temperatures above 45F. This noncompliance is being linked to noncompliance (#150) JDD5910114705N/1 dated 11/4/2013 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4508012 717N-1	01/17/2014	01D01	SPS Verification	C	On 01/14/2014 in the Old Shipping Dock around 0130HPST, I observed a stainless steel tank with a 1/2 inch crack in the corner with readily visible product residue in it. I informed Mr. (B)(6), of this issue. He indicated one of his people would take care of it. I waited until after PRE-OP was over and rechecked on it. It was missed and I tagged it, U.S. Reject Tag # B43241104. I then notified Ms. (B)(6) of it and it was taken to shop for repair. Later in the day, Ms. (B)(7)(C), C.S.I. released the Tag. This is a violation of the above 9 CFR's.
6036	P6164A	OIJ4601011 718N-1	01/17/2014	04A06	Poultry Finished Product Standards	C	On January 17, 2014 I, CSI (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is 25 points. My test at 2251 resulted in 42 points. At approximately 2320 a retest was performed by (B)(6) using a tighten criteria of 25 points which failed with 30 points. I verbally notified (B)(6) of the noncompliance and that I would be issuing a NR. The plant implemented the required procedures for FPS failure. The Prechill nonconformances I observed at 2251 were: 3 ingesta < 1/16" (3 pts), 5 partial oil glands (5 pts), 4 partial lungs (4 pts), 8 whole lungs (16 pts), 1 partial crop (2 pts), 1 trachea > 1" (2 pts), 2 small feathers (2 pts), 4 large feathers (4 pts), and 2 long hocks (4 pts). On December 12, 2013, NR # OIJ3913124612N (#85) was issued for processing noncompliance. The written response given that Maintenance made adjustments to bring the process under control were not effective to prevent recurrence. This noncompliance is linked to NR # OIJ3913124612N (#85) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the December 19, 2013 meeting.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN042201 3016N-1	01/16/2014	01D01	SPS Verification	C	<p>On January 16, 2014 at approximately 1550 hours while walking through Raw Side Cooler #2, I observed noncompliance with SPS Regulatory Requirement(s) 416.1 and 416.4(d).Raw Side Cooler #2:&nbsp;I observed beaded condensation along the overhead stainless steel strip next to the overhead refrigeration unit and also on the overhead entrance door to cooler #2 (product traffic area).&nbsp;I informed and showed Mr. (B)(6) and Mr (B)(6) , the noncompliance.&nbsp;At the time of my observation I did not see any condensation dripping and the product staged in the cooler was completely covered.Immediate corrective action was implemented by Mr.(B)(6) by having the overhead structures wiped down and monitoring the condensation for the rest of the shift.&nbsp;Sanitary conditions was restored at 1605 hours.&nbsp;This does not comply with Regulatory Requirement(s) 416.1 which states in part:&nbsp;Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure product is not adulterated", and 416.4(d) which states in part: "Product must be protected during storage".This noncompliance is linked to NR#LQN4803115908N/1 dated 11/8/13, for a similar noncompliance on condensation in the coolers. This document serves as written notification that continue failure to comply with regulatory requirement(s) 9 CFR Part 416 could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.</p>
5112	M18909	JDD5722013 015N-1	01/15/2014	01D01	SPS Verification	C	<p>On 01/15/2014 at approximately 1300Hrs while performing ante-mortem inspection task, I observed a noncompliance to 9 CFR 381.95(c). I observed 4 clean; edible, clear plastic lined combo bins containing edible foods products. The product filled the combo bins and&nbsp;no red color consistent with an application of visible denaturant was present on any of the food products in the combo bins. The chicken and turkey food products (breasts, paws, fillets, thigh, whole body birds and ground products) were outside near the plants condemn dump truck. All of the bins plastic liner were open with the food products exposed. The exposed food products had written on the bins&nbsp;PC- 1/13/14. The products appeared to have been frozen in boxes prior to being put into the combo bins. (B)(6) was notified of the noncompliance and shown the edible food products with no denaturant. Ms.(B)(6) found a plant employee who had noticed&nbsp;the bins of food product&nbsp;at approximately 0200Hrs. At approximately 1312Hrs the product was released&nbsp;after verifying the plants implemented corrective actions and the liberal denaturizing which was applied in&nbsp;my presence.&nbsp;</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM571401 2415N-1	01/15/2014	01D01	SPS Verification	C	<p>This morning approximately at 0745 hours, while performing PHIS routine SPS task (Other Inspection Requirements/ Facilities and Equipment Standard), the following noncompliance was observed: Line 1, Cook side of the establishment (b)(4) transfer belt metal cover has crack on one of the corner. I informed (B)(6) of the non-compliance. Immediately the part was revoved and sends it to the maintenance shop for repair. Poorly maintained facilities and equipment can and do harbor food borne pathogens, which can then multiply and be dispersed throughout the food processing environment increasing the chances of product contamination which can render product adulterated. 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that the product is not adulterated". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>
5129	M210	LQN240201 0814N-1	01/14/2014	01D01	SPS Verification	C	<p>On January 13, 2014 at approximately 1440 hours, I observed noncompliance with SPS regulatory requirement(s) 416.1, 416.4(d).Cook Side Film Room:&nbsp; I observed one roll of tan color plastic liners (food contact) with part of the roll&nbsp;laying directly on the floor.&nbsp;The tan color plastic is used to line the bins and tanks that edible product comes in contact with.&nbsp;U.S. Reject Tag NO. B38934386 was applied to the roll of plastic liners.&nbsp;Ms. (B)(6) was informed and showed the noncompliance.&nbsp;Ms. (B)(6) was also informed.&nbsp; &nbsp;Immediate corrective action was implemented by management :&nbsp;Ms. (B)(6) removed all of the plastic liners that was in contact with the floor and disposed into the trash.&nbsp;The rest of the plastic liners was properly wrap up.&nbsp;After sanitary conditions were restored U.S. Reject Tag NO. B38934386 was removed.This does not comply with Regulation 416.1; which states in part:&nbsp;"Each official establishment must be operated and maintained in a manner&nbsp;sufficient to&nbsp;prevent the creation of&nbsp;insanitary conditions and to ensure that product is not adulterated".This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3123010 513N-1	01/13/2014	01D01	SPS Verification	C	<p>On 01/13/2014 at approximately 1315Hrs, I was notified by Dr. (B)(7)(C), &nbsp;SPHV&nbsp;that Ms. (B)(6) and Ms. (B)(6), &nbsp;food inspectors, had just observed a live cock roach inside the U.S.D.A. break room. &nbsp;They saw the&nbsp;roach moving on the wall above the break table. The wall&nbsp;is connected to the plant's entry hallway. They called out as they tried to terminate the roach using a paper towel roll. Dr. (B)(7)(C) was near by and he was able to&nbsp;terminated the live cock roach when it landed on the table (B)(6) was notified of the noncompliance and showed the terminated cock roach. The roach was removed and the table was sanitized. She notified plant management. This observed incident of a live cock roach inside the establishment's break room is in violation to 9 CFR 416.2(a) Grounds and Pest Control and 9 CFR 416.2(b)(3) walls/floors/ceilings constructed to prevent entrance of vermin. The establishment does have in place a outside pest management service.</p>
5568	M20923	XUM251601 4013N-1	01/13/2014	01D01	SPS Verification	C	<p>This morning approximately at 1410 hours, while performing PHIS routine SPS task (Other Inspection Requirements/ Facilities and Equipment Standard), the following noncompliance was observed: Line 2, Cook side of the establishment one of the electrical motor of MFG conveyor belt is very rusty. I informed (B)(6) and (B)(6) of the non-compliance. Poorly maintained facilities and equipment can and do harbor food borne pathogens, which can then multiply and be dispersed throughout the food processing environment increasing the chances of product contamination which can render product adulterated. 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that the product is not adulterated". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM302301 4613N-1	01/13/2014	01C01	Operational SSOP Record Review	C	<p>On 1/13/2104, at approximately 2025 hours, while performing a directed SSOP Record Review inspection task in response to a deficiency in the QC Lab, I observed the following noncompliance: while reviewing the SSOP Monitoring Log dated 1/10/14 Shift 1, Part&nbsp;2 Operational Sanitation, Section 1 Raw Products, there was a response in the Comments Corrective portion of the Monitoring Log complete by QC employee with the initial's NX. The response stated, (B)(4)</p> <p>. I noticed that there was no condemn&nbsp;report attached to the SSOP form. This is a procedure that the establishment performs to show&nbsp;when product has been condemned for various reasons at the plant. I inquired with the night shift QC Dept. and the Production Management on the status of the 40 lbs of QC retained product.&nbsp;I was informed that no condemn report had been completed&nbsp;for the 40 lbs of exposed 95507&nbsp;Turkey Ground Meat product identified on the SSOP Monitoring Log and the status of the retained product was unknown, a noncompliance per 9 CFR 416.15(b) and&nbsp;416.16(a). I showed and informed Mr. (B)(6) of the forthcoming noncompliance. The requirement of 9 CFR 416.15(b), 416.16(a) and the establishment's SSOP Plan Part 2, Section 1, Implementation and Monitoring #3 were not met.</p>
5308	M6137	BXL3104010 912N-1	01/12/2014	01B02	Pre-Op SSOP Review and Observation	C	<p>On 01/10/2014 at approximately 2230 hours while monitoring Pre-Operational Sanitation standards in Plant 2, I observed the following. There was varying amounts of black UFM(Unidentified Foreign Material) that smeared like grease &nbsp;on the shackles and&nbsp;guide bars&nbsp;above the inflow section of the scalders for kill line. The shackles were cleaned with green pads and paper towels.&nbsp;The area&nbsp;was released by approximately 2257 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) and 9 CFR 416.13(c).&nbsp;&nbsp;</p>
5308	M6137	BXL5704014 912N-1	01/12/2014	01C02	Operational SSOP Review and Observation	C	<p>On 01/08/2014 at approximately 0115 hours whole monitoring Pre-Chill Finished Product Standards on line in Plant 2, I observed the following. After taking a standard 10 bird sample there was a piece of shiny metal measuring approximately 5mm by 3mm by 2mm attached to the connective tissue in the neck area of a carcass. I informed (B)(6). According to PDD, FSIS&nbsp;considers metal of any size on a carcass to be an unacceptable contaminant that should be addressed by the establishments' Hazard Analysis.&nbsp;The establishment has no metal detectors. The issue of metal contamination has been discussed at previous morning meetings with the establishment. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1815010 511N-1	01/11/2014	01802	Pre-Op SSOP Review and Observation	O	On 01/11/14 at approximately 0840 Hours while performing pre-operational sanitation verification in the Packaging Department with CSI (B)(7)(C), Dr. (B)(7)(C) observed the stainless steel product shoot lid at the end line (B)(4) having a cracked and broken hinge on one end. Regulatory control action was taken by applying U.S. Reject tag #B 39930856 to Line (B)(4) and informing (B)(6) and (B)(6) of the noncompliance to 9CFR 416.2(b)(1) regulatory control was relinquished at approximately 0920 Hours after lid and hinge were removed and area was cleaned and sanitized.
5308	M6137	BXL2517010 111N-1	01/11/2014	03J04	Poultry Zero Tolerance Verification	C	On 01/11/2014 at approximately 1444 hours, while performing the Zero Tolerance Task on Line (B)(4), I found visible fecal contamination on one of the ten birds I randomly removed. The fecal was located on the top side of the tail by the vent area. The fecal material measured approximately 1/8" in diameter in size, olive green in color and pasty in texture. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (B)(6) of the noncompliance and the protocol for fecal failure was implemented. Quality Control performed the recheck at approximately 1513 hours and passed, bringing the process back into control. My findings indicate a noncompliance with 9CFR 381.65(e), 9CFR 417.2(c)(4), and the critical limit of CCP2B, (B)(4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ0218014 611N-1	01/11/2014	06D02	Other Inspection Requirements	C	At approximately 2148 on 01-10-14, I, CS (B)(7)(C) performed the missing viscera test component of the regularly scheduled Other Inspection Requirements task. The maximum allowed missing viscera at the line speed of (B)(4) is (b)(4) and I observed 14. (B)(6) witnessed the test and I verbally informed her of the failed test results. At approximately 2210, I performed the retest for missing viscera and I observed 17 (B)(6). Swing Shift witnessed the retest. I immediately notified him of the failed test results, that I was taking the regulatory control action of slowing the line to (B)(4) as per (b)(4) requirements, and that a NR would be issued to document the noncompliance. At approximately 2216, I performed a missing viscera retest requested by (B)(6) to verify process control at the line speed of (B)(4). The maximum allowed missing viscera at the line speed of (B)(4) is (b)(4) and I observed 6. The line speed was increased to (B)(4). At approximately 2258, I performed the missing viscera test to verify process control at the line speed of (B)(4) and I observed 8. This NR is linked to NR # OIJ401114109N issued on swing shift, 11-08-13. Including this NR, there have been four linked Other Inspection Requirements NRs issued in the last 90 days for the same root cause. Maintenance adjustments in response to previous Other Inspection Requirements NRs were not effective in preventing this NR. Other Inspection Requirements NRs were most recently discussed and documented during a weekly Establishment Awareness Meeting on 11-21-13.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM372301 2910N-1	01/10/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	<p>On 1/10/2014, at approximately 1600 hours, while performing a routine scheduled HACCP Record Review inspection task in the QC Managers Office, I observed the following noncompliance: In the Fully Cooked Shelf Stable Whole Muscle / Diced Stripped Product hazard analysis the establishment identifies "Allergens" as a chemical hazard not reasonably likely to occur at the following steps in the hazard analysis; "Glaze Mix and Pre-Mixed" and "Glaze Mixing". The establishment implements a "Corporate Allergen Control Program" prerequisite program, which maintains that allergenic ingredients are identified and controlled were they are introduced into the process; that the hazard is not reasonably likely to occur. However, the establishment does not identify "Allergens" as a hazard, at all applicable steps in the hazard analysis. The establishment failed to identify "Allergens" at the following steps; "Pro Grill", "Cooking", "Dicing / Slicing", "Cooling and Freezing", "Scaling and Packaging", and "WIP product in combo / labeling". Allergenic ingredients are utilized at these steps in the process. Failing to identify all hazards at those steps does not comply with 417.2(a)(1) and also the failure to document the prerequisite program that prevents the hazard of undeclared allergens through cross contamination or mislabeling at the steps described does not comply with 417.5(a)(1) by not supporting the decisions that allergens are not reasonably likely to occur at those steps. The requirements of Title 9 CFR 417.2(a)(1), 417.5(a)(1) and the establishment's "Corporate Allergen Control Program" were not met. </p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA300901 0809N-1	01/09/2014	01D01	SPS Verification	O	<p>While performing a Sanitation Performance Standard Inspection in the establishment's Raw processing department the following noncompliance were observed: 1. At approximately 0426 hours in the raw/cook side transfer holding cooler there were 2 full pallets of cheddar cheese product stored slightly under the overhead air unit. The top row of boxes were observed with some heavily covered unidentifiable black gradual looking material and drip of clear liquid randomly scattered over the top portion of all the boxes in areas to numerous to count. The liquid and unidentifiable material appeared to have come from the air unit. Some (approx. 5) of the boxes of product were slightly opened. The palletized containers of product did not have any cardboard box slips protector or other materials on the top of the boxes to protect the containers from foreign elements. Further investigation confirmed that no product contamination was involved. (B)(6) was immediately notified. No retain tag was applied because immediate corrective actions were taken by the establishment. 2. At approximately 0431 hours in the raw storage cooler I observed 4 combos of "Low fat Chicken Product" with the date 01/04/14 stored directly under the 2 air units (2 combos under each unit). I observed some clear liquid (that appeared to be condensate) that was falling from the each air units directly onto the blue plastic cover that was over the product. Further investigation confirmed that no product contamination was involved. The ceiling of the raw storage cooler had heavy liquid condensation build up over approximately 1/3 of the area (B)(6) was immediately notified. No retain tag was applied because immediate corrective actions were taken by the establishment. -Raw (B)(6) was later notified of all the noncompliance and he assisted with the corrective measures. -The observed conditions did not meet the requirements of 9 CFR 416.1/Sanitation Performance Standards General Rule, 9 CFR 416.4(d)/Preventing insanitary conditions where product is storage, 9CFR 416.4(b)/Non food contact surfaces cleaning and 9 CFR 416.2(d)/Ventilation. -This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).</p>
5112	M18909	JDD3206015 313N-1	01/09/2014	01D01	SPS Verification	O	bygf76y

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM061201 0209N-1	01/09/2014	01B02	Pre-Op SSOP Review and Observation	C	At approximately 0705 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Cook side of the establishment: I found piece of chicken stuck on ishida scale bracket from the previous day of production. Upon continuing my inspection Line 1 (b)(4) transfer blue belt one of the bar underneath has few food particles also from the previous day of production. I took a regulatory control action and applied USDA retain/rejected tag# B24829883. I informed (B)(6) and (B)(6) and of the non-compliance. The finding described in the non-compliance was on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0745 hours. Plant SSOP Section1, page1, states: (B)(4). 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
5568	M20923	XUM322201 2709N-1	01/09/2014	01D01	SPS Verification	C	On 1/09/2014, at approximately 1928 hours, while performing a directed Sanitation Performance Standards (SPS) inspection task in response to a deficiency, I observed the following noncompliance: several cobb webs on the ceiling overhead exhaust fan cover in the Compacter Room of the Raw Area creating insanitary conditions, a noncompliance per 9 CFR 416.1 and 416.2(b)(3). I took regulatory control by rejecting the area with US Tag # 24829912. I showed and informed Mr. (B)(6) of the forthcoming noncompliance. After corrective actions were performed by production and sanitary conditions were concerned, I relinquished the US Tag at 2005 hours. The requirements of 9 CFR 416.1 and 416.2(b)(3) were not met.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA121401 0508N-1	01/08/2014	01C02	Operational SSOP Review and Observation	O	<p>On 01/08/14, while performing a Sanitation Performance Standard Inspection of the box rooms and shipping department to assure all product, equipment and product package containers were properly stored, I found the following noncompliance. 1. At approximately 0845 hours, I observed a pallet of partially covered and unprotected premade brown boxes, stacked approximately 7 rows high (to numerous to count) of the same unassembled box containers. These premade box containers have been observed in use in the packing area for direct handling/contact by the packing employees immediately before packing the ready to eat product. The pallet of premade boxes were partially (approx. 15-20) uncovered (exposed) with the possibility of being affected by foreign materials in the box room/shipping area (e.g. dust, fumes, hair, wood chips and etc.). The box room area is not required by the establishment GMPs for employees to wear hair covers/nets, or special footwear. The box room area is also used for continuous transporting of garbage/trash, chemicals, maintenance equipment, wood pallets, and pallet jacks and etc. The box room is an entrance point for the some employees from the outside (before covering the hair or changing footwear or garments). The conditions that the premade boxes were being handled and stored did not meet the requirements of 9 CFR 416.4(d). Employees (b) (6) was initially notified and (B)(6) was later notified and observed the pallet of boxes. No product contamination was observed. No regulatory control tag was applied because Employee (b) (6) took immediate corrective actions as instructed by the supervisor. 2. At approximately 0851 hours while inspecting the cook side dry ingredient storage cooler, I observed a pallet of dry ingredients (whole grain batter) that had one busted bag of product that had spilled onto the floor and frame of the storage shelf. The opening in the bag of product appeared to be approx. 4 to 5 inches in circumference and the opening in the bag left the product exposed. (B)(6) was notified. No tag was applied because I observed as immediate corrective action was taken by the establishment. -A similar noncompliance was observed on 09/17/13 and documented on NR #AOA3213091217N/1. The previous written further planned action that was provided by the establishment on 11/13/13 that states, (B)(4)</p> <p>appeared to be ineffective in preventing this noncompliance. -Continued failure to meet regulatory requirements can lead to enforcement actions described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2008014 008N-1	01/08/2014	01D01	SPS Verification	O	On 01/08/2014 at approximately 0350 hours, Line Food Inspector (B)(7)(C) observed a live cockroach when he was washing his gloves in the sink that it's located in Line 2 behind station #7 in Plant #1 during his USDA break time. The cockroach was running away from the sink. Food Inspector (b)(7)(C) caught the cockroach and contacted CSI (B)(7)(C). I informed (B)(6) and (B)(6) his finding. Cockroaches are carriers of bacterial contamination and disease which can spread to exposed product, and creates an insanitary condition. The sink was washed with potable water. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2 (a).
5310	M6137B	FFA2122010 908N-1	01/08/2014	01C02	Operational SSOP Review and Observation	C	On January 8, 2014 at approximately 1855 hours while performing my operational sanitation inspection in the Raw Side Blending/Rework area I observed noncompliance with SSOP Regulatory Requirement 416.13(c), and SPS 416.1, 416.4(d). I observed several small pieces of blue plastic casing on the re-work chicken franks product code 11005 dated 01/07/14. The chicken franks had already been cleaned and put into a clean cardboard bin ready to be used. U.S. Retain Tag NO. B34377425 was applied to this bin of Chicken Franks. Mr. (B)(6) was informed and showed the noncompliance and Ms. (B)(6) was also informed. At 2105 hours after the Re-work product was re-cleaned, and re-inspected U.S. Retain Tag NO. B34377425 was removed and product was released. This does not comply with Regulatory Requirement 416.1; which states in part: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated", 416.4(d); which states in part: "Product must be protected from adulteration during processing, handling, storage, loading, and unloading", and 416.13(c), which states in part: "Each official establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". This noncompliance report serves as written notification that failure to comply with regulatory requirement(s) of 9 CFR 416 could result in additional regulatory or administrative actions.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH540501 0808N-1	01/08/2014	03J02	Slaughter HACCP	C	<p>&nbsp;On the night shift that began on 01/07/2014, at approximately 0401 Hours, I was in the Evisceration Department, line #2, to perform Finish product Standards Verification for pre-chill standards.&nbsp; &nbsp; I randomly selected 10 carcasses at a collection point after the inside/outside rinse cabinet, designated by the Establishment as the point to collect carcasses for this procedure.&nbsp; There are no further interventions by the Establishment beyond this point.&nbsp;</p> <p>&nbsp; On the first carcass that I inspected, I observed a substance inside carcass, in the kidney area that appeared to be fecal material.&nbsp; I summoned Mr. (B)(6) and he agreed that the material was feces.&nbsp; The feces was approximately 1/16 inch in diameter to 1/8 inch in diameter and numbered 3 specks. The feces was brownish tan to dark brown in color and greasy to the touch.&nbsp; The material smeared easily to the touch. &nbsp; At approximately 0000 Hours I was informed that the cause of the deviation was investigated and found to be, (B)(4) " &nbsp; The preventive measure given was, (B)(4) &nbsp;</p> <p>&nbsp; &nbsp; The requirements of Regulations 381.65(e) and 417.2(c)(4) were not being met. &nbsp; Refer to NR#NHH3204011807N / 1, dated 07/07/2014, for similar non – compliance. &nbsp; All measures taken by the establishment to prevent recurrence to date have been ineffective or may not have been implemented properly.&nbsp; &nbsp;</p>
1326 1	M33901	HAY070301 3909N-1	01/08/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	<p>On the calendar date of January 8, 2014 at approximately 2210 hours while performing the Fully Cooked, Not Shelf Stable HACCP task, the following noncompliance was observed: I, CSI (B)(7)(C), reviewed the HACCP records generated on the previous days operations, 1/7/2014. The records included the results of the monitoring and verification procedures at the CCP's, the initials of the person who made the entries, and the time in which the entries were made. The records also show that product temperatures were monitored after midnight and the results are acceptable, as the temperatures met the critical limits prescribed in the HACCP plan. The results recorded after midnight were actually entered on 1/8/14. However, the "DATE" section of the record only contains "1/7/14, which indicates that all entries were made on the date of 1/7/14. Please be advised that records generated under the Raw, Intact HACCP Plan&nbsp;for the date of 1/7/14, which are recorded on the Individually Frozen In-Process Temperature Monitoring Log, also show entries made after midnight but the person(s) making the entries failed to record the date of 1/8/14 next to the entries. (B)(6) &nbsp;</p> <p>&nbsp; , was shown the noncompliance and she&nbsp;confirmed the findings. Ms. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3010012407N-1	01/07/2014	01802	Pre-Op SSOP Review and Observation	C	In Tray Pack 01/07/2014 during PRE-OP I observed poultry residue on center line product contact zone and the Pink UFM noted in the Q. C. Leaker Check Apparatus. This was pointed out to Mr. (B)(6) and Mr. (B)(6). This is a violation of the Establishment's written SSOP program and the following above 9 CFR's.. This is linked to NR 176-2013, Dated 12/14/2013, JDD0310124414N/1 and its Three Associated Links.
5308	M6137	BXL3808015307N-1	01/07/2014	01D01	SPS Verification	O	On 01/07/2014 at approximately 0458 hours, Line Food Inspector (B)(7)(C) observed a live juvenile cockroach when she was working on Line 1 on station #4 in Plant #1. The cockroach was crawling on the gray plastic tub that the company used to save the wings from the trimming. The tub was empty and turned upside down because it was almost company break time. Food Inspector (B)(7)(C) caught the cockroach and contacted CSI (B)(7)(C). I informed (B)(6) and (B)(6) of her finding. Cockroaches are carriers of bacterial contamination and disease which can spread to exposed product, and creates an insanitary condition. The area was washed with potable water. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2 (a).
5310	M6137B	FFA0416013507N-1	01/07/2014	01D01	SPS Verification	C	On January 7, 2014 while walking through the cooking area, I observed noncompliance with SPS regulatory requirement(s) 416.1, 416.2(d) and 416.4(b). At approximately 11:35 hours I observed beaded dripping condensation on the bottom side of the gray beams and iron rails between oven #3 and the (B)(4) chiller area no product was affected. I informed and showed (B)(6) and (B)(6) the noncompliance. They had an employee wipe down the condensation in my presence. This NR represents SPS noncompliance of the regulations cited above; as well as written notification that failure to comply with regulatory requirement(s) may result in additional regulatory or administrative action as described in 9 CFR 500.4. This NR is link to NR #FFA0216125111 Dated 12/11/2013 for a similar noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH211301 3607N-1	01/07/2014	01D01	SPS Verification	C	<p>On 01/07/2014 at approximately 1145 hours while performing an SPS task in the paw room/giblet chiller area, I observed that water from the top of the ice machine chute was splashing onto the ceiling and other overhead structures and dripping onto covered plastic totes used for product; water was also dripping from overhead structures onto the floor adjacent to an ice bin containing potable ice. The outside surface of the exit end of the neck chiller was also insanitary and contained numerous fat particles and brown grease; a section of the outside surface of the neck chiller contained an area of rust approximately 10-12 inches in diameter. Adjacent glycol pipes attached to the neck chiller had extensive rust and a brown greasy substance along 24 and 30 inch sections of the pipes. Additionally, there was a 12-18 inch crack in the plastic insulation around a large pipe at the end of the neck chiller; the exposed surface of the pipe contained extensive rust and a brown/black greasy substance. USDA Reject/Retain tag # B38075651 was assigned to these deficiencies. I advised Mr. (B)(6), of these issues and that a Non-compliance Record would be issued. There was no product contamination involved with this non-compliance. The establishment did not meet the regulation requirements of CFR9 416.1, CFR9 416.2(b)(1), and CFR9 416.2(b)(2), which states that the establishment will operate in a manner to prevent insanitary conditions and in good repair.</p>
1325 7	P33900	NHH320401 1807N-1	01/07/2014	03J04	Poultry Zero Tolerance Verification	C	<p>On the night of production that began on January 6, 2014, at approximately 0345 hours while performing a Poultry Zero Tolerance task at the evisceration line 2 pre-chill station, I found feces inside the third bird of a ten bird set. The feces was located on the inner ventral surface of the bird's abdominal cavity at the level of the keel. The feces was approximately 1/8 inch by 1/8 inch, was pasty in texture, and was dark green in color. (B)(6) was shown the carcass. (B)(6) informed me that the cause of the fecal failure was a broken shackle guide in the inside-outside bird washer. The establishment's measure to prevent recurrence was to replace the broken shackle guide. The establishment did not meet the regulatory requirements of 9 CFR 381.65(e) and 9 CFR 417.2(c)(4). Refer to NR #NHH0200014502N written on December 31, 2013, for a similar noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH240801 0006N-1	01/06/2014	01C02	Operational SSOP Review and Observation	C	<p>#3-14 At approximately 0718 while performing an operational sanitation observation and review task in the further processing areas I observed insanitary conditions in the thigh deboning/roastisserie department of room two. I observed whole thighs, fat and debris, and thigh trimmings along the wall, along the thigh deboning line and in the traffic area between thigh and roastisserie pack out conveyors. There was a massive pile of bones in the area thigh bones exit the deboning machine. The work area was totally congested with hardly any space to allow for wash down or cleanup of any sort while employees are working on the line. The requirements of 416.11 and the establishment's SSOP plan which requires (B)(4) . The line lead was notified and US tag #B38075641 was assigned to the noncompliance. The employees were removed from the line so that the floor area and stands could be washed to an area where the water and debris could drain properly. The line was released after sanitary conditions were restored. The same noncompliance was cited on 12/12/2013 and Management's response was that floor man will rinse the floor before leaving the production area. Employees were informed to push debris that is under the line to the wall and maneuver into a larger drain. Any efforts to do so either were unaccomplished or have been ineffective. Another noncompliance observed were insanitary conditions while wearing and storing aprons. In room one I observed two plastic hanging on the floor rack with the ties touching the floor. (B)(6) was notified. In room two there was one plastic smock hanging with the ties touching the floor. Another employee was observed walking to her work area with the garment untied allowing the ties drag over the floor. The establishment SSOP states that (B)(4) These requirements are not being met. The same noncompliance was cited on 12/19/2013 and efforts to prevent the recurrence of this noncompliance has been unsuccessful.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH450201 0006N-1	01/06/2014	04A06	Poultry Finished Product Standards	C	<p>2335 hours-01/05/2014-04C04-Chiller room, Line #2 exit end of chill system. &nbsp; On the night shift that began on 01/05/2014, at approximately 2318 hours, I monitored Procedure 04C04 (Finished Product standards for carcasses exiting the chill system).&nbsp; &nbsp;The test was being performed by (B)(6) on production line #2. On the initial test a score of 27 was obtained.&nbsp; This is 17 points above what is allowed for this test.&nbsp; Mr. (B)(6) performed a Verification check at 2326 hours with a result of 22.&nbsp; Action test at 2329 received a score of 11.&nbsp; &nbsp; Mr.(B)(6) informed the (B)(6) that the line was not in compliance and that the product needed to be retained for rework.&nbsp; For approximately four minutes Mr. (B)(6) and I observed product entering the room from the non-compliant line and being hung on the production line along with product from line #1.&nbsp; Mr.(B)(6) attempted to have the noncompliant product diverted from this line for approximately four and a half minutes before being successful.&nbsp; During this time product that was not eligible for production was being mixed with eligible product.&nbsp; &nbsp; (B)(6) was informed of the noncompliance, and he over saw the collection and retention of the product. &nbsp; &nbsp;</p>
1325 7	P33900	NHH010101 4504N-1	01/04/2014	01C02	Operational SSOP Review and Observation	C	<p>On the night shift that began on 01/03/2014 I was in the Evisceration Room at Establishment 33900&nbsp; P to perform a finished product standards procedure on Evisceration line #2.&nbsp; As I walked through the room on my way to the pre-chill station, I saw oily, black colored water dripping from the rail and the turn wheels on the #2 carcass line.&nbsp; This oily water was dripping from the greasy rail onto the carcasses below.&nbsp; &nbsp; &nbsp; Regulatory Control Action was taken by stopping the line and since the (B)(6) was present, he had the lines and turn wheels dried in a timely manner so On the production shift that began on 01/03/2014, at approximately 2140, I was in the no other action was taken at this time.&nbsp; I then released the line to production. &nbsp; The Preventive Measure given by Mr (B)(6) was that the line leads would inspect the shackle line before production begins. &nbsp; Mr. (B)(6) was informed that a Noncompliance Record would be issued documenting the noncompliance. &nbsp; For similar noncompliance refer to NR # NHH2204122803N / 1, dated 12/02/2013. &nbsp; The requirements of Regulations 416.1 and 416.13(c) were not being met. &nbsp; The Establishments SSOP plan objective is (B)(4)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3808012 403N-1	01/03/2014	01802	Pre-Op SSOP Review and Observation	O	<p>On 01/03/2014 at approximately 0100 hours while monitoring Pre-Operational sanitation in Packaging Area #1,I observed the following. There was a layer of pasty fat and tissue on a cutting wheel on the out flow side of Breast Processor #9. The wing section collection belt that runs under the breast processors had numerous specks and smears of black UFM(Unidentified Foreign Material) that smeared like grease. The area was recleaned and released by approximately 0115 hours.</p> <p>In Packaging Area #2, the (B)(4) the red fire fighting piping is severely deteriorated. The rust and peeling/flaking paint is extensive. At several locations the flaking rust and paint is in granular size pieces that easily falls off the tops of the pipes with the slightest contact.</p> <p>In many locations the fire fighting piping is directly over the lines creating an insanitary condition.</p> <p>At approximately 0130 hours in Plant #1 there was pasty fat and tissue on the metal support brackets and semi-dried yellowish UFM on the rubber fingers on Picker #2 on Line 2. The area was released by approximately 0135 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2922014 302N-1	01/02/2014	03C02	Raw Intact HACCP	C	<p>On 01/02/2014 at approximately&nbsp;1248Hrs, I performed a physical verification check of the Raw Not Ground Turkey Breast and Turkey Unsorted Skins which were weighed/scanned/loaded in a trailer for shipping to the establishment's Plant # 2. Using a company calibrated thermometer, I took the temperature of one Turkey 1 Brst, boneless, skinless, W/O&nbsp;FLT (3.50 - 5.00 weight)&nbsp;and one Turkey Unsorted skins container.&nbsp;The temperatures of the Breast were (B)(4) & (B)(4) and the Skins were (B)(4) & (B)(4). U.S. Retain Tag NO's:B39554882 & B39554881 were applied to the loaded affected Turkey Breast and Skins for temperatures above (B)(4) at shipping. (B)(6) , was notified of the noncompliance and verified my temperature findings at shipping. The (B)(4) Ice appeared not to be evenly dispersed over the turkey breast and skins. Mr. (B)(6) notified the plant Q.C. The establishment chose to add more (B)(4) to the affected (1912 pounds) of turkey breast and (1773 pounds) of turkey skins with kill date 1/2/2014 and with time 1217Hrs & 1225Hrs leaving the boning room. At approximately1505Hrs the turkey breast and skins were released back to shipping after verifying all of the food products temperature readings which were performed by (B)(6) were below (B)(4) This observed incident of turkey products being shipped above (B)(4) is in violation to 9 CFR 381.66(b) and 417.2(c)(4) monitoring at the critical limit. The establishment's supporting documentation for Salmonella Initiative Program (SIP) states: '(B)(4)</p> <p>(B)(4)</p> <p>The establishment's HACCP Plan at shipping states: '(B)(4)</p> <p>Since the supporting documentation for your SIP waiver states that (B)(4)</p> <p>and the SIP is used as justification in your HACCP Plan, a violation of 417.5(a)(2) also exists.&nbsp;This noncompliance is being linked to noncompliance (#156) JDD5604112312N/1 dated 11/11/2013 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0311011 602N-1	01/02/2014	04A06	Poultry Finished Product Standards	C	<p>On 01/02/2014 while monitoring the Establishment's Reprocessing Procedures on Line (B)(6) in Plant #1, I observed the following noncompliance. At approximately 0825 hours I randomly removed a 10 bird sample and found one split tail bird with airsacculitis exudates remaining in the bird. I informed (B)(6) of my findings and at approximately 0829 hours I took a 10 bird sample for my recheck. Out of the 10 bird recheck I found four birds with airsacculitis exudates remaining in the bird. I immediately took regulatory control action by stopping the line, and I informed (B)(6) of the noncompliance. The line was started and all missing tail and split tail birds were retained while corrective actions were implemented. I tagged the tank of retained birds with U.S. Retained/Reject Tag #B31406693, pending rework of the product. Quality Control performed a recheck at approximately 0839 hours and passed, bringing the process back into control. I removed my tag and released the product to Quality Control and she applied her "Hold" tag to the retained tank of birds. At approximately 0957 hours Quality Control performed a recheck on the retained tank of birds and passed, the birds were released back to production. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 381.84 and 9CFR 381.76(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5308012 202N-1	01/02/2014	01C02	Operational SSOP Review and Observation	C	<p>On 01/02/2014 at approximately 0425 hours while performing a direct observation function under Step 14 (b)(4) CCP-3B of the establishments' Notice of Deferral Verification Plan dated October 13, 2013, I observed the following. In the Rotisserie Room, I observed the injection process of the birds through packaging and labeling. While observing the Gas Flush part of the process, I observed that the stainless probes that are inserted into the plastic product bags to extract the air prior to sealing were coming into contact with the injected carcasses in the product bags. At approximately 0430 hours the injection process was completed and the establishment started to box out bulk packed product 00626 breast meat using the same Gas Flush machines. In the main Packaging Area the bulk product is packaged in to blue plastic 10 pound bags, placed into gray product baskets, crusted (chilled to 40°F or below) then held for the boxing process. The gray baskets that the bulk product is placed in are not treated as product contact surfaces. As the baskets of bulk product were being emptied in Rotisserie at approximately 0430 hours during boxing process I observed varying amounts of black and brown UFM (Unidentified Foreign Material) on the bottoms and sides of the baskets. The exterior of the blue plastic bags that the bulk product is packaged in that was in contact with the gray baskets was not being decontaminated in any way before being placed into the plastic liner before gas flushing. Again I observed the Gas Flush process and the stainless probes were coming into contact with the contaminated blue plastic bags that the bulk product is packaged in. As soon as the boxing of the bulk was finished the Second Processing Rinse began. During the Second Processing Rinse I observed packaging materials (boxes with plastic liners) were not covered/protected from over spray during the wash down. The establishments Second Process Rinse Procedure states under step (1) "(B)(4)". "I contacted (b)(6) and the affected liners in boxes on the conveyor belt behind the brown packaging belt area were discarded. I also observed that the sanitizer (B)(4) was not applied to the product contact surfaces, stainless probes, of the Gas Flush Machines 1-4. The Second Rinse Procedure states under step 5(a) (B)(4) (B)(4) and under (b) (B)(4). (B)(6) was contacted and an employee applied (B)(4) to the working surfaces on the 4 units. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.13(b), 9 CFR 416.13(c) and 9 CFR 416.15(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5708010 502N-1	01/02/2014	04A06	Poultry Finished Product Standards	C	On 01/02/2014 at approximately 0620 hours while performing the weekly monitoring of Reprocessing Line (B)(6) processes in Plant 1, I observed the following. After taking a standard 10 bird sample, I observed three birds with airsacculitis exudates. The exudates were inside the carcass on the keel bone near the interclavicular area. Of the random 10 bird sample 5 of the birds had split tails including the three with the visible exudates. The establishment has the tails split before the birds are placed on to line (B)(6) as an indicator that the carcass needs to be vacuumed for what ever reason. At this point the process is judged to be out of control. The line was stopped and Department (B)(6) was called. Adjustments were made to personnel and training was conducted. The line was restated and a recheck passed at approximately 0633 hours. The line was running at approximately (B)(4) (birds per minute) and there were two house inspection and three employees vacuuming at the time of the failure. My findings indicated a noncompliance with 9 CFR 381.84.
5308	M6137	BXL0717124 531N-1	12/31/2013	06D02	Other Inspection Requirements	C	At approximately 1238 hours while performing a presentation check on Line (B)(4) in Plant #2 I observed the following noncompliance. The first station on Line (B)(4) had (3) viscera on shackle and (1) contamination inside for a total of 30 nonconformance points. This exceeds the limit of (B)(6) points or 2 occurrences for one error for the process to be in control. I informed (B)(6) of the failure. QC did a recheck at approximately 1247 hours which also failed with (2) viscera on shackle and (3) not reflected, which exceeds the limit of (B)(6) occurrences for one error. The line speed was immediately reduced as per protocol (B)(4) to (B)(4). QC performed a recheck at 1307 hours that passed at (B)(4), the line speed was then raised to (B)(4). QC did another recheck at (B)(4) which passed, bringing the process back in control. My findings indicate a noncompliance with the regulatory regulations of regulation 9CFR 381.76(b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2013121 331N-1	12/31/2013	04A06	Poultry Finished Product Standards	C	<p>At approximately 1040 hours while monitoring the Establishments On Line Reprocessing procedure on Line (B)(4), I observed the following noncompliance. After taking a random 10 bird sample of split tails from Line (B)(4) I found 2 of the 10 birds had airsacculitis exudates remaining. The exudates were found on the inside of one carcass in the airsac on the left side and in the second carcass there was a large piece on the left flap that measured approximately 1/2" in diameter. I immediately informed (B)(6) of the noncompliance. (B)(6) immediately went and instructed personnel on the vacuuming procedure, as there were already 2 people vacuuming and the line was at (B)(4). I performed a recheck at 1050 hours which passed bringing the process back on control. My findings indicate a noncompliance with the regulatory regulations of regulations 9CFR 381.76(b) and 9CFR 381.84.</p>
5308	M6137	BXL3208123 831N-1	12/31/2013	03J02	Slaughter HACCP	C	<p>On 12/31/2013, while performing a HACCP Slaughter Review and Observation Task in Plant #2, Reprocessing Line (B)(4) I found a noncompliance with the following regulatory requirements of regulations of 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 0438 hours, I randomly removed a 10 bird sample from Reprocessing Line (B)(4) after the final house inspector station, I found one out of the ten birds with visible fecal contamination outside of the bird, on the right side by the tail area. The fecal material was green in color, pasty in texture and measured approximately 1/4" diameter in size. I immediately stopped the line and informed the Lead Person and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0444 hours and it passed. This is a violation of the critical limits of CCP-1B (B)(4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH020001 4502N-1	12/31/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On the night of production that began on December 30, 2013 at approximately 2136 hours while performing the Poultry Zero Tolerance task at the designated line 1 prechill station at establishment P33900 after randomly selecting 10 carcasses, fecal material was observed on the seventh carcass inspected. The fecal material was green in color, pasty in texture and easily smeared when touched. The three smears observed each measured approximately one eighth inch by one eighth inch and were located in the tail area. Mr. (B)(6) was notified of the finding and informed the noncompliance would be documented on a noncompliance record. According to the plant's investigation the cause of the noncompliance was the IOBW was not properly adjusted for the size of bird. The measure to prevent recurrence was (B)(4). The requirements of 9 CFR 381.65(e) and 417.2(c)(4) were not met. Refer to NR NHH2408125816N/1 dated December 16, 2013 for similar noncompliance. The measure to prevent recurrence for this noncompliance was maintenance will monitor the I/O wash height 2 times more during the shift. These measures may have been implemented incorrectly or may have been ineffective at preventing recurrence.</p>
5308	M6137	BXL2918124 830N-1	12/30/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 1537 hours while performing a Zero Tolerance task on Line (B)(4) in Plant #2, I observed the following noncompliance. After (B)(6) removed a standard 10 bird sample from the line, I observed 1 bird with visible fecal contamination. The fecal material was inside the carcass on the left side. It measured approximately 1/2" x 1 1/2" and extended from the left leaf fat to the kidney area above the tail. The fecal material was brownish green in color and thick and pasty in texture. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck after the line gap and it passed at approximately 1610 hours. My findings indicate a noncompliance with the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter, regulations 9CFR 381.65(e) and 9CFR 417.2(c)(4).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5108125 630N-1	12/30/2013	04A06	Poultry Finished Product Standards	C	On 12/30/2013, while performing Pre-Chill Finished Product Standards Task, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.84. At approximately 0548 hours, I randomly removed a 10 bird sample from Line B in Plant #2 for my FPS check. I found one out of the ten birds with visible airsacculitis exudates, the bird had split tail. The establishment marking system uses a split tail to mark the birds requiring vacuuming. At approximately 0553 hours, Quality Control performed a recheck and failed. (B)(6) found two out of ten birds with split tail containing airsacculitis exudates. QC informed the Line Supervisor and birds from that line were retained. At approximately 0600 hours QC performed another recheck and it passed. The retained product was reworked. (B)(6) was informed about the noncompliance.
5309	P6137A	NJN191212 4031N-1	12/30/2013	04A06	Poultry Finished Product Standards	O	While performing a finished product standards check at approximately 1130 hours, on the reprocessing line prior to the birds entering the chiller, I observed a noncompliance. In a sample of ten carcasses, there were eight carcasses with split tail (which identifies that vacuuming is required to remove all affected tissues including the kidneys). Three out of the eight carcasses had yellow gelatinous tissue inside, located beside the pelvic bone and on the flap area, and another two carcasses had parts of the affected kidneys not vacuumed. I immediately took regulatory control action by stopping the re-processing line and showed Mr. (B)(6), my findings and informed him of the forthcoming noncompliance. The presence of five carcasses with airsacculitis affected tissues out of eight carcasses indicates that the re-processing line was not under control. The plant failed to effectively apply their procedures for air-sac and comply with federal regulation 9 CFR 381.84.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5708125 428N-1	12/28/2013	03J02	Slaughter HACCP	O	On 12/28/2013 at approximately 0555 hours while monitoring Post-Chill Finished Product Standards from product exiting Chiller #4, I observed the following. After collecting a standard 10 bird sample I found one bird with visible fecal contamination. There was a gizzard with approximately 6" of intestine attached inside the carcass. The cut end of the intestine was visible at the opening to the abdominal cavity. There was fecal material leaking from the cut end of the intestine onto the left exterior side of the carcass on to the thigh area approximately 1" from the base of the tail (B)(6) was observing so I immediately showed him the carcass and the fecal contamination. The fecal material was a smear, medium brown in color and measured approximately 3/8" by 1/8" in size. The hanging of carcasses going into packaging was stopped. A recheck passed at approximately 0558 hours. A partial tank of carcasses was placed under QC hold pending reinspection (B)(6) was informed of the noncompliance. My findings indicated a noncompliance with 9 CFR 381.65(e) and 9 CFR 417.2(c)(4).
5308	M6137	BXL5901124 528N-1	12/28/2013	01D01	SPS Verification	C	On 12/27/13 at approximately 2319 hours I was giving an Inspector a break in Plant one, line #2, Station #7, when I noticed a juvenile cock roach sitting on the left side faucet. I stop the line, took a piece of paper towel and killed the roach.I then started the line and turn on my call light (B)(6) answered my light and I informed him of the cock roach. My findings indicate a non compliance with CFR 416.2(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN091412 5927N-1	12/27/2013	01D01	SPS Verification	C	<p>While performing the review and observation component of one Sanitation Performance Standard (SPS) task, I observed noncompliance with SPS regulatory requirement 416.1 and 416.4(d). At approximately 0857 hrs in the Raw Product Processing Department/Injection Area, I observed numerous flakes (approximately 20 count <math>\leq 1/16''</math>) of black unidentifiable foreign material (UFM) lying on the top surface of one large plastic bag which served to line one edible product stainless steel tank (# 562) and to protect the raw product contained within. I observed that the protective plastic material was partially draped back leaving a portion of the raw product contained within the tank exposed. Upon further investigation, additional black flakes of UFM (approximately 10 count <math>\leq 1/16''</math>) were observed lying on top of and in direct contact with random surfaces of the exposed raw product. Official regulatory control action was taken and U.S. Retain Tag No. B39554792 was used to retain the contaminated product (Turkey Breast Meat-Est. 157). (B)(6), was promptly notified who immediately implemented corrective action. I asked (b)(6) where the U.S. Retained tank of raw product had been stored prior to being staged in the Injection Area. (B)(6) stated that the tank had been retrieved from Raw Product Cooler #4. Upon appropriate product disposition, official regulatory control action was relinquished and the above cited U.S. Retain Tag was removed (1225 hrs.). A review of the establishment's written SSOP Program was performed. Section II. Operational Objective states, (B)(4)</p> <p>"A similar noncompliance with the same root cause (black UFM on raw exposed product and protective plastic covering in Cooler #4) was observed and documented on NRLQN3923085210N/1 dated 8/10/2013. Plant Management's elected written response states, (B)(4)</p> <p>This linkage serves to demonstrate that the preventive measures were either not implemented or were ineffective in preventing recurrence of SPS regulatory noncompliance (cross contamination of raw product). Note: To date Plant Management has proffered that the source of the black UFM has not yet been identified. This document serves as written notification that failure to comply with regulatory requirements in 9 CFR Part 416 could result in contamination or adulteration of product and insanitary conditions and could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0409121 927N-1	12/27/2013	06D02	Other Inspection Requirements	C	<p>On 12/27/2013 at approximately 0003 hours the inspectors on line (b)(6) were complaining about the way the carcasses were arriving at the inspection station. After checking the Presentation Log for the shift and finding no issues documented I performed the task and observed the following. The first station on line (b)(4) had (1) viscera not uniform, (5) viscera on shackle, (1) membrane, (3) not reflected, (3) parts inside for a total on 59 nonconformance points. This exceeded the limits of (b)(4) points or (b)(4) occurrences for one error for the process to be in control. A total of over 40 nonconformance points requires an immediate reduction in line speed. I contacted (b)(6) and informed him that the process was out of control. The line was slowed to (b)(4) birds per minute. The second station had (1) viscera not uniform, (2) viscera on shackle, (3) not reflected and (2) parts inside for a total of 32 nonconformance points. The third station had (1) viscera on shackle, (1) membrane, (2) not reflected and (4) parts inside for a total of 18 nonconformance points. A Quality Control recheck passed at 0010 hours at (b)(4) (birds per minute) and a second recheck at 0040 hours passed at (b)(4) bringing the process back into control. My findings indicated a noncompliance with 9 CFR 381.76(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ1021122 026N-1	12/26/2013	04B01	Labeling - Product Standards	C	<p>On 12-24-13 at approximately 1434, I, CS (B)(7)(C), was performing the regularly scheduled Labeling-Product Standards PHIS Task in the packaging area. I observed a pallet of twenty two cases of product &nbsp;# 090201 Frying Chicken Whole Breast located at the east end of the Rotis Area. I observed that some of the case's box end labels had a slaughter date of 12-23-13 and a Julian date of 357. According to the establishment's labeling procedure, the correct Julian date for 12-24-13 is 358. I did not know when this product had been packaged. To answer this question, at approximately 1438, I discussed the issue with (B)(6), and showed him what I observed in the Rotis Area. &nbsp;Mr. (B)(6) explained the product was part of an order of two hundred and thirty cases and had been slaughtered 12-23-12 and packaged 12-24-13. Mr. (B)(6) explained that two hundred cases were already on a trailer located at the shipping dock. At approximately 1439, I verbally informed Mr. (B)(6) that I was issuing a noncompliance record for the mislabeled cases with the wrong Julian date and applied US Rejected/US Retained Tag # B37852272 to one of the cases on the pallet. At approximately 1448, with the assistance of (B)(6), the two cases of product that had been mislabeled were relabeled with labels with the correct slaughter date and Julian date. At approximately 1449, I removed the US Rejected/Us Retained Tag from the cases and released the product back into the establishment's control. &nbsp;At approximately 1452, with the assistance of (B)(6), the two hundred cases of product # 090201 were located on five pallets inside trailer # 285 at bay # 3 at the shipping dock. I visually verified the labels on the cases had the correct slaughter date and Julian date. This NR is not linked to any recently issued NR for the same root cause.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ4509121 326N-1	12/26/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On December 26, 2013 at 0705 I, CSI (B)(7)(C) performed a routine scheduled Poultry Zero Tolerance task. I observed visible fecal material on one of the ten randomly selected carcasses. The 1/2" by 1/8" strip of dark olive green fecal material was found on the interior of the bird located along the right thigh/hip. Adjacent to the green fecal material was white urate approximately 1/8" in diameter. I verbally notified (B)(6) and (B)(6) of the failure and that a NR would be issued. The plant implemented their fecal failure program. The verbal response given as to the cause was a nozzle in the New York wash cabinet was not working. The nozzle was repaired. A retest by QC found no further incidence of visible fecal present. The verbal preventative measure given was that the New York bird wash cabinet nozzles will be added to the Maintenance machine checks required to be performed at every plant break. Records show that on December 4, 2013, NR# OIJ0908123505N (#84) was written for fecal found on a wing. The written response states the cause was the New York bird wash cabinet had a malfunctioning spray nozzle. The preventative action was that the New York bird wash cabinet was to be monitored every half hour until December 13, 2013. This NR is linked to NR# OIJ0908123505N (#84). The Establishment Awareness Meeting notes show the last time fecal noncompliances were discussed was on December 5, 2013.</p>
5308	M6137	BXL2807120 924N-1	12/24/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 12/23/2013 at approximately 2223 hours while monitoring the establishments Pre-Operational Sanitation standards in Plant 2, I observed the following. The Scalders at the end of line 1 were being drained for cleaning. As discussed at the morning meeting with management on 12/18 the establishments' SSOP Pre-Operational Sanitation procedure states in part (B)(4)</p> <p>A review of the SSOP Pre-Operational sanitation Implementation and Monitoring Log for the shift revealed that Plant 2 was released at 2213 hours by the SSOP for 'operations' although cleaning of the Scalders was not completed until approximately 2238 hours. At approximately 2226 hours there was a heavy yellowish pasty UFM(Unidentified Foreign Material) on the top of the guide bar associated with second Picker on line 1. The unit was recleaned and released by approximately 2232 hours. At approximately 2250 hours there were 3 hoses that each had several feet coated with a pink slimy UFM. The hoses are associated with the chiller aeration system. The hoses were disconnected and flushed restoring sanitary conditions by approximately 2256 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.13(c) and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2114125 923N-1	12/23/2013	03J02	Slaughter HACCP	C	<p>While performing Pre-Chill Finished Products Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4).At approximately 0957 hours, I randomly removed a 10 bird sample from Line (B)(6) in Plant #2, I found one out of the ten birds with visible fecal contamination inside of the bird, on the right leaf fat area. The fecal material was brownish in color, creamy in texture and measured approximately 1/8" diameter in size. This exceed the limit of Zero Tolerance for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1027 hours and it passed.This is a violation of the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.</p>
5112	M18909	JDD5907121 420N-1	12/20/2013	01D03	Poultry Sanitary Dressing	C	<p>On 12/16/2013, Dr. (B)(7)(C), at about 0230 H PST observed a bird from Tanked Off Birds being returned to line without washing off the Fecal Contamination. They were adding the affected carcass to the community vat, this is at the Hock Cutter/Rehang Station. Dr. (B)(7)(C) took control of the Carcass and had it reconditioned by Mr. (B)(6) prior to him putting it back on the line. Mr. (B)(6) and Ms. (B)(6) were notified of this issue and of our intent to document. The birds were tanked off because of the size (birds were abnormally small) and condition of the birds, Contamination with Fecal before and after opening the cavity. This in turn caused the Establishment to stop the kill line for while, tank off birds while getting caught up on the reprocessing of birds with Fecal Contamination that had been removed at the Two Inspection Stations. Noted: Later this Lot the Establishment stationed one employee on each line spaying fecal contamination off the carcass prior to opening. The contamination rate was 25%. This is a violation of of the Establishment written SSOP Program stating in (B)(4) " and the above 9 CFR's.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1323120 020N-1	12/20/2013	01C02	Operational SSOP Review and Observation	C	<p>On 12/19/2013 at approximately 0400 hours while performing a direct observation function under Step 10 (b)(4) CCP-3B of the establishments' Notice of Deferral Verification Plan dated October 13, 2013, I observed the following. At Rehang 1 at approximately 0400 hours I monitored the mid-shift Second Processing Rinse Procedure. At approximately 0440 hours according to (B)(6) the requirements of the process were met and packaging production resumed. I had monitored the area the entire time and the 'kickers' for the Check/Weight lines and the parts of the drip trays that drain back into the (B)(4) spray cabinets that are treated as product contact surfaces had not been rinsed or treated with (B)(4). I informed (B)(6) who called (B)(6), (B)(6) and (B)(6) and I repeated my observations. I was informed by (B)(6) that he was not aware of the requirement to (B)(4) the kickers or the drip pans so he would not do so today. I informed him that a noncompliance would be issued. A review of the Establishments' HACCP Plan - Raw Intact - Packaging Step 6 Sort/Size under Potential Hazard lists (B) Salmonella and then Is the Hazard Significant? YES. Under Justification for Decision it states (B)(4).</p> <p>Supplement 53 is listed as a supporting document. Supplement 53 states under procedure Step 4 (B)(4).</p> <p>The procedures in Supplement 53 regarding (B)(4) application were not implemented as written. My findings indicated a noncompliance with 9 CFR 416.13(b) & (c), and 9 CFR 416.15(a) & (b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2504120 519N-1	12/19/2013	01C02	Operational SSOP Review and Observation	O	<p>On 12/18/2013 at approximately 2220 hours after the area had been released from Pre-Operational Sanitation and while monitoring Operational Sanitation in the Rotisserie Room, I observed the following. There was an employee standing on the top of the (B)(4) Tank for the Injection Machine assisting with the assembly of the Injector Machine. The establishments' SSOP Section II and Operational sanitation under Implementation (B)(4)</p> <p>(B)(4) There was no plastic or other protective measure in use as the employee boots were in direct contact with the top of the tank. The SSOP and Operational Sanitation under Corrective Action a Plant Management Team Member under Restoration of Sanitary Conditions: (B)(4)</p> <p>(B)(4) "A review of the SSOP Daily Implementation and Monitoring log for the shift under Operational SSOP found everything acceptable for the shift. The lack of access to reassemble the machine was discussed with management previously at a weekly meeting. My findings indicated indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.3(a), 9 CFR 416.12(a), 9 CFR 416.14 and 9 CFR 416.15(b). and</p>
5308	M6137	BXL3617124 719N-1	12/19/2013	03B02	Raw Non-Intact HACCP	C	<p>On 12/18/2013, at approximately 1800 hours, while performing HACCP Raw Non-Intact Record Review Task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.5 (a)(3). The day before (12/17/2013) while performing direct observation on Raw Non-Intact task in the Rotisserie Room, I observed the following. During the mid-shift (lunch break) rinse, the HACCP monitor or designee measured the sanitizer concentration on five contact surfaces. The first check Quality Control had two failures, (each of (B)(4) of (B)(4) and the third recheck passed (B)(4) ppm of (B)(4). The second and the third regular checks passed. The fourth check had again two failures, (each of (B)(4) ppm of (B)(4) and the third recheck passed (B)(4) ppm of (B)(4). The fifth regular check passed. When I review the records, the HACCP Monitoring Log -CCP 3B- (B)(4), Raw Non-Intact, dated on 12/17/2013, PM shift, did not have any Corrective Action Log. I observed that the corrective actions were performed but not documented in the Corrective Action Log. I informed Quality Control (B)(6) about the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA1304124 619N-1	12/19/2013	01D01	SPS Verification	C	<p>On December 19, 2013 at approximately 0145 hours, after the establishment had finished their pre-operational sanitation inspection and prior to the start of operation, I observed noncompliance with SPS 416.1; 416.2(b)(1), and 416.4(b). While performing my pre-operational sanitation inspection on Oven #1 and Oven #2, I observed that at the exit end of oven 1 and 2 the overhead exhaust drip pans and supports have an excessive amount of what appears to be Rust and Smoke build up. I informed and showed (B)(6) the noncompliance. Ms. (B)(6), was also informed. This does not comply with Regulatory Requirements: 416.1; which states in part, "Each official establishment must operate in a manner to prevent insanitary conditions", 416.2(b)(1); "Establishment buildings, compartments must be kept in good repair", 416.4(b); "Non-food contact surfaces of facilities must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.</p>
1325 7	P33900	NHH501212 3119N-1	12/19/2013	01C02	Operational SSOP Review and Observation	C	<p>#200 At 0638 hours while walking down the hall to enter the evisceration area I observed two sleeved aprons hanging on the rack along the hallway were resting on the floor. The ties on these aprons are extremely long and measures need to be taken to prevent the ties from dragging on the floor hanging or wearing them. The rack in the further processing hallway also had three aprons hanging that were in contact with the floor. US tag numbers B38075647 and B38075646 were applied to the aprons. Management was notified and all the aprons that were contacting the floor were thrown away. The SSOP plan states that (B)(4) " This requirement and the requirements of requirements of 416.11 were not met.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1231 11	V210A	000061912 3519N-1	12/19/2013	04B05	General Labeling (V)	C	On December 19, 2013 while performing a visual inspection of "Chicken Paws" to be exported to Hong Kong I observed noncompliance with 9 CFR part 381.96 & 381.123 of the Meat & Poultry Regulations. At 16:45 hours I observed four pallets of product stamped with export MPJ#567367; the plant number on the label; P6137A was printed directly into the inspection bug and unclear to read; as well there were several cases of product where the plant number was tore off of the label all together, I was unable to determine the plant number. Mr. (B)(6) & Mr. (B)(6) were both verbally notified and shown the noncompliance. A regulatory control action; (RCA) was taken on the four pallets with U.S. Retain tags# B43241946, 47, 48, 49. At 18:30 hours when the plant implemented corrective action I relinquished the (RCA). This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions as described in 9 CFR 500.4.
1231 11	V210A	000430112 2319N-1	12/19/2013	01D04	SPS Verification (V)	C	On December 18, 2013, at approximately 1645 hours I was performing my export inspection on the boxes of product staged in the shipping dock at V210A. I observed that the lighting near door #5 where some of the product was staged to be inspected was not acceptable making it difficult to check the plant number, exports stamp number, use by dates, and labels on each box of product. I informed (B)(6) who accompany me when I performed my export inspection. Mr.(B)(6) informed me that he would notify his boss Mr.(B)(6).This is a violation of Regulation 416.2(c); which states in part: "Lighting of good quality and sufficient intensity is required in areas where product is stored or examined".This document serves as written notification that failure to comply with regulatory requirement(s) in 9 CFR 416 could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3505123 318N-1	12/18/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On 12/17/2013 at approximately 2200 hours while monitoring the Establishments' Pre-Operational Sanitation standards in Plant #1, I observed the following. There was a heavy layer of pasty yellowish UFM(Unidentified Foreign Material) on the stainless guide bar above the third Picker for line #2. The unit was cleaned and released by approximately 2210 hours. At approximately 2330 hours Packaging Area 1 in the Plant #1 Rehang area there was a thick coating of dried black and brown UFM on the guide bars for the Check /Weight line. An area approximately 6 feet long of the guide bars on the return side of line 1 & 2 and the spray assemblies at the same location were recleaned and released by approximately 0000 hours. At approximately 2340 hours there were several pieces of fat and tissue to approximately 1/4" on the inside surfaces of a stainless steel tank covered with blue plastic and staged for use near the outflow conveyor for Chiller 2. The blue plastic is used by the Establishment to identify tanks that are clean and ready for use. The tank was rinsed with potable water restoring sanitary conditions. At approximately 2335 hours there were numerous pieces of tissue to approximately 1" inside of the (B)(4) unit filter. The filter was rinsed with potable water and returned to service by approximately 2345 hours. (B)(6) was informed of the noncompliance. At approximately 0004 hours in Packaging Area #1 along line B on the blue product belt for the (B)(4) Dip system there was black UFM(Unidentified Foreign Material) that smeared like grease contaminating an area of the belt measuring approximately 1 square foot. There was also several pieces of tissue to approximately 1/4" on the stainless under the belt at the same location. There were several pieces of fat and tissue measuring to approximately 2" on the sprocket for the tray belt at the head of line B. The area was cleaned and released. At approximately 0010 hours there was fat and tissue to approximately 2" on the chain of Leg Processors 1-3. The machines were released by approximately 0015 hours. At approximately 0025 hours in Packaging Area 2, the (B)(4), there was black UFM (Unidentified Foreign Material) that appeared to be mold along the ceiling support beam near the vertical belt that transports breast fillets from the final trim table to Packaging Area 1. The area will be cleaned after production. (B)(6) was informed of the noncompliance. As discussed in the morning meeting on 12/18 the establishments' SSOP Pre-Operational Sanitation procedure under Monitoring states in part (B)(4)</p> <p>Yet for each area even with the SSOP log completed certifying that the area is 'released for operations' the USDA inspector is told by the area Sanitation Supervisor that the area is not ready with cleaning still in progress. The SSOP Pre-Operational Sanitation 'Implementation' daily procedure steps should</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							<p>routinely be completed before the 'Monitoring' step is performed. &nbsp;This issue was discussed with management at the morning meeting on 12/18/2013. My findings indicated a noncompliance with 9 CFR 416.1,&nbsp;&nbsp; 9 CFR 416.4(a)&nbsp;&nbsp;&nbsp;& (b), 9 CFR 416.13(c)&nbsp;&nbsp; and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3805124 018N-1	12/18/2013	01D01	SPS Verification	O	<p>On 12/17/2013 at approximately 2000 hours while monitoring the establishments' Operational Sanitation Standards in the Plant #1 Cooler, I observed the following. (b) (4) Refrigeration Unit W-1 mounted from the ceiling near the Staging Cooler door was in the defrost cycle. Thawing condensates were dripping from the bottom the the drip pan onto three pallets of brown product tubs of giblets staged directly below the cooler unit. The condensates were adding an untold number and variety of contaminants on the exterior of the brown product tubs that are handled during dumping by employees wearing green product contact gloves. The condensates were creating an insanitary condition. I contacted (B)(6) and showed him the noncompliance. A mechanic was called and after checking the computer he said that the unit was defrosting. The drip pan that should be collecting the condensates and directing them to a drain was leaking. I got a ladder and inside the drip pan was a large area of a blackened slimy mass of UFM (Identified Foreign Material). I collected some of the UFM and it consisted of plastics coated with a blackened grease like substance. The defrosting fluids were passing through the blackened mass before dripping from the leaking catch tray onto the brown product tubs. The tubs were moved and reconditioned with (B)(4) water. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).</p>
5308	M6137	BXL3817120 318N-1	12/18/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0858 hours while monitoring the shift change rinse procedure and (B)(4) application at the Plant #2 Post Chill Rehang area, I observed the following noncompliance. Production employees were rinsing and applying sanitizer (B)(4) to the product contact surfaces as prescribed in the SSOP Plan. A company employee was still rinsing Line #2 at Rehang 2 when he was asked to hurry up so (B)(4) could be applied at which time he stopped rinsing the line, without rinsing inside the drop chutes for carcasses to reach the lower belt. I then observed company personnel applying the sanitizer (B)(4) to Line (B)(4) the Bag Fryer line. When the employee was through with the line, I had observed that he had not sprayed inside the drop chutes that take birds to the lower belt, which is a product contact surface. I immediately informed QC and (B)(6) of the noncompliance. The SSOP Plan states in part under Second Processing Rinse Procedure that (B)(4) ". (B)(6) had a sanitation employee rinse the inside of the drop chutes on Line #2 and then had sanitizer (B)(4) applied to the inside of the drop chutes on Line #2 and the Bag Fryer Line (B)(4) as well, restoring sanitary conditions.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2621120 817N-1	12/17/2013	01C02	Operational SSOP Review and Observation	O	<p>On 12/16/2013 at approximately 1935 hours while monitoring Operational Sanitation in Packaging, I observed the following. There were employees deboning leg meat on line 1 and at the salvaged parts table adjacent to line 1 and placing the meat in blue plastic bags. The establishments' Notice of Deferral Verification Plan dated October 13, 2013 step 17 had the establishment install Acidified (B)(4) sprays on all lines. The HACCP Plan - Raw Intact - Packaging step 7. Cut/Deboning/Trim under (C) Chlorine and (B) Pathogens states 'The process is designed to reduce the risk associated with the hazard. (b) (4) (B)(4) (B)(4) Supplement 59 and has the (B)(4) sprayers monitored (b) (4) (B)(4) The SSOP Daily Implementation and Monitoring Log - Packaging for the shift showed that the last sprayer check in Packaging was performed at 1612 hours. The sprayers were not on as required by the establishments' Verification Plan. I contacted (B)(6) and a partial rack of leg meat was placed into 3 brown tubs to be treated and repacked. My findings indicated a noncompliance with 9 CFR 416.13(b) & (c) and the establishments' Verification Plan.</p>
5308	M6137	BXL2710125 717N-1	12/17/2013	03J04	Poultry Zero Tolerance Verification	C	<p>While performing Zero Tolerance Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). On 12/16/2013, at approximately 1243 hours, (B)(6) removed a 10 bird sample from Line #1 in Plant #1, I found one out the ten birds with visible fecal contamination, inside of the bird at the left side, close to the tail. The fecal material was brownish in color, creamy in texture and measured approximately 1/4" diameter in size. This exceed the limit of Zero Tolerance for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1312 hours and it passed. This is a violation of the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM580212 3617N-1	12/17/2013	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On 12/16/2013, at approximately 2020 hours, while performing a routine scheduled HACCP Records Review inspection task in the QC Managers Office, I observed the following noncompliance: while reviewing the Fully Cooked Shelf Stable Whole Muscle / Diced Stripped HACCP Program's Hazard Analysis dated 12/16/13, several process steps from the Refrigerated Storage Step to the Shipping WIP Product to FTP2 Plant or approved Co-Packer for High Pressure Pasteurization Step were missing the hazard of concern, a noncompliance per 9 CFR 417.5(a)(1). The hazard analysis did document the hazard as not likely to occur and establishment's reasoning / prerequisite program used, thus there were no food safety hazards identified with the establishment shipping adulterated product into commerce during that production. I showed and informed Mr. (B)(6), Production Superintendent of the forthcoming noncompliance. The requirement of 9 CFR 417.5(a)(1) was not met.
5112	M18909	JDD1523125 816N-1	12/16/2013	01B02	Pre-Op SSOP Review and Observation	C	On PRE-OP this date 12/16/2013 I observed the following: 1) Black Piece of Plastic 1/2 in long, on the End Chute off the Breast Sorting Belt. 2) Grease Zirk missing on bearing at Spiral Belt, this has been gone several days. 3) Product Residue on both side of the door between Cooler Five and Raw Fab. 4) In little Dry Storage Room off of Raw Fab, the racks there had Product Residue on them. 5) Broken Air Lines on bottom of Chiller B. Mr. (B)(6), Mr. (B)(6) and Ms. (B)(6) were advised of these issues and no note of these were seen in Q.C. POaperwork. This is a violation of the Establishments SSOP program and the above listed 9 CFR's. This linked to NR 176-2013, Dated 12/14/2013, JDD0310124414N/1 and its associated JDD Numbers.
5112	M18909	JDD5119121 417N-1	12/16/2013	03J02	Slaughter HACCP	C	On 12/16/2013 at approximately 1824Hrs while reviewing the establishments 12/14/2013 records in the Quality Control Lab as part of my Slaughter records task, I found the following noncompliance to the relevant regulations cited above. The (b)(4) (CCP 2B) -Gib Temperature Monitoring and Documentation Log dated 12/14/2013 showed that the shift B HACCP Monitor performed her temperature check at 1812Hrs. The record did not show the second required hourly temperature check for the 1800Hrs. The pre-shipment review at 0600Hrs on 12/16/2013 to ensure completeness was performed by plant management also the HACCP record was reviewed and verified on 12/16/2013 by Quality Control. (B)(6) was notified of the noncompliance by e-mail. Dr. (B)(7)(C) SPHV was also notified of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5907125 616N-1	12/16/2013	01C02	Operational SSOP Review and Observation	C	<p>Observed Boning Supervisor&nbsp;Ms. (B)(6) employee doing operational tasks of putting liners in tanks. I then checked the tanks and the employee had liners in&nbsp;five&nbsp;tanks that had product residue in them. Mr. (B)(6) was witness to the events.&nbsp;The tanks were then recleaned by Sanitation. Ms. (B)(6) was advised of the operational noncompliance as was Ms. (B)(6). There was not any previous documentation of this issue, &nbsp;prior to my notification of the same. Along the same issue Mr. (B)(6), employee is putting equipment into a dry storage area and the equipment has pieces of poultry residue too numerous to readily count. This was put in there, "&nbsp;not cleaned". This is a grinder and it is the (B)(6) office and Mr. (B)(6) &nbsp;is witness as to the condition of the grinder. This is a violation of the Establishment's written SSOP program, stating in part: " (B)(4) "</p> <p>" This is also a violation of the above 9 CFR's. This is linked 152-2013, JDD1623115706N/1, Dated 11/06/2013 and 158-2013, JDD3803110513N/1, Dated 11/13/2013 and both NR's associated JDD Numbers.</p>
5309	P6137A	NJN310312 1817N-1	12/16/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>At approximately 0049 hours, after the QC Technicians had performed Pre Operational Sanitation and released the area for production, I proceeded to perform Pre Operational Sanitation in Area 2-Packaging/ Section C: Segment Line & (B)(4). While doing so, I observed numerous pieces of fat and skin on and around Leg Processor # 2 as well as conveyors directly below LP #2. On a supporting structure above there was grease and fat build up from the previous day's production. I took immediate regulatory control action by applying US Rejected Tag # B 43303634 to the affected area and informed Mr. (B)(6) of the forthcoming Non Compliance Record. At 0103 hours, after the restoration of sanitary conditions, I reinspected and released the area. The establishment failed to adequately monitor the implementation of the sanitation SOP, which in turn created an insanitary condition. The findings represent a non-compliance with 9 CFR 416.4a, 416.4b and 416.13c.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH240812 5816N-1	12/16/2013	03J04	Poultry Zero Tolerance Verification	C	#199At approximately 0803 hours while performing a zero tolerance task on eviscerating two I observed feces inside the lower keel area of the first sample bird. It was approximately 3/16" in diameter, olive green in color with a pasty consistency. The bird was shown to QA, maintenance personnel, and Management. The establishment failed to comply with the requirements of CFR 381.65(e). After investigating the incident, according to the report,Maintenance found that the I/O wash was too low for the smaller birds and the probe not entering the cavity of the bird. It also stated that Maintenance will monitor the I/O wash height 2 more times during the shift.
5310	M6137B	FFA2100121 815N-1	12/15/2013	01D01	SPS Verification	C	On December 14, 2013 at 1510 hours while monitoring the operation in the Frank Peeling Area I observed insanitary conditions. I observed an excessive amount of product on the floor in front and underneath the Frank Peelers numbers 1, 2, and 3. I observed excessive amount of product on the floor underneath the Hoppers/Convery Belts to (b)(4) numbers 1, 2, and 3. At the time of my observation I did not see anyone cleaning up in this area. Mr. (B)(6) and Ms. (B)(6), was informed. Immediate Corrective Action was implemented by Management: Product was condemn and the floor was cleaned and sanitized.This does not comply with Regulation 416.1 which states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated", and Regulation 416.2(b)(2); which states in part: "Floors within the establishment must be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions". This NR is Linked to NR#FFA5818120006N/1 dated 12/06/13, for a similar noncompliance. As of today 12/14/2013, Management has not given a written response to this NR.This document serves as written notification that continue failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.
5112	M18909	JDD0310124 414N-1	12/14/2013	01B02	Pre-Op SSOP Review and Observation	C	1) Water Reuse Tank off of Chiller B had Poultry Residue in it. 2) Product Discharge Belt into Chiller A had Poultry Residue on it. 3) Product Residue and Rust in the Final Wash. 4) Hoses in I/O Wash One are frayed. 5) Overheads by Picker Three with Feathers > 10. Mr. (B)(6), Mr. (B)(6) and Mr. (B)(6) were notified of these issues. No documentation of these issues was observed in QC Paperwork. The is a violation of the Establishment's written SSOP program and the above listed 9 CFR's. This is linked to NR 172-2013, Dated 12/09/2013; 171-2013, dated 12/07/2013; 168-20132, Dated 12/02/2013 and their associated JDD Numbers.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0423125 514N-1	12/14/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 12/14/2014 at approximately 1730Hrs while performing my PHIS Zero Tolerance fecal check, I observed visible fecal material on the 10th bird sampled out of the ten whole body Light Hen Turkeys sampling test from line one. The feces was found on the left side of the distal pelvic cavity at the cavity opening. The fecal material was non granular; uniformly green in color, moist and pasty consistency with the distinct odor consistent with fecal material. The two fecal material pieces were at the same site one in front of the other. They were approximately 10mm x 3mm and 8mm x 3 mm in size. U.S. Retain Tag NO:B39554629 was applied to the affected carcass. (B)(6); (B)(6), (B)(6) and Dr.(B)(7)(C), SPHV were notified of the noncompliance and shown the affected carcass. Dr.(B)(7)(C) concurred that it was fecal material. Ms.(B)(6) immediately implemented the establishment's corrective actions. The had the affected turkey reconditioned by trimming and (B)(4) spraying and reinspection. At approximately 1836Hrs the turkey was released back to production after verifying the plant's corrective actions and reinspection. Ms.(B)(6) conducted her rechecks after the final wash and they passed. This observed incident of visible fecal material is a noncompliance to 9 CFR 381.65(e). Also is a violation to 9 CFR 417.2(c)(4) monitoring at the critical control point to ensure compliance to the established CCP 4B (B)(4) after the final wash and before entering the chiller. At approximately 2055Hrs the plants implemented corrective actions at the post chill were completed and passed by Ms.(B)(6) Ms.(B)(6) verified the checks per HACCP Plan. This noncompliance is a repeated noncompliance and is being linked to noncompliance (#173) JDD5422121809N/1 dated 12/9/2013; (#170) JDD2423120405N/1 dated 12/5/2013, (#167) JDD 1623110427N/1 dated 11/27/2013 and (#134) JDD5821101818 dated 10/17/2013 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5008124 214N-1	12/14/2013	04803	Labeling - Net Weights	C	<p>On 12/14/2013 at approximately 0540 hours while monitoring Weigh & Price, I observed the following. As the Night Shift was finished in Weigh & Price Production Supervisors and Quality Control were leaving for the Day. I left Weigh & Price to ensure other production areas were finished. I again passed through the Weigh & Price area at approximately 0550 hours on my way home when I observed establishment personnel boxing out product in Weigh & Price. I went to the Production Supervisors office and the Quality Control office but everyone was gone. I went to NCDC to see if a QC person was monitoring the Net Weight process. An employee placing the cases onto a pallet said QC already went home. I asked for a Supervisor and found (B)(6) in the NCDC loading area. I asked if he frequently operated without Quality Control personnel monitoring the Weigh & Price function. He said that Weigh & Price personnel normally do not go home so early. The employee palletizing the product said they were expecting approximately 40 cases. I checked a case of wings and a case of B/S breast for Net Weight compliance using a nearby QC Scale and found that none of the packages were in compliance (net or better). I explained (B)(6) at the scale that the weight on the consumer packaging label should be the weight of the product plus the tare. The product including 3 cases of 00510 wings for order 704201, 22 cases of b/s breast for order 708001 and 8 cases of 00510 wings for order 702500 were placed under USDA retained until being released for rework at 1719 hours on 12/16/2013. A review of the establishments computer showed that the last entries in Weigh & Price by Quality Control were made at 0512 hours and 0531 hours. No checks were made of the wings and B/S Breast packed at 0550 hours. A review of the establishments' Master Container Net Content Compliance Testing Program - RTC Plants under responsibility states 'It is the responsibility of QC personnel to follow this procedure when sampling product for net weight compliance purposes. There were no QC personnel available. The product was for a Sunday order and with the day shift coming in at 0930 hours until orders were filled there was no reason to by pass normal Quality Control Net weight procedures. My findings indicated a noncompliance with 9 CFR 442.1, 9 CFR 442.2 and NIST Handbook 133.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2423123 713N-1	12/13/2013	01D01	SPS Verification	C	<p>On 12/13/2013 at approximately 1323Hrs, I observed standing water/fluid approximately 3" deep at the Cooler #3 drain and extended outwards from the drain approximately 3' x 3'. The drain runs across the entire hallway. The floor drain appeared to be backing up in the cooler #3 hallway. At this time the Boning Room was performing a shift washdown. The wheels of three tanks which contained edible food products and 2 tanks of clean ice were staged in the standing water/fluids. (B)(6) was notified and observed the overflowing drain. Ms. (B)(6) called to the personnel in the Boning Room to check their drains. She had the cooler #3 traffic stopped. The affected area was cleared of the water/fluids (fat, skin, meat) debris. The area was cleaned and sanitized. All of the wheels were sanitized. The food traffic area resumed at approximately 1329Hrs. I observed the restored sanitary conditions no U.S. retain tag was applied. I did not observe any direct food product contact adulteration at this time of my observation. The standing water at the drain was creating insanitary conditions that may lead to product contamination and/or a potential cross contamination when the tanks are moved to production areas. This observation is in violation to the relevant regulation cited above. Joe Lemos, Supervisor was notified of the noncompliance.</p>
5129	M210	LQN301812 3513N-1	12/13/2013	01D01	SPS Verification	C	<p>On December 13, 2013 while performing a routine patrol of the oven control room I observed noncompliance with SPS regulatory requirement(s) 416.2(b)(1) & 416.2(b)(2). At 16:11 hours I observed three large cracks running down the east, white painted wall located at the end of (B)(4) chiller #3 and oven #7; two of the cracks had areas of paint beginning to chip away from the wall, the cracks run from the ceiling to the base of the wall. Mr. (B)(6) was verbally notified and shown the noncompliance. This NR serves as written notification of a SPS noncompliance; as well as notification that failure to comply with regulatory requirement(s) may lead to additional regulatory or administrative actions as described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA0817122 613N-1	12/13/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On December 12, 2013 at approximately 0130 hours, after the establishment had finished their pre-operational sanitation inspection and prior to the start of operation, I observed noncompliance with SSOP Regulatory Requirement(s) 416.13(c), SPS 416.4(a), and 416.4(b). While performing my pre-operational sanitation inspection in the Raw Side Department I observed Rust on the inside of the Large Spice Bin (product contact). I observed one small piece of meat on the inside surface of the stainless steel bucket that is used to measure and weigh ingredient (product contact). I observed several pieces of meat on the bottom side of the small dumper platform (non-product contact). U.S. Reject Tag NO. B38937058 was applied to the Bin and Bucket. Mr. (B)(6), Ms. (B)(6), and Ms. (B)(6) was informed and showed the noncompliance. Immediate corrective action was implemented by management. The Spice Bin, Stainless Steel Bucket, and Dumper was Re-washed, Sanitized, and Re-inspected. After sanitary conditions was restored U.S. Reject Tag NO. B38937058 was removed. This does not comply with Regulatory Requirement(s) 416.13(c); which states in part: "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's, 416.4(a); which states in part: All food-contact surfaces must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product", 416.4(b); which states in part: "Non-food-contact surfaces must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions". This NR is lined to NR#FFA5203122903N/1 dated 12/03/13 for a similar noncompliance on Pre-op Product Contact Surface. This document serves as written notification that continue failure to comply with regulatory requirement(s) of 9 CFR Part 416 could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH391312 5713N-1	12/13/2013	01C02	Operational SSOP Review and Observation	C	<p>#198At approximately 0842 while performing an operational sanitation observation and review task shortly after the beginning of the shift I observed insanitary conditions in the thigh deboning/roastisserie department of room two. I observed fat and debris, puddled water, thigh trimmings, and a pile of bones along the thigh deboning line and in the traffic area between thigh and roastisserie pack out conveyors. The work area was totally congested with hardly any space to allow for wash down or cleanup of any sort while employees are working on the line. There is also a problem with proper drainage in the area. The requirements of 416.11 and the establishment's SSOP plan which requires that (B)(4) (B)(6) was notified and US tag #B38075645 was assigned to the noncompliance. The employees were removed from the line so that the floor area and stands could be washed to an area where the water and debris could drain properly. The line was released after sanitary conditions were restored.</p>
5308	M6137	BXL0418122 312N-1	12/12/2013	03J02	Slaughter HACCP	C	<p>While reviewing the company computer records for CP's, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.5 (a)(1).The Salvage Parts Treatment (CP-19) for 12/11/2013, AM shift -Plant #1- had only three checks, at 0002 hours, 0254 hours and 0356 hours. The last check between the hours of 0500 and 0700 for that day was not performed. HACCP Plan -Slaughter Plant 1- under step #37 states in part: (B)(4)</p> <p>The process is designed to reduce the risk associated with the hazard. Parts are washed with (B)(4) water or (B)(4) to reduce bacterial contamination. Supplements 2,7,17,18,56. HACCP Supplement #56, Salvage Parts Treatment: CP-19 under procedure #4 states in part "(B)(4) (B)(6) was informed about the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3804125 712N-1	12/12/2013	01B02	Pre-Op SSOP Review and Observation	C	On 12/11/2013 at approximately 2137 hours while monitoring the Establishments' Pre-Operational Sanitation standards in Plant #2,I observed the following. There was a yellowish pasty UFM (Unidentified Foreign Material) on the fingersofthe second Picker on Line (B)(6). The fingers on the half of the unit randomly selected were scrubbed then rinsed with potable water restoring sanitary conditions by approximately 2145 hours. There was a heavy;laver of a yellowish pasty UFM on the fingersof the third Picker on line (B)(6). There were numerous pieces to approximately 1/8" of tissue and feathers on the guide bars associated with the picker.The guide bar and thefingers on the half of the picker randomly selected were scrubbed then rinsed with potable water restoring sanitary conditions by approximately 2230 hours. (B)(6) was informed of the noncompliance. This is a recurring issue that has been discussed with the Establishment at previous morning meetings andhas yet to beresolved. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c) and 9 CFR 416.14.
5568	M20923	XUM582012 1912N-1	12/12/2013	01D01	SPS Verification	C	On 12/12/13, at approximately 1811 hours, while performing a directed Sanitation Performance Standards (SPS) inspection task on the Cooked Area by the entrance to Line (B)(4) Iobserved the following noncompliance: an overhead dome light CL-4-18 with chipping paint directly over exposedproductbeing further processed on thetransfer conveyor beltcreatinginsanitary conditions, a noncompliance per 9 CFR 416.1 and 416.4(b). This condition could cross contaminate/adulterateexposed Pop Dog product being ran on the transfer belt in a post lethality processing environment. I took regulatory control by stopping the Line (B)(4) production and rejecting the area with US Tag # 24829894. I showed and informed Mr. (B)(6) of the forthcoming noncompliance. After corrective action were performed by production and sanitary conditions were restored, I relinquished the US Tag at 1832 hours. The requirements of 9 CFR 416.1 and 416.4(b) were not met.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ3913124 612N-1	12/12/2013	04A06	Poultry Finished Product Standards	C	<p>On December 12, 2013 I, CSI (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is 50 points. My test at 0942 resulted in 43 points. At 0950 a retest was performed by (B)(6) using a tighten criteria of 25 points which failed with 32 points. I verbally notified (B)(6) of the noncompliance and that I would be issuing a NR. The plant implemented the required procedures for FPs failure. The Prechill nonconformances I observed at 0942 were: 3 ingesta < 1/16" (3 pts), 6 partial oil glands (6 pts), 2 whole oil glands (4 pts), 4 whole lungs (8 pts), 1 trachea < 1" (1 pt), 6 trachea > 1" (12 pts), 6 small feathers (6 pts), and 3 large feathers (3 pts). On October 18, 2013, NR # OIJ2416101418N (#80) was issued for processing noncompliance. The written response given is that Maintenance made adjustments to bring the process under control. This noncompliance is linked to NR # OIJ2416101418N (#80) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the October 24, 2013 meeting.</p>
1325 7	P33900	NHH411112 2912N-1	12/12/2013	03J04	Poultry Zero Tolerance Verification	C	<p>#197At approximately 0837 hours while performing a zero tolerance task on eviscerating line one I observed feces inside the lower keel area of the ninth sample bird. It was approximately 3/16" in diameter, olive green in color with a pasty consistency. The bird was shown to QA, maintenance personnel, and Management. The establishment failed to comply with the requirements of CFR 381.65(e). After investigating the incident, Maintenance found that the (B)(4) bottom cam was too high causing the opener arm to push intestines to the front of the birds. The cam was lowered so it would not lift the bird to high.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH550012 5412N-1	12/12/2013	06D02	Other Inspection Requirements	C	<p>On the night shift that began on 12/11/2013, at approximately 2125 hours I was in the picking room of Establishment 33900 P. This Establishment uses a batching system of inspection, if the carcass is condemned or hung back for re-inspection the paw condemn button is pressed and a batch of paws are condemned. This insures that all paws from condemned carcasses are also condemned. I asked a picking room employee to block the electronic eye on both lines for a second. If the paws were put into the drain, this would prove the establishment could segregate and discard the affected paws. The result of the test was that the establishment could not collect any of the paws that are used to show that all condemned paws would be captured and condemned. I talked to Dr. (B)(7)(C) the IIC on night shift and explained what I had observed and informed him that I was going to reject the paw system. Regulatory Control Action was taken by applying USDA Reject Tag #B38075846 to the system.</p> <p>After repairs to the system, at approximately 2130, another test was performed on the line #1 system and the results allowed the Establishment to begin collecting paws at 2230 Hours, after the system had been rinsed with (B)(4) water. The requirements of Regulation 381.76(b) were not being met. Refer to NR NHH2504123402N / 1 dated 12/02/2013 for similar noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4420120 511N-1	12/11/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0915 hours while monitoring the Establishment's Second Processing Rinse procedure, I observed the following noncompliance. While observing the shift change rinse in the Rotisserie Room, I was watching a sanitation employee rinsing near the (B)(4) tank, which had been covered prior to the rinse procedure with blue plastic. I noticed the end of the (B)(4) tank has a bracket attached to it that the large screen sits in while in use and the plastic covering the tank had not completely covered the end of the tank where the bracket attaches to it. There was a gap approximately 1" wide x the width of the tank. While the employee was rinsing, overspray from water hitting the outside of the injection machine went into the (B)(4) in the tank in the form of spray and from dripping off of the plastic covering the tank. As the outside of the injection machine is not considered a product contact surface and is not cleaned as such, the overspray water contaminated the (B)(4). I immediately took regulatory control action and attached USDA Retain tag # B31 407354 to the tank. I immediately notified (B)(6) of the noncompliance. (B)(6) immediately had the employee drain the (B)(4) tank and rinse it, she then had them apply (B)(4) to the tank to ensure it was clean. The tank was then tested for (B)(4) the test strip read (B)(4), restoring sanitary conditions. I then released the (B)(4) tank back to production and removed my tag at approximately 0935 hours. My findings indicate a noncompliance with the regulatory regulations of regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5617122 811N-1	12/11/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0900 hours while walking past the Post Chill Rehang area in Plant #1, I observed the following noncompliance. As I was walking by Drop #3 I observed a bird on the top of an almost full cardboard bin with black UFM (unidentified foreign material) on the hock. Upon further investigation I found 3 more birds on the top with black UFM on the hocks. I immediately took regulatory control action and attached USDA Retain tag #B31 407355 to the bin and notified (B)(6) of the noncompliance. (B)(6) had the bin of birds covered and removed for rework. He then notified the company employees working the line at rehang to watch for birds with the black UFM on the hocks and put them in stainless steel carts for rework as well. The bin of birds was reworked and I performed a recheck which passed at approximately 1721 hours, at which time I removed my tag. USDA (B)(6) was advised of the noncompliance. (B)(6) on further investigation found numerous birds exiting Chiller #1 with black UFM on the hocks. (B)(6) immediately advised Quality Control personnel of his findings so that they could take corrective actions. The company took corrective action by reducing the line speed and having employees trim the contaminated parts for the rest of the day. At approximately 1010 hours while performing a Finished Products Standards task on Line 1B in Plant #1, I collected a random 10 bird sample from the line and found 4 out of the 10 birds with black UFM on the hocks. I immediately stopped the line and informed QC and (B)(6) of my findings. They immediately started checking the birds that were on the line for UFM and pulled them off for rework. They then notified the employees to watch for UFM on the hocks and clean them. At approximately 1022 hours QC did a recheck on the line and it passed, bringing the process back in control. My findings as well as (B)(6) findings indicate a noncompliance with the regulatory regulations of regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA0216125 111N-1	12/11/2013	01C02	Operational SSOP Review and Observation	C	<p>On 12/11/2013 at approximately 1330 hours while performing my Operational Sanitation Inspection. I observed the following noncompliance. In the oven area between the (B)(4) chiller and ovens 3 and 4 there was numerous beads of condensation dripping from the over head beams. I informed and showed (B)(6) and (B)(6) the noncompliance. At the time of my observation I did not see any condensation dripping into the Frank racks. Mr (B)(6) immediately moved any racks that were close to the affected area and began to wipe down the condensation in my presence. This does not comply with the establishment written SSOP program which states in part: Objective; (B)(4)</p> <p>. This is also a violation of Regulatory Requirement(s) which states in part: 416.1; "Operate in a manner to prevent insanitary conditions", 416.4(d); "Product must be protected during processing", and 416.13(c); "Plant monitors implementation of SSOP Procedures". This noncompliance report serves as written notification that failure to comply with regulatory requirement(s) of CFR 416 could result in additional regulatory or administrative action.</p>
1326 1	M33901	HAY120912 4211N-1	12/11/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On the calendar date December 11, 2013 (Wednesday) at approximately 0715 hours while performing the Pre-Op SSOP Review and Observation task in zone 4 the following noncompliance was observed: I, CSI (B)(7)(C) observed two pieces of fat/meat present on the product belt of the Injector machine that's set up on the Individually Wrapped Individually Frozen, Line (B)(6). The pieces fat/meat had a brownish color and ranged from 4/16" to 7/16" in size. This belt is a product contact surface. The Injector Machine was rejected with U.S. Rejected tag #B39506491. Mr (B)(6) and Ms. (B)(6) were informed and shown the insanitary conditions. I informed Mr. Blanch that the conditions present on the equipment was from previous operations, he immediately had (B)(4) sanitation workers to reclean the Injector Machine. At 0730, zone 4 was released after equipment had been cleaned and sanitized. The establishment's SSOP, states that (B)(4)</p> <p>"Regulatory requirements were not met for 9 CFR 416.13(c) and 416.11. For similar noncompliance record with the same cause, refer to NR HAY1116095219N/1 dated 9/19/13 where the Plant Management Response states "the affected pieces of equipment were recleaned, rinsed, re-inspected, passed and sanitized."</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3814124 510N-1	12/10/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0850 hours, while monitoring the change-shift rinse procedure at the rehang area #2, I observed the following (B)(4)</p> <p>(B)(4) Two carts and a table that the USDA Graders used to inspected the birds for Grade A, located at the beginning of the sorting lines were not sanitized with (B)(4). The table that USDA used to performed the FPS post-chill check and is located between the chillers was also not sanitized with (B)(4). The SSOP Plan states in part under Second Processing Rinse Procedure that (B)(4)</p> <p>(B)(6) was nearby and I asked her if the area was finished, she had all her checks done and sanitation personnel were also finished. I informed (b) (6) about the noncompliance. She informed (B)(6) of the deviation. (B)(6) and sanitation employees, rinsed and sanitized the carts and the tables. At approximately 0915 hours the area was released. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.13 (b) and 9CFR 416.13 (c).</p>
5308	M6137	BXL5317123 410N-1	12/10/2013	03J02	Slaughter HACCP	C	<p>At approximately 1400 hours while performing HACCP Slaughter Record Review Task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.4 (a)(2)(iii). The HACCP Monitoring Log-CCP 1B-Salvage Parts Inspection dated on 12/06/2013, Plant #2 AM shift "Records Review" was not performed by Quality Control or designee. The HACCP Plan Slaughter Plant #1, States in part under Verification Procedures that (B)(4)</p> <p>(B)(6) informed of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2123123 409N-1	12/09/2013	04B01	Labeling - Product Standards	C	<p>On 12/09/2013 at approximately 1552Hrs, I observed a noncompliance to 9 CFR 381.129(6)(i) in that "Raw poultry product whose internal temperature has ever been below (b)(4) may not bear a label declaration of "FRESH". Raw poultry product bearing a label declaration of "fresh" but whose internal temperature has ever been below (b)(4) is misleading. In the Bagging Department, I observed plant personnel taking (b) (4) Fresh Young Organic Turkey out of their bag. They took two birds to the line and put the birds into Fresh Young Turkey bags (Foster Farms) at the Bag Line. Using a company calibrated thermometer, I took the temperature of the two turkeys which were bagged on the line. My temperatures were (b)(4) and (b)(4). I notified (B)(6) and showed him my findings. (B)(6) and Dr. (B)(7)(C) SPHV were notified of the noncompliance. U.S. Retain Tag NO:B39554627 was applied to the birds found with temperatures below (b)(4) Ms. (B)(6) took temperature of the (b) (4) Fresh Turkey's. She found ten more birds with temperatures (b)(4) & (b)(4) She had all 12 birds with temperatures below (b)(4) put into a tank. She will notified Boning Room Supervision of the issue. The retain tag will remain pending plant decision.</p>
5112	M18909	JDD3707124 809N-1	12/09/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>At 0200 H PST I was asked to do PRE-OP in Boning Room and I observed the following issues: 1) By wing belt, the overheads had black UFM on it., 2) 2nd grinder for MDP had poultry residue on it., 3) Conveyor off of Drum Machine had peeling surfaces coming off of the Cutting Board Type Material., 4) In Raw Fab the Switch on the Stand for large grinder had poultry residue on it. Mr. (B)(6), Mr. (B)(6), and Mr. (B)(6) were notified of the noncompliances. No documentation of these was observed. Mr. (B)(6) was also advised of missing wear guides on conveyor feeding the MDP PRE-GRINDER. This is a violation of the Establishment's written SSOP program and the above 9 CFR's. This is linked to the following NR 171-2013, Dated 12/07/2013, JDD3907120807N/1 and it's associated JDD numbers.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5422121 809N-1	12/09/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 12/09/2013 at approximately 1825Hrs while performing my PHIS Zero Tolerance fecal check, I observed visible fecal material on the first bird sampled out of the ten whole body Consumer Tom Turkeys sampling test. The feces was found on the upper third of the right thigh in front of the longitudinal axis of the thigh bone or femur. The fecal material was non granular; uniformly green in color; moist and pasty consistency with the distinct odor consistent with fecal material. The fecal material was approximately 10mm x 3.5mm in size. U.S. Retain Tag NO: B39554628 was applied to the affected carcass (B)(6); (B)(6), (B)(6) and Dr. (B)(7)(C), SPHV were notified of the noncompliance and shown the affected carcass. Dr. (B)(7)(C) concurred that it was fecal material. Ms. (B)(6) immediately implemented the establishment's corrective actions. She had the affected turkey reconditioned by trimming and (B)(4) spraying and reinspection. At approximately 1913Hrs the turkey was released back to production after verifying the plant's corrective actions and reinspection. Ms. (B)(6) conducted her rechecks after the final wash and they passed. This observed incident of visible fecal material is a noncompliance to 9 CFR 381.65(e). Also it is in violation to 9 CFR 417.2(c)(4) monitoring at the critical control point to ensure compliance to the established CCP 4B (B)(4) after the final wash and before entering the chiller. At approximately 2138Hrs the plant's implemented corrective actions at the post chill were completed and passed by Ms. (B)(6). Ms. (B)(6) verified the checks. This noncompliance is being linked to noncompliance (#170) JDD2423120405N/1 dated 12/5/2013; (#167) JDD1623110427N/1 dated 11/27/2013 and (#134) JDD5821101818 dated 10/17/2013 for the same cause respectively.</p>
5308	M6137	BXL1018121 509N-1	12/09/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>While monitoring the Establishments' Pre-operational Sanitation Procedures in Plant #2 (Evisceration), I observed a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4 (b) and 9CFR 416.13 (c). At approximately 0658 hours while inspecting Area #2, picker 1- Line (B)(6) I found in the scalders (unit #5) that it is next to the picker, white/cream color residue in the water covering the entire scalders. The residue appeared to be melted fat. I went to check the scalders for Line (B)(4) (unit #8) and found the same issue. (B)(6) was informed. He immediately drained the water from both scalders and had sanitation personnel rinsed and scrubbed both scalders. At approximately 0723 hours, I reinspected and found them to be clean, I then released the area.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3417120 109N-1	12/09/2013	01802	Pre-Op SSOP Review and Observation	C	At approximately 0855 hours while performing Pre-Op SSOP review and observation task in the (B)(4) room I observed the following noncompliance. While inspecting the Breast Tender Harvester conveyor belts I observed a large piece of dried breast meat left over from the previous shifts production, which was 2 days prior. The piece of breast meat was approximately 1 1/2" x 1/2" in size, it was located on the small belt that dumps the tenders into bins and tanks, it was on the side of the bracket, the bracket is in continuous contact with the belt. I also found ground up breast meat on the ends of the brackets and multiple tiny pieces along the edge of one of the brackets holding the belt, between the belt and the bracket. I immediately informed (B)(6) of the noncompliance. (B)(6) immediately had a sanitation employee clean and rinse the belt and brackets, restoring sanitary conditions by approximately 0905 hours. My findings indicate a noncompliance with the regulatory regulations of regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4(d).
1325 7	P33900	NHH030312 4510N-1	12/09/2013	01802	Pre-Op SSOP Review and Observation	C	On the night of production which began on 12/09/2013, Inspection performed scheduled PHIS procedure Pre-op SSOP Review and Observation in the Further Processing Department of 33900 P. This was after Sanitation had finished cleaning the equipment and QA had finished their Pre-operational inspection of the equipment and released the area for USDA inspection. There are no additional Sanitation or Pre-operational steps prior to the start of production. The following noncompliances were observed: At 2328 hours while checking the Truss Conveyor (Zone #13-Unit #11), Inspection found the Conveyor (Product contact surface) in an unsanitary condition: Weld Spots and tiny gritty and grainy particles. Inspection took Regulatory Control Action by applying US Reject Tag #B3075666 to the Unit until it could be recleaned and reinspected, and was released at 0046 Hours. At 2338 Hours while checking the Case Scale Infeed Conveyor (Zone #15-Unit #17) and also a Product Contace Surface, Inspection found the surface of the Belt in an unsanitary condition with a thin layer of grease that appeared to be several days old and could be scraped off with the fingernail. Inspection took Regulatory Control Action by applying US Reject Tag #B38075671 to the Unit until it could be restored to a sanitary condition and released at 0000 Hours. The Requirements of 9CFR 416.13(c) were not being met and (B)(6) was shown the noncompliance and advised that a Noncompliance Record would be issued. The items of Equipment cited were Stumble-on Finds. For a similar noncompliance refer to NR #NHH2522113213N/1 dated 11/13/2013. To date, all Preventive Measures may not have been implemented as described or were ineffective in preventing recurrence.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH291712 3709N-1	12/09/2013	01D01	SPS Verification	C	<p>On 12/09/2013 while performing an export task on the front dock at approximately 1650 hours, I observed rain water dripping excessively from the overhead bay doors of bay # 3, # 4, and # 5. Bay # 3 was the loading bay for the export load, bay # 4 was partially loaded with other product and bay # 5 did not have a trailer in it at that time. There were no precautions being administered that I could see or was told they were using to prevent the dripping water from contaminating the boxes containing the product. The rain water was contaminated and it was dripping from an unsanitized area. I tagged the affected bays with U. S. Retain/Reject tag #'s B38075968 for bay's # 3 and # 4 as they were being utilized and U. S. Retain/Reject tag # B38075655 for bay # 5 that was not in use at the moment. I advised Mr. (B)(6), and they were tagged and a noncompliance would be issued. Mr. (B)(6) had maintenance hang plastic to divert the dripping water and I removed my tags allowing the establishment to resume loading product on the trailers. No product was contaminated. This clearly violates CFR9 416.1; CFR9 416.2(b); CFR9 416.4(d) which states the establishment must operate in a manner to prevent insanitary conditions, maintain sound construction, good repair, and sufficient size, and protect the product during processing, handling, storage, loading, unloading, and transportation.</p>
5112	M18909	JDD3907120 807N-1	12/07/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>At 0450 H PST in evisceration I observed the following 1): In final gizzard defatter was a rock and poultry residue. 2): Five pieces of poultry residue in the cross over belt to Chiller A. 3): Numerous feathers in picking room. 4) Rosier had dripping condensation from overheads in to unit and one bagged bird with bag torn open found in the Rosier. The carcass was condemned. This is a violation of the Establishments written SSOP Program and the above CFR's. Mr. (B)(6), Mr. (B)(6), and Mr. (B)(6) were all advised or shown the Noncompliances. No note of these issues were in Q.C. Documentation. This is linked to NR #165-2013, Dated 11/19/2013 JDD3504114321N/1 and it's associated Linking JDD # and NR # 168-2013, Dated 12/03/2013, JDD22001218031N/1 and it's associated linkages.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1007123 807N-1	12/07/2013	01C02	Operational SSOP Review and Observation	C	<p>On 12/07/2013 at approximately 0225 hours while monitoring the Establishments' Sanitation Performance Standards in Plant 1, I observed the following. There was a clear fluid dripping from the side of a ceiling mounted ventilation duct above the Check/Weight lines near the final trim station access to line (B)(6). The fluid was dripping on to a blue wheel that supports the chain for line (B)(6) and the dripping onto the carcasses passing down Reprocessing line (B)(6) just prior to entering the Chilling System. The fluid dripping from a leaking ceiling on to carcasses was creating an insanitary condition. I contacted (B)(6) who was nearby and showed him the noncompliance. The line was stopped. Carcasses on Line (B)(6) were tanked off and placed on hold pending reconditioning. Plastic was affixed at the location to direct the fluid to a drip pan. A QC red tag was placed on a partial tank of birds for reconditioning. A steady rain was observed falling during a Good Commercial Practices procedure conducted at approximately 0200 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1) and 9 CFR 416.4(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1407123 607N-1	12/07/2013	04B04	General Labeling	C	<p>On 12/05/2013 at approximately 2000 hours while performing a Labeling procedure in the Weigh & Price Cooler (Finished Product A & B) I observed racks of product in the general storage area as old as 11/29/2013. An employee was conducting an inventory at the time. I returned at approximately 2010 hours on 12/06/2013 to see if the old product had been culled. The cooler seemed to be colder than normal and my pocket thermometer registered temperatures between 22 and (B)(4) °F. Production was done so I waited until (B)(6) arrived at approximately 2145 hours. (B)(6) helped me with a company calibrated thermometer in the QC Office. In the Weigh & Price Cooler using the company calibrated thermometer I showed QC & (B)(6) the temperature of a couple of packages of Boneless Skinless Thighs that registered to (B)(4) °F. I told her I would take up the issue with the Weigh & Price Supervisor. At 2245 hours again using the company calibrated thermometer I showed Weigh & (B)(6) the temperatures of several packages of boneless skinless product. The product below (B)(4) was confined to racks with dates of 12/04/2013 to 11/29/2013 except for 5 racks of Organics located on the 'B' side of the cooler that were dated 12/05/2013. 12 racks of (b) (4) and Foster Farms boneless skinless product and two racks of (b) (4) thighs labeled "Fresh" were culled and placed on hold for being too cold to be labeled as fresh. A printout from Refrigeration indicated that the Weigh & Price Cooler temperature was below (B)(4) the monitoring station for the entire day. A review of the HACCP Plan -Raw Intact -Packaging Step 12 (Shipping) states in part "(B)(4)". Supplement 35 under 'Crust Tunnel' states (b) (4) is &lt; (B)(4) and Note: (b) (4) (B)(4) The Establishments' Weigh & Price procedure does not include monitoring of Shipping temperatures. A check of Foster Farms Refrigerated Status Report for 12/6/2013 lists a target temperature for Finished Product 'A & B' Coolers as (B)(4). While the log registers temperatures every 4 hours for PLT1, PLT2, NCDC, Deli and DC 2 Coolers there is no documentation for the actual monitoring of Finished Product Coolers "A & B". A computer printout from Refrigeration from 11/30/2013 thru 12/06/2013 indicated that temperatures in the Weigh & Price Coolers varied between approximately 20°F and 25°F at the monitoring station. The product was released on 12/09/2013 and 12/10/2013 for down grading to</p>

[illegible]

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA301412 1006N-1	12/06/2013	01D01	SPS Verification	C	<p>On Friday 12/06/13 at approximately 1350 hours while performing Sanitation Performance Standard Inspection in the Retail Fryer room area, I observed the extended space in the fryer room that is located to the left side of Fryer #8. In the open space beside fryer #8 I noticed there was evidence of a liquid substance that had run down the wall in two areas and there was some clear liquid dripping from the edge of the ceiling close to the beam that separated the open space from product fryer # 8. There were rainy weather conditions at the time of my observance. There were 3 unopened boxes of sticks that are used in the edible product process stored in the open space area. The unopened boxes of sticks were not affected by the unsanitary condition of the liquid substance. Production employee traffic was observed in the effected area however I did not observe any employees being affected by the falling liquid. (B)(6) and (B)(6) was notified. I observed as the unopened boxes of sticks were removed from the area and the maintenance department immediately closed the area off to stop any further production employees traffic until the process was under control. I observed as (B)(6) instructed the employees not to enter the effected area until corrective action were complete. No FSIS regulatory control tag was provided because I observed as (B)(6) took immediate corrective action. No product or product contact surfaces were affected. (B)(6) came by the FSIS office at approximately 1425 hours to inform me that the maintenance department had taken action in the ceiling to prevent any further leaking conditions in that area. He also said that maintenance would continue to monitor the area to assure sanitary conditions were maintained. -A similar noncompliance was observed on 08/22/13 and documented by Inspector (B)(7)(C) on NR#AOA1222081022N/1 dated 08/22/13. The preventive measure (further planned action) provided by the establishment that states, (B)(4) appears to be ineffective in preventing this noncompliance. -This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s). -Continued failure to meet regulatory requirements can lead to enforcement actions described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0518121 806N-1	12/06/2013	01D01	SPS Verification	C	<p>At approximately 1020 hours while walking through the packaging area, I walked by&nbsp;Line (B)(4) (the Leg Processors)&nbsp;and observed the following noncompliance.&nbsp;While walking by the leg processors I observed the bottom of the drip pan directly above Leg Processors #11,12,13 and 14 had what appeared to be heavy beaded condensation&nbsp;the full length of the drip pan.&nbsp;&nbsp;I was informed by the Line lead person that it was over spray from the shift change wash down that had not been cleaned.&nbsp;The over spray was dripping all around the line.&nbsp;I immediately informed (B)(6) of&nbsp;the noncompliance.&nbsp;(B)(6) immediately had a plant employee stop the line and remove the product from the line.&nbsp;&nbsp;(B)(6) then had sanitation wipe&nbsp;down the drip pan, restoring sanitary conditions.&nbsp;My findings indicate a noncompliance with the regulatory requirements of regulations 9CFR 416.1, 9CFR 416.2(d), 9CFR 416.4(b) and 9CFR 416.4(d).</p>
5310	M6137B	FFA5818120 006N-1	12/06/2013	01D01	SPS Verification	C	<p>On December 06, 2013 at 1520 hours while walking to the oven room I observed insanitary conditions.&nbsp;&nbsp;I observed franks all over the floor in front of Oven #1 and Oven #2.&nbsp;At the time of my observation I did not see any supervisor in the area nor did I see anyone cleaning up in this area.&nbsp;Ms. (B)(6) ., and Mr (B)(6) was informed.&nbsp;Immediate Corrective Action was implemented by Management:&nbsp;Product was condemn and the floor was cleaned and sanitized.At approximately 1533 hours after performing my product temperature check on product in oven number #3, I observed rust on the overhead beams in front of Oven #4 and Oven #3, I also observed on the overhead unit in front of Oven #4 Rust on the bottom of the unit drip pan (product traffic areas).&nbsp;This unit was brought to management attention in the weekly&nbsp;meeting dated 10/08/13.&nbsp;I left a voice mail for Mr. (B)(6) and also informed Ms. (B)(6) about the noncompliance.This does not comply with Regulation 416.1 which states in part: "Each official establishment must operate in a manner to prevent insanitary conditions", 416.2(b)(1) which states in part:&nbsp; "Establishment buildings, compartments must be kept in good repair", and 416.4(b) which states in part: "Non-food contact surfaces of facilities, equipment, and utensils must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product".This document serves as written notification that failure to comply regulatory requirement(s) could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM451312 3106N-1	12/06/2013	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 645 hours, while performing a routine Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Raw side of the establishment: I found few pieces of food particles on hopper pipe, from the previous day of production. Upon continuing my inspection: Line (B) I found small piece of food particles on hopper A , hopper B and C4 conveyor belt, also from the previous day of production. All finding described in the non-compliance were on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. I took a regulatory control action and applied USDA retain/rejected tag# B24829889. I informed (B)(6) and (B)(6) of the non-compliance. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0720 hours. Plant SSOP Section1, page1, states: (B)(4) (B)(4)". 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2423120 405N-1	12/05/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 12/5/2013 at approximately 1645Hrs while performing my PHIS Zero Tolerance fecal check, I observed visible fecal materials on the 7th. bird sampled out of the ten whole body light hen turkey sampling test. The fecal material was inside the turkey's pelvic and kidney area. U.S. retain Tag NO:B39554890 was applied to the affected carcass. The size of the fecal materials were approximately 1/2" x 1/4" on the turkeys pelvic cavity and approximately 1/4" x 1/8" in size on the kidney. The fecal was greenish in color, semi-solid in nature with the distinct odor consistent with fecal material. The line two ten bird random sample was collected after the final wash and before entrance into the chiller by the establishment's (B)(6). I notified and showed the fecal materials to Dr. (B)(7)(C), SPHV; (B)(6) and (B)(6) and Dr. (B)(7)(C) concurred that it was fecal material. Dr. (B)(7)(C) and I watched as (B)(6) using a knife removed the feces from the turkey. She put it on the top side of her left gloved hand. She moved the fecal around with the knife and smelled it. She then put the fecal back into the turkey (not in the site found and the fecal was not the amount that I had found). I hung the turkey inside the product wash cabinet for reconditioning and requested to be present for the reconditioning. Ms. (B)(6) conducted her required fecal checks after the final wash and they passed. At approximately 1730Hrs I watched (B)(6) put the affected turkey on the USDA table and then she took a picture of the fecal inside the turkey. She had the turkey reconditioned by (B)(4) and trimmed. The turkey was released back to production at approximately 1734Hrs after verifying the reconditioning and reinspection. This observed incident of visible-fecal material is a noncompliance to 9 CFR 381.65(e). Also is in violation to 9 CFR 417.2(c)(4) monitoring at the critical control point to ensure compliance to the established CCP 4B (B)(4) after the final wash and before entering the chiller. At approximately 2005Hrs the plant's implemented corrective action at the post chill were completed and passed by Ms. (B)(6). Ms. (B)(6) verified the checks (B)(6) was notified of the noncompliance. This noncompliance is being linked to noncompliance (#167) JDD1623110427N/1 dated 11/27/2013; (#134) JDD5821101818N/1 dated 10/17/2013 and (#112) JDD1623092204N/1 dated 9/4/2013 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0916121 505N-1	12/05/2013	04A06	Poultry Finished Product Standards	C	At approximately 1248 hours while performing a Poultry Finished Products Standards check on Line# [REDACTED] in Plant 2, I observed the following noncompliance. After removing a 10 bird sample from Line [REDACTED] found 3 birds with split tails with airsacculitis exudates remaining. I immediately informed [REDACTED] (B)(6) and [REDACTED] (B)(6) of the noncompliance. [REDACTED] (B)(6) asked me to do a recheck immediately, at which time I found 1 more bird with airsacculitis exudates remaining. [REDACTED] (B)(6) immediately started tanking birds, with all split tail and missing tail birds being retained. Another person was added to vacuum and I performed another recheck at approximately 1316 hours that passed, bringing the process back in control. QC put their hold tag on the tank for rework. QC rechecked the tank of birds and released it back to production at 1404 hours. My findings indicate a noncompliance with the regulatory requirements of regulations 9CFR 381.76(b) and 381.84.
5308	M6137	BXL2104124 805N-1	12/05/2013	01C02	Operational SSOP Review and Observation	C	On 12/05/2013 at approximately 0055 hours in the MV Cooler there was a partial stack of brown product tubs with a few specks of black UFM (Unidentified Foreign Material) on the outside. I separated several of the tubs and found more black specks inside. I observed the area for several minutes and production personnel were using the brown product tubs from another pallet closer to the door. The tubs were on a wooden pallet covered with blue plastic. A second stack of brown product tubs on the same pallet still had a lid on top and was partly wrapped with clear plastic. The plastic wrap is used by the establishment to identify clean product tubs. I contacted [REDACTED] (B)(6) and showed him the noncompliance. The tubs were taken to the tub wash room. In the tub wash room, I checked several more of the tubs from the affected stack and found two pieces of wood measuring approximately 1/2" by 1/8" in two separate tubs. There were also numerous specks of black and brown UFM to approximately 1/4" on several of the tubs. Approximately half of the tubs in the stack were dirty. A check of the Establishments' 12-05-2013 SSOP Daily Implementation and Monitoring Log for the shift in the MV Cooler at 2341 hours [REDACTED] (B)(6) found everything in the cooler to be acceptable. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH010312 5705N-1	12/05/2013	01C02	Operational SSOP Review and Observation	C	<p>On the night of production that began on December 3, 2013 at approximately 0408 hours while performing Sanitation Performance Standards verification activities in room 1 Further Processing, a plant employee was observed using a floor hose with his gloved hands to spray off his boots.&nbsp;The employee then went to the breast processor line and began putting product into the machine without washing or sanitizing his gloves.&nbsp;The line was rejected and the product retained with US tag B38075664.&nbsp;Mr. (B)(6), and Mr. (B)(6) were notified of the noncompliance.&nbsp;Inspection observed as sanitary conditions were restored to the breast processor and belts.&nbsp;The product, approximately 150 pounds of breast meat, was taken to the wash station and washed with (B)(4) water.&nbsp;Mr. (B)(6) stated "The employee would be retrained" as a preventive measure.&nbsp;The regulatory control action was then released.&nbsp;Mr. (B)(6) was informed the noncompliance would be documented on a noncompliance record and that due the staffing shortage and the associated time constraints the NR would not be issued to the plant until the following shift. Refer to NR NHH2202094917N/1 dated September 17, 2013 for a similar noncompliance.&nbsp;The preventive measure for this noncompliance was (B)(4).&nbsp;These measures may have been implemented incorrectly or may have been ineffective at preventing recurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0623123 204N-1	12/04/2013	01C02	Operational SSOP Review and Observation	C	<p>On 12/4/2013 1745Hrs Dr. (B)(7)(C), SPHV and (B)(6) went to the Quality Control Lab during our record review as part of my Operation Sanitation (SSOP) records review task for 12/2 & 12/3/13 dates. I found the establishment failed to make available the SSOP monitoring verification record performed by the plant Quality Control on 12/3/2013 for the "A" shift's Evisceration production. The shift "A" was scheduled for 7.87Hrs and was in operation for approximately 8Hrs. This production time of approximately 8Hrs with no available SOP monitoring verification record is a violation to 9 CFR 416.16(a) which states in part; "each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the Sanitation SOP's..." This is also in violation to the plant's page one: Personnel Responsibility Monitoring and Sanitation SOP's which states in part; (B)(4)</p> <p>" (B)(4)</p> <p>"&nbsp; (B)(6) pulled the records out of the plant's file for us. Dr. (B)(7)(C) verified that the record was missing from the 12/3/13 filed SOP's. (B)(6) was notified of the missing record. She looked for the record and when she could not find the record she notified (B)(6). Ms. (B)(6) also verified the record was not available. Ms. (B)(6) was notified of the record keeping noncompliance.</p>
5308	M6137	BXL2719122 104N-1	12/04/2013	03J04	Poultry Zero Tolerance Verification	C	<p>While performing Zero Tolerance Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 1317 hours, (B)(6) removed a 10 bird sample from Line #1 in Plant #1, I found one out of the ten birds with visible fecal contamination outside of the bird between the neck and the wing area. The fecal material was dark green in color, pasty in texture and measured approximately 1/4" wide by 3/4" long. This exceeded the limit of Zero Tolerance for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 1346 hours and it passed. This is a violation of the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3119122 104N-1	12/04/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1325 hours, while monitoring the mid-shift rinse procedure at the rehang area #1, I observed the following: (B)(4) as prescribed in the SSOP Plan. The drip pan that is attached to the (B)(4) cabinet at the rehang area #1 and is identified as a food contact surface, was not rinsed and sanitized. The SSOP Plan states in part under Second Processing Rinse Procedure (B)(4) ". This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.13 (b) and 9CFR 416.13 (c) (B)(6) and (B)(6) were notified about the noncompliance.</p>
5308	M6137	BXL4304123 504N-1	12/04/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 12/03/2013 at approximately 2200 hours while monitoring Pre-Operational Sanitation Procedures in Plant 1, I observed the following. There was heavy beaded condensation over a large area on the concrete ceiling between stations 4 and 8. The ceiling was mopped off by approximately 2220 hours. At approximately 2202 hours there was a pink colored slimy UFM (Unidentified Foreign Material) inside two air hoses used to agitate the chiller water for Chiller #2. The UFM filled several feet of each hose. The hoses were disconnected and flushed restoring sanitary conditions. (B)(6) was informed of the noncompliance. At approximately 2320 hours in Packaging Area 1, there were numerous black specks of UFM that smeared like grease/oil on the white wheels that hold the product during cutting on Leg Processors 4-6. There was pasty fat on the white nylon product portion of the ejector arm that moves the product from the shackle to the Leg Processor for Leg Processors 4 & 5. The area was recleaned restoring sanitary conditions by approximately 2325 hours. In Packaging Area #2, the (B)(4) Room, the white product cones on lines 1- are severely deteriorated with scuffs, scratches and deep cuts. The plastic pieces becoming part of the product is creating a Physical Hazard condition. The rough surfaces are also making it impossible to clean the cones efficiently. (B)(6) was informed of the noncompliance. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(a) and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM581412 3104N-1	12/04/2013	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 0715 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 2, Cook side of the establishment: I found pieces of chicken stuck on (b)(4) scale bracket from the previous day of production. I took a regulatory control action and applied USDA retain/rejected tag# B24829879. I informed sanitation (B)(6) and (B)(6) and of the non-compliance. The finding described in the non-compliance was on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0755 hours. Plant SSOP Section1, page1, states: (B)(4) 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>
6036	P6164A	OIJ0908123 505N-1	12/04/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On December 4, 2013 at 1333 I, CSI (B)(7)(C) performed a routine scheduled Poultry Zero Tolerance task. I observed visible fecal material on one of the ten randomly selected carcasses. PHV (B)(7)(C) verified my finding. The 3/4" by 1/8" strip of fecal material was found on the left wingtip area consisting of dark green creamy material. I verbally notified (B)(6) of the failure and that a NR would be issued. The plant implemented their fecal failure program. The verbal response given as to the cause was the bottom nozzle of the New York wash cabinet was not working. The nozzle was replaced. A retest by QC found no further incidence of visible fecal present. The verbal preventative measure given was that the New York bird wash cabinet nozzles will be checked every half hour until December 13, 2013. Records show that there have been no fecal noncompliances since August 29, 2013 which was caused by the PNT rollers. Therefore, this NR is not linked to any other NR. The Establishment Awareness Meeting notes show the last time fecal noncompliances were discussed was on September 5, 2013.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2200121 803N-1	12/03/2013	01802	Pre-Op SSOP Review and Observation	C	On 12/02/2013, I observed the following: (1) Belting needed trimmed up on Grader Belts; A and B.; (2) Poultry Residue on Contherm Seals, (3) Hand Wash sign in Boning by MDP is separating and appears to have mold growth, (4) Rusty Interior Motors and Pumps on all injectors, (I was told months ago they were to be sand blasted and reconditioned). (5) Observed a piece of loose plastic in Filter Part in Cooler Nine. (6) Six Stainless Steel Tanks from Sister Plant were found with product residue in them. (7) Yellow Checkweigh line has loose parts that need tightening. (8) Cracks in end chute off of the Breast Sorter. These were shown to Mr (B)(6) and or Mr (B)(6). Ms (B)(6) was advised of these issues. This is linked to NR 0125-2013, Dated 10/3/2013 and its linkages.
5308	M6137	BXL0217121 403N-1	12/03/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1030 hours while performing Zero Tolerance Fecal Task, I observed three out the ten birds from each line in Plant #1, with black UFM (Unidentified Foreign Material) on the hock of the bird. I went to performed a Post-Chill Finished Product Standards at the exit of the chiller and found more birds with UFM on them. For the past two weeks at the weekly meeting USDA informed Management about the issue. USDA documented on MOI # BXL0111113927G and BXL4619114320G that CSI's and Line Inspectors saw black UFM on the hock of the birds. At approximately 0500 hours CS (B)(7)(C) informed (B)(6) about the same issue. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.4 (a) and 9CFR 416.4 (d) (B)(6) was informed about the noncompliance.
5308	M6137	BXL5308122 903N-1	12/03/2013	03J02	Slaughter HACCP	C	On 12/02/2013 during the 0100 hour while performing a direct observation of the establishments' proffered IOBW Monitoring procedure from the Verification Plan, I observed the following. The Quality Control monitor performed a check verifying the sprayers, shower heads and pumps and the psi, timing, alignment, and improper shackling on the IOBW's on Lines (B)(4) and (B)(4). I did not observe her monitoring the IOBW on the reprocessing Line (B)(4). I later checked the computer records for the IOBW on Line (B)(4) and checks were performed at 1040, 1131, 1246, 0331, and 0425 hours. There was no record of a check being done at the 0100 hour, (lunch is during the 0200 hour). The Notice of Deferral Verification Plan #4 states in part (B)(4). I informed (B)(6) of the noncompliance. My findings indicate a noncompliance with regulatory requirements of regulation 9CFR 417.5(a)(1).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA5203122 903N-1	12/03/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On December 02, 2013 at approximately 0130 hours, after the establishment had finished their pre-operational sanitation inspection and prior to the start of operation, I observed noncompliance with SSOP Regulatory Requirement(s) 416.13(c) and SPS&nbsp;416.4(a). Raw Side Blending Room: I observed several specks of black unidentifiable foreign material on the inside surface of the Large Frank Hopper(product contact) and aslo several specks of black&nbsp;unidentifiable foreign material on one of the white shovels (product contact). U.S. Reject Tag NO. B38934391 was applied to the Hopper and Shovel. (B)(6) and (B)(6) was informed and showed the noncompliance. Immediate corrective action was implemented by management: The Hopper and Shovel was re-washed and sanitized. After sanitary conditions was restored U.S. Reject Tag NO. B38934391 was removed.This does not comply with Regulatory Requirement(s) 416.13(c); which states in part: "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's, and 416.4(a); which states in part: "All food-contact surfaces, must be cleaned and sanitized prior to the start of production". This NR is linked to NR# FFA1704092319N/1 dated 09/19/13 for a similar noncompliance on Pre-op Product Contact Surface. Management written response in Part:</p> <p>" Employee was instructed to inspect the equipment and re-clean when necessary", " Maintenance was asked not to handle the equipment until it has been released during USDA inspection and to re-sanitize food contact surfaces when necessary".This document serves as written notification that continue failure to comply with regulatory requirement(s) of 9 CFR Part 416 could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM171212 5603N-1	12/03/2013	01D01	SPS Verification	C	<p>At approximately 0945 hours, while performing a schedule routine SPS inspection task, on the cook side of the establishment, I observed the following noncompliance: Raw side of the production, I observed beaded and dripping condensation above air unit in front of wing cooler. I informed and showed to (B)(6) and (B)(6) of my finding. Immediate corrective action was performed by establishment upon notification of my finding. Plant SSOP Part 2 Operational Sanitation, Section 2, and Subsection B: Equipment and Facilities, Step 4 which states (B)(4). 9CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated". 9CFR 416.2(d) states: "Ventilation adequate to control odors vapors and condensation to the extent necessary to prevent adulteration of the product and the creation of insanitary condition must be provided". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>
6036	P6164A	OIJ1103121 903N-1	12/03/2013	01D01	SPS Verification	C	<p>At approximately 1843 on 11-30-13, while I, CSI (B)(7)(C), was performing the scheduled Raw Non Intact HACCP PHIS Task in the IF area, (B)(6), asked to speak with me. At approximately 1844, she showed me a leak from the elbow of a pipe containing (b)(4). It was located above and west of the box sealer in the IF area. I visually verified the leak did not directly contaminate product and was not in a high traffic area for moving or staging product. At approximately 1845, I verbally informed (B)(6) that I was issuing a noncompliance record. The (b)(4) pipe leak was the creation of a condition which may lead to adulteration of product. At approximately 1856, with the assistance of establishment employees, a red condemn barrel wrapped with yellow caution tape was placed below the leak. At approximately 1857, I applied US Rejected/US Retained Tag # B37852253 to the red barrel. At approximately 2335, I was informed by (B)(6), the leaking (b)(4) pipe had been wrapped with plastic by maintenance. At approximately 2336, I visually verified the (b)(4) pipe had been wrapped and I removed the US Rejected/US Retained Tag # B37852253 I had applied to the red barrel in the IF area. This NR is not linked to any other recent NR for the same root cause.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH180312 3304N-1	12/03/2013	03C02	Raw Intact HACCP	C	<p>On the night of production that began on December 3, 2013 while in the HACCP office performing the records review portion of the raw intact HACCP task, the following was observed in the hazard analysis for rotis product. At the (B)(4) recirculation step of the rotis hazard analysis a biological hazard (Salmonella) was identified but was considered not reasonably likely to occur. The basis for this decision is outgrowth of the organism is controlled by keeping the (B)(4) below (B)(4) nbsp; The (B)(4) temperature control program and results of the SIP sampling are cited in the HACCP plan at the (B)(4) recirculation step as supporting documentation for this decision. nbsp; Mr. (B)(6) , was asked how the cited supporting documentation could justify that reusing (B)(4) that had previously been applied to raw poultry, the excess collected and subsequently reused and reapplied to additional raw poultry would not introduce a microbiological hazard into the process. nbsp; Mr. (B)(6) indicated he had no explanation. nbsp; Reuse of the (B)(4) was not addressed elsewhere in the HACCP or SSOP plans or in any prerequisite program and there were no antimicrobial steps in the (B)(4) recirculation process. nbsp; The establishment was reusing (B)(4) at the time. Mr. (B)(6) was informed the requirements of 9 CFR 417.2(a) and 417.5(a)(1) and 417.5(a)(2) were not met and the noncompliance would be documented on a noncompliance record. nbsp; For a similar noncompliance refer to NR NHH1404070929N/1 dated July 28, 2013. nbsp;</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH220412 2803N-1	12/03/2013	01C02	Operational SSOP Review and Observation	C	<p>On the production shift that began on 09/18/2013, at approximately 2130, I was in the Evisceration Room Department at Establishment 33900 P to perform a finished product standards procedure on Evisceration line#2. As I walked through the room on my way to the pre-chill station, I saw an oily rust colored liquid on the floor under the viscera shackle line on the #2 viscera line. This oily water was dripping from the greasy rail onto the edible viscera below. Regulatory Control Action was taken by rejecting the line with USDA Reject Tag #B38075842. Mr. (B)(6) was shown the non-compliance. The shackles were washed down with food grade chemicals and (B)(4) to remove the substance from the shackles by Sanitation, as a corrective action. I then released the line to production. The Preventive Measure given by Mr. (B)(6) was that (B)(6) would inspect the shackle line before production begins, for the rest of the week (12/03-12/06). Mr. (B)(6) was informed a Noncompliance Record would be issued documenting the noncompliance. The requirements of Regulations 416.1 and 416.13(c) were not being met.</p> <p>The Establishments SSOP plan objective is (B)(4)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1608122 502N-1	12/02/2013	01C02	Operational SSOP Review and Observation	C	At approximately 2215 hours Food Inspector (B)(7)(C) on line 2 station 7 at startup observed black UFM (Unidentified Foreign Material) on the viscera. I collected several more sets of viscera and contacted Department (B)(6). There were numerous specks and flakes to approximately 1/4" on the fat on the gizzard and on other tissues (hearts, livers, intestines) that extended below the length of a normal hanging visceral. From the location of the UFM on the viscera it was obvious that the viscera was being dragged across some insanitary surface. The line was already stopped as it was out of sequence. A small number of viscera at stations 7 & 8 involved were condemned. A mechanic was called to address the issue. The line was repaired and after lunch I observed the same black UFM on the viscera at stations 7 & 8. The inspectors on stations 7 & 8 were told to condemn viscera hanging lower then a normal set of viscera until the end of the shift. (B)(6) was informed of the ongoing condemnation and the noncompliance. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(d), 9 CFR 416.4(d) and 9 CFR 416.14.
5308	M6137	BXL1808124 902N-1	12/02/2013	03J04	Poultry Zero Tolerance Verification	C	At approximately 0542 hours while performing a Zero Tolerance check on line 2 in Plant 1, I observed the following. After taking a standard 10 bird sample, I observed one bird with visible fecal contamination. The fecal material was inside the carcass adjacent to the opening cut on the left side. The fecal material was olive green in color, pastry in texture and measured approximately 1/4" by 1/8" in size. This exceeded the Zero Tolerance for the process to be in control. (B)(6) was shown the fecal material and the protocol for fecal failure was implemented. A recheck passed at approximately 0517 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4), and the CCP-2B (b)(4) of the Plant's HACCP Plan for Slaughter.
5568	M20923	XUM112112 5102N-1	12/02/2013	01B01	Pre-Op SSOP Record Review	C	On 12/2/2013, at approximately 1857 hours, while performing a routine scheduled SSOP Pre-Op Record Review in the QC Lab, I observed the following noncompliance: while reviewing the SSOP Weekly Implementation and Monitoring Log dated 11/25/2013 the QC Representative with the initials (B)(6) identified an unacceptable finding at 06:40 hours during Pre-Op on Part 1 Pre-Operational Sanitation, Section 1 Raw Area, Unit 79 (front of GCO) and didn't document the corrective actions performed to the area, a noncompliance per 9 CFR 416.16(a). I showed and informed Mr. (B)(6) of the forthcoming noncompliance. The requirement of 9 CFR 416.16(a) was not met.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ0721125 102N-1	12/02/2013	01C02	Operational SSOP Review and Observation	O	<p>At approximately 2348 on 11-29-13, I, CSI (B)(7)(C) was observing sanitary conditions in the packaging area. I observed nineteen unwrapped trays of product # 90883 Jumbo Thighs stacked one on top of each other in two piles. The trays were located on either side of the thigh line belt immediately east of the thigh line wrapper. I observed the bottoms of the trays were in direct contact with product in the trays below them. It is reasonable to assume, considering the conditions I observed, there was direct product contamination. At approximately 2349, I showed (B)(6) (B)(6), the conditions and verbally informed her I would be issuing a noncompliance record. At approximately 2350, I observed (B)(6) and (B)(6) (B)(6), remove the product from the nineteen trays and place it in a brown tub. At that time, (B)(6) proposed a corrective action. To ensure the appropriate disposition of the product, the contaminated product would be salvaged according to the establishment's written Reprocessing Floor Salvage Program. I agreed. At approximately 2351, I took a regulatory control action and applied US Rejected/US Retained Tag # B37852254 to the brown tub containing the contaminated product. I observed the tub of retained product as it was moved to the packaging floor salvage station. At approximately 0030, after observing the process several times, I observed the establishment employee had finished individually washing and inspecting the contaminated product and putting it into another tub. This tub had a QC retained tag applied to it as per the establishment written salvage procedure. At approximately 0031, I removed the US Rejected/US Retained Tag # B37852254 from the tub and released the product. Later on the morning of 11-30-13, I verified the proposed preventative measure of retraining the establishment employee on the proper handling of trays had been completed. It was documented on the establishment's Employee Retraining and Monitoring Form as completed on 11-29-13. This NR is not linked to any other recent NR for the same root cause.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH130612 1002N-1	12/02/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At 0359 hours on the night of production which began on 12/01/2013, while performing required PHIS Poultry Zero-Tolerance task at the designated Line #1 Pre-chill station at est. 33900 P, after randomly selecting 10 slaughtered and eviscerated and chilled chicken carcasses for the subgroup test and having begun the test at 0358 hours, Inspection found fecal material on the 5th bird in the set. The fecal material was a dark green color and of a pasty consistency which would easily smear to the touch. It consisted of three pieces 1/4" in diameter and 1/8" in thickness, located on the inside of the breast area. (B)(6)</p> <p>(B)(6) was shown the carcass and he concurred that the material in question was indeed feces. Upon investigation, it was found that the cause of the fecal find was (B)(4). Plant Management's Measure to prevent recurrence was "Employee counseled; first step of Company Disciplinary Policy." The requirements of 9CFR381.65(e) and 417.2(c)(4) were not met and Mr. (B)(6) was advised that the incident would be documented on a Noncompliance Record. Refer to NR #NHH2304110330N/1 dated 11/30/2013 for a similar Noncompliance. Plant Management's measure to prevent recurrence was: (B)(4)</p> <p>(B)(6). To date all preventive measures may not have been implemented as described or were ineffective in preventing recurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH250412 3402N-1	12/02/2013	06D02	Other Inspection Requirements	C	<p>On the night shift that began on 10/01/2013, at approximately 2215 hours I asked the Evisceration supervisor, Mr. (B)(6), to perform a test in the picking room of establishment 33900. This Establishment uses a batching system of inspection, if the carcass is condemned or hung back for re-inspection the paw condemn button is pressed and a batch of paws are condemned. This insures that all paws from condemned carcasses are also condemned. The result of the test was that the establishment could not collect any of the paws that are used to show that all condemned paws would be captured and condemned. I talked to Dr. (B)(7)(C) the IIC on night shift and explained what I had observed and informed him that I was going to reject the paw system. Regulatory Control Action was taken by applying USDA Reject Tag #B38075841 to the system. At approximately 2230 another test was performed on the line#1 system and the results allowed the Establishment to begin collecting paws from that line at 2300 Hours, after the system had been rinsed with (b)(4) water. At approximately 2305 another test was performed on line #2 paw system and the results displayed that the condemned paws could be captured and condemned. At this time I was on the line inspecting carcasses due to a staffing shortage. The Establishment began collecting paws from that system also. The requirements of Regulation 381.76(b) were not being met. Refer to NR NHH4600104801N / 1 dated 10/01/2013 for similar noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY521912 3301N-1	12/01/2013	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of December 1, 2013 (Sunday) at approximately 1820h while performing the Operational SSOP Review and Observation task, I observed the following noncompliance during shift 2: I, CSI (B)(7)(C), observed a production employee pick up an empty cardboard roll from the floor and lay it on top of the freezer plate for line (B)(4) in the "IF" department. The plate freezer film was being replaced. The old cardboard roller had fallen on the floor. A production employee picked it up from the floor and laid it on the surface of the product freezer plate. No product was on the plate freezer, but the surface of the product freezer plate was contaminated by the cardboard roll from the floor. I immediately rejected the line with U. S. Tag #B34 913535 and informed the (B)(6) and Mr. (B)(6) (Shift 2) that there was SSOP noncompliance. In addition, Mr. (B)(6) was shown the empty cardboard roll and he was shown the area of the plate freezer that had been contaminated. In order to restore sanitary conditions, maintenance turned the freezer plate off. Mr. (B)(6) had the freezer plate rinsed and sanitized. As a preventive measure, he stated that the employee involved would be retrained. After corrective actions were completed at approx. 1845h, the regulatory control action (U. S. Tag B34 913535) was removed. (No product was contaminated.) The establishment's Standard Operating Procedures for Sanitation (Part 2; Section 1) states: (B)(4). Equipment was not maintained in a sanitary manner and ineffective SSOP monitoring failed to prevent equipment used to transport raw product to the freezer from contamination. In addition, the regulatory requirements for 416.13(c), 416.1, and 416.4(d) were not met.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH230411 0330N-1	11/30/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At 0339 hours on the night of production which began on 11/29/2013, while performing required PHIS Poultry Zero-Tolerance task at the designated Line #1 Pre-chill station at est. 33900 P, after randomly selecting 10 slaughtered and eviscerated and chilled chicken carcasses for the subgroup test and having begun the test at 0339 hours, Inspection found fecal material on the 1st bird in the set. The fecal material was a dark green color and of a pasty consistency which would easily smear to the touch. It consisted of one piece 1/8" in diameter and thickness, located on the outside of the bird on the upper right drumstick. (B)(6)</p> <p>(B)(6) was shown the carcass and he concurred that the material in question was indeed feces. Upon investigation, it was found that the cause of the fecal find was (B)(4)</p> <p>(B)(4) Plant</p> <p>Management's Measure to prevent recurrence was (B)(4)</p> <p>(B)(6)." The requirements of 9CFR381.65(e) and 417.2(c)(4) were not met and Mr. (B)(6) was advised that the incident would be documented on a Noncompliance Record. Refer to NR #NHH5502112830N/1 dated 11/30/2013 for a similar Noncompliance. To date all preventive measures may not have been implemented as described or were ineffective in preventing recurrence.</p>
1325 7	P33900	NHH331311 3930N-1	11/30/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 1136 hours I performed a 10 bird Zero Tolerance task at the designated check station on (b)(4) line. the first sample bird contained feces in the lower kidney crypt area just below the tail of the bird. It was a smear of about 1/4 of an inch, past, and bright green in color. On the third and fifth sample bird there visible feces bedded in the same location as the first sample and were close to an inch or more in diameter of the same consistency. After finding three incidents in the 10 bird sample and having knowledge of the amount fecal contamination we were having due to the bird size, I took official control action by stopping the line. I notified and showed (B)(6) the three birds. Maintenance began an investigation to determine the cause. Afterwards (B)(6) notified me that the high pressure rinse nozzle on the line had been readjusted. I then released line. Shortly afterwards I began doing a check at the final trim station to determine if the adjusted showerhead had taken care of the problem. About the seventh bird that I looked at had a glob of feces an inch or so in diameter inside the crypts under the tail. I allowed the bird to continue through the final rinse before the chiller entrance and when I removed it the fecal matter was still present. I showed this to (B)(6) and the line was stopped immediately. Further investigation was done and it was found that the IOBW had a busted hose. The line remained down until the hose was removed and replaced. QA was notified of the fecal failure.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH550211 2830N-1	11/30/2013	03J04	Poultry Zero Tolerance Verification	C	On November 29, 2013, at approximately 2148 hours while performing a Poultry Zero Tolerance task at the evisceration line 2 pre-chill station, I found feces inside of the tenth bird of a ten bird set. The feces was inside the cavity of the bird, just cranial to the tail. It was approximately one inch long by 1/16 inch wide and was brown in color. (B)(6) was shown the carcass, and I informed him of the noncompliance. Upon further investigation, Mr. (B)(6) said that the cause of the fecal find was that the inside-outside bird wash was not properly adjusted to accommodate small birds. The establishment's measure to prevent recurrence was to retrain employees how to properly adjust the equipment. The establishment did not meet the regulatory requirements of 9 CFR 381.65(e) and 9 CFR 417.2(c)(4). Refer to NR #NHH4923113310N written on November 13, 2013, for a similar noncompliance. (B)(6)

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1623110 427N-1	11/27/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 11/27/2013 at approximately 1554Hrs while performing my PHIS Zero Tolerance feces check, I observed visible fecal materials on the first bird sampled out of the ten whole body light hen turkey sampling test. One of the fecal material was lodged inside the turkeys pelvic cavity and the second was on the inside flap (same right side). U.S. Retain Tag NO: B39554892 was applied to the affected carcass. The fecal materials were approximately 1/4" x 1/4" (pelvic cavity) and 1/8" x 1/8" (inside flap) in size; greenish, with white material in it which is an indicative of uric acid) in color, as per Dr. (B)(7)(C) SPHV, semi-solid in nature with the distinct odor consistent with fecal material. The line two ten bird random sample was collected after the final wash and before entrance into the chiller by the establishment's helper. I showed the fecal material to (B)(6) ; (B)(6) and (B)(6) Dr. (B)(7)(C) also was shown the fecal materials. Dr. (B)(7)(C) concurred that it was fecal materials. Ms. (B)(6) immediately implemented the establishment's corrective actions. She had the turkey reconditioning by trimming and (b)(4) water (b)(4) ppm spraying and reinspection. At approximately 1600Hrs the turkey was released back to production after verifying the plant's appropriate corrective actions and reinspection. Ms. (B)(6) conducted her rechecks after the final wash and they passed. This observed incident of visible-fecal material is a noncompliance to 9 CFR 381.65(e). Also is in violation to 9 CFR 417.2(c)(4) monitoring at the critical control point to ensure compliance to the established CCP 4B (b)(4)) after the final wash and before entering the chiller. At approximately 1919Hrs the plant's implemented corrective actions at the post chill were completed and passed by Ms. (B)(6) Ms. (B)(6) verified the checks. (B)(6) was notified of the noncompliance. This noncompliance is being linked to noncompliance (#134) JDD5821101818N/1 dated 10/17/2013 and (#112) JDD1623092204N/1 dated 9/4/2013 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2504113 727N-1	11/27/2013	03J02	Slaughter HACCP	C	On 11/27/2013 at approximately 0145 hours in Packaging while monitoring sprayer functions &required by the Establishments' Verification Plan that &resulted from a Notice Of Intended Enforcement (NOIE) dated October 7, 2013, I observed the following. On Line ^{(B)(6)} there was &an uncut gizzard with &approximately 2" of intestine attached and two more pieces of intestines piled on top of a half breast. There was fecal material leaking from the intestines onto the half breast. I contacted ^{(B)(6)} . The half breast and intestines were scooped up and placed onto a yellow product tray. The immediate area of the belt was checked for more intestines but none were found. The half breast had not been packaged as it was a 'B' grade that would be sent to the end of the line for deboning. The fecal material &on the half breast was light brown, creamy in texture and measured approximately 1" by 1/8" in size. As the product was coming from Plant #1 ^{(B)(6)} was called &and shown the noncompliance. ^{(B)(6)} was called to perform immediate corrective actions. My findings indicated a noncompliance with 9 CFR 381.65(a), 9 CFR 381.65(e) and 9 CFR 417.2(c)(4). &.&.&.&.
5308	M6137	BXL3802113 427N-1	11/27/2013	01C02	Operational SSOP Review and Observation	C	At approximately 0500 hours while walking &past Line #2 in &Plant 1 I observed the following noncompliance. &The heater duct that is directly above Station #8, &Line #2 &the reprocessing line was covered in heavy beaded condensation that was dripping close to the line. &I immediately informed ^{(B)(6)} of my concerns, at which time he began cleaning the &heater duct &with a sponge mop. &The condensation dripped heavily from the mop spraying condensation on Station #8, Line #2 and Line ^{(B)(6)} which had birds on it at the time. &I immediately stopped the line &and ^{(B)(6)} finished cleaning the heater duct, at which time the lines and Station ^{(B)(6)} were rinsed off. &The birds on the reprocessing line ^{(B)(6)} &at Station #8 were condemned, restoring sanitary conditions by approximately 0535 hours. &My findings indicate a noncompliance with the regulatory requirements of ®ulations 9CFR 416.4(b), 9CFR 416.1, 9CFR 416.4(d) and 9CFR 416.2(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4700112 527N-1	11/27/2013	01C02	Operational SSOP Review and Observation	C	On 11/26/2013 at approximately 0724 hours while monitoring Facilities in Plant #1 rehang area, I observed the following. There was (b)(4) spraying onto a light fixture from (b)(4) Cabinet used to treat carcasses going into Packaging for lines 191 & 197. The fluid was dripping from approximately a 1 1/2 foot section of the light fixture into a tank of WOG's (with out giblets) being collected for the Rotisserie Room. The Rotisserie WOG's have already received there final microbial intervention. The light fixture is treated as a non-product contact surface. The fluids would rinse untold contaminants from the light fixture on to the finished product creating an insanitary condition. (B)(6) was called and after seeing the problem called for a mechanic. The partial tank of WOG's was reconditioned with (b)(4) water and returned to production by 0745 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), and 9 CFR 416.2(b)(1).
5308	M6137	BXL5000115 627N-1	11/27/2013	01B02	Pre-Op SSOP Review and Observation	C	On 11/26/2013 at approximately 2145 hours while monitoring the Establishments' Pre-Operational Sanitation standards in Plant #2, I observed the following. There was a coating of a light brown pasty UFM (Unidentified Foreign Material) on the black fingers associated with the fourth Picker on line 191. The UFM was in the grooves and on the smooth surfaces of most of the fingers associated with the unit. (B)(4) was applied to the unit followed by a potable water rinse which removed very little of the UFM. The UFM was on the last three pickers on line 191 and was discussed at the morning meeting on 11/27/2013. At approximately 2204 hours there was three paint chips to approximately 1/2" by 1/8" medium gray in color on the incline belt that moves product from the Reprocessing Line 191 to the Chillers. The belt was rinsed with potable water restoring sanitary conditions. The top of the wall opening that the incline conveyor belt passes through is severely deteriorated with rust and peeling paint that is the same color as that found on the belt. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.2(b)(1), 9 CFR 416.13(c) and 9 CFR 416.14.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2618110 626N-1	11/26/2013	03C02	Raw Intact HACCP	C	<p>On 11/26/2013 at approximately 1100 hours while performing a HACCP Raw-Intact Record Review Task, I found the following; the HACCP Monitoring Log -CCP 3B- (b)(4), Plant #2 Rehang, dated on 11/22/2013, PM shift had a concentration failure on one of the five sanitizer concentration checks. The first check at 1327 had a concentration of (b)(4) ppm of sanitizer (b)(4). The second check (Drop #7 top C) had (b)(4) ppm of sanitizer (b)(4). At the comments Quality Control or designee had fail re-check, 1347 released". The following three checks were in compliance. I asked (B)(6) about the failure. The concentration and the location for the recheck were missing. She informed me that the corrective action was completed, Quality Control or designee did not document the recheck concentration of the sanitizer (b)(4) and the location for the failure on the corrective action Log. My findings indicate a noncompliance with the following regulatory requirements of regulation 9CFR 417.5 (a)(3). I notified (B)(6) of the noncompliance.</p>
5308	M6137	BXL3018110 926N-1	11/26/2013	03J02	Slaughter HACCP	C	<p>On 11/26/2013 at approximately 1100 hours while performing a HACCP Slaughter Record Review Task, I found the following; the HACCP Monitoring Log -CCP 2B- (b)(4) (Plant 2) PM Shift dated on 11/22/2013 at approximately 1019 hours, Line (b)(4), had a Zero Tolerance Failure by Quality Control. Production started performing corrective actions as the HACCP Plan for Slaughter Plant #2 stated. Corrective actions were performed and finished at approximately 1224 hours. The Pre-Shipment Records Review CCP 2B (b)(4) mid-Shift, was signed at 1201 hours. The signed documented certifies that the product is ready to be shipped. The Pre-Shipment Records Review, mid-Shift was signed before the corrective actions for the failure were completed. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 417.5 (c). I notified (B)(6) of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN211811 0726N-1	11/26/2013	03J02	Slaughter HACCP	O	<p>In regards to the establishment's corrective actions to the Notice of Intended Enforcement (NOIE), issued on 10/07/13; the following noncompliance has been noted. The verification plan included several antimicrobial treatments to mitigate bacterial pathogens. According to the Notice of Deferral Verification plan dated 10/13/13 (including the most recent revision dated 11/6/13), the establishment made a commitment to implement a pre-chill (b)(4) cabinet by 10/20/13 and monitor the (b)(4) concentration. In addition, per the verification plan, the establishment is to monitor the (B)(4) levels of the "Chiller Fresh Make Up" as well as the "Chiller Red Water" with acceptable levels of (b)(4) ppm FAC and (b)(4) ppm FAC, respectively. From 11/18/13 to 11/20/13, the establishment discontinued the use and monitoring of (b)(4) concentration for the pre-chill (b)(4) cabinets. Also, from 11/18/13 to the present, the establishment discontinued the use and monitoring of acidified (B)(4) in the chiller. These actions contradict the terms outlined in the Notice of Deferral Verification Plan, dated 10/13/13 (including the most recent revision dated November 6, 2013). Consequently, there is noncompliance with 9 CFR 417.5(a)1. The noncompliance referenced above was discussed with (B)(6), on November 22, 2013 by the FLS, Dr. (B)(7)(C) and EIAO (B)(7)(C).</p>
5309	P6137A	NJN391211 5827N-1	11/26/2013	01C02	Operational SSOP Review and Observation	C	<p>While I was performing an operational sanitation task in the fillet department, at approximately 1245 hours, I observed a mist of water raised from the area between (b)(4) # (b)(4) & (b)(4). When I went there to check the area, I found a plant employee washing down the floor using high presser water. I immediately stopped him because he over sprayed the portable incline conveyor as well as the products on the conveyor. I informed Mr. (B)(6), of the noncompliance and explained to him that the incline conveyor is too close to the floor which exposes the conveyor as well as the product to the splashes of contaminated water from the floor. Also, I suggested that using the squeegee is better during operations, to clean the debris. Mr. (B)(6) stopped the production line, washed and sanitized the conveyor, and sent the affected product to be reprocessed. The plant failed to comply with the regulations 9 CFR 416.1, 9 CFR 416.4(d), and protect the product from cross contamination.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3113110 025N-1	11/25/2013	03J02	Slaughter HACCP	O	On 11/19/2013 while reviewing the company's computer records for IOBW (CP-4), I observed the following. On Line #1 the frequency of one hour on one check was over by 28 minutes. On Line #2 the frequency of one hour on one check was over by 38 minutes and on reprocessing Line (B)(6) the frequency of one hour on one check was over by 30 minutes. This is a noncompliance of the establishment not following the proffered IOBW Monitoring procedure. The Notice of Deferral Verification Plan #4. states in part "(B)(4) (B)(6) of the noncompliance. My findings indicate a noncompliance with regulatory requirements of regulation 9CFR 417.5(a)(1).
1325 7	P33900	NHH232311 1625N-1	11/25/2013	01B02	Pre-Op SSOP Review and Observation	C	On the night of production which began on 11/25/2013, Inspection performed scheduled PHIS procedure Pre-op SSOP Review and Observation in the Evisceration Department of 33900 P. This was after Sanitation had finished cleaning the equipment and QA had finished their Pre-operational inspection of the equipment and released the area for USDA inspection. There are no additional Sanitation or Pre-operational steps prior to the start of production. The following noncompliance was observed: At 2035 hours while checking Line #2 Paw Unloader (Unit #1/Zone #3), Inspection found the Picker Fingers (Product contact surface) in an unsanitary condition with a greasy black residue which would easily rub off onto the hand. Inspection took Regulatory Control Action by applying US Reject Tag #B38075678 to the Unit until it could be recleaned and reinspected, and was released at 2124 Hours. The Requirements of 9CFR 416.13(c) were not being met and (B)(6) was shown the noncompliance and advised that a Noncompliance Record would be issued. The item of Equipment was randomly selected for Inspection as required. For a similar noncompliance refer to NR #NHH4423105223N/1 dated 10/23/2013. To date, all Preventive Measures may not have been implemented as described or were ineffective in preventing recurrence.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1609113 423N-1	11/23/2013	04A06	Poultry Finished Product Standards	O	On 11/23/2013 at approximately 0511 hours while performing a Post-Chill Finished Product Standards check in Plant #1 from Chiller#1, I observed the following. After taking a standard random 10 bird sample, I accumulated 12 nonconformance points. 5 of the 10 birds had black UFM(Unidentified Foreign Material) on the back side of the left hock. I contacted (B)(6) and informed him of the noncompliance. A QC recheck failed with 9 nonconformance points at 0539 hours. At this point the process is judged to be out of control. Post-Chill rechecks at 0546 hours and 0600 hours brought the process back into control. Post-Chill rechecks were performed every 30 minutes until the end of the shift. An employee was stationed near the (b)(4) to wipe off the UFM until the end of the shift. (B)(6) stated that it was determined that the UFM was caused by dirt on the shackles being transferred to the carcasses at the auto-rehanger and that a work order to acid wash the shackles over the weekend had been submitted. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv) (d)(3). and 90 CFR 381.65(a).
5309	P6137A	NJN150111 2923N-1	11/23/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 2235 hours, after the QC Technician had performed Pre operational Sanitation and released the area for production, I went on to perform the Pre-operation Sanitation task in area five, new products room, section A (Rotisserie Line). While doing so, I observed a precipitation of salt residue inside the pipe of the (B)(4) tank from the previous production shift. The residue measured approximately a ¼ of an inch in thickness, whitish in color, and extended along the length of the pipe. The (B)(4) tank was rejected with US tag NO. B43303529. At 2255 hours, and after the restoration of sanitary conditions, I re-inspected and released the tank. I informed Mr. (B)(6), of the non compliance. The establishment failed to adequately monitor the implementation of sanitation SOP which in turn created insanitary conditions. This finding represents a non-compliance with 9CFR 416.13(c), 9CFR 416.4(a) and 9 CFR 416.1. Plant's written SSOP, part (1) Preoperational Sanitation section 4 further Processing, dated 10/15/2013 revised, which states: (B)(4) ". Continued failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action as described in 9 CFR 500.4.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA4421113 522N-1	11/22/2013	01D01	SPS Verification	C	<p>On November 22, 2013, at approximately 0215 hours prior to the start of operation in the Blending Room I observed the following noncompliance. On the underneath side of the metal bar that runs across the large blender dumper I observed a sharp piece of metal and pieces of glue like material, this metal bar comes in contact with product, but at the time of my observation operation had not started. U.S. Reject Tag NO. B34377420 was applied to the dumper. Ms. (B)(6) and Ms. (B)(6) was informed and showed the noncompliance. Ms. (B)(6) was also informed. At approximately 0300 hours the metal bar was repaired and re-inspected by CS (B)(7)(C) and released after sanitary conditions restored. This does not comply with Regulatory Requirement(s) 416.1; which states in part: "Each official establishment must be operated and maintained in a manner to ensure product is not adulterated", 416.3(a); which states in part: "Equipment and utensils must be maintained in sanitary conditions so as not to adulterate product". This document serves as written notification that failure to comply with the regulatory requirement(s) of 9 CFR 416 could result in additional regulatory action as described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0905114 121N-1	11/21/2013	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 2139 hours while monitoring the Establishments Pre-Operational Sanitation Standards in Plant #2, CSI (b)(7)(F) observed the following noncompliance. While inspecting the Line 1 Stunner, I observed a large amount of sand, ingesta and feathers from the previous days production floating in the water at the bottom of the stunner. I immediately informed (b)(6) of the noncompliance. The stunner was cleaned, restoring sanitary conditions and released at approximately 2213 hours. At approximately 2151 hours while inspecting Picker #3 on Line 1, there was a brown residue buildup on the metal plates associated with the picker fingers, the residue easily scraped off with a fingernail. There were also numerous feathers all over the picker and a thick, slimy yellow film on the back side of the rubber curtain at the top of the picker. I immediately informed (B)(6) of the noncompliance. The picker was cleaned restoring sanitary conditions by approximately 2215 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c). At approximately 2154 hours in Plant #1 (b)(7)(C) observed the following. There were several specks and smears to approximately 1/2" of black UFM (Unidentified Foreign Material) on the product contact surfaces of rehang belt and on the white rollers that support the rehang belt for line #1. There was black UFM that smeared like grease on the white nylon material covering the guide bar above the rehang belt. The nylon material was replaced. There was a piece of caulking coated with black UFM that appeared to be mold hanging loose from the drip pan located adjacent to the rehang belt. Sanitary conditions were restored by approximately 2217 hours. The Cropper for Line 1, at approximately 2213 hours, the shaft that extends into the carcass during production had varying amounts of black UFM. The unit was cleaned and released by approximately 2219 hours. At approximately 2220 hours there was flakes of black UFM measuring to approximately 3/8" by 1/4" on 2 chiller paddles near the line 1 carcass drop unit for product entering Chiller #1. The UFM was removed. At approximately 2222 hours there were several specks of black UFM on the paddle at the outflow side of chiller #2. There was a wear mark approximately 6" in length on the end of a paddle at the exit end of chiller #2 with loose metal flakes. A small loose piece measuring approximately 2mm by 1mm was removed. (B)(6) was present so I showed him the deteriorated condition of the paddle. There was several pieces of tissue to approximately 2" on the exit conveyor belt also from chiller #2. Sanitary conditions were restored by approximately 2225 hours. (B)(6) was informed of the noncompliance. In Rotisserie at approximately 2325 hours, the needles for the</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							<p>injection machine were installed in the injection machine and not out ready for inspection. The needles were removed, inspected and reinstalled. At approximately 2327 hours there was a large amount of brown UFM leaking from a gear assembly for the dumper unit. The brown UFM wipes off easily with any contact. A mechanic was informed. The area was recleaned. The brown UFM will continue to collect on the outside support bracket until repairs are made. At approximately 2328 hours there were several flakes of black UFM on the first two white product belts on the right side of the Rotisserie cone line. There was a piece of tissue measuring approximately 2" by 1/4" inside the white nylon injection belt at the out flow side of the injection machine. Sanitary conditions were restored by approximately 2330 hours. (B)(6) was informed of the noncompliance. In Packaging Area #1 at approximately 0000 hours there was brown UFM leaking from a gear assembly at the end of the overhead wing conveyor belt. The gear assembly associated with the belt located at the end of the belt near the elevator. The conveyor belt transports the wings from the (b)(4) Deboning room to the Packaging Area. The brown UFM was dripping from the unit onto a second flexible product conveyor belt directly below it. Plastic was attached to the assembly until repairs can be made. The area was recleaned and released by approximately 0025 hours. (B)(6) was informed of the noncompliance. In Packaging Area #2, the (b)(4) Room, there was a red paint chip measuring approximately 1/8" on a salvaged parts table near line #1. The fire fighting system piping mounted on the ceiling is painted the same bright red color. If on a chicken the bright red paint would be mistaken for a piece of blood. There were two white paint chips on a product belt along line #2. Paint issues in the (b)(4) Room were addressed at the morning meeting with establishment on 11/20/2013 and documented on MOI BXL4619114320G. Towards the end of Pre-Operational Sanitation the drains in the (b)(4) Room overflowed due to a plugged drain in the Paw Room. The water backs up in the (b)(4) Deboning Room, Plant #1 Cooler, and the Staging Cooler. Supervisors were called. Production was shut down on the loading dock and traffic through the plant 1 cooler was stopped. The drains were cleared. (B)(6) had the floors rinsed and treated with (b)(4). The (b)(4) Room, Cooler #1, and the Staging Cooler were released by approximately 0230 hours. The Paw Room was rinsed and treated with (b)(4) by approximately 0330 restoring sanitary conditions. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.2(e)(4), 9 CFR 416.3(a), 9 CFR 416.3(b) and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4820110 321N-1	11/21/2013	03J02	Slaughter HACCP	C	<p>While reviewing the company computer records, I found the following; (b)(4) (CP-19) was not performed on night shift in plant #1 on 11/20/2013 and only two checks were performed on 11/21/2013 in Plant #1 night shift also. I asked (B)(6) for a print out of Salvage Parts Treatment results for these two days. She informed me later that the Salvage Parts Treatment Procedure was not performed on the 11/20/2013 in Plant #1, and on 11/21/2013 Quality Control performed only two checks. HACCP Plan -Slaughter Plant 1- under step #37 states in part : (b)(4) Justification for decision. (b)(4) .</p> <p>Supplements 2, 7, 17, 18, 56. HACCP Supplement #56, Salvage Parts Treatment: CP-19 under procedure #4 states in part ' (B)(4) ". This is a noncompliance with the following regulatory requirements of regulation 9CFR 417.5(a)(2).</p>
5309	P6137A	NJN451411 1322N-1	11/21/2013	04A06	Poultry Finished Product Standards	C	<p>At approximately 0915 hours, while performing the finished product standards check on the reprocessing line, I found seven carcasses that were contaminated with ingesta on the crop area, two of them having bruises. The size of the contaminated areas varied from ½ inch to 1 inch. Also, I found one bird with excessive amounts of feathers on its back and the wings. I immediately stopped the reprocessing line and showed Mr (B)(6) , and Mr (B)(6) , my findings and informed them of the forthcoming noncompliance. The plant failed to keep the reprocessing line in compliance with the federal regulations. 9CFR 381.89 states: "Any part of a carcass which is badly bruised shall be condemned and, if the whole carcass is affected as a result of the bruise, the whole carcass shall be condemned. Parts of a carcass which show only slight reddening from a bruise may be passed for food." 9 CFR 381.91(b)(1) states: " Any carcass of poultry accidentally contaminated during slaughter with digestive tract contents shall not be condemned if promptly reprocessed under the supervision of an inspector and thereafter found not to be adulterated. Contaminated surfaces that are cut shall be removed only by trimming. Contaminated inner surfaces that are not cut may be cleaned by trimming alone, or at an approved reprocessing station away from the main processing line, by any method that will remove the contamination, such as vacuuming, washing, and trimming, singly or in combination. All visible specks of contamination must be removed, and if the inner surfaces are reprocessed other than solely by trimming, all surfaces of the carcass shall be treated with (b)(4) water containing 100 ppm available (B)(4) "</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH420511 2521N-1	11/21/2013	04B04	General Labeling	C	On the night shift of production that began on 11/20/2013, I was in room #1 Further Processing department at Est.33900 P to perform post chill requirements on product exiting the line #1 chill system. When I started to collect carcasses for the line #2 chill system check the chillers were stopped and no carcasses were exiting the system. I asked the (B)(6) , how long the system would be down. Mr. (B)(6) explained the system was turned off for up to thirty minutes to separate the small Halah birds from the large Halah birds. I asked for the moisture protocol procedures that would determine the amount of moisture that the carcasses would retain from this stoppage. Ms. (B)(6) could not produce the document so Inspection could not determine if the establishment had met the requirements of 9CFR Ch.III Part 441.10.
1325 7	P33900	NHH460311 0921N-1	11/21/2013	03J02	Slaughter HACCP	C	At approximately 0300 hours on 11/21/13 while completing a HACCP Slaughter task from 11/18/13 inspection noted the following noncompliance. The records for CCP-1 on 11/18/2013 indicated the interval between CCP 1 monitoring checks exceeded the frequency of “(b)(4)” specified in the HACCP plan. For line 1, CCP 1 was monitored at 0334 hours and again at 0439 hours for a total interval of 65 minutes. Production on line 1 was ongoing during this entire interval. The requirements of 9 CFR 417.2(c)(4) and 417.5(a)(3) were not met. (B)(6) was notified of the noncompliance and informed it would be documented on a NR. For a similar noncompliance refer to NR NHH4602110812N/1.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4103115 220N-1	11/20/2013	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 2140 hours while monitoring the establishments Pre-Operational Sanitation Standards in Plant #2, CSI (B)(7)(C) observed the following noncompliance. There was whole chicken foot floating in a brown cloudy puddle of water in the bottom of the stunner. Sanitation immediately removed the chicken paw and the stunner was cleaned restoring sanitary conditions by approximately 2145 hours. At approximately 2145 hours there was a heavy layer of brown UFM(Unidentified Foreign Material) on the fingers for Picker #5 on Line (B)(6). The UFM easily scraped off with a finger nail. The unit was cleaned and released by approximately 0115 hours. My findings indicate a noncompliance with the regulatory requirements of 9CFR 416.4(a), 9CFR 416.1, 9CFR 416.13(c) and 9CFR 416.4(d). On 11/19/2013 CSI (B)(7)(C) while monitoring the Establishments' Pre-Operational Sanitation standards in Plant #1 made the following observations. At approximately 2152 hours there was greasy product residue and feathers on the guide bars associated with the Line #1 Hock Nicker. There was also dried product residue with black UFM(Unidentified Foreign Material) that appeared to be mold on support bracket near the top of the chain housing. The unit was cleaned and released by approximately 2159 hours. At approximately 2212 hours there was heavy beaded condensation and over spray on the ceiling and equipment support brackets throughout the Line (B)(6) room. The ceiling was dried off with a sponge mop. The sponges had fat and tissue imbedded and were deteriorating with pieces of sponge loose. The sponges used caused the condensates to drip on the equipment throughout most of the room creating an insanitary condition. The equipment was given a through rinse and the space was released at approximately 2229 hours. There was several specks of black UFM that smeared like grease on the inside of Chiller #1 on the out flow side. There was also heavy beaded condensation on the ceiling over the out flow side of chillers 1 & 2. Sanitary conditions were restored by approximately 2250 hours. (B)(6) was informed of the noncompliance. In Packaging Area #1 at approximately 2345 hours there was black UFM along most of the tray belt associated with line (B)(4). The belt was recleaned and sanitary conditions were restored by approximately 0004 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.2(d), and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2515114 121N-1	11/19/2013	01D01	SPS Verification	C	On 11/19/13 around 11:15 Hrs while I was going around the plant I observed close to the osteo and salvage room one spray container lying with some chemical inside. There was no MSDS or ingredient label on it; and (B)(6) and (B)(6) were notified of the non compliance . This is a violation of 9CFR 416.4(c).
5112	M18909	JDD3504114 321N-1	11/19/2013	01B02	Pre-Op SSOP Review and Observation	C	On 11/19/2013 at approximately 1000Hrs while performing pre-operational sanitation of the plant's Evisceration; Raw Fabrication Grinding and Bagging Department's after the plant Q.C. and before start up of production. I observed the following noncompliance. (B)(6) was notified of the noncompliance and shown all incidents. I observed all of the plant's implemented corrective actions to the affected food contact surfaces. Mr. (B)(6) and Mr. (B)(6) verified the non food contact surfaces. 1.) Evisceration - Auto Kill blade had blood (food contact). b.) Chiller A end slide to chiller B- had many pieces of meat, skin and fat (food contact surface). c.) Trussing - had four (UFM) black grease drips on the food contact table. Also -The trussing belt- had a broken belt section which was not trimmed. The maintenance was called and replaced the broken section. d.) Final Wash- had UFM black grease drips on the middle section (non food contact). e.) The white conveyor into chiller A- had four pieces of meat one feather and two areas of meat residues (food contact). f.) White incline exiting the Gizzard defatter- had UFM black grease drips (food contact). g.) Steel glove- one had meat (food contact). 2.) Raw Fabrication Grinding- The # 1 grinder dumper- had meat residues on the hand bar (food contact). b. (B)(4) injector- had meat residues (food contact). 3.) Bagging Department- The blue line belt was unraveling at the edge and was dragging onto the floor when the conveyor was moving (food contact). The maintenance was notified to trim. The observed incidents of food contact surfaces found with meat, meat residues, skin, fat, feathers, UFM and untrimmed belt's from previous days operations is in violation to 9 CFR 416.4(d); 416.13(c) and 416.4(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance is being linked to noncompliance (#161) JDD4803115918N/1 dated 11/16/2013; (#153) JDD2203112512N/1 dated 11/11/2013 and (#147) JDD411114204N/1 dated 11/4/2013 for the same cause respectively.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN020311 4419N-1	11/19/2013	01C02	Operational SSOP Review and Observation	C	<p>On November 18, 2013 at approximately 1900 hours, while performing my Operational Sanitation Inspection in the Oven Room, Slice Pack Staging Room, and Coolers I observed the following noncompliance. Oven Room: (a) I observed 5 pieces of product on the floor (b) I observed no sanitizer in the hand dip station, and (c) I observed no inedible barrel in the oven room. I informed and showed Mr. (B)(6) the noncompliance, Immediate Corrective Action: Product was put into inedible barrel and hand dip station was filled with sanitizer. Slice Pack Staging Room: I observed 13 to 15 pieces of product (product code 6054) on the floor. Cook Pack Cooler: I observed two pieces of product on the floor. Slice Pack Cooler: I observed three pieces of product on the floor. Management Immediate Corrective Action: Product was condemned and floor cleaned and sanitized. At 1930 hours sanitary conditions were restored. This does not comply with Regulation 416.1; which states in part: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure product is not adulterated", and 416.13(c); which states in part: "Plant monitors implementation of SSOP procedures". This noncompliance report serves as written notification that failure to comply with regulatory requirement(s) of 9 CFR 416 could result in additional regulatory or administrative actions.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1307113 919N-1	11/19/2013	01C02	Operational SSOP Review and Observation	C	<p>On 11/19/2013 at approximately 0200 hours while conducting a Finished Product Standards check in Plant #1, I observed the following. There was condensation dripping from the ventilation ducting on to the QC Finished Product Standards (FPS) table on the line #1 side of the plant. The ducting extends from the QC FPS table over eviscerating lines 1 & 2 and ends at an exhaust vent on the line 2 side of the plant near the Cropping Machine. There was heavy beaded condensation along the entire length of the ducting. A second separate ventilation line extending from the entrance door to the employee break area to the exhaust duct between stations 4 & 8. The ducting passes over line 2 and also had beaded condensation along its entire length. I contacted (B)(6) and showed him the noncompliance. The condensation was wiped up but immediately came back. Paper towels were placed on the light fixture to catch the dripping condensates. A mechanic was called to adjust the ventilation. I checked back later and the condensation was again being wiped off by an establishment employee. Ventilation ducting is treated as a non-product contact surface which is seldom cleaned. The contaminants added by the dripping condensates is causing an insanitary condition. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2107112 419N-1	11/19/2013	03J02	Slaughter HACCP	C	<p>On 11/16/2013 at approximately 0525 hours while performing a direct observation task as part of the Verification Plan resulting from a Notice of Intended Enforcement (NOIE) dated October 7, 2013, I observed the following: I was observing the Establishments' (b)(4) monitor perform a scheduled check when we observed that the (b)(4) spray on overhead line going into Packaging was not working. Line (b)(4) was running and untreated carcasses were entering Packaging. The monitor called a Packaging Supervisor to stop the line and she called a mechanic to make repairs. With the line stopped (B)(6) arrived and QC hold tags were applied to a pallet of front halves at the Plant #2 Halvers, to a rack of legs and a rack of thighs at a location near Packaging lines (b)(4) & (b)(4). The product collected before the line stopped were tagged in my presence. I left assuming that corrective action was in progress. On 11/18/2013 at approximately 2030 hours I conducted a HACCP Slaughter records review of records filed from 11/16/2013. The CCP-7B (b)(4) for Plant #2 for 11/16/2013 showed the failure of the spray on overhead line at 0525 hours. The last good check was at 0435 hours. A Corrective Action Log for the HACCP Slaughter failure documented that 'Product was Involved' and that a pallet of front halves and two racks of legs and of thighs were held for treatment with (b)(4). When I left the area on 11/16/2013 there were approximately 600 carcasses hanging from the (b)(4) unit past the Halving machine all the way to the Leg Processors with most of the shackles full. This product is cut, separated and directed to Packaging lines (b)(4) & (b)(4). A like amount of product is arriving onto Packaging belts 8 & 9. The treated product arriving from plant #1 was contaminated by the untreated product arriving from plant #2. The Establishment on line (b)(4) was also packing leg and thighs from Packaging Lines (b)(4) & (b)(4) from the untreated product. There was a bin of thighs being collected adjacent to line (b)(4). A full bin normally weighs approximately 2000 pounds. The Establishments Corrective action Log for the HACCP Slaughter failure does not address any of this product. A review of the establishment HACCP Plan - Slaughter Plant #2 Step 27 (b)(4) lists (B) Pathogens: i.e. Salmonella and Is the Hazard Significant? YES. Under 'Justification for Decision' it states (b)(4) CCP-7B - Corrective action' lists Supplement #10 as a supporting document for their decision. Supplement 10 under #3. Corrective Action Procedure (Concentration failure, (b)(4) application) states under (f.) "If the line was not stopped at the time of the failure, product from the last passing check will be identified and placed on hold using the (b)(4) Corrective Action</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							Checklist." &The establishment has no records &of the affected product being used to pack the legs and thighs on lines [REDACTED] &:[REDACTED] &into 'Picnic Packs' on line [REDACTED], the bin of thighs being collected near Packaging line [REDACTED] nor the 600 carcasses on the overhead &line [REDACTED] from the &; inoperable (b)(4) spray cabinet to the Leg processors. &This is a failure of the Establishments' Corrective Action procedure as outlined in Supplement #10 to prevent contaminated carcasses from entering commerce. & My findings indicated a noncompliance with 9 CFR 417.3(c).
5308	M6137	BXL4520111 119N-1	11/19/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1335 hours, &while performing direct observation &on the Second Processing Rinse (mid-shift) at the Rotisserie Room, &l &observed the following; sanitation employees were &washing the area and &applying the sanitizer ([REDACTED]). I observed &when Quality Control &&did the ([REDACTED]) sanitizer &concentration check, at approximately 1344 hours. The SSOP Plan states in part under procedure that '(B)(4)' . The sanitation employees were almost finished with the application of the ([REDACTED]) sanitizer when Quality Control measured the concentration.My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.13(b) and 9CFR 416.13 (c).I informed (B)(6) of the noncompliance. &

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1911114 318N-1	11/18/2013	03J02	Slaughter HACCP	C	<p>On 11/18/2013 at approximately 0616Hrs, I observed the collection barrels of Turkey Fries at line one and line two. The plant's attached tag&nbsp;#645935 & 36&nbsp;showed both barrels collection time was 0415Hrs. I was at the Line 2&nbsp;barrel&nbsp;filling out my U.S. Retain Tag NO:B39554891&nbsp;to&nbsp;apply to the barrel with temperature 98.6F. (B)(6) came up to me and was notified of the noncompliance and shown the temperature 98.6F. I also notified him that line one barrel of fries&nbsp;would be retained. The line one and line two Turkey fries had no&nbsp;ice or CO2.&nbsp;The establishment's CCP 2B requirement for fries had exceeded the time and temperature of 40F within 2 hours of harvesting. A plant employee took the line one barrel of fries and put them into the chilling tank. Mr. (B)(6) chose to plant condemn all of the&nbsp;fries. The line two barrel of fries approximately 40 pounds was immediately taken out side and condemned/denatured.&nbsp;The line one turkey fries&nbsp;(44 pounds) were plant condemned when they came out of the chilling tank at approximately 0650Hrs. This observed incident of Turkey fries found exceeding the two hour&nbsp;time limit and 40F temperature from harvesting is a violation to 9 CFR 381.66(c)(4) and&nbsp;the plant's monitoring of the turkey fries 9 CFR 417.5(a)(3).&nbsp;(B)(6) was also notified of the noncompliance.</p>
5308	M6137	BXL1314110 618N-1	11/18/2013	03C02	Raw Intact HACCP	C	<p>On 11/16/2013 while observing Quality Control personnel perform the CCP3B procedure in the Packaging Department at shift change,I observed the following noncompliance. Q.C. was measuring the sanitizer concentration on 5 contact surfaces in Packaging 1 Area. She was waiting for an employee to sanitize the halver machine that is located by the aged breast cooler and the&nbsp;deboning table. After the sanitizer was applied to the halver, Q.C. measured the (b)(4) sanitizer concentration on the halver chute and the concentration was zero on the test strip. She did not document the result on the CCP3B (b)(4).&nbsp;Q.C. then checked the (b)(4) sanitizer coming out of the hose and it was also zero, she informed Supervision.&nbsp;Another Q.C. personnel came over and informed her that production would not be using the halver and then informed her which lines were going to be running. Both Q.C. personnel left the halver area, and sanitizer was not reapplied. The HACCP Plan states in part, (B)(4), (B)(4), Further planned actions must be taken to ensure compliance with 9CFR 417.3. I informed (B)(6) of the noncompliance. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 417.2(c)(4), 9CFR 417.2(c)(5), 9CFR 417.2(c)(6), 9CFR 417.4(a)(2)(ii), 9CFR 417.5(a)(3), and 9CFR 417.5(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2020115 818N-1	11/18/2013	01B02	Pre-Op SSOP Review and Observation	C	While monitoring the Establishments' Pre-operational Sanitation Procedures in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.13 (c).At approximately 0709 hours in the Area #4, Unit #16 Final Trim Station Line #1 and Line #2 and (b)(4) Cabinets, I found the drip pan for Line #2 that is going directly to the recycle water tank with chunks of dried and semi-dried fat from the previous day production. The drip pan from Line #1 that is attached to the (b)(4) cabinet had several spots of black material that appeared to be grease and also residue on the entire drip pan of the same material. I immediately attached a U.S. Retained/Rejected Tag #B31 406311 to the area and informed (B)(6) and (B)(6) about the noncompliance. They had an employee to scrub and rinse the area. Sanitary Conditions were restored at approximately 0717 hours, I then removed my tag.
5769	M6492	DIO0702110 018N-1	11/18/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 2300 hrs., I started my Pre-Operational Review and Observation task upon learning from (B)(6) that the area to be Pre-Oped is ready(Raw side). I noticed at kettle number 8 that there is a food residue(approximately 1"x3/4" in size) from previous production which is located at the connecting junction between pump and pipe that feeds the Burrito fillings down to the line. This surface is a Food Contact Surface. I notified Ms. (B)(6) and Sanitation personnel immediately cleaned and sanitized the affected surface and my reinspection revealed no trace of food residue. Had this contaminant not been found, it will potentially adulterate product that will be produced. This is in violation of Title 9CFR416.4(a) Sanitary Operations and 9CFR416.13(c) Implementation of SOP's 9CFR416.4(a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. 9CFR416.13(c) Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH370411 2419N-1	11/18/2013	01C01	Operational SSOP Record Review	C	<p>On the night of production that began on November 18, 2013, while performing SSOP records review, I found the following noncompliance.&nbsp; There were three SSOP deviations documented by the establishment where the preventive measure for each deviation was an employee received instructions from a supervisor.&nbsp; There was no documentation that these instructions were given.&nbsp; Therefore the preventive measure could not be verified.&nbsp; For another deviation the preventive measure was an area check would be performed; however, the check was not documented.&nbsp; The preventive measure for another deviation was training would be provided by the warehouse. There was no documentation for this training. This training could not be verified.&nbsp; Mr. (B)(6) was notified the noncompliance would be documented on an NR. The requirements of 9 CFR 416.16(a) were not met.&nbsp; For a similar noncompliance refer to NR NHH1201100414N/1 dated October 13, 2013.&nbsp; The preventive measure for this noncompliance was 'Supervisor responsible for assuring Preliminary Response Forms will be answered by the end of the shift and retrained as such.'&nbsp; These measures may have been ineffective or implemented incorrectly.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3502114 518N-1	11/17/2013	04C05	Poultry Good Commercial Practices	C	<p>On 11/17/2013 at approximately 0715Hrs while giving a break to the line food inspector, I, (B)(7)(C), CSI observed the following non-compliance. While providing a break, I hung back 2 cadavers for Dr. (B)(7)(C) SPHV to verify. Once the inspector returned from break, I immediately went outside to check Good Commercial Practices at the live hang/kill line area. Dr. (B)(7)(C) examined the cadavers and determined that birds were cadavers; one of the cadavers had a kill cut but did not bleed fully, and the other did not have a kill cut. Upon confirmation of the cadavers, Dr. (B)(7)(C) notified (B)(6), about the two cadavers so immediate corrective action could be done; this is the plant's standard practice. When birds are determined to be cadavers, the establishment implements immediate corrective actions. During this time, both evisceration lines one and two were running at the maximum allowable speed of (B)(4) per line with two line inspectors for birds 16 lbs or over. Outside at the live hang/kill line area, I observed that the establishment was running mixed heavy hens and heavy toms. At the entrance to the inside scald area, an establishment employee was using a knife to manually cut the necks of the birds that were not properly stunned and birds that were missed by the automatic kill blade. While he was trying to cut the turkeys, I observed the birds violently thrashing about, indicating improper stunning. A second plant employee stationed at the automatic kill blade was also using his knife to make manual cuts due to violent thrashing. These turkeys were missing the single line auto kill blade/knife because they were not sufficiently stunned. I also observed the employee at the automatic kill blade has to wipe blood from his face before attempting to make another cut. This employee at the auto kill did not stop the line. Due to the inadequate stunning, the thrashing birds, and the difficulty the plant employee was having in making the kill cut, I was concerned that the process was out of control and I proceeded to ask another employee on the kill floor to notify a Supervisor. The employee was unable to raise a supervisor, so I hurried to the USDA Office to notify Dr. (B)(7)(C) that the outside kill needed to be stopped. Upon arrival at the USDA office, I discovered that Dr. (B)(7)(C) had to go to the evisceration floor due to more cadavers. At this time, I also went to the scalding area at approximately 0725Hrs. I observed two heavy tom turkeys with their heads up (in an arched manner) looking at me as birds were going into pre-scald. Dr. (B)(7)(C) examined 11 cadavers between the two inspection lines; five of the cadavers did not have the kill cuts and six cadavers had kill cuts but did not bleed sufficiently. In total, the establishment had a total of 13 cadavers at the inspectors' station within an approximately 15-minute time frame. The last cadaver was noted at 0730 hours by line inspector (B)(7)(C). The neck and head of all of the 11 birds were collected and subsequently shown to Mr. (B)(6), in the USDA</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							office; the establishment did not dispute Dr.(B)(7)(C) findings that in this cluster of 11 cadavers, 5 were without a kill cut and 6 were with a kill cut but the birds were insufficiently bled, which made them also cadavers. (B)(6) notified me at approximately 0740Hrs that the issue was addressed. I notified Mr. (B)(6) that a noncompliance will be issued. Dr.(B)(7)(C) concurred that the plant was not following good commercial practice, as evidenced by birds dying other than by slaughter and not being bled out properly, which is in violation to 9 CFR 381.65(b) which states in part; "Poultry must be slaughtered in accordance with good commercial practice in a manner that will result in thorough bleeding of the carcasses and ensure that breathing has stopped prior to scalding."
5112	M18909	JDD0802115 218N-1	11/16/2013	04A03	MSS; MSP; PDBFT; PDPFT; PDCB; PDCP; AMRS	C	On 11/16/2013 at approximately 2150Hrs while performing my PHIS MSP task, I observed the (MSP) Mechanically Separated Poultry floor analyzer perform the bone content analysis. The bone content analyzer showed the bone content was (b)(4) This test was for Bin # 25 with time 2147Hrs. I saw the personnel take the MSP bin to the new shipping dock with the Bonning Room Scale attached Tag #T001812522 and time 2157Hrs. I went to the plant's Quality Control lab to verify if a recheck sample was performed. (B)(6) was in the lab and she had not been notified of a needed retest for Bin #25 with (b)(4) Bone. (B)(6) was notified of the noncompliance. Mr. (B)(6) went with me to the shipping dock and we collected a retest sample, per plant requirement. Ms. (B)(6) performed a retest on the sample in the Quality Control lab Analyzer. The bone content was (b)(4) The retest passed and the MSP Bin # 25 was released back to shipping at approximately 2200Hrs after verifying the establishment's implemented corrective actions. This observed incident of the plant not following their corrective action when the first test exceeded the (b)(4) bone content required is in violation to 9 CFR 381.173 and Directive 7160.1. This is also a violation to establishment's in place (b)(4) bone requirement and corrective action procedure for the MSP.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4803115 918N-1	11/16/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On 11/16/2013 at approximately 1110Hrs while performing pre-operational sanitation of the plant's Evisceration; Boning Room, Bagging and Raw Fabrication grinding Department's after the plant Q.C. and before start up of production. I observed the following noncompliance (B)(6) was notified of the noncompliance and shown all incidents. I observed all of the plant's implemented corrective actions to the affected food contact and non food contact surfaces. 1.) Evisceration - Scalding (middle) had many long feathers (food contact) surface. a.) Hock Cutters (hand held holder) had meat and meat residues on the entire inside (food contact) surface. b.) The blue incline conveyor to chiller A had meat, skin and fat on the bottom side (non direct food contact) surface. c.) Gizzard splitter had two long feathers (food contact) surface. d.) Chiller A end metal slide conveyor had many pieces of meat, fat, skin and meat residues (food contact) surface. 2.) Boning Room - Fillet conveyor had two pieces of meat (food contact) surface. a.) The fillet conveyor had two broken untrimmed belt pieces. The maintenance was called and replaced the two broken belt sections. b.) The stainless steel work table had two pieces of meat (food contact) surface. 3.) Raw Fabrication- had meat residues inside the #1 grinder (food contact) surface. a.) The #1 grinder screen had meat residues (food contact) surface. 4.) Bagging Department - had belt threads wrapped around the yellow conveyor roller under side (non food contact) surface. a.) The Top slide conveyor which enters the Roser had meat; rust, blue and black netting, metal clips and a piece of a turkey bag (non direct food contact) surface when turkey bags are closed. The observed incidents of food contact surfaces found with meat, meat residues, skin, fat and feathers from previous days operations is a violation to 9 CFR 416.4(d); 416.13(c), and 416.4(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance is being linked to noncompliance (#157) JDD2203112512N/1 dated 11/11/2013; (147) JDD0411114204N/1 dated 11/4/2013 and (#145) JDD4511100430N/1 dated 10/30/2013 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2512115 516N-1	11/16/2013	01C02	Operational SSOP Review and Observation	C	On 11/16/2013 while observing the Second Processing Rinse Procedure and CCP3B Procedure at shift change in the Packaging Department, I observed the following noncompliance. Q.C. personnel were measuring the sanitizer concentration on 5 contact surfaces in Packaging 1 area. The (b)(4) sanitizer was measuring zero from the hose and (B)(6) was informed. Two employees started applying (b)(4) t from the back pack sprayer to the fillet line. The (b)(4) concentration was within the acceptable range. Q.C. personnel was checking the contact surface on the saddlepack line and as I was standing there I noticed that on Line (b)(4) there were some wings already on the belt. I asked Q.C. if Line (b)(4) had been checked and she informed the employee with the back pack sprayer of (b)(4) to spray the belt. The wings were not removed from the belt before the sanitizer was applied. The Notice of Deferral Verification Plan #17 states in part that "Edible product will be removed from product contact surfaces." The establishment's SSOP Plan states in part, "(B)(4) (B)(4) The wings were condemned and l informed (B)(6) of the noncompliance. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.13(c), 9CFR 416.13(b), and 9CFR 416.12(a).
5308	M6137	BXL3203111 916N-1	11/16/2013	01D01	SPS Verification	C	On 11/15/13 at approximately 0103 hours while performing SPS Verification checks in the Rotisserie Room I observed the following noncompliance. I observed heavy beaded condensation on the ceiling above the injector machine and metal detector and pvc pipe next to the injection machine. I immediately took regulatory control by applying U.S. Reject tag # B31408102 to the area and informing (B)(6) of my findings, Mr. Short immediately stopped production and informed (B)(6) of my findings. All condensation was wiped off to restore sanitary conditions. Regulatory control was relinquished at approximately 0112 hours and production was then resumed.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY431711 3616N-1	11/16/2013	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of November 16, 2013 (Saturday) at approximately 1522h while performing the Operational SSOP Review and Observation task, I observed the following noncompliance during change of shift from shift I to shift 2: I, CS (B)(7)(C), observed multiple droplets of condensation located on the underside of 2 drip pans and several pipes that were directly above Line (B) in the "IF" processing area. One of the drip pans was angled downward and water was dripping off the pan from the lowest corner of the pan every 3-5 seconds and landing on the plate freezer film used to transport raw poultry product to the freezer. This is a product contact area. At the time of the observation (1522h), no product was on the line due to the shift change. I immediately informed the lead person to call the shift I supervisor for the area. Mr. (B)(6) arrived at approx. 1530h and was shown the dripping condensation that was landing on the product plate freezer film. In addition, he was shown the other drip pan and pipes directly above line (B) that had multiple beads of condensation on them. I informed Mr. (B)(6) that there was SSOP non-compliance and the line was rejected with U. S. Tag #B29 699994. In order to restore sanitary conditions, Mr. (B)(6) had maintenance level the drip pan above line (B)(4). In addition, all drip pans and pipes were wiped down. He had the plate freezer film removed and new film placed on the line. There was a fan not operating by line (B) which was unplugged. Mr. (B)(6) plugged it in and the fan began operating. As a preventive measure, Mr. (B)(6) stated he would retrain the employees for line (B) concerning condensation. In addition, he asked the SSOP monitor for Shift II to do an extra SSOP monitoring check for line (B) for 11/16/13. The regulatory control action (U. S. Tag B29 699994) was removed at approx. 1552h after the preventive measures were stated, sanitary conditions restored, and the product freezer film removed. The establishment's Standard Operating Procedures for Sanitation (Part 2; Section 1) states: (B)(4). Lack of adequate ventilation and ineffective SSOP monitoring failed to prevent product contact equipment from contamination with condensation. In addition, regulatory requirement for 416.13(c), 416.2(d) and 416.1 were not met. For a similar SSOP noncompliance record with the same cause (inadequate ventilation to control condensation), which resulted in product contamination, refer to HAY1122111802/1 dated 11/2/13. In addition on 11/5/13 and 11/6/13, there were 2 SPS NRs documented due to the same cause (inadequate ventilation; see NRs HAY1516111505N/1 and HAY5107110607N/1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1706115 717N-1	11/14/2013	01C02	Operational SSOP Review and Observation	C	<p>On 11/14/2013 at approximately 1008Hrs, I observed seven whole body packaged turkey's on the floor at the netting area. The bagged turkeys were at two employees feet and one was under a tank. At approximately 1012Hrs, I observed one employee pick up one of the whole body turkeys from the floor. He put it on to the food contact bag line. He then handed it to another employee which was on the other side of the line. The second employee put the turkey through the netting and then put it on to the line. The bagged turkey which was picked up from the floor was not rinsed. The two employees did not wash/sanitize their hands/gloves or the conveyor/table prior to or after putting the bagged turkey onto the line. (B)(6) and (B)(6) were immediately notified of the noncompliance. I showed Mr (B)(6) &nbsp;the affected turkey which was traveling on the conveyor belt. Mr. (B)(6) immediately removed the turkey form the belt. He had the affected bagged turkey reconditioned by (b)(4) water spraying (b)(4) at the product wash cabinet. He had the affected food contact conveyor sanitized. He had all employees in the area sanitize their gloved hands. Sanitary conditions were restored. This observed incident of a packaged food product picked up from the non food contact floor and put back with clean packaged food products on a clean conveyor is in violation to 9 CFR 416.4(a); 416.5(a), 416.4(d). This is also a violation to the establishment's Operational Sanitation 11 - A # 7.) Establishment's methods for production; (b)(4)</p> <p>. " was not met.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3117115 314N-1	11/14/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0910 hours, I was monitoring the second processing, rinse procedure (shift change) and I observed the following; Production employees were rinsing and applying the sanitizer (b)(4) as prescribed in the SSOP Plan on some of the product surfaces areas in Main Packaging.&nbsp;At approximately 0920 hours they finished. I observed that the blue conveyor belt that transfer product from the dumper to the saddle pack line was not rinsed and sanitized, the&nbsp;reconditioning station between Line #2 and Line (b)(4), two carts that were stationed there, one for dirty product and one for clean product were&nbsp;also not&nbsp;rinsed&nbsp;and sanitized.&nbsp;I tagged the area with U.S. Retained/ Rejected Tag # B31 406312I and contacted Department&nbsp;(B)(6) and (B)(6) and informed them about the noncompliance. The SSOP Plan states in part under Second Processing Rinse Procedure that (B)(4).</p> <p>Supervisors' contacted sanitation employees from dayshift and night shift, and they rinsed and sanitized the area. I released the area at approximately 0930 hours. My findings indicated a noncompliance with the following regulatory requirements of regulations 9CFR 416.13 (b) and 9CFR 416.13 (c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4206110 714N-1	11/14/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On 11/13/13 at approximately 2320 hours while performing pre-operational sanitation verification in plant 1 rehang area, after the establishments pre-operational checks and before the start of operation CSI (B)(7)(C) and CSI (B)(7)(C) found the following non-compliances to 9CFR 416.4(b) and 9CFR 416.4(a). Fat and protein build up was found on the (b)(4) filtering/tumbler unit and piping. The support beams and the conveyor belts utilized in the rehang area of plant 1 was observed to be in unsanitary due to fat and protein build up. (B)(6) was notified of our findings. Effected area's were cleaned before start up to restore sanitary conditions</p> <p>At approximately 2332 hours while performing pre-operational verification after the establishments pre-operation checks and start of operation in plant 2 rehang area CSI (B)(7)(C) and CSI (B)(7)(C) found fat on line (b) loop belt and line (b) conveyor belt, Fat and fat build up was found on # 9 drop conveyor machine and chutes. The plastic curtain that hung over the exit of the chute was torn and cracked and unsanitary with small pieces of fat on all surfaces. The bed and conveyor belt beneath the chute was observed to be unsanitary due to small pieces of fat and protein buildup the the surface. Sanitation (B)(6) was notified of our findings Effected areas were cleaned before start up restore sanitary conditions</p> <p>At approximately 2350 hours while performing pre-operation verification after the establishments pre-operation checks and before the start of operation in the (b)(4) room CSI (B)(7)(C) and CSI (B)(7)(C) found fat and protein buildup on (b)(4) deboning 3 and 4 units and supporting frames, Fat was also found on the contact surfaces of the product transfer belts of the units unsanitary due to small pieces of fat . We also found fat and protein residue on the walls of the (b)(4) room. (B)(6) was notified of our findings. Effected areas were cleaned before start up to restore sanitary conditions.</p>
5308	M6137	BXL4523113 414N-1	11/14/2013	01D01	SPS Verification	C	<p>On 11/13/13 at approximately 0020 hours while performing the review and observation component of sanitation performance standard task code CSI (B)(7)(C) and CSI (B)(7)(C) observed the following noncompliance to 9CFR 416.2(b)(1). In plant one we observed the curtain next to the inside outside bird washer that sanitation uses for over spray protection to be poorly maintained. There were large tears and worn spots in the fabric. (B)(6) was informed of our observation and noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2117112 613N-1	11/13/2013	06D02	Other Inspection Requirements	C	At approximately 1028 hours, while performing reprocessing procedures on Line (B)(7)(C) (Reprocessing Line) in Plant #2, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b). After I took my 10 bird sample for the reprocessing check, I observed that there was not enough light intensity. This area is being used to inspect CCP-1B (b)(4) as a critical control point and the reprocessing defects. SCS (B)(7)(C) measured the light intensity and it was 50 foot-candles. We asked (B)(6) to call an electrician. (B)(6) verified the light intensity and it was below 200 foot-candles. Electricians installed a temporary light, the light intensity was over 200 foot-candles. We informed (B)(6) of the noncompliance.
5308	M6137	BXL4706115 513N-1	11/13/2013	01B02	Pre-Op SSOP Review and Observation	C	On 11/12/13 at approximately 2142 Hours while performing pre-operational sanitation verification after the establishments pre-operational checks and before the start of production, CSI (B)(7)(C) and CS (B)(7)(C) observed the following noncompliance. In area 1, unit 25 live hanging table we observed fat and feathers from the previous days production on the hanging table and wall, U.S. Reject tag # B41800076 was applied to the table and informed (B)(6) of my findings. In area 2 feathers and fat was observed in picker # 2, line 1 and picker # 3 line 2, In area 4 we observed at inspection station # 7 fat from the previous days production. Fat residue was found floating in chiller # 2 by Dr (B)(7)(C) fat residue was removed before start of operation. At approximately 2250 hours while performing pre-operational sanitation verification after the establishments pre-operational checks and before the start of operation CS (B)(7)(C) and CS (B)(7)(C) the following noncompliance in the Rotisserie Room. Fat was found under the Packer product conveyor belt. (B)(6) was notified of our findings. Belt was cleaned to restore sanitary conditions. At approximately 2300 hours while performing pre-operational sanitation verification after the establishments pre-operational checks and the start of operation in the Paw room CSI (B)(7)(C) and CS (B)(7)(C) found a white plastic shovel in disrepair with pieces of plastic flaking off. Sanitation (B)(6) was notified of our findings. Shovel was removed and destroyed. At approximately 2325 hours while performing pre-operational sanitation verification after the establishments pre-operational checks and before the start of operation, the following noncompliance was observed in Packing department. At the front and back Leg Processers, Fat from the previous days production was observed on the leg processers (B)(6) was notified of our findings. Leg processors and area was cleaned before start of operation.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5014112 913N-1	11/13/2013	06D02	Other Inspection Requirements	C	On 11/04/2013, at approximately 0915 hours, I was ready to perform a Post-Chill Finished Product Standard Task. To start the process, I wanted to wash the FPS table adjacent to Chiller #2 in Plant #1 and no water was available from the hose. I informed (B)(6) and he informed me that he will called maintenance to fix it. I came back at approximately 1500 hours to perform a Post-Chill Task again at Chiller #2 and still no water was available. I informed (B)(6) of the noncompliance, he then called maintenance. At approximately 1540 hours maintenance fixed the pipe and water was available.This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5206112 213N-1	11/13/2013	01C02	Operational SSOP Review and Observation	C	<p>On 11/12/13 at approximately 0007 hours while performing SSOP review and observation; verification in plant 1 cooler; CS (B)(7)(C) and CSI (B)(7)(C) observed the following non-compliance to 9CFR 416.4(d) and 9CFR 416.2(d). We observed heavy beaded condensation on the ceiling and pipes of plant 1 cooler, upon further inspection of the cooler I observed directly underneath a section of heavy beaded condensation; a full tank of whole body chickens that had; it's blue plastic tank covering partly exposing the product inside. The tank had a fully exposed chicken laying on top of the tank cover. We immediately took regulatory control action by applying U.S. Retain tag # B31407422 to the tank of chickens and informing (B)(6) of my findings. Mr (B)(6) took corrective action by removing all the tanks underneath the condensation and replacing the tank covers and condemning the chicken that was exposed and wiping all the condensation to restore sanitary conditions. Regulatory control was relinquished at approximately 0120 hours and U.S. Retain tag # B31407422 was removed. At approximately 0020 hours while checking plant 1 staging cooler for condensation; we observed heavy beaded condensation under the cooling unit of the staging cooler, Dripping condensation was observed falling onto a pallet with; cardboard boxes; of whole body chickens that were bagged and not exposed to the condensation. I immediately took regulatory control by applying U.S. Retain tag # B 31406172 to the pallet and informing; Plant manager; (B)(6) of my findings. Mr (B)(6) took corrective action by having the pallet removed from the area and having the condensation wiped off and replacing the boxes with new ones. Regulatory control was relinquished at approximately 0122 hours and U.S. Retain tag # B31406172 was removed. At approximately 0500 hours SCS (B)(7)(C) and CSI (B)(7)(C) observed beaded and dripping condensation from the lights above the (b)(4) room. Beaded condensation was observed above exposed product on the table and conveyers and cones. (B)(6) and (B)(6) was notified of the noncompliance. Production stopped and all condensation was removed from the lights, tables, conveyors and effected cones was washed. area was released at approximately 0523 hours.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM592011 0413N-1	11/13/2013	01D01	SPS Verification	C	On 11/13/2013, at approximately 1838 hours, while performing a directed Sanitation Performance Standards (SPS) inspection task in response to a deficiency on the Cook Area Line ^{(B)(6)} Mezzanine, I observed the following noncompliance: a fire sprinkler attached to the overhead ceiling missing a cover plate causing a condition of exposed insulation directly over processing wing product creating insanitary conditions, a noncompliance per 9 CFR 416.1 and 416.2(b)(2). This condition was in the post lethality processing area and could lead to the spread of pathogens of a food safety concern and cross contaminate exposed product. I took regulatory control by stopping the Line ^{(B)(6)} production and rejected the area with US Tag 785927. I showed and informed Mr. ^{(B)(6)} of the forthcoming noncompliance. After corrective actions were performed by production and sanitary conditions were restored, I relinquished the US Tag at 1850 hours. The requirements of 9 CFR 416.1 and 416.2(b)(2) were not met.
1325 7	P33900	NHH151511 1213N-1	11/13/2013	01D01	SPS Verification	C	179At 0814 hours while performing an operational sanitation observation and review task I came across combos of inedible product (livers) in the inedible section of the back cooler that did not have denaturant applied. Management was notified and shown the combos. All of the combos had denaturant applied to the liners but there was no visible denaturant on the product in at least 3 of the combos. Edible and inedible containers of product were stored together. CFR 381.95 states that denaturing shall be accomplished by liberally applying it to all of the carcasses and parts. CFR 416.2b states that inedible and edible must be separated by time or space. These requirements were not met; therefore, regulatory control action was taken and the product was retained and the cooler was rejected. The area was released after all requirements were met.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH252211 3213N-1	11/13/2013	01C02	Operational SSOP Review and Observation	O	<p>On the calendar date of November 13, 2013 at approximately 0814 hours while in route to the pre-chill station to perform zero tolerance verification, the following noncompliance was observed: The establishment's SSOP states that (B)(4)</p> <p>(B)(4), I, CSI (B)(7)(C), observed that a plastic tote at the reprocessing station exhibited black foreign particles. The tote was positioned for use directly behind the reprocessing line. At this time, I randomly selected and inspected 4 totes from the nearby pallet. My inspection revealed black stains that smeared with touch, brown residue, and fat particles on the inner surface of 3 of the totes. The totes were rejected with U.S. REJECTED tag # B40172786 (B)(6)</p> <p>(B)(6), was shown the noncompliance, and she confirmed the findings. Ms. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record should be discussed during the next weekly meeting. A similar noncompliance record was documented on November 11, 2011; please reference NR # NHH5106115212N-1. The establishment's response to NR # NHH5106115212N-1 is pending.</p>
1325 7	P33900	NHH291311 3913N-1	11/13/2013	01C02	Operational SSOP Review and Observation	C	<p>#177On 11/12/13 while performing SPS tasks I observed that containers of product (inedible livers) staged in the designated "Inedible " section of the cooler were not properly labeled as such. The establishment's SSOP states that (B)(4)</p> <p>(B)(4) " These requirements along with the requirements of CFR 381.95 were not met. Management was notified and as a corrective action denaturant was placed on the product and inedible stickers were placed on all combos.</p>
1325 7	P33900	NHH471411 2713N-1	11/13/2013	01C02	Operational SSOP Review and Observation	C	<p>178At 0814 while touring the giblet room I observed 3 grossly contaminated containers being prepared to place inedible livers in . The combos had not been washed prior to bringing them in the plant. They contained a black build up on the inside and outside. These contents were also seen in the deep embedded grooves on the lips of each container. Slots had been cut on either side of one of the containers. There was mildew and traces of old meat scraps inside all of the combos. The establishment's SSOP states that (B)(4)</p> <p>(B)(4) " Management was notified and shown the condition of the combos. The combos were retained. During the same tour I inspected the inedible section of the cooler where I found containers of product which had not been labeled as such. The establishment SSOP also states that (B)(4)</p> <p>(B)(4) " These requirements and the requirements of 415.11 were not met therefore official control action was taken. corrective actions were completed and as a preventive measure, a written procedure for handling inedible product and containers was written by Management.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH460211 0812N-1	11/12/2013	03J02	Slaughter HACCP	C	On the night of production which began on 11/11/2013, Inspection checked the HACCP Records for the Production Shift beginning on 11/10/2013 for the Slaughter HACCP CCP's (Zero-tolerance for Whole Birds and Cut-up Parts and Pre-Shipment Review). In the Amendment Section of the Establishment's Slaughter HACCP Plan an entry was made on 10/31/2013 concerning two Fecal Finds at the Post-chill Station on 09/13/2013 and 10/03/2013 respectively. It stated that a Reassessment of the Plan would be done by 11/08/2013. The QA Department was unable to produce Documentation of the Reassessment of the HACCP Plan. The Requirement's of 9CFR 417.4(a)(3)(ii) were not met and (B)(6) was informed that a Non-compliance Record would be issued. Refer to NR #NHH1222094216N/1 (#136) dated 09/16/2013 for a similar Non-compliance.
5112	M18909	JDD2203112 512N-1	11/11/2013	01B02	Pre-Op SSOP Review and Observation	C	On 11/11/2013 at approximately 1150Hrs while performing pre-operational sanitation of the plant's Evisceration; Boning Room, Raw Fabrication Grinding and the Bagging Department's after the plant Q.C. and before start up of production, I observed the following noncompliance. (B)(6) and/or (B)(6) were notified of the noncompliance and shown all incidents. I observed all implemented corrective actions to food contact and non food contact surfaces. Evisceration- Outside kill area many feathers on the non food contact floor. b.) White conveyor which carries the turkey's into chiller A had too many to count pieces of meat, fat and skin (food contact). (c) Small gizzard table had three pieces of meat (food contact). d) Gib chiller had three meat pieces and meat residues (food contact). 2.) Boning Room - Drum (b)(4) had meat and meat residues (food contact) on a white piece which is attached. b.) Thigh (b)(4) - had meat and meat residues on a white piece which is attached; also meat and meat residues on the top left wheel (food contact). c.) The white thigh conveyor table had two pieces of meat (food contact). Raw Fabrication grinding room had meat and meat residues inside # 1 grinder (food contact). b.) The #1 grinder screen had meat residues (food contact). Bagging Roser Exit - lower belt had blue netting wrapped and jammed on the bottom side of the end roller (non food). b.) Second and third roser conveyor belt also had blue netting jammed in the rollers and one torn turkey bag (non food). The observed incidents of food contact surfaces found with meat, meat residues, fat and skin from previous days operations is in violation to 9 CFR 416.4(d); 416.13(c) and 416.4(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance is being linked to noncompliance (#147) JDD0411114204N/1 dated 11/4/2013; (#145) JDD4511100430N/1 dated 10/30/2013 and (#143) JDD3811102726N/1 dated 10/26/2013 for the same cause respectively.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4808112 212N-1	11/11/2013	01C02	Operational SSOP Review and Observation	C	<p>On 11/11/2013 at approximately 0125Hrs, I observed a plant employee bring a Osteo Bird to the blue incline chiller belt. The employee put the Osteo bird on the incline in front of me and walked away. The incline was carrying birds into the chiller at this time. I removed the bird from the conveyor because I could see debris on the carcass. The carcass breast skin was pushed back, I observed 3 black specks; one brown speck and one brownish piece, approximately 3/8" x 2mm in size of floor debris on the turkey. The debris were attached to the fascia. The HACCP personnel who was assisting me with my task at the pre chill USDA table call the employee back and ask him where he had collected the Osteo carcass. The employee showed us where the bird had fallen from the overhead conveyor belt onto the floor near the ladder. The personnel gave the carcass to an personnel working at the product wash cabinet for reconditioned. Then he put the carcass on the chiller conveyer. Dr. (B)(7)(C) and (B)(6) were notified of the noncompliance and shown the floor debris on the carcass. Mr. (B)(6) immediately implemented the plant's appropriate corrective action. He had the affected carcass reconditioning by trimming and (b)(4) water spraying. The carcass was reinspected and released back to production flow at approximately 0135Hrs after verifying the plant's corrective actions. This observed incident of food product adulteration by UFM (floor debris) not removed is in violation to the establishment's Operational Sanitation 11 Objective which states: (B)(4) Sub - #7.) Dropped edible product will be picked up in a timely manner. Whole body or part - Rinsed and trimmed as needed." The needed trimming was not done. This is also in violation to the relevent regulations cited above.</p>
5112	M18909	JDD5219114 611N-1	11/11/2013	01D01	SPS Verification	O	<p>At 0459 H PST, 11/11/2013 at the Carcass Dumper in the Boning Area, I observed several overhead Ceiling Panel missing and or loose. Ms (B)(6) and Mr. (B)(6) were shown the noncompliance and advised of Documentation of the same. Q.C. paerwork did not reflect this noncompliance prior to my notification of the same. This is a violation of the above 9 CFR's. This was written before (SAME ROOT CAUSE) on PRE-OP Noncompliance report 0107-2013, Dated 08/26/2013, JDD1010082526N/1 and Five other associated JDD Numbers and is linked. The repairs has proven inadequate or ineffective.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5604112 312N-1	11/11/2013	03C02	Raw Intact HACCP	C	<p>On 11/11/2013 at approximately 2222Hrs, I performed a physical verification check of the Raw Not Ground Turkey Breast and Drum meat which was weighed/scanned/loaded for shipping to the establishment's Plant #2. Using a company calibrated thermometer, I took the temperature of three Turkey Breast 1 Bl SL W/O Flt Hen and one Turkey Drum SO container which was loaded in trailer #3901 at the new Shipping Dock.&nbsp;The temperatures were (B)(4) &(B)(4) U.S. Retain Tag NO's:B43241034; (B)(4) were applied to the loaded affected Breast & Drum meat for temperatures above (B)(4) at shipping. (B)(6) ; (B)(6) and (B)(6) were notified of the noncompliance and verified my temperature findings at shipping. The (B)(4) appeared not to be evenly dispersed over the turkey meat. The establishment chose to add more (B)(4) and put the affected (2046, 2097,&nbsp;2132) pounds of Breast and (2327) pounds of turkey drum meat products into the P-157 blast. At approximately 0230Hrs on 11/12/13 all of the Turkey Breast and Drum meat were released back to shipping after verifying that all of the food products was (B)(4) and below. This observed incident of turkey products being shipped above (B)(4) is in violation to 9 CFR 381.66 (b) and 417.2(c)(4) monitoring at the critical limit. The establishment's supporting documentation for Salmonella Initiative Program (SIP) states; (b)(4)</p> <p>(b)(4)</p> <p>The establishment's HACCP Plan at shipping states; (B)(4) . Product will be maintained at or below (B)(4) Since the supporting documentation for your SIP waiver states that the establishment will (b)(4) and the SIP is used as justification in your HACCP plan, a violation of 417.5(a)(2) also exists.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH040711 2312N-1	11/11/2013	01D01	SPS Verification	C	<p>On the calendar date of November 11, 2013 at approximately 1626 hours while performing the Operational SSOP Review and Observation task, the following facility noncompliance was observed: The Operational Sanitation section of the establishment's SSOP's states that (B)(4) (B)(4), I, CS(B)(7)(C), observed multiple droplets of condensation on the overhead white piping (parallel to the hang line) in room 1 of the further processing department. The condensate covered approximately 25 ft. of the piping. At the time of the findings, whole birds were being processed in the area. Also, the area of the ceiling in which the piping begins exhibited heavy moisture as well. (B)(6) (B)(6), was shown the noncompliance, and he confirmed the findings. Mr. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on October 30, 2013; please reference NR # NHH4602102430N-1. The establishment's response to NR # NHH4602102430N-1 of, "The condensation was removed." - failed to prevent recurrence.</p>
1325 7	P33900	NHH510611 5212N-1	11/11/2013	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of November 11, 2013 at approximately 1642 hours while performing the Operational SSOP Review and Observation task, the following noncompliances were observed: The establishment's SSOP states that (B)(4) (B)(4), I, CS(B)(7)(C), observed blood specs, fat particles, and greasy residue on the inside of 9 plastic tubs near the front half drop conveyor. The tubs were pulled from a pallet labeled "Clean". I randomly selected and inspected 6 additional tubs from the pallet and 4 of the tubs exhibited an orange residue which was greasy to the touch. The outside of 2 of the tubs exhibited the same residue. The tubs were rejected with U.S. REJECTED tag # B40172782. (B)(6) (B)(6), was shown the noncompliance and he agreed to the findings. Mr. (B)(6) was informed that a noncompliance record would be issued. A similar noncompliance record was documented on October 29, 2013; please reference NR # NHH3405104029N-1. The establishment's response to NR # NHH3405104029N-1 of, "The affected tools were rinsed and sanitized." - failed to prevent recurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH492311 3310N-1	11/10/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At 2133 hours on the night of production which began on 11/10/2013, while performing required PHIS Poultry Zero-Tolerance task at the designated Line #2 Pre-chill station at est. 33900 P, after randomly selecting 10 slaughtered and eviscerated and chilled chicken carcasses for the subgroup test and having begun the test at 2133 hours, Inspection found fecal material on the 1st bird in the set. The fecal material was a dark green color and of a pasty consistency which would easily smear to the touch. It consisted of one piece 1/4" in diameter and measuring approximately 1/16" in width, located inside the carcass in the Kidney Crypt area.</p> <p>(B)(6) was shown the carcass and he concurred that the material in question was indeed feces. Upon investigation, it was found that the cause of the fecal find was "High Pressure tripped out causing (b)(4) to be clogged up resulting in fecal failure". Plant Management's Measure to prevent recurrence was "Turned 2nd High Pressure Pump on and replaced clogged Spray Nozzle on (b)(4) The requirements of 9CFR381.65(e) and 417.2(c)(4) were not met and Mr. (B)(6) was advised that the incident would be documented on a Noncompliance Record.&nbsp;Refer to NR #NHH0412112308N/1 dated 11/08/2013 for a similar Noncompliance. Plant Management's measure to prevent recurrence was: "The height was raised on the (b)(4) Machine and will be monitored for the duration of the day." To date all preventive measures may not have been implemented as described or were ineffective in preventing recurrence.</p>

[illegible]

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA3419110 109N-1	11/09/2013	01C02	Operational SSOP Review and Observation	C	<p>On November 9, 2013 at approximately 1635 hours while performing my Operational Sanitation Inspection in the "Raw Side Blending Room" I observed noncompliance with SSOP regulatory requirement 416.13(c) and SPS 416.1, 416.4(d).Raw Side Blending Room:&nbsp; I observed one damaged&nbsp;bin of Chicken MDP&nbsp;staged in the blending room ready to be used.&nbsp; The bin was damaged at the bottom leg area and the plastic liner was torn exposing the Chicken MDP. &nbsp;U.S. Retain Tag NO B38934390 was applied to this bin of MDP.&nbsp;(B)(6) and Ms. (B)(6) , was informed and showed the noncompliance.&nbsp; Immediate corrective action was implemented by management.&nbsp; At 1755 hours the bin of Chicken MDP was condemn and denatured in my presence. With the establishment back into compliance, U.S. Retain Tag NO B38934390 was removed.This does not comply with the establishment written SSOP Program which states in part:&nbsp;Objective;(B)(4) .&nbsp; This is also a violation of Regulatory Requirement(s) which states in part: 416.1; "Operate in a manner to prevent insanitary conditions", 416.4(d); which states in part: "Product must be protected during processing, handling, and storage", and 416.3(c) which states in part: "Plant monitors implementation of SSOP Procedures".This noncompliance report serves as written notification that failure to comply with regulatory requirement(s) of 9 CFR 416 could result in additional regulatory or administrative actions.</p>

[illegible]

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN032211 1408N-1	11/08/2013	01C02	Operational SSOP Review and Observation	C	<p>On November 8, 2013 while performing my operational sanitation inspection in the Raw Side Warehouse I observed the following noncompliance.&nbsp; At approximately 1745 hours I observed a plant employee taking his bags of spices to the production area.&nbsp;&nbsp; On his cart was two bags of brown sugar.&nbsp;&nbsp; The bags of brown sugar had round holes along the side of the bags and the brown sugar was exposed.&nbsp; U.S. Retain Tag B38934387 was applied to the damaged bags of brown sugar.&nbsp; I informed and showed (B)(6) and (B)(6) the noncompliance.Upon further investigation three more bags of brown sugar was found damaged with holes in the bags.&nbsp; Immediate Corrective Action was implemented by management all five bags of brown sugar was condemn by management in my presence.&nbsp; This does not comply with Regulatory Requirement 416.1 which states in part: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated", and 416.4(d) which states in part: "Product must be protected from adulteration during processing, handling, storage, loading, and unloading".&nbsp;&nbsp; Upon review of the establishment's written SSOP Program on page #3 Part II Operational Sanitation:&nbsp; (B)(4) ". This NR serves as written notification that failure to comply with the regulatory requirement(s) of 9 CFR 416 could result in additional regulatory or administrative actions".</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN311511 5508N-1	11/08/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1305 while performing Operational Sanitation Review and Observation on the Raw side, I observed a small white edible roll around barrel in the Raw Oven area by the salt (B)(4) mixing tank. The white barrel had a yellow liquid like substance roughly 3 1/2 inches deep in it that was slippery to the touch. No noticeable odor was smelled. I also observed multiple (8) black like specks (1/16in.) in size on the inside surface of the barrel. There was no identification on the white barrel indicating what the yellow substance is. This is a noncompliance of Regulation 416.4(c) and a failure of the Plant Operational Sanitation Plan. U.S. Retained Tag NO. B39554790 was applied to the small white barrel with the yellow liquid (B)(6) and (B)(6) were notified and observed the white barrel with the yellow liquid in it. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
5129	M210	LQN480311 5908N-1	11/08/2013	01D01	SPS Verification	C	On November 7, 2013 while walking through Raw Side Cooler #4 I observed noncompliance with SPS regulatory requirement(s) 416.1 and 416.4(d). At approximately 2340 hours I observed dripping condensation on the overhead roll up door entering raw side cooler #4. U.S. Reject Tag NO. B38937094 was applied to Cooler #4 door. I informed and showed (B)(6) and (B)(6) the noncompliance. This is a product traffic area but at the time of my observation no product was being taken into Cooler #4. Immediate Corrective action was implemented by management: Cooler #4 Door was completely wiped down in my presence. At approximately 2350 hours sanitary conditions was restored and U.S. Reject Tag NO. B38937094 was removed. This does not comply with Regulatory Requirement 416.1 which states in part: "Each official establishment must be operate in a manner to prevent insanitary conditions and to ensure product is not adulterated", and Regulatory Requirement 416.4(d) which states in part: "Product must be protected from adulteration during processing, handling, and storage". This document serves as written notification that failure to comply with regulatory requirement(s) of 9 CFR 416 could result in additional regulatory action as described in 9 CFR 500.4.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2305111 408N-1	11/08/2013	01C02	Operational SSOP Review and Observation	C	On 11/08/2013 at approximately 0130 hours in Packaging while monitoring (b)(4) Belt Sprays function installed by the establishment as part of the corrective action resulting from the (NOIE) Notice of Intended Enforcement dated October 7, 2013, I observed the following. A (b)(4) unit for saddle packed product was recently installed. Using a ladder, I observed that the required spray rinse at the end of the line was not operating. I moved to the opposite side of the unit and found the valve to the water hose that supplies rinse water to the unit was in the closed position. I contacted (B)(6) and asked why the required rinse was not on. He opened the valve but the spray heads only emitted an occasional drop of water. Mechanics were called and the spray heads were removed and cleaned restoring the rinse. 1 1/2 racks approximately 6 1/2 brown product tubs of wings were unwrapped so that the required rinse could be applied. Sanitary conditions were restored by approximately 0235 hours. A review of the establishment computer records revealed that the concentration of (b)(4) at 0102 hours was documented to be at a concentration of (b)(4) ppm. A second computer entry "N/A" was made under 'Potable Water Rinse'. I reviewed the establishments' HACCP Plant -Raw Intact-Packaging Step 16 Saddlepack Dip. Under Potential Hazards Introduced, Controlled or Reduced at the step it lists (C) (b)(4) and Is the hazard Significant? NO. Under 'Justification for Decision' it states (b)(4) . A review of FSIS Directive 7120.1 Rev dated 8/13/2013 under 'Antimicrobial lists (b)(4) used 'To treat the surface of raw poultry carcasses or parts (skin-on or skinless) and then 'Dip tank application' to treat poultry carcasses/parts 'not to exceed 10 seconds'... and then "When application is not followed by immersion in a chiller, the treatment will be followed by a potable water rinse." Product treated with (b)(4) and not rinsed is considered to be contaminated. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN150511 5908N-1	11/08/2013	04A06	Poultry Finished Product Standards	C	At 0300 hours while I was performing Finished Product Standards (FPS) check on the reprocessing line of the evisceration department; I observed one split tail carcass, out of a ten carcass sample, which had one side with kidney tissues still inside the pelvic cavity. Carcasses are marked with split tails to identify that vacuuming is required to remove and condemn all affected tissues including the kidneys. I performed a recheck at 0307 hours and observed two out of the ten split tail carcasses with, again, one side of the kidney tissue not removed from the inside of the pelvic cavity. I immediately informed (B)(6); and (B)(6) representative of my findings and forthcoming noncompliance report. Immediately, Mr. (B)(6) and Mr. (B)(6) started the establishments' corrective actions as prescribed in the establishment's vacuum procedure. The requirements of 9 CFR 381.84, 9 CFR 381.76 table 1 #7 and Plant Standard Criteria for air sac were not met. This document serves as notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
1325 7	P33900	NHH041211 2308N-1	11/08/2013	03J02	Slaughter HACCP	C	On November 08, 2013 while performing a routine pre-chill task at approximately 0829 hours on evisceration line #2, I observed fecal material on the right wing tip of the seventh bird of a ten bird sample. It was greenish gray in color, approximately an 1/8 inch in diameter and located in the hollow of the inside wing tip. The findings indicated a deviation from the critical limit, no visible feces at CCP 1, as prescribed in the establishment's HACCP plan. There were no adequate interventions between this step and the chilling tanks when I performed this check. Therefore it is reasonable to assume that the feces would have entered the chilling tanks in violation of Regulation 9 CFR 381.65(e). Mr. (B)(6) informed me that the cause of the noncompliance was equipment failure. The height was raised on the vent machine and will be monitored for the duration of the day. Mr. (B)(6), and (B)(6), were shown the noncompliance and they confirmed the findings. A similar noncompliance record was documented on 10/17/13, please reference NR # NHH1812105817N/1.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0504114 307N-1	11/07/2013	01B01	Pre-Op SSOP Record Review	C	<p>On 11/05/2013 at approximately 2130 hours while performing a records verification procedure required by the establishments' (NOIE) issued on October 7, 2013, I observed the following. The establishments' Pre-Operational Sanitation - Bio Trace Sampling Log-Evisceration/Packaging for 11/02/2013 registered a failure in Area 3 (b)(4) Room Line 1 on 10/28/2013 with a reading of 584 Relative Light Units(RLU's). The 'Corrective Action' section on the form has not been updated with the new requirements outlined under the Establishments' 'Notice of Deferral Verification Plan of October 13,2013. Which states under the Sanitation Standard Operating Procedures (SSOP) and Sanitation Performance Standards (SPS) section, Item 16, in part (b) (4)</p> <p>_____;" I contacted (B)(6) who performs the Bio Trace Testing on the AM shift and asked her who does the rechecks for the PM shift. She said she did but was not aware of the failure. A review of the Bio-Trace Log for the week of 11/4 revealed that no checks were done on the failed item as part of the randomly selected items and that no required rechecks had been performed. I informed her that a noncompliance would be issued and she stated that correcting action for the noncompliance would address starting that night by adding the recheck to the randomly selected items. My findings indicated a noncompliance with 9 CFR 416.12(a), 9 CFR 416.(a),(b) & (c), and 9 CFR 416.16(a).</p>
5308	M6137	BXL1004115 607N-1	11/07/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 11/6/2013 at approximately 0010 hours while monitoring the Establishments' Pre-Operational Sanitation Standards in Packaging Area #1, I observed the following. There were several specks to approximately 1/16" of black UFM (Unidentified Foreign Material) that smeared like grease on the top and product contact side of the white nylon wheel for Leg Processors 7 & 8. The white wheels hold the product during cutting then drops the cut portion onto a collection belt that takes it to the packaging point. There was a piece of semi-dried tissue to approximately 3" on the under side of Leg Processor #7 and another piece of similar size on Leg Processor #9 near the chain. There was approximately 5 pieces of fat each several square inches in size on the drum associated with the collection belt under Leg Processors 7-9. The Leg processors were cleaned and sanitized then released at approximately 0025 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1804112 007N-1	11/07/2013	01D01	SPS Verification	C	On 11/06/2013 at approximately 2215 hours while monitoring the Establishments' Pre-Operation Sanitation Standards in Plant #1, I observed the following. There was a piece of stainless steel approximately 3" long by 1mm thick; peeling off a guide bar associated with the (b)(4) for Line #1. The affected guide bar is on the out flow side of the unit. The guide bar is directly above the carcasses that is being opened at this point in the process. Flaking metal is creating an insanitary condition. This is a reoccurring issue caused by metal to metal contact between the guide bars and the carcass shackles. I contacted (B)(6) who called a mechanic. A piece of emery cloth was used to smooth the affected area. A review of the Establishments' HACCP Plan -Slaughter Plant #1 under (P) Physical Hazards states 'None Identified'. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).
5309	P6137A	NJN291211 3007N-1	11/07/2013	01D01	SPS Verification	C	Tuesday, November 5, 2013, at approximately 1940 hours, while in the fillet department I observed, in area six (section "C"), that the (singulators, cabinet, transfer and twin scale belt # 5) drip pan hose was missing. Due to this there was a continuous dripping of water onto the north side cross feeder belt # 2. The plant failed to comply with the regulations 9 CFR 416.4(d) and 9 CFR 416.1. 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." 9 CFR 416.4(d) states: "Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments." I immediately tagged the drip pan with USDA tag # B43303939 and informed Mr. (B)(6), of the noncompliance. Mr. (B)(6) stopped the north side cross feeder belt, until they fixed the drip pan hose, and sanitized feeder belt #2. I brought Mr. (B)(6) and maintenance attention to the north side & south side cross feeder belts running over each other with no drip pans underneath the upper and middle belts, causing the dripping of water and an accumulation of small pieces of muscle and fat on the lower belts and surrounding structures. On Friday November 8th I checked the area, after they had completed the installation of the drip pans, and the area was found acceptable. Mr. (B)(6) informed me that the maintenance will change the drainage hoses of the five singulators, cabinet drip pans for effective drainage. On Monday, November 11th I checked the singulators cabinet drip pan hoses and they were found acceptable.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH001511 3007N-1	11/07/2013	01C02	Operational SSOP Review and Observation	C	<p>At 0839 hours I observed insanitary conditions and cross contamination of cut-up product in the reprocessing area of the evisceration department. The first four stands in the reprocessing area were being used to salvage cut-up product. Cut-up table #4 contained 5-6 carcasses piled together. Cut up table #3 had 6-8 frames piled at one end, removed parts stacked in the middle and 6-7 birds piled at the other end and scattered over the grate which was partly submerged in water due to the catch basin under the grill being stopped up. Water from the basin had also spilled over on the table area leaving all the product on the table in standing water. Cut-up table #2 had carcasses stacked on each end of the table area. The operations at those tables were stopped and (B)(6) was notified and shown the conditions of the salvage stations. US Reject/Retain tag #B38075589 was assigned. The establishment's approved reprocessing procedure for cut-up salvage states that birds will be removed from the reprocessing line at the station(s) labeled Cut-up and handled individually until reconditioned. This is done because the carcass has already been designated as contaminated. First, there weren't any signs on any of the reprocessing stations. Second, salvage product prior to conditioning and reconditioned product were comingled at all of the stations. (Example: piling removed parts on the table allowing them to accumulate and be oversprayed and recontaminated by other carcasses before placing them in the designated totes.) At 1003 hours same conditions were observed at the IP salvage station. There were 8 unprocessed carcasses piled on the grate and the table. There is a statement in your Air Sac and IP salvage procedure that allows more than one bird on the salvage table as long as they are not being piled on top of each other. However, these requirements also were not met also.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1623115 706N-1	11/06/2013	01C01	Operational SSOP Record Review	O	<p>On the 7th during the PM hours, I notified Ms. (B)(6) that the Blue Incline Belt Bottom Door was open and allowing carcasses to go on the floor. She informed the Maintenance Leadperson. It still did not get fixed. Ms. (B)(6) mentioned that Maintenance was aware of this issue on the 6th. There was not any interventions in place to keep carcasses from getting on floor. I observed several carcasses get on the floor and were reconditioned. This is a violation of the Establishment's written SSOP Program which states in part: " (B)(4)</p> <p>bsp; This substance of this quote was not met. This is also a violation of the following 9 CFR's: §416.4 Sanitary operations. (d) Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments. §416.13 Implementation of SOP's. (b) Each official establishment shall conduct all other procedures in the Sanitation SOP's at the frequencies specified. (c) Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's. This is linked to the following Noncompliance 151-2013, Dated 11/02/2013.</p>
5129	M210	LQN562111 2706N-1	11/06/2013	01D01	SPS Verification	C	<p>On November 6, 2013 at 1555 hours when I walked up to wash my hands at the hand wash sink in the raws side Catering Department I observed noncompliance with SPS Regulatory Requirement(s) 416.1; and 416.4(b). Raw Side Hand Wash Sink: I observed that the hand wash sink in the Catering Department was plugged up with meat and water. Inside the hand wash sink was two sausage trays that is used for the D Shape products. U.S. Reject Tag NO. B38937091 was applied to the hand wash sinks and sausage trays. (B)(6) and QC Rep Mr. (B)(6) was informed and showed the noncompliance. At 1615 hours after sanitary condition was restored (hand wash sink and sausage trays washed and sanitized) U.S. Reject Tag NO. B38937091 was removed. This does not comply with Regulatory Requirement(s) 416.1 which states in part: "Each official establishment must operate in a manner to prevent insanitary conditions and to ensure product is not adulterated", and 416.4(b); which states in part: "Non-Food-Contact surfaces of facilities, equipment and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". This document serves as written notification that failure to comply with the regulatory requirement(s) of 9 CFR 416 could result in additional regulatory action as described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0820110 406N-1	11/06/2013	01C01	Operational SSOP Record Review	C	On 11/05/2013 at approximately 1500 hours, I went to review the Establishments' Pre-Operational and Operational Sanitation Records (Daily Monitoring Logs) for the previous days. The SSOP Monitoring Log for Loading Dock for Day shift dated on 11/02/2013 was missing. I asked (B)(6) about the SSOP Daily Implementation and Monitoring Log for the Loading Dock. She informed me later that the SSOP Log in Loading Dock was performed but she can not find the Log. This is a noncompliance with the following regulatory requirements with regulation 9CFR 416.16 (a).
5308	M6137	BXL5117111 006N-1	11/06/2013	03J02	Slaughter HACCP	C	While performing Finished Product Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2(c)(4). At approximately 1233 hours, I randomly removed a 10 bird sample from Line #1 in Plant #1, I found one out of the ten birds with visible fecal contamination inside the bird at the right side, under the leaf fat area. The fecal material was a smear measuring approximately 5/16" diameter in size, green and white in color and pasty in texture. This exceed the limit of (b)(4) for the process to be in control. I informed (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 1245 hours and it passed. This is a violation of the critical limits of CCP-2B (b)(4) of the Plant's HACCP Plan for Slaughter.
1326 1	M33901	HAY470711 5907N-1	11/06/2013	01C02	Operational SSOP Review and Observation	C	On the calendar date of November 6, 2012 at approximately 0739 hours while performing the Operational SSOP Review and Observation task, the following noncompliance was observed: I, CS (B)(7)(C), observed beaded condensation and what appeared to be sud-like foam steadily dripping from underneath the grinder (near the X-Ray machine) into a combo of ground chicken. The combo was retained with U.S. RETAINED tag # B40172783 (B)(6), was shown the noncompliance and he confirmed the findings. Mr. (B)(6) stated that the sud-like foam was actually sanitizer used by the sanitation crew, and since the sanitizing solution was diluted, that no product adulteration existed. I requested to review information on the sanitizer and was presented with the MSDS for (b)(4) Sanitizer, which is the common name for the sanitizer. The information stated that "Before use as a sanitizer, food products & packaging material must be removed from the room or carefully protected." The MSDS also states "Allow sanitized surfaces to adequately drain before contact with food and then air." Mr. (B)(6) was informed that a noncompliance record would be issued. This non compliance record will be discussed during the next weekly meeting.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY510711 0607N-1	11/06/2013	01D01	SPS Verification	C	<p>On the calendar date of November 6, 2013 at approximately 0705 hours while performing the Operational SSOP Review and Observation task, I, CS(B)(7)(C), observed the following facility noncompliances: 1) Droplets of condensation on the ledge above the air curtain between the shipping cooler and the IF department. 2) Beaded condensation on a pipe directly above a stainless lug containing chicken breast on line 2 -zone 3. Condensation was also observed on a pipe above the conveyor leading into the breeding area where chicken patties were being processed. 3) Multiple beads of condensation on the underside of the cooling unit above the hopper to the Ex-Ray machine. At the time of the findings, boneless skinless chicken breast were inside the hopper. Please be advised that employees in these areas were shown the condensation, and corrective actions were initiated. No product adulteration was observed. Also, at approximately 0836 hour while walking through the shipping cooler, I observed condensation dripping from the underside of a catch pan. At the time of the findings, water splatter was observed on one bag of batter, which was staged on a pallet below the drip pan. No contamination occurred, as the bag was sealed. (B)(6), was shown the noncompliance and corrective actions were initiated. Mr. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on November 5, 2013; please reference NR # HAY1516111505N/1. The establishment's response to NR # HAY1516111505N/1 is pending.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4323113 105N-1	11/05/2013	01C02	Operational SSOP Review and Observation	O	<p>On 11/05/2013, I observed a Blue Tub, Designated by the Establishment's Color Coding System for edible use. It had a Ink Pen in it. Ink Pen not a product contact surface. This was on the Offal Wrapping Machine. I notified Ms. (B)(6) and Ms. (B)(6). Additionally this morning, 11/07/2013, I observed Gray Tote/Tub with scissors in it and the Establishment's color code (Gray) for inedible. Ms.(B)(6) and Ms.(B)(6) notified as was Ms. (B)(6) and Mr. (B)(6) by the phone. This is linked to 0148-2013. Dated 11/04/2013, JDD123111704N/1. This is a violation of the Establishment's written SSOP program stating in part: (B)(4)</p> <p>" was not met. This is also a violation of the following 9 CFR's: §416.4 Sanitary operations. (a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. §416.13 Implementation of SSOP Procedures (c) Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's. §416.14 Maintenance of Sanitation SOP's. Each official establishment shall routinely evaluate the effectiveness of the Sanitation SOP's and the procedures therein in preventing direct contamination or adulteration of product(s) and shall revise both as necessary to keep them effective and current with respect to changes in facilities, equipment, utensils, operations, or personnel.</p>
5309	P6137A	NJN510611 2005N-1	11/05/2013	01C02	Operational SSOP Review and Observation	C	<p>At 0705 hrs. I was observing an employee in the packaging department between the chiller exit and (b)(4) #4, knife salvaging one legged carcasses by hand. The employee was using a movable wheeled stainless steel salvage table. On this table there were several carcasses piled on top that were in the process of being salvaged. I observed that the employee had a steel, used for sharpening his knife, that had rust formation down the entire length of the steel. This steel was on top of the table, coming into contact with the carcasses that were piled on the table. I contacted (B)(6) and (B)(6). I informed them of the non compliance to the regulations cited above. The steel was removed from production. The product involved was sent to the reprocessing process. The establishment's Sanitation Standard Operating Procedures, Part 2, Section 2 states (B)(4)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN542011 2805N-1	11/05/2013	01D01	SPS Verification	C	<p>At approximately 1042 hours, I was in the MDP room when I observed a plant employee lifting a wooden pallet from the wet dirty floor, laying its bottom on his smock while moving it. Being that the bottom of the pallet was dirty and wet from the floor, it soiled the employees smock. After moving the pallet, the employee proceeded to work with his soiled smock. I immediately stopped him and called the (B)(6), and informed him of the noncompliance. Mr. (B)(6), without delay, asked the employee to change his sock. I, also noticed that all the employees working in the DMP room were all not wearing sleeve coverings, which is a requirement in this circumstance because they were handling exposed product. I explained this to Ms. (B)(6), and asked her if they can wear aprons to be easy to wash and sanitize and provide them with sleeve covers. Ms. (B)(6) brought aprons and sleeve covers to all the DMP room employees to wear. The plant failed to comply with the regulations 9 CFR 416.1, 416.5(a) & (b), and their SSOP modification which states that: (B)(4)</p> <p>"</p>
1326 1	M33901	HAY061611 2905N-1	11/05/2013	01C02	Operational SSOP Review and Observation	C	<p>&nbsp;On the calendar date of November 5, 2013 at approximately 0933 hours while performing the Operational SSOP Review and Observation task, the following noncompliance was observed: I, CSI (B)(7)(C), observed an employee near the mega jet line handling cardboard boxes and frozen meat blocks of Ground Chicken Breasts simultaneously. A close examination of the box lids revealed foreign particles, which were gritty to the touch, and wood pieces from damaged pallets. At the time of the findings, 4 meat blocks were in a combo ready for processing. I observed as the employee remove lids from 2 additional boxes and then proceeded to remove the frozen meat blocks with the same gloves that came in contact with the insanitary lids without washing or sanitizing his hands. I took regulatory control as delineated in 9 CFR 416.6 and asked the employee to cease operations. The product was retained with U.S. RETAINED tag # B38464348. (B)(6), and (B)(6), were shown the noncompliance and they confirmed the findings. Mr. (B)(6) was notified that a noncompliance record would be issued. Please be advised that approximately 300 lbs of frozen Ground Chicken Breast Meat was denatured and condemned. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on 11/2/2013; please reference NR # HAY1122111802N/1. The establishment's response to NR # HAY1122111802N/1 is pending.</p>

[illegible]

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0411114 204N-1	11/04/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On 11/4/2013 at approximately 1030Hrs while performing pre-operational sanitation of the plant's Evisceration; MSP, Boning, Cooler 9, Raw Fabrication grinding, Tray Pack, Box Out and Bagging Departments, after the plant Q.C. and before start up of production,&nbsp;I observed the following noncompliance.</p> <p>(B)(6) and/or (B)(6) were notified of the noncompliance and shown all incidents. I observed all corrective action to food contact and non food contact surfaces. Evisceration - NE Scalding (food contact) had many feathers in the scald water. b.) Straddle picker & tail puller (food contact) both had meat, meat residues and feathers. c.) neck conveyor - had one blood and two meat pieces (food contact). d.) Retrussing table&nbsp;- had two feathers on the top side (food contact) and&nbsp;had one meat piece and feathers on the underside (non food contact). e.) Gizzard splitter - &nbsp;had two meat pieces, meat residues and four feathers (food contact). f.) Three steel gloves - had meat. g.) Chiller A - 1st. section - had many pieces of meat and&nbsp;fat on the screens and meat residues on one paddle (food contact). h.) Chiller B - exit 1st section had four meat pieces and one Esophagus (food contact). 2.) Raw Fabrication grinder - (B)(4) needle injector - had one 2" x 1/4" blue hard plastic tie up which was laying on the food contact injector. 3.) MSP - Beehive screen had two meat pieces and meat residues (food contact). b.) Contherm # 2 had meat residues (food contact). 4.) Boning - White cutting board - had three pieces of meat. b.) Blade Saw - had meat residues (food contact). 5.) Bagging - Product wash cabinet (inside) had one piece of meat. b.) One piece (8" x 1/8") of belt trimmings on the underside (non food contact).&nbsp;The observed incidents of food contact surfaces found with meat, meat residues, feathers, plastic tie up&nbsp;from previous days operations is in violation to 9 CFR 416.4(d); 416.13(c) and 416.4(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance is being linked to noncompliance (#145) JDD4511100430N/1 dated 10/30/2013; (#143) JDD3811102726N/1 dated 10/26/2013 and (#136) JDD1711103122N/1 dated 10/22/2013 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5910114 705N-1	11/04/2013	03J02	Slaughter HACCP	C	<p>On 11/04/2013 at approximately 0920 & 0930Hrs and again at approximately 2225Hrs, I found the plant failed to meet the established Boning Department Chilling CCP 5B requirement of (B)(4) or less within 8Hrs from slaughter. Using a company calibrated thermometer, I performed a physical verification check of the Whole Body Heavy Tom Turkeys (Lot# 7988) which were at the Chiller B exit. My findings were (B)(4) & (B)(4) & (B)(4). U.S. Retain Tag NO's: B31 390407 & 08 were attached to two combo bin, approximately 4000 pounds, with temperatures above (B)(4). The attached plant's tags showed the combo bins exiting the chiller & at 0320Hrs & 0321Hrs. (B)(6) was notified of the noncompliance and verified my findings. Mr. (B)(6) chose to add more ice to the affected turkeys. (B)(6) was called and she also applied her retain tags. At approximately 1130Hrs the affected product was rechecked and the temperature was (B)(4) and below. 2.) At approximately 2225 to 2331Hrs on 11/4/2013, I found Turkey Brst 1 B/L S/L W/O Flt Tom and Turkey Trim A.K. white with temperatures exceeding the time and temperature requirement of (B)(4) within 8Hrs from slaughter. The affected food products was on the New Shipping Dock for shipping. U.S. Retain Tag NO's: B39554693; (B)(4) & (B)(4) where applied to turkey product with temperatures exceeding (B)(4). The plant's attached tags showed the turkey breast and white trim leaving the Boning Room at 0810; 0941, 1035, 1043, 0956, 0824 & 1042Hrs. Using a company calibrated thermometer. My temperature findings were (B)(4) & (B)(6) and (B)(6) were notified of the noncompliance and verified my temperature findings. Mr. (B)(6) had the affected product put into the P-157 blast (B)(6). also added her retain tags. On 11/5/2013 at approximately 1120Hrs (3 released) and 2320Hrs (4 released). The (11535 total pounds) of turkey breast and one bin of white trim was released back to production after verifying all of the affected product was at or below (B)(4). The establishment chose to run the University of Wisconsin PMP calculation and it showed no Salmonella outgrowth using the 1100pm dated 11/4/2013 to 1100am on 11/5/2013. The establishment has Salmonella Initiative Program (SIP), a waiver to 9 CFR 381.66(b). This waiver allows the establishment chill whole birds/parts to (B)(4) in 8Hrs from slaughter. This observed incident of product temperatures above (B)(4) exceeding the 8Hrs from slaughter is in violation to the plant's HACCP Plan at the Boning Department monitoring of CCP 5B which states in part; (B)(4)</p> <p>(B)(4)</p> <p>The plant's CCP 5B established company</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							critical limit which states; (B)(4) was not sufficient in preventing temperatures above 45F. This noncompliance is being linked to noncompliance (#108)JDD2323083626N/1 dated 08/26/2013 for the same cause respectively.
5129	M210	LQN3000112504N-1	11/04/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On November 3, 2013 at approximately 2150 hours while performing my Pre-Operational Sanitation inspection in the HPP Department I observed noncompliance with SPS regulatory requirements 416.4(b).&nbsp;HPP Packaged/Box Out Area:&nbsp;After the packaged product received it's lethality step and exit the HPP Department into the Packaged Box Out Area I&nbsp;observed &nbsp;both Chutes where bags of product come in contact with prior to being boxed&nbsp;out had a build up of black unidentifiable foreign material on the top surface of the chutes, which may create insanitary conditions. I immediately informed and showed Ms (B)(6) the noncompliance.&nbsp;Immediate Corrective Action was implemented to restore sanitary conditions in my presence.&nbsp;The HPP Department is address in the establishment written SSOP.&nbsp;1.&nbsp;Pre-Operational Sanitation Objective:&nbsp;(b) (4)</p> <p>This does not comply with Regulatory Requirements 416.4(b); which states in part: "Non-food-contact surfaces must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions".&nbsp;This NR is linked to NR#LQN1600102214N/1 dated 10/14/13, for a similar NR on Pre-op Inspection in the HPP Department.&nbsp;Management response to NR#LQN1600102214N/1; "Immediately after USDA rejected the boards they were removed and disposed of in the presence of USDA.</p>
5308	M6137	BXL2219112804N-1	11/04/2013	01D01	SPS Verification	C	<p>At approximately&nbsp;1625 hours, Line Food Inspector (B)(7)(C) observed a live juvenile cockroach when she was applying sanitizer to her gloves from the sanitizer dispenser box that is located between Line (B)(4) and Line (B)(4) attached to the wall in front of the ice machine. She caught the cockroach and contacted CSI (B)(7)(C) and CSI (B)(7)(C) and showed them her findings. We contacted (B)(6) and showed him our findings. (B)(6) contacted (B)(6).&nbsp;The area was washed.This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2 (a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2709113 904N-1	11/04/2013	01802	Pre-Op SSOP Review and Observation	C	On 11/04/2013 at approximately 0652 hours while monitoring the establishments Pre-Operational Sanitation procedures in Plant #2, I observed the following. In Area #2, Unit # 9, 1/2 of Picker #1 Line (B)(6), there were numerous feathers, too many to count, from the last production day which was 11/02/2013, inside the picker. I informed (B)(6) of the noncompliance. I continued with the Pre-Operational Sanitation procedure and I observed also in Area #2, Unit # 22, 1/2 of Picker #4 Line (B)(6) also had numerous feathers inside the picker. I again informed (B)(6). Sanitation rewashed both pickers, restoring sanitary conditions. I reinspected and released the pickers at approximately 0704 hours. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.1, 9CFR 416.14, 9CFR 416.4(a), and 9CFR 416.13(c).
5309	P6137A	NJN441411 4904N-1	11/04/2013	04A06	Poultry Finished Product Standards	C	At approximately 0911 hours, while performing the finished product standards check on the reprocessing line, I found six carcasses with trim defects. Four of them had cellulitis lesions on the breast and flab areas ranging from three to one square inches, one carcass had a large mutilated area about two square inches on the breast, and another had part of the cloacae and intestine still attached (approximately one inch long). Also, I found a carcass that was contaminated with ingesta on the crop area. I immediately stopped the reprocessing line and showed Mr. (B)(6), and Mr. (B)(6) my findings and informed them of the forthcoming noncompliance. The plant failed to keep the reprocessing line in compliance with the federal regulations. 9 CFR 381.86 states: "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned." 9 CFR 381.91(b)(1) states: "Any carcass of poultry accidentally contaminated during slaughter with digestive tract contents shall not be condemned if promptly reprocessed under the supervision of an inspector and thereafter found not to be adulterated. Contaminated surfaces that are cut shall be removed only by trimming. Contaminated inner surfaces that are not cut may be cleaned by trimming alone, or at an approved reprocessing station away from the main processing line, by any method that will remove the contamination, such as vacuuming, washing, and trimming, singly or in combination. All visible specks of contamination must be removed, and if the inner surfaces are reprocessed other than solely by trimming, all surfaces of the carcass shall be treated with (b)(4) water containing (b)(4) ppm available (B)(4) "

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH280211 3904N-1	11/04/2013	01C01	Operational SSOP Record Review	C	<p>At&nbsp;approximately 0100 hours on 11/4/13 Inspection observed the following noncompliance.&nbsp;While a performing scheduled SSOP Records Review task for the night of production that began on 10/31/13, a SSOP deficiency was noted for 11/1/13 at 0257 hours. The deficiency involved 90 lbs of WOGS on the floor. The establishment determined the chiller exit belt diverter gate was at fault. The establishment gave a preventive measure of (B)(4)</p> <p>There was no notation/documentation in the SSOP Record that this preventive measure was performed. This is a noncompliance of section 9CFR 416.15(b) and 9CFR 416.16(a). (B)(6) was notified of this noncompliance. Refer to NR#NHH1201100414N for a similar noncompliance.</p> <p>&nbsp;</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY112211 1802N-1	11/02/2013	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of November 2, 2013 (Saturday) at approximately 2055h while performing the Operational SSOP Review and Observation task, I observed the following noncompliance: I, CS(B)(7)(C), observed 5-10 droplets of condensation located on the underside of a drip pan &nbsp;directly above Line¹⁵ product.&nbsp;Raw, unfrozen wing poultry product was being processed on line¹⁶ when I observed the condensation droplets.&nbsp;I immediately informed the lead person for the line (Mr. (B)(6)) to stop the line.&nbsp;He had the line stopped and proceeded to find some plastic to cover the product, but before he could return with the plastic I observed it drip onto product located on the stopped line.&nbsp;I immediately informed management (Ms (B)(6)) that product on the line had been contaminated with the dripping condensate from the drip pan.&nbsp;She condemned about 5 lbs of wing product and removed several feet of the plate freezer film the product was on to restore sanitary conditions.&nbsp;As a preventive measure, she informed me that someone had turned the fan off that was used for adequate ventilation above line¹⁶ &nbsp;She immediately turned it on and informed me she would retrain her employees to keep the fan on.&nbsp;After this preventive measure was stated, &nbsp;sanitary conditions restored and the product involved condemned, I allowed production to resume.&nbsp;As a regulatory action, I had the line stopped, but a U. S. tag was unnecessary since I remained until all corrective actions were taken that met 416.15. &nbsp;Production resumed at approx. 2100h. The establishment's Standard Operating Procedures for Sanitation (Part 2; Section 1) states: (B)(4)</p> <p>.&nbsp;&nbsp; Lack of adequate ventilation and ineffective SSOP monitoring failed to prevent product and product contact equipment from contamination with condensation.&nbsp;In addition, regulatory requirement for 416.13(c), 416.2(d) and 416.1 were not met. For a similar noncompliance record with the same cause (inadequate ventilation to control condensation) please refer to HAY0614093509N/1 dated 9/9/13.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4201114 502N-1	11/01/2013	03J02	Slaughter HACCP	C	<p>On 11/01/2013 at approximately 0819Hrs, I observed that the establishment failed to remove the WIP (work in process) tag prior to putting the reprocessed whole body turkeys into production flow. I saw two plant employees taking whole body turkeys out of a barrel and putting them into a tank containing whole body turkeys. The barrel was tagged with a WIP (work in process) red tag. The tank of whole body turkeys had been released by the HACCP Monitor. One employee was putting the whole body turkeys from the tank onto the blue incline which was taking the birds into the chiller. U.S. Retain Tag NO:B39554900 was applied to the tank containing the WIP birds from the barrel. Ms. (B)(6) was near by and was notified of the noncompliance. She called (B)(6) to come to the chiller incline. Mr. (B)(6) was notified of the noncompliance and showed the WIP tagged empty barrel. I notified Mr. (B)(6) that the employees had put the bird from the barrel into the tank. He questioned the employees. He took immediate corrective actions. He had all of the birds in the tank reconditioned bird by bird with (b)(4) ppm (b)(4) water spraying. The whole body reprocessed birds were released back to production flow at approximately 0848Hrs after verifying the plant's appropriate corrective actions and reinspection. This observed incident of personnel not following the establishment's Reprocessing Whole body Turkey's WIP procedure is in violation to the Reprocessing Whole body turkeys HACCP Plan monitoring for CCP 1B. The in place CCP 1B is to comply with 9 CFR 381.65(e) zero tolerance for feces and the plant's in place monitoring 9 CFR 417.2(c)(4). This noncompliance is being linked to noncompliance (#118) JDD2321092618N/1 dated 9/18/2013 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN511911 0401N-1	11/01/2013	04A06	Poultry Finished Product Standards	C	<p>At&nbsp;1545 hours, I was performing a zero tolerance verification task on the tubs of salvaged parts in the evisceration department.&nbsp;I randomly selected 5 pieces of salvaged parts from each tub.&nbsp;I found one piece of drum stick contaminated with unidentified black foreign material in a tub identified from A-line. &nbsp;The size of the foreign material was approximately ½ centimeter by ¼ of centimeter, I tagged the tub with the USDA retain tag # B43303858, and showed my finding to (B)(6), and (B)(6).&nbsp;The product was released after the corrective actions were proffered,&nbsp;which involved reworking the tub of product.&nbsp;I also informed&nbsp;(B)(6),&nbsp;of the non compliance with 9 CFR 381.65(a) which states:</p> <p>"Operations and procedures involving the processing, other handling, or storing of any poultry product must be strictly in accord with clean and sanitary practices and must be conducted in a manner that will result in sanitary processing, proper inspection, and the production of poultry and poultry products that are not adulterated."</p>
5310	M6137B	FFA0713113 901N-1	11/01/2013	01D01	SPS Verification	C	<p>On November 1, 2013 while making a routine patrol of the establishment's raw production department; (kitchen) I observed noncompliance with SPS regulatory requirement(s) 416.2(d), 416.1, 416.4(d) and 416.2(b)(1). At 10:44 hours I observed beaded dripping condensation on the bottom side of the gray beams and iron rails between oven #1 & #2 loading areas in front of stuffer #6; no product affected. As well there was a brass valve leaking water onto the walls and the white pvc pipes behind the small blender. (B)(6) were notified and shown the condensation and (B)(6) was notified and shown the leaking valve. This NR represents SPS noncompliance of the regulations cited above; as well as written notification that failure to comply with regulatory requirement(s) may result in additional regulatory or administrative actions as described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4511100 430N-1	10/30/2013	01801	Pre-Op SSOP Record Review	C	<p>On 10/30/2013 at approximately 0050Hrs while performing pre-operational sanitation of the plant's Chiller B; MSP, Boning Room and Raw Fabrication Grinding Departments, after the plant Q.C. and before start up of production, I observed the following noncompliance. (B)(6) were notified of the noncompliance and shown all incidents. I observed all corrective actions to food contact surfaces. 1.) Evisceration - Chiller B- The 6th. bays&nbsp;section had 4 pieces of meat and one meat residue. 2.) MSP and&nbsp;Boning Room - The # 4 cylinder had meat on the inside. B.) The grey thigh&nbsp;trim belt on the top side had meat residues. 3.) Raw Fabrication Grinding Room - The (B)(4) (injector) had meat and meat residues. This observed incidents of food contact surface found with meat and meat residues from previous days&nbsp;operations is in violation to 9 CFR 416.4(a); 416.4(d) and 416.13(c). This noncompliance is being linked to noncompliance (#143) JDD3811102726N/1 dated 10/26/2013; (#136) JDD1711103122N/1 dated 10/22/2013, and (#135) JDD1507102418N/1 dated 10/18/2013 for the same cause respectively.&nbsp;</p>
5129	M210	LQN160910 0730N-1	10/30/2013	01D01	SPS Verification	C	<p>At approximately 0615 while performing hands on Pre-Operational Sanitation, on October 30th, 2013, after company Pre-Operational Sanitation and before the start of production in Zone E, I observed a non compliance with the (b) (4) Blenders.I&nbsp;requested that&nbsp;both of the chain drive cabinets (5' wide X 6' tall)&nbsp;for the (b) (4) Blenders be opened up&nbsp;for inspection. Maintenance has the tool to open the cabinets. Once the cabinets for the (b) (4) Blenders were opened, I observed the inside of the cabinets, the gears and chains were covered in a red like substance&nbsp;that was slick and smeared at the touch. I observed meat tissue pieces, to numerous to count,&nbsp;ranging in size from 1/4 inch to 2 inches from the previous days production on the inside of the cabinet doors and thru out the intire cabinet. The inside of the gear drive cabinet is a non product contact surface, but could create crosscontamination from liquid draining out the bottom of the cabinet onto the floor.This is a noncompliance of Regulation 416.1 and 416.4(b) and a failure of the company SSOP Plan Pg. 2. I. (B)(6) observed the noncompliance. (B)(6) &nbsp;was notified and observed noncompliance (B)(6) for nights was notified and observed the cabinets.&nbsp;Inspection was informed that sanitation does not have access to the cabinets for daily cleaning.This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5102104 030N-1	10/30/2013	04A06	Poultry Finished Product Standards	C	On 10/30/2013 at approximately 0006 hours while performing a Pre-Chill Finished Product Standards check on line (B)(6) in Plant #2, I observed the following. After taking a standard random 10 bird sample, I accumulated 45 nonconformance points. 7 of the 10 birds had crops. This exceeded the subgroup absolute limit of (B)(6) points. I contacted (B)(6) and informed him of the failure. A QC recheck failed at 0016 hours with 37 nonconformance points. 5 of the 10 birds had crops. At this point the process is judged to be out of control. Pre-Chill rechecks at 0046 and 0117 hours brought the process back into control. Post-Chill checks at 0028 hours and for every 30 minutes until 0200 hours passed. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv)(d)(4).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN230210 0430N-1	10/30/2013	01C02	Operational SSOP Review and Observation	C	<p>On Sunday October 27th, at the beginning of the night shift, CS (B)(7)(C) observed the following on the first process area: At approximately 2315 hours while walking through the slaughter area, she observed birds falling from the auto re- hang equipment on to the floor. During approximately 5 to 8 minutes the birds were consistently falling on the floor making two piles of approximately 200 birds each. Some of the birds were directly falling inside of the drain blocking the flow of water in the drain, which started to rise almost reaching the surface of the floor. (B)(6), started picking up the bird from the drain and by doing so, her boot came into direct contact with the pile of birds on the floor. As she removed the carcasses from the drain, she was holding and swinging them on top of the pile of birds on the floor. These carcasses were heavily dripping causing cross contamination on the rest of the birds. The water from the drain is loaded with contaminants including feces, which may increase bacteria growth on contaminated carcasses. She condemned the birds from the drain but proceeded to grab the hose with the intention to rinse the rest of cross contaminated birds. CSI (B)(7)(C) immediately approached her and explained to her that those birds had been cross contaminated with water from the drain. (B)(6) then proceeded to condemn the rest of the birds on the pile. Approximately a full inedible barrel was filled with condemned carcasses. There was a second employee that came to the area and grabbed the hose and started to wash the birds on the other pile. He was spraying each carcass and placing them on the re- hang conveyor. At approximately 2330 hours, CS (B)(7)(C) requested (B)(6) to perform a (B)(4) check on the hose being utilized to rinse the birds from the floor. There was no (B)(4) being supplied through this hose. She then, notified (B)(6) and proceeded to place a Rejected /Retained hold tag N0 B43303847 on the hose. This hose was not connected to the main (B)(4) piping system and therefore removed by maintenance. Another hose was connected directly from the (b)(4) piping system and brought above the auto re hang equipment and down onto the area where birds fall on the floor and are to be rinsed. The (B)(4) level on this new hose was 48 PPM. CSI (B)(7)(C) released the US hold tag, after sanitary conditions were restored. This is a failure to implement the establishment's SSOP program as written. As stated on the SSOP Part 2- Operational Sanitation, Section 1 for Evisceration, under Description of Sanitation Procedures states: (B)(4)</p> <p>(B)(6) was notified of the non compliance the morning of 10/28/2013 at approximately 0530 hours. This represents non compliance with regulatory requirements of regulations 9 CFR 416.4(d) and 416.13(c)</p>

[illegible]

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH460210 2430N-1	10/30/2013	01D01	SPS Verification	C	<p>On the night shift that began on 10/29/2013, at approximately 2310, I was in the further processing department at Establishment 33900&nbsp;P. &nbsp;I was in Room 1, further processing when I observed heavily beaded condensation on the yellow hose and the electrical conduit pipes in the overhead.&nbsp;This condensation was actively dripping on the floor.&nbsp;This area has a product drop-slide and the establishment has a floor salvage procedure in the area so I was about to reject the area.&nbsp;A QA Tech in the area told me she would have the condensation dried and the floor re-washed, which she did in a timely manner so no Regulatory Control Action was taken.&nbsp;When this was done I continued monitoring the area. &nbsp;The establishment's SSOP plan objective states:</p> <p>&nbsp;(B)(4)</p> <p>"&nbsp;&nbsp;The SSOP plan also states on page 10, paragraph 4, (B)(4)</p> <p>&nbsp;Regulation 416.2 (d) states "Ventilation. Ventilation adequate to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product and the creation of insanitary conditions must be provided. &nbsp;The requirements of 9 CFR 416.2(d)&nbsp;was not met. &nbsp;Refer to NR #NHH4604103809N / 1, dated 10/09/2013 for similar non-compliance of dripping condensation. &nbsp;&nbsp;&nbsp;To date all measures to prevent recurrence by management may not have been implemented properly or were ineffective.</p>
5308	M6137	BXL3608105 329N-1	10/29/2013	03J02	Slaughter HACCP	C	<p>On 10/29/2013 at approximately 0046 hours while monitoring Post-Chill Finished Product Standards in Plant #1 from product exiting Chiller #2, I observed the following. After taking a standard 10 bird sample, I observed one bird with visible fecal contamination. There was a&nbsp;cloacae&nbsp;with approximately 2" of intestine attached inside at the tail.&nbsp;The &nbsp;fecal material was inside the carcass&nbsp;on tissue under the left side fat flap. The fecal material was light brown in color, pasty in texture and measured approximately 1/4" by 1/4". This exceeded the limit of (b)(4) for the process to be in control. I had the hanging of product going into Packaging stopped. There were no QC personnel available so I performed a recheck that passed at approximately 0049 hours.</p> <p>(B)(6) was informed. The procedure for a Post-Chill&nbsp;&nbsp;fecal failure was implemented. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the CCP-2B Zero Fecal Contamination of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH340510 4029N-1	10/29/2013	01C02	Operational SSOP Review and Observation	C	<p>On the night of production that began on October 28, 2013 at approximately 2340 hours in Room 1 Further Processing I observed two stainless steel scoops and two stainless steel shovels on the roller belt used to transport boxed product to the cooler.&nbsp;This belt is not considered a product contact surface and the scoops and shovels were thereby contaminated.&nbsp;When asked what the utensils were used for, Mr. (B)(6), stated the scoops and shovels were used to place ice onto product.&nbsp;The utensils were rejected with US tag B38075687.&nbsp;Mr. (B)(6) was notified the noncompliance would be documented on a noncompliance record.&nbsp;Mr. (B)(6) restored sanitary condition to the utensils and as a verbal preventive measure, stated the responsible employee would be retrained to properly handle the scoops and shovels.&nbsp;The regulatory control action was then released.&nbsp;At approximately 2345 hours at the end of the grade A wog line, boxes with plastic liners were stacked on each other such that the outer surface of the box contacted the inner surface of the liner, a product contact surface, thereby contaminating the liners.&nbsp;Six boxes and liners were rejected with US tag B38075683.&nbsp;Mr. (B)(6), was notified of the noncompliance and informed it would be documented on a noncompliance record.&nbsp;Inspection observed as Mr. (B)(6) discarded the packaging material.&nbsp;As a preventive measure, Mr. (B)(6) stated the responsible employees would be retrained.&nbsp;The regulatory control action was then released. The establishment's SSOP plan states (B)(4) " The requirements of 9 CFR 416.13(c) were not met. For a similar noncompliance refer to NR NHH5113102621N/1 dated October 21, 2013.&nbsp;The preventive measure for this noncompliance was employees would wash their hands prior to handling product.&nbsp;These measures may have been implemented incorrectly or may have been ineffective at preventing recurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH030310 2928N-1	10/28/2013	01C02	Operational SSOP Review and Observation	C	<p>On the production shift that began on 10/27/2013, at approximately 2315 Hours I was in Room #2 at Establishment 33900 P. I was in the marination line area to perform operational sanitation inspection on product contact surfaces of the fryer marination line. Two production personnel were mixing marination for the start of operations. These 2 workers were opening and mixing marination without removing the outer wrapper of the bag. These outer wrappers are considered insanitary and the Establishment's procedure is to remove the outer wrapper before emptying the contents into the mixer. Regulatory Control Action was taken by applying USDA Reject Tag numbered B38075840 to the Start/Stop switch of the marination machine. The non-compliance was shown to Ms. (B)(6) and she had the marination emptied from the mixer and the marination pipes and the mixer and pipes recleaned and sanitized. Ms. (B)(6) was informed that a non-compliance record would be issued. The requirements of Regulations 416.4(d) and 416.13(c) were not being met. The preventive measure given by Ms. (B)(6) was that the employee that was opening the bags would be written up for improper job performance.</p> <p>Refer to NR #NHH2900073301N/ 1, dated 08/20/2013 for similar non-compliance of an adulterant on product contact surfaces (insides of hoses).</p> <p>The Establishment's SSOP plan objective is</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2815101 226N-1	10/26/2013	01C02	Operational SSOP Review and Observation	O	On 10/26/13 at approximately 1251 Hours while performing Operational SSOP Review and Observation task in cooler # 1. I observed the following non-compliance . I observed a stainless tank containing approximately 1652 pounds of edible necks with a tank liner that was torn along the top sides of the liner. Brown and black grease was observed along side the non food contact surface of the liner near the tears in the liner. No grease came into contact with product. I immediately took regulatory control by applying U.S. Retain tag # B39554887 to the tank and informing (B)(6) of my findings. Mr. (B)(6) took immediate corrective action in my presence by removing effected part of the liner and replacing the tank with a new cover. Sanitary conditions were restored and regulatory control was relinquished.
5112	M18909	JDD3811102 726N-1	10/26/2013	01B02	Pre-Op SSOP Review and Observation	C	On 10/26/2013 at approximately 1220Hrs while performing pre-operational sanitation of the plant's Evisceration, Raw Fabrication, MSP and Bag Line Departments, after the plant Q.C. and before start up of production, I observed the following noncompliance. (B)(6) and (B)(6) were notified of the noncompliance and shown all incidents. I observed all corrective actions to food contact surfaces and non food contact surfaces. 1.) Evisceration - Trussing table (food contact) had UFM (rail type) dripping from the overhead line. One was flake black pieces and One was black liquid dripping. b.) Gizzard Splitter and Gizzard Defatter (food contact) - both had meat pieces; gizzard peel and feathers. c.) Chiller Transfer A to B - 3 pieces of meat. 2.) Bag Line- Yellow line had one meat and one trachea on bottom side of conveyor (non food contact). The Red line had two pieces of meat on bottom side of conveyor (non food contact). The Blue line conveyor (food contact) had UFM flakes (brown & black) which fell from the ceiling when the employee was removing condensation. 3.) Raw Fabrication - Poss Machine (food contact) had meat on 2 of the parts and one piece of meat on the metal detector (inside). 4.) MSP - Beehive screen (food contact) had 2 pieces of meat. One part had meat residues; One long pipe had 2 pieces of meat. The observed incidents of food contact surface found with meat, meat residues, feathers and black & brown UFM from previous days operations is in violation to 9 CFR 416.4(d); 416.13(c) and 416.4(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance is being linked to noncompliance (#136) JDD1711103122N/1 dated 10/22/2013 and (#135) JDD1507102418N/1 dated 10/18/2013 for the same cause respectively.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4507103 926N-1	10/26/2013	03J02	Slaughter HACCP	C	<p>On 10/25/2013 at approximately 2200 hours while reviewing a previously requested copy of the establishments' computer records, I observed the following. It appeared that since 10/16/2013 when red water readings in chiller #3 at 2316 hours that the establishment has been adding (B)(4) to Chiller #3 while 'Organic' product was being processed. After startup for slaughter; kill date 10/26/13 at approximately 0100 hours; I checked the computer records and found entries at 12:14 PM that 'Makeup water' was 34ppm and at 2301 hours that the red water was 3.9ppm. A review of the establishments' HACCP Plant for Slaughter for Plant #2-Organic" Step 24 'Carcass Chilling' under Potential Hazards Introduced, Controlled, or Reduced at this point (c): Chemical has "NONE Identified". I contacted (B)(6) and asked him about the (B)(4) being used in Chiller #3. I read him the section from the HACCP Plan for Slaughter -Organics which does not include a reference for the use of (B)(4) as a processing aid and informed him of the noncompliance for an inadequate hazard analysis. My findings indicated a noncompliance with 9 CFR 417.2(a)(1), 9 CFR 417.2(c)(1), 9 CFR 417.2(c)(2)(i), 9 CFR 417.2(c)(3), 9 CFR 417.4(a)(3)(i), 9 CFR 417.5(a)(1) and 9 CFR 417.5(a)(2).</p>
5308	M6137	BXL4716100 426N-1	10/26/2013	01C01	Operational SSOP Record Review	C	<p>On 10/25/2013 while performing an Operational Sanitation Records Review Task, I observed that there was no SSOP Log for the Loading Dock on 10/20/2013, A.M. shift. I asked (B)(6) about the missing SSOP Log and she informed me that she would investigate the matter as it was the A.M. shift Log. The next day, 10/26/2013, (B)(6) informed me that no SSOP Log for the "Dock" on 10/20/2013 had been documented. The SSOP Plan states in part, that QA Inspector or designee (B)(4) informed (B)(6) of the noncompliance. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.13(b), 9CFR 416.16(a), and 9CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2403101 426N-1	10/25/2013	01D01	SPS Verification	O	<p>On 10/25/2013 at approximately 0517Hrs, I observed heavily beaded condensation on the bottom side of the approximately 2" wide grey beam (non food contact) which runs parallel to the white (food contact) large cooler units drip pan at the boning room rehang table. The beam is directly over the turkey processing line and processing table. The line was full of whole body turkeys at this time of my observation. I immediately notified Ms (B)(6) and showed her the beaded condensation/water. I ask for a supervisor. (B)(6) came and implemented appropriate corrective action. He had the hanging line stopped. He covered the line with plastic. He was also shown heavily beaded condensation/water which was on a grey beam over the line and also on the ceiling at the overhead turn wheel. He had the condensation removed by wiping. He restarted the line at approximately 0521Hrs. I did not observe any direct food products adulteration at this time. This observed incident of heavily beaded condensation over food products and processing line during production was creating insanitary conditions and a potential food products adulteration. This is in violation to the relevant regulation cited above. This noncompliance is being linked to noncompliance (#111) JDD4522091103N/1 dated 9/3/2013 and (#92) JDD2523074126N/1 dated 7/26/2013 for the same cause respectively. Mr. (B)(6) were notified of the noncompliance.</p>
5112	M18909	JDD2511100 026N-1	10/25/2013	06D02	Other Inspection Requirements	C	<p>On 10/25/2013 at approximately 0830Hrs, I found the establishment failed to meet the regulatory requirements to 9 CFR 381.68(b). When I looked at the plant's (presentation/line speed) checks for line One and line two. I found the speed was 42 birds per minute at 709Hrs on line two and 42 birds per minute on line One at 705Hrs. The Evisceration at this time (655 to 739Hrs) was running Consumer Tom Turkeys with scheduled weight 25 pounds each bird. The line speed was exceeded on line one and line two. This is in violation to the Maximum inspection rates for (NTIS) New Turkey Inspection System regulation chart which states in part..maximum line speed for birds weighting 16 pounds are more for two inspector on one line is 41 birds per minute. (B)(6) was immediately notified and Ms (B)(6) notified (B)(6) that a noncompliance will be issued. This noncompliance is being linked to noncompliance JDD2521095525N/1 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3420102 525N-1	10/25/2013	01D01	SPS Verification	C	On 10/25/13 at approximately 1810 Hours while performing SPS Verification check in cooler # 4. I observed beaded condensation on the overhead beams and pipes above covered tanks of product. No product was contaminated by the condensation. I immediately took regulatory control by applying U.S. Reject tag # B39554888 to the area and informing (B)(6) of my findings. Mr. (B)(6) took immediate corrective action in my presence by removing the tanks of product from the area and removing the condensation from the beams and pipes to restore sanitary conditions. U.S. Reject tag # B39554888 was removed and regulatory control was relinquished at approximately 1835 Hours.
5308	M6137	BXL0521105 625N-1	10/25/2013	03B02	Raw Non-Intact HACCP	C	At approximately 1520 hours while performing a HACCP Raw-Non Intact Records Review task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.2 (c)(4).The HACCP Monitoring Log -CCP3B- Sanitizer Concentration Verification Raw-Non Intact, dated on 10/23/2013 for AM shift, had Monitoring, Direct Observation and Records Review with the same initials. I asked (B)(6) if it was the same Quality Control or designee person that signed the HACCP Raw-Non Intact Log. She informed me later that the Direct Observation was performed by the same person that performed the monitoring of activities and Records Review. I explained that Quality Control or designee can not perform Direct Observation on their own monitoring activities. I informed (B)(6) about the noncompliance.
5308	M6137	BXL1121102 425N-1	10/25/2013	03J02	Slaughter HACCP	C	At approximately 1500 hours while performing a HACCP Slaughter Records review task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.2 (c)(4).The HACCP monitoring Log -CCP2B- Final Bird Washer, Plant #2 (Line (B)(4) and (B)(4)) AM shift had the following Zero Tolerance checks times: Line (B)(4), 0333 hours and 0440 hours. Line (B)(4), 0340 hours and 0447 hours. The gap between the two checks on Line (B)(4) was one hour and seven minutes and on Line (B)(4) was one hour and seven minutes also.The HACCP Plan states in part under monitor procedures that " (B)(4) (B)(4)).I informed (B)(6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5023105 525N-1	10/25/2013	01B01	Pre-Op SSOP Record Review	C	<p>On 10/24/2013 at approximately 2200 hours while performing a records verification procedure required by the establishments' (NOIE) issued on October 7, 2013, I observed the following. The establishments' Pre-Operational Sanitation - Bio Trace Sampling Log - Evisceration/Packaging for the week of 10/18/2013 registered a failure of ss (stainless steel) tanks in Area #5 on 10/18 with a reading of 1514 measured in Relative Light Units (RLU's). The unit was recleaned and a retest registered 43. The 'Corrective Action' section on the form has not been updated with the new requirements outlined under the Establishments' 'Notice of Deferral Verification Plan of October 13, 2013. Which states under the Sanitation Standard Operating Procedures (SSOP) and Sanitation Performance Standards (SPS) section, item 16, in part (B)(4)</p> <p>(b) (4)</p> <p>"The required 5 rechecks are not documented because (B)(6) was not aware of the new requirements. I discussed the noncompliance with (B)(6) and made her aware of the new requirements. My findings indicated a noncompliance with 9 CFR 416.12(a), 9 CFR 416.(a),(b) & (c), and 9 CFR 416.16(a).</p>
5309	P6137A	NJN020510 4125N-1	10/25/2013	04C05	Poultry Good Commercial Practices	C	<p>At 0230 AM on October 25, 2013 during the night shift at Est. P 6137A, I observed the following non compliance: A carcass, which clearly showed signs of having died by means other than slaughter, was found coming down evisceration line B. The carcass was congested on one side, with large areas of icthemia on the breast. The viscera was very congested, and the liver was very dark, congested, and friable. I showed the carcass to (B)(6) and (B)(6). Regulations not met include 9 CFR 381.65(b) which states that poultry must be slaughtered in a manner which will result in thorough bleeding of the carcass, 9 CFR 381.71 which states that carcasses showing on antemortem any disease or condition that would cause condemnation on post-mortem inspection shall be condemned, 9 CFR 381.83-Carcasses showing evidence of septicemia or toxemia, or evidence of an abnormal physiological condition shall be condemned. This would include dying chickens as well as those dead on arrival.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA321110 3924N-1	10/24/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On 10/24/13 while performing Sanitation Standard Pre-operational Inspection. The following deficiencies were observed after the establishment's Q. C. Technician had informed me that the establishment's inspection was complete. 1. At approximately 0418 hours I observed a roll of blue plastic liners that were wet with an unidentified type of liquid, laying directly on top of a wooden pallet that had approximately 9 bags of uncovered evaporated salt stored on it. The blue liners have been observed in used to cover combos that contain edible product. The manner that the blue combo liners (product contact surfaces) were stored could have cause insanitary condition to the product. (B)(6) was notified. No reject tag was applied as I observed immediate corrective actions. The area was release at approximately 0425. 2. At approximately 0501 hours, before FSIS had completed the inspection of the peel room area to determine the sanitary conditions, I observed an employee attempting to enter the peel room area with a pallet that contained a roll of blue combo liners (product contact surface) and dry ingredients. The outer layer of the liner had a misty looking liquid covering the surface and the liners were observed lying directly on top of the bags of dry ingredients with undetermined sanitary conditions. The employee's actions to enter the area with product before pre-op inspection was completed and the condition of the blue combo liners (product contact surfaces), did not meet the requirements outlined in, FSIS-PHIS Directive 5000.1 "Verifying an Establishment's Food Safety System", Chapter 2 part III "Sanitation Standard Operating Procedures (Sanitation SOPs) (B)(6) was notified. 3. At approximately 0520 hours I observed 2 batter pumps that had some thick whitest liquid looking material coming out of the bell areas while maintenance was attempting to prepare them for my inspection, while inspecting the pumps I observed some highly visible creamy whitish looking material build up inside the metal portion of the pump and around the inside rubber seal area. The whitish material appeared to be product batter left from the previous day's production. Official control action was taken. (B)(6) was notified. U.S. retain tag #B22393369 was applied. Q.C. informed me that the area had been cleaned and was ready for re-inspection. While I was re-inspecting the pumps, I observed some whitish dry crusty looking substance around the entire edge of the inside seal of one of the pumps. (B)(6) was notified. The area was released at approximately 0558 when corrective measures were verified by FSIS. 4. At approximately 0534 hours while inspecting the frank product wash sinks located at the end of each fryer in the frying room, I observed some sticky, gluey material at the top right hand corner on 3 sinks (at fryers #s 2, 3 & 7). The material was covering an area approximately 6X4 square inches. The material appeared to be the glue or tape left as a result of removing the equipment label signs (Frank Wash Sink). The (B)(6) was notified. No reject tags were applied as I observed immediate corrective action by</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							the establishment. The area was released at approx. 0608 hours. -The deficiencies describe on this noncompliance record did not met all the requirement of 9CFR 416.13(c), 416.1, 416.4(a) 416.4(d).-This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).
5112	M18909	JDD0402105 225N-1	10/24/2013	03C02	Raw Intact HACCP	C	<p>On 10/23/2013 at approximately 0900Hrs, Dr. (B)(7)(C) and I reviewed the 10/18/2013 (Chicken (B)(4) Monitoring Log) during our records review. We found that the plant failed to document what was done to the product as part of the plant's corrective action when the (B)(4) level was 2300ppm which is above the recommended level of use. The plant's Quality Control Raw Fabrication (b)(4) (b)(4) Log for Chicken (B)(4) showed that on 10/18/2013 at 1606Hrs, the Boneless Chicken Breast with Rib Meat concentrations were 2300ppm. As part of the plant's corrective action for (b)(4) the maintenance was informed. The record did not show what happened to the product. The plant's HACCP Plan identified (b)(4) chemical contamination as "not likely to occur" because of an established (B)(4) Monitoring program (Attachment # 7) (FTP1 (B)(4) Monitoring T1.1/090 Revision # 2 page 2 of 2 date 12/16/11). The (b)(4) procedure states, (b)(4)</p> <p>"&nbsp; The 2300ppm is above the recommended use by the supplier. The Plant Chicken (B)(4) Monitoring Record did not document the corrective action done to the product when the (b)(4) level was at 2300ppm.&nbsp; This failure to document the corrective action done to the Chicken Breast food products is a recordkeeping violation to 9 CFR 417.3(c) which states, "All corrective actions taken in accordance with this section shall be documented in records that are subject to verification in accordance with 417.4(a)(2)(iii) and the recordkeeping requirements of 417.5(a)(3) of this part" and 5000.1 (B)(6) and (B)(6) were notified of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1301100 125N-1	10/24/2013	01C02	Operational SSOP Review and Observation	O	<p>On 10/24/2013 at approximately 0841Hrs, Dr. (B)(7)(C) observed a plant Boning Room personnel using a inedible red labeled stainless steel hook/rod (hand tool) to scoop together 16 pieces of drumsticks that fell on the floor underneath the drumstick conveyor belt prior to the feeding of drumstick to be deboned in the drumstick (B)(4). The floor is a non food contact surface and the plant employee tried to scoop the product towards her by using a red labeled hook which is used for inedible product only according to Plant Good Commercial Practice. By scooping the products towards her, she further contaminated the product by allowing drumsticks to brush against the floor, a nonfood contact surface. She placed the drumsticks in a white edible barrel for reconditioning. U.S. Retain Tag NO: B39554834 was applied to the edible barrel containing the affected 16 drumsticks. (B)(6) was immediately notified of the noncompliance and showed the drumsticks in the edible barrel and inedible hook used on the product. Mr. (B)(6) chose to plant condemn the affected drumsticks. This observed incident of an employee using a inedible hand tool to scoop up dropped edible product which she put into an edible barrel for reconditioning is a violation to the relevant regulation cited above. This is also in violation to the establishment's in place Operational Sanitation 11-A.) # 2.) (B)(4)</p> <p>" B. " (B)(4)</p> <p>was not met. Also the establishment's in place GMP (good manufacturing practices) "Production tools: Stainless rod/hook with red tape - inedible use or inedible product." was not implemented.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0405101 824N-1	10/24/2013	01D01	SPS Verification	C	<p>On 10/23/2013 at approximately 2225 hours while monitoring Pre-Operational Sanitation in Plant #1, I observed the following. There were metal splinters on a guide bar associated with the bird drop assembly at the point where carcasses enter chiller #2. The splinters measured approximately 4mm to 10mm in size. The guide bar is worn with the edges raised and flattened. The splinters were flaking off from the flattened edges. The loose splinters were removed. (B)(6) will have maintenance remove the flattened edges after production. At this point in the process carcasses are being removed from the evisceration line and dropped into the chiller. With the affected guide bar directly above the carcasses the metal splinters will end up in the carcasses or in the chiller. At approximately 0025 hours in Packaging Area #2 there was a small flake measuring less than 1/4" that appeared to be red paint on an overhead product belt near the entrance to the (b)(4) room. The fire fighting piping throughout the (b)(4) room has deteriorated with rust and loose peeling flaking red paint throughout. I informed (B)(6) of the noncompliance. A work order will be submitted. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(2).</p>
5308	M6137	BXL0813105 024N-1	10/24/2013	03J02	Slaughter HACCP	C	<p>On 10/23/2013 at approximately 1008 hours while conducting a Post-Chill Finished Products Standards procedure on product exiting Chiller #4 in Plant #2, I observed the following. After collecting a standard 10 bird sample, I observed one carcass with a shiny piece of metal approximately 3mm in size attached to the connective tissue by the neck area. I informed (B)(6) and (B)(6) of the noncompliance. According to PDD, FSIS considers metal of any size on a carcass to be an unacceptable contaminant that should be addressed by the establishments' Hazard Analysis. The Establishments' HACCP Plan - Slaughter Plant #2 under (P) Physical Hazards states (B)(4). The product was on a chiller exit conveyor belt just prior to hanging for final microbial intervention and packaging. The issue of metal contamination has been discussed at previous morning meetings with the establishment. One tank of whole birds was retained by Quality Control. The birds were reworked and released by Quality Control. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.4(d), 9CFR 417.3(b)(1), 9CFR 417.3(b)(2), 9CFR 417.3(b)(3), and 9CFR 417.3(b)(4).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH210310 4123N-1	10/23/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On the night of production which began on 10/22/2013, Inspection performed PHIS procedure; SSOP Review and Observation in the 2nd Processing Department of 33900 P. This was after Sanitation had finished cleaning the equipment and QA had finished their Pre-operational inspection of the equipment and released the area to production. There are no additional Sanitation or Pre-operational steps prior to the start of production. The following noncompliance was observed: At 2318 hours while waiting for the birds to exit the chiller for a Post chill testing of line 1, I noticed grease residue on the shackles. I proceeded on to the hang line where I found the shackles (Product contact surface) in an unsanitary condition with grease residue, and debris particles. Inspection took Regulatory Control Action by applying US Reject Tag #B38075587 to the hangline until it was recleaned and reinspected, and was released at 2338 Hours. (B)(6) was shown the noncompliance. To date, all Preventive Measures may not have been implemented as described or were ineffective in preventing recurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH442310 5223N-1	10/23/2013	01802	Pre-Op SSOP Review and Observation	C	On the night of production which began on 10/23/2013, Inspection performed scheduled PHIS procedure Pre-op SSOP Review and Observation in the Evisceration Department of 33900 P. This was after Sanitation had finished cleaning the equipment and QA had finished their Pre-operational inspection of the equipment and released the area for USDA inspection. There are no additional Sanitation or Pre-operational steps prior to the start of production. The following noncompliance was observed: At 2037 hours while checking Line #1 Paw Unloader (Unit #1/Zone #2), Inspection found the Picker Fingers (Product contact surface) in an unsanitary condition with a greasy black residue which would easily rub off onto the hand. Inspection took Regulatory Control Action by applying US Reject Tag #B29699073 to the Unit until it could be recleaned and reinspected, and was released at 2104 Hours. The Requirements of 9CFR 416.13(c) were not being met and (B)(6) was shown the noncompliance and advised that a Noncompliance Record would be issued. This item of Equipment was randomly selected for Inspection as required. For a similar noncompliance refer to NR #NHH4900083727N/1 dated 08/26/2013. To date, all Preventive Measures may not have been implemented as described or were ineffective in preventing recurrence.
4630	M7322	AOA580710 3722N-1	10/22/2013	01802	Pre-Op SSOP Review and Observation	C	On 10/22/13, while performing Pre-Operational Sanitation Standard Operational Procedures Inspection, after the Establishment's Quality Control Technician informed me that her inspection was complete and the areas were ready for processing, the following deficiencies were observed: 1. At 0539 hours I observed what appeared to be bread crumbs (to numerous to count) on the product contact surface of the retail line incline conveyor belt that is located immediately after the retail line wide pack out belt. Official control action was taken. (B)(6) was notified. US reject tag #B23922689 was applied. I released the area at approximately 0556 hours when correct measures were verified. 2. At 0552 hours I observe the freezer product decline belt and stainless steel slide pan at the retail processing line area had what appeared to be very visible dry and wet bread crumbs to numerous to count (over 20) on the open left area of slide pan and randomly scattered throughout the product conveyor belt. There were what appeared to be loose bread crumbs, product grease and scum build up on bottom product conveyor guide rails and turn wheels. Official control action was taken. (B)(6) and (B)(6) was notified. US retain tag #B8541730 was applied. The area was released at approximately 0615 hours when corrective measures were verified. The listed deficiencies did not meet the requirements of 9 CFR 416.13(c) & 9 CFR 416.4(a).-This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0711105 822N-1	10/22/2013	03J02	Slaughter HACCP	C	On 10/22/2013 at approximately 1325Hrs, I observed the collection barrels of Turkey Fries at both lines. The plant's attached tags showed the time of collection was 1100Hrs (2300). U.S. Retain Tag NO's: B39554883 & 84 were applied to the barrels of fries with temperatures 95.7F & 92.6F. The establishment's CCP 2B requirement for fries had exceeded the time and temperature of 40F within 2 hours of harvesting. The turkey fries did not have any ice or CO2. When I presented this to management, (B)(6) informed me that they did not start collection until 1130Hrs. This observed incident is a record keeping violation to 9 CFR 417.5(a)(3) since the plants recorded time on the barrels and what Mr. (B)(6) said that the collection started time is not the same. Mr. (B)(6) chose to plant condemn the 92 pounds of turkey fries. Mr. (B)(6) was notified of the noncompliance.
5112	M18909	JDD1711103 122N-1	10/22/2013	01B02	Pre-Op SSOP Review and Observation	C	On 10/22/2013 at approximately 1020Hrs while performing pre-operational sanitation of the plant's Evisceration, Boning Room, Raw Fabrication and Cooler 9 Departments, after the Q.C. and before start up of production, I observed the following noncompliance. (B)(6) and (B)(6) were notified of the noncompliance and shown all incidents. I observed all corrective actions to food contact surfaces and non food contact surfaces except the solution screen. No retain tags were applied. 1.) Evisceration-SK5 Kill machine had dried blood on knife and feathers on (non food contact)-overhead shackles. b.) Quill Puller-had meat and feathers. c.) NE Main Scalding had feathers in the scald water and on the (non food contact) shackles (too many to count on both). d.) Picker # 4 had fat residues and feathers. e.) (b) (4) Hock Cutter had meat residues, fat and feathers. f.) Osteo room had meat, blood on the racks and feathers on the (non food contact) floor. g.) Chiller A (1st part) screens full of meat and fat. 2.) Boning Room-Thigh Deboner (B)(4) had meat and fat. b.) Drum Deboner (B)(4) had meat, fat and black UFM. 3.) Raw Fabrication Grinding- (b) (4) (injector) had meat. b.) Injection solution tank-The small screen had meat and was torn. The torn screen was taken to maintenance for repair. 4.) Cooler 9 (Raw Fabrication further processing)- The patty machine (form plate) had meat. The observed incidents of food contact surface found with meat, blood, fat, meat residues, black UFM and feathers from previous days operations is in violation to 9 CFR 416.4(d); 416.13(c) and 416.4(a). The small screen is in violation to 9 CFR 416.3(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance JDD1711103122N/1 is being linked to noncompliance (#135) JDD1507102418N/1 dated 10/18/2013 for the same cause respectively.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3118101 022N-1	10/22/2013	03J04	Poultry Zero Tolerance Verification	C	While performing a Zero Tolerance Fecal Task, I observed noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4).At approximately 1447 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination outside of the bird on the skin of the neck. The fecal material was approximately 1/4" diameter in size, green in color and pasty in texture. This exceed the limit of (b)(4) for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1510 hours and it passed.This is a violation of the critical limits of CCP-2B (b)(4) of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL3614103 721N-1	10/21/2013	01C02	Operational SSOP Review and Observation	C	On 10/21/2013 at approximately 0909 hours, I observed birds coming out of Chiller #3 in Plant #2. I noticed that there were no production or Quality Control Supervisors monitoring the birds as they exited the chiller.The establishments SSOP Correcting Action Logs under 'What actions were taken or are being taken to prevent recurrence...' has consistently stated "Product will continue to be monitored by Supervision prior to being put into production". I started inspecting the birds coming out of Chiller #3 and I observed several birds with black/brown UFM on them. The employees that hang the birds coming out of Chiller #3, started arriving at the re-hang belt and I informed them not to hang the birds as I went to inform a Supervisor. I saw (B)(6) come over to the re-hang area and I showed him one of the birds with black UFM on it. He started tanking the birds and I tagged the tank with U.S. Rejected/U.S. Retained tag # B31408109. Quality Control applied their Red Hold tag on the tank and I removed my tag. I informed (B)(6) of the noncompliance.Quality Control retained ten tanks of whole birds, four pallets of front breast halves and 26 lbs. of drums, thighs, and leg quarters. The whole birds were reconditioned, the breasts were reworked, and the drums, thighs, and leg quarters were condemned. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.14, 9CFR 416.12(a), 9CFR 416.15(b) and 9CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN131410 2921N-1	10/21/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 1140 hours, while performing PHIS Zero-tolerance task, in the Evisceration Department on the reprocessing off-line, prior to the birds entering the chiller, I observed one carcass in the ten (10) carcasses random sample contaminated with visible fecal material approximately one inch by half inch in diameter, brown in color, paste-like consistency, and located on the top of the hock joint, also there was another two pieces of fecal material on the leg approximately half inch by half inch in diameter, greenish in color pasty in consistency. I took regulatory control action by stopping the reprocessing line and applied US retain tag # B43303652 on the affected carcass. The findings were shown to (B)(6), and (B)(6). At approximately 1110 hours, the reprocessing line and the affected carcasses were released to the establishment allowing QC representative to perform the plant corrective actions. Mr. (B)(6) was informed of the forthcoming NR. The findings of fecal material on a carcass passed the final wash cabinet en route to the chilling system represents a zero tolerance failure as outlined in the establishment's HACCP and in accordance with the regulations 9 CFR 381.65(e) which states: "poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank". 9 CFR 417.2(c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits". The establishment's written HACCP Plan dated 4/18/2013 states (b)(4).</p> <p>A similar NR was documented on 09/30/2013 # NJN2416091630N/1, no plant response. PHIS slaughter HACCP task performed to verify that all corrective and preventive measures were completed. The plant determined that the cause of the deviation was a sprayer found in wrong position not spraying the top part of the hock. The chiller overflow was turned up to ¼ gallon of water per bird, and the chiller was marked to identify the end of the effected lot. Post chill checks were performed (b)(4) until the murk came out at 1317 hours. All post chill checks were found acceptable.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN300710 5421N-1	10/21/2013	01D01	SPS Verification	C	At approximately 0249, while I was passing through the evisceration department employee break room, I observed the following non compliances: the floor had stagnant water, used paper towels and debris everywhere. I proceeded to live hang rest room I observed the floor filled with used paper towels and filthy tissues. Also the rest room had no running hot water. Mr. (B)(6) , was informed and he took corrective actions to restore sanitary condition and also notified of the forthcoming non-compliance record.The Requirements of 9 CFR 416.1, 9 CFR 416.2(b) (2), 9 CFR 416.2(h) (1) and 9 CFR 416.2(h) (2) were not met. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s) as described in 9 CFR 500.4.
5309	P6137A	NJN560110 2321N-1	10/21/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 2252 hours, and after sanitation and QC performed preoperational sanitation and released the New Products Room for operations. I performed PHIS task, preoperational sanitation, in the area 5, Section C: IQF # 2 I observed the following noncompliance: In unit # 16 (product incline conveyor), I observed numerous pieces of fat and muscle from previous shift of production ranges from 1/8 inch to ½ inch in diameter. The product incline conveyor is direct product contact surface. I immediately applied U.S. Rejected tag NO. B43303520 notified and showed Mr. (B)(6) , of my findings and the forthcoming NR. The unit was re-washed, sanitized, re-inspected found acceptable and released at 2300 hours. At approximately 2356 hours. CSI (B)(7) was performing pre-operation inspection in the food service area, when he observed a piece of fat, approximately four inches by one inch inside of a blue drip pan hose that is located adjacent to unit # 21 (multicut # 1) according to the pre-op schematics. Mr. (B)(6) was present during this inspection. The hose was rewashed and found acceptable. The area was released at 0003 hrs. The requirements of 9 CFR 416.1, 9 CFR 416.4(a) and 9 CFR 416.4(b) were not met. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action as described in 9 CFR 500.4.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH511310 2621N-1	10/21/2013	01C02	Operational SSOP Review and Observation	C	<p>#160At approximately 1001 as I entered room one second processing I observed cross contamination of product at the first tray pack line. There were at least four employees were handling trays of product that had already gone through the (b)(4) wrapping and sealing machine and restyling the trayed product simultaneously and placing them back on the conveyor. Inside the (b)(4) there is a stained cloth textured belt that does not appear to be properly cleaned or sanitized daily. The wire conveyor inside the (b)(4) also accumulates a rust like buildup during operations. The blue belt at the end of the line also has a brownish buildup inside the links. These surfaces cannot be considered as product contact surfaces; therefore, once the bottom of the trays and wrappers contact these surfaces they should be handled in a manner that prevents cross contamination of the product. These requirements were not met. Us tag #B36322947 was applied to the operation and the affected product. (B)(6) and (B)(6) were shown the condition of the belts. As a preventive measure, Management stated that when reworking trayed, the employee handling and opening the trays will not handle product prior to washing/sanitizing their hands. The affected product (~35 trays) was taken to the product wash station. &nbsp;The area was released after sanitary conditions were restored.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0309103 919N-1	10/19/2013	03J02	Slaughter HACCP	C	<p>On 10/18/2013 at approximately 2250 hours while monitoring the Establishments' computer records for CP-5 (B)(4) pH and (B)(4) Monitoring, I observed the following. An establishment employee at 0219 hours on 10/15/2013 recorded that the 'Red Water' (B)(4) in Chiller #4 was at 8.3 ppm (parts per million). At 0651 hours also on 10/15/2013 the recorded value of the 'Red Water' (B)(4) was (b)(4) ppm in Chiller #3. At 23:01 hours on 10/16/2013 for Chiller #3 the recorded value was (b)(4) ppm. On 10/17/2013 at 0.09 hours the Red Water (B)(4) in Chiller #3 was recorded as being at (b)(4) ppm. At 0229 hours on 10/17/2013 the red water (B)(4) was (b)(4) ppm in Chiller #4. At 0608 hours on 10/17/2013 the red water (B)(4) in chiller #3 was recorded as being (b)(4) ppm. At 2252 hours on 10/17/2013 the red water (B)(4) was recorded as being at 16.3 ppm for chiller #3. At 2346 hours on 10/17/2013 the red water from chiller #3 was recorded as being at 11.8 ppm. A review of the establishments' HACCP Plan - Slaughter plant, Step 24 Carcass Chiller under Hazards lists (C) Chemical then is the hazard significant. NO. Under 'Justification for Decision' it states (b)(4) ree (B)(4) concentration for the recirculated water and the chiller water is monitored as part of a plant program. Supplement 7 CP-5 (B)(4) pH, and (B)(4) monitoring under (B)(4) Monitoring' states that (b)(4) for carcass chiller red water and that (b)(4) is the operating limit. Under 'Corrective Action' it states "Notify maintenance/production. Perform a recheck once notified by maintenance that adjustments has been made." Item 7 on the Establishments Action Plan resulting from an NOIE dated October 13, 2013 is for (B)(4) and (B)(4) lists 'Carcass Chiller Red Water and states "The operating limits are < (b)(4) ppm free (B)(4) and pH (b)(4) . Even after being informed of the noncompliance as of 10/24/2013 the establishment continues to fail on a nightly basis. My findings indicated a noncompliance with 9 CFR 417.5(a)(1)."</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1507102 418N-1	10/18/2013	01802	Pre-Op SSOP Review and Observation	C	On 10/18/13 at approximately 0423 hours while performing Pre-Operational sanitation after the establishments Pre-Operations checks and before the start of production in the Raw Fab # 9 cooler room I observed the following non-compliances. In the Raw Fab # 9 cooler room. I observed fat and muscle residue on the walls of entrance to the room from the previous days production, this is a non-compliance to 416.2(b)(2). Fat and muscle tissue and residue was observed on the exterior non product contact surfaces and interior product contact surfaces of the (b)(4) and (b)(4) machines from the previous days production, This is a non-compliance to 416.13(a) , 416.4(a) and 416.4(b). I immediately took regulatory control by applying U.S. Reject tag # B31390666 to the machines and room and informing (B)(6) and (B)(6) of my findings. Mr. (B)(6) and Mr. (B)(6) took immediate corrective action in my presence cleaning and sanitizing the room and machines to restore sanitary conditions.
5308	M6137	BXL0315104 718N-1	10/18/2013	03J02	Slaughter HACCP	C	On 10/18/2013 at approximately 0907 hours while performing Finished Product Standards task, I reviewed the HACCP Monitoring Log - CCP 2B- (b)(4) (Plant #2) on PM shift, Line (b)(4) and I found that one check was missing. I asked (B)(6) about the missing check because I saw the Quality Control performing a check. She informed me later that the Zero Tolerance check was performed at 0847 hours by Quality Control but not annotated in the HACCP Log at the time performed. This is a noncompliance with the following regulatory requirements of regulation 9CFR 417.5 (b).
5308	M6137	BXL1205103 018N-1	10/18/2013	01C01	Operational SSOP Record Review	C	On 10/16/2013 at approximately 2310 hours while verifying corrective action by the Establishment in response to the Notice of Intended Enforcement action dated October 7, 2013, I observed the following. The Establishments Action Plan Item 16 refers to an ATP Bio-trace procedure that was to be addressed in the Establishments' SSOP beginning October 14, 2013. The record review revealed no entry in the Establishments SSOP that addresses the ATP-Bio-trace procedure. My findings indicated a noncompliance with 9 CFR 416.12(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN451610 2218N-1	10/18/2013	01D01	SPS Verification	C	<p>While in the packaging area, at approximately 10 28 hours, I noticed an employee heading towards the door of the cooler, which is located beside the spice room. He was wearing a freezer suit and stacker gloves and dragging a red trash receptacle. The trash receptacle was empty but, heavily soiled with filth. I immediately stopped him from entering the cooler with the soiled trash receptacle. Without a response, he head towards the hose in the packaging area, picked up the hose, and started to wash it down. Again, I stopped him and informed him that he is not to wash nor enter into the production area at all with any filthy contaminants. He then left the trash receptacle and headed to enter the cooler. I, once more, stopped him and told him that again his gloves were now contaminated from the trash can and he cannot enter nor touch anything in the production area, so he took them off and throw them down into the filthy trash can that he had left in front of me. I tagged the trash receptacle with the USDA reject tag # B43303655 and, since there were no supervisors at the time, I had one of the lead persons call a supervisor over. Mr. (B)(6) came to me in the packaging area and I inform him of the events and the forthcoming noncompliance. The plant failed to comply with the regulations cited. 9 CFR 416.2(h)(3) states: "Refuse receptacles must be constructed and maintained in a manner that protects against the creation of insanitary conditions and the adulteration of product." 9 CFR 416.4(b) states: "Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." 9 CFR 416.5 states: "All persons working in contact with product, food-contact surfaces, and product-packaging materials must adhere to hygienic practices while on duty to prevent adulteration of product and the creation of insanitary conditions."</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ2416101 418N-1	10/18/2013	04A06	Poultry Finished Product Standards	C	<p>On October 18, 2013 I, CS (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is 50 points. My test at 1233 resulted in 47 points. At 1245 a retest was performed by (B)(6) using a tighten criteria of 25 points which failed with 31 points. I verbally notified (B)(6) of the noncompliance and that I would be issuing a NR. The plant implemented the required procedures for FPs failure. The Prechill nonconformances I observed at 0706 were: 3 ingesta < 1/16" (3 pts), 5 partial oil glands (5 pts), 2 whole oil glands (4 pts), 2 partial lungs (2 pts), 4 whole lungs (8 pts), 1 cloaca (5 pts), 1 bursa (2 pts), 4 small feathers (4 pts), 8 large feathers (8 pts), and 3 long hocks (6 pts). On October 16, 2013, NR # OIJ151610191N (#79) was issued for processing noncompliance. The written response given is that Maintenance made adjustments to bring the process under control. This noncompliance is linked to NR # OIJ151610191N (#79) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the October 17, 2013 meeting.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5821101 818N-1	10/17/2013	03J02	Slaughter HACCP	O	<p>On 10/17/2013 at approximately 1100Hrs during my (Finish Product Standard)&nbsp;random 10 necks per sample check, I observed one turkey neck with visible fecal material out of the ten. The fecal material was found on two sites close to the base of the neck. The thick and mucoid fecal materials were medium to dark olive green with a brownish tinge which is consistent with fecal material. &nbsp;Both of the fecal materials were approximately 2" x 1/4" x 2mm thick. U.S. Retain Tag NO:B39554626 was applied to the tank which had the affected neck. I requested the sanitation personnel, who was at the turkey pickers, to notify (B)(6) to come to the neck removal and chilling area. Ms. (B)(6) was shown the fecal material on the neck. I notified (B)(6), and Dr. (B)(7)(C) SPHV&nbsp;of the noncompliance and showed them the fecal material which was still attached to the turkey neck. Dr. (B)(7)(C) concurred that it was fecal material. Ms. (B)(6) said it appears to be bile. She kept the neck. Ms. (B)(6) had all&nbsp;of the necks in the tank&nbsp;(one by one) reconditioned with (b)(4) water spraying (b)(4) ppm/trimming and reinspected. The necks approximately 1800 pounds were released back to production flow at approximately 1555Hrs after verifying the plant's implemented corrective action and reinspection by&nbsp;Ms. (B)(6). The establishment does not monitor the necks for&nbsp;fecal&nbsp;at the neck collection/ ice&nbsp;chilling tanks. The plant's HACCP Plan does not identify feces as a hazard in the neck collection/chilling. I asked (B)(6), and he said to use the CCP 3B (b)(4).&nbsp;The necks collected&nbsp;from reprocessed birds are monitored for feces at the establishment's (CCP 3B) check and when found free of feces are added to the neck chilling tank. This observed incident of visible fecal material not removed is a noncompliance to the establishment's&nbsp;CCP 3B (b)(4)s critical limit per 9 CFR 381.65(e) and 417.2(c)(4) monitoring at the critical control point prior to entering&nbsp;into the chilling tank. This noncompliance JDD5821101818N/1 is being linked to noncompliance (#112) JDD1623092204N/1 dated 9/4/2013 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1205100417N-1	10/17/2013	04A06	Poultry Finished Product Standards	C	On 10/16/2013 at approximately 0334 hours while monitoring Post-Chill Finished Product Standards from product exiting the Chillers in Plant #2,I observed the following. The last of the carcasses were coming out of Chiller #3. The Post-Chill Finished Product Standards log for the shift had an establishment entry for product exiting Chiller #3 at 0032 hours.No further checks were made by the establishment for the shift for chiller #3. Periods between checks at the post-chill are not to exceed (b)(4) . I contacted (B)(6) and informed him of the noncompliance. I checked with live hang and they finished hanging 'Organic' at 0152 hours. My findings indicated a noncompliance with 9 CFR 381.76(e)(1)(i).
5308	M6137	BXL4620105417N-1	10/17/2013	01C02	Operational SSOP Review and Observation	C	On 10/17/2013 at approximately 1735 hours, while walking pass the Re-hang area in Plant #1, I observed the following noncompliance. There was a tank of whole birds, approximately 1/4 full next to the chick weight line #1 . Directly above the tank was a drip pan that was dripping water into the tank of birds. I tagged the tank with U.S. Rejected/U.S. Retained tag #B31408104 and I informed (B)(6) and he called (B)(6) who I informed of the noncompliance. The birds were washed at approximately 1800 hours, I removed the tag and the tank was washed, restoring sanitary conditions. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.4(d).
5310	M6137B	FFA5601105717N-1	10/17/2013	04B04	General Labeling	C	On October 16, 2013 at approximately 2200 hours, while performing Operational Sanitation in Cooler #2, I observed five white edible barrels full of franks with no identification or labels. I immediately tagged the product with U.S. Retain Tag NO. B34377191, B31408670, B31408539, B31408537, B31408662. Ms. (B)(6) and Ms. (B)(6) was informed and showed the noncompliance. Immediate Corrective Action was implemented by Management: All five barrels of franks was condemn in my presence. After product was condemn and denatured U.S. Retain Tags were removed. This does not comply with CFR 9 381.116 which states in part: "Wording on labels of immediate containers". This noncompliance is linked to NR# FFA5218091320N/1 dated 09/20/13, for a similar noncompliance. As of today 10/16/13, Management has not given a written response to this NR. This NR serves as written notification of a labeling noncompliance. Continue failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH081310 4417N-1	10/17/2013	01C02	Operational SSOP Review and Observation	C	<p>On Thursday, October 17, 2013 while leaving the Evisceration Department at approximately 1110 hours I observed the following noncompliance. At the Reprocessing Area in evisceration there were totes and lids staged to be used for parts on a dollie. There was two stacks that had ten each in them. The top two totes were found to be in an insanitary condition. There was black specks inside the totes. I removed the top two totes and checked three more totes they had black specks in them too. One of the totes had some dried fat inside of it. The totes (20) were rejected with US Reject Tag # B 29 699853. Mr. (B)(6), was notified and informed the noncompliance would be documented on a noncompliance report. Mr. (B)(6) had the totes taken back to the tub wash room to be rewashed. As a preventive measure, Mr. (B)(6), said "the employee that is responsible for getting the totes for reprocessing would check each tote before they bring it to the Reprocessing Area". The requirements of 9 CFR 416.13(c) were not met. The establishments SSOP plan states (B)(4) "There has not been a similar noncompliance written in the last thirty days.</p>
1325 7	P33900	NHH181210 5817N-1	10/17/2013	03J02	Slaughter HACCP	C	<p>On Thursday, October 17, 2013, at approximately 1101 hours, while performing Poultry Finished Product Standards (Prechill) on Evisceration Line #1, I observed fecal contamination on the outside of the tenth carcass randomly selected for the ten bird sample. The fecal material was located on the back of the carcass underneath the oil gland. There was two pieces of fecal, both approximately 1/8 inch in size and light brown in color. It had a watery texture to the touch. There were no plant employees between me and the chilling tanks when I performed this check. Therefore, it is reasonable to assume that the feces would have entered the chilling tanks in violation of Regulation 9 CFR 381.65(e). Ms (B)(6), was notified of the deviation for the Critical Control Point CCP-1, (b)(4) at CCP-1, and she was shown the carcass. She immediately implemented the establishment's corrective action for visible feces at CCP-1. At 1115 hours, Mr. (B)(6), notified me that the cause of the noncompliance was equipment malfunction. Mr. (B)(6) stated, "that the Bird Brush was turning in the wrong direction". Maintenance corrected the direction of the motor. The preventive measure that was given was that production will perform two checks on the Bird Brush two times for the rest of the shift. A similar noncompliance was documented on NR NHH4602090526N/1 dated 09/26/2013. The further planned action may not have been implemented or was ineffective in preventing the reoccurrence of this similar noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0123100 616N-1	10/16/2013	01C02	Operational SSOP Review and Observation	C	<p>On 10/16/2013 at approximately 1140Hrs, I observed UFM (unidentified foreign material) on the Chiller B exit food contact belt. The UFM was very black in color; thick/smear grease type when touched/rubbed. The thick UFM was smeared approximately 1" x 10" in size on the food contact belt. The UFM appeared to be a drip/chunk and then smeared. The food contact chiller belt was full of whole body heavy tom turkeys at this time. I saw (B)(6) near the Bagging Area. I notified her of the UFM on the belt. She called (B)(6). U.S. Retain Tag NO:B39554696 was applied to the affected food contact belt. I showed the UFM to Mr. (B)(6) and Ms.(B)(6). Mr. (B)(6) stopped the belt and removed the UFM from the belt using sanitized towels. The belt was released for operations at approximately 1142Hrs after verifying the restored sanitary conditions. U.S. Retain Tag No's: B39554115 & B39554424 were applied to one and 3/4 tanks of whole body turkeys which were on the affected conveyor belt. At approximately 1230Hrs the (2800 pounds) of heavy tom turkeys were released back to production flow after verifying the plant's implemented reconditioning by (b)(4) ppm (b)(4) water spraying/trimming and reinspection. One Turkey was found with UFM. Mr. (B)(6) was notified of the noncompliance. This observed incident of UFM on a food contact surface during food production operations is in violation to 9 CFR 416.4(a); 416.4(d) and monitoring of the plant's operational sanitation 9 CFR 416.13(c). This noncompliance JDD0123100616N/1 is being linked to noncompliance (#130) JDD2422102710N/1 dated 10/10/2013; (#119) JDD1922091518N/1 dated 9/17/2013 for the same cause respectively.</p>
5112	M18909	JDD3123104 616N-1	10/16/2013	01C02	Operational SSOP Review and Observation	C	<p>On 10/16/2013 at approximately 1304Hrs, I was notified by (B)(7)(C), line one inspector, that she had just observed a live fly land on 3 turkeys in front of her. The live fly landed on one turkey's tail. The fly flew to another turkey and landed on the turkey's tail. The fly flew to another turkey and landed on its leg. Ms.(B)(7)(C) stopped the line and had her trimmer removed the three affected turkeys from the line for reconditioning. Ms.(B)(7)(C) was able to terminate the fly when it landed on the turkey's leg. The Evisceration line was full of whole body turkey's at this time. This observed incident of a live fly landing on food products during food products operation is in violation to 9 CFR 416.2(a); 416.4(d) and the establishment's monitoring of their operational sanitation 9 CFR 416.13(c). The establishment does have in place a outside pest management service. The three affected turkey's were reconditioned by (b)(4) water spraying (b)(4) ppm and reinspection off line. The turkey's were returned to production flow. This noncompliance JDD3123104616N/1 is being linked to noncompliance (#116) JDD4809095216N/1 dated 9/16/2013. (B)(6) and (B)(6) were notified of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1117104 116N-1	10/16/2013	01C01	Operational SSOP Record Review	C	On 10/16/2013 at approximately 1100 hours while performing Operational Sanitation Records Review Task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 416.13 (b) and 9CFR 416.13 (c). The SSOP Daily Implementation and Monitoring Log dated on 10/15/2013 AM shift for WP Rewrap Room, under Operational SSOP monitoring had only two checks, one at 0212 hours and the other at 0606 hours. Operational Sanitation procedures states in part under monitoring frequency of action (minimum four times per shift) by QA inspector or designee. Observations are recorded on the SSOP daily implementation and monitoring log for operations. I informed (B)(6) of the noncompliance.
6036	P6164A	OIJ1516101 916N-1	10/16/2013	04A06	Poultry Finished Product Standards	C	On October 16, 2013 I, CS (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is (b)(4) points. My test at 1330 resulted in 34 points. Plant records showed a failure within the last 5 tests and a CuSum above the start number of 11. Specifically the test at 0936 resulted in a CuSum of (b)(4). The plant implemented the required procedures for FPS failure. I verbally notified (B)(6) that I would be issuing a NR. Plant records show no failures occurred at Post chill and the plant achieved two passing tests at Prechill at 1408. No further failures occurred for the remainder of the shift. The Prechill nonconformances I observed were: 6 partial oil glands (6 pts), 5 partial lungs (5 pts), 4 whole lungs (8 pts), 1 cloaca (5 pts), 1 partial crop (2 pts), 3 small feathers (3 pts), 3 large feathers (3 pts), and 1 long hocks (2 pts). On this same day NR # OIJ2213103616N (#78) was issued for processing noncompliance. This noncompliance is linked to NR # OIJ2213103616N (#78) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the October 10, 2013 meeting.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ2213103 616N-1	10/16/2013	04A06	Poultry Finished Product Standards	C	<p>On October 16, 2013 I, CSI (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is (b)(4) points. My test at 0850 resulted in 45 points. At 0923 a retest was performed by (B)(6) using a tighten criteria of 25 points which failed with (b)(4) points. I verbally notified (B)(6) of the noncompliance and that I would be issuing a NR. The plant implemented the required procedures for FPs failure. Plant records show 2 passing tests were achieved at 0943 and no failures occurred at Postchill. The Prechill nonconformances I observed at 0706 were: 3 ingesta < 1/16" (3 pts), 5 partial oil glands (5 pts), 5 partial lungs (5 pts), 5 whole lungs (10 pts), 2 bursa (4 pts), 2 partial crop (4 pts), 1 trachea < 1" (1 pt), 6 small feathers (6 pts), 5 large feathers (5 pts), and 1 long hocks (2 pts). On October 9, 2013, NR # OIJ3522102109N (#74) was issued for processing noncompliance. No response is available at this time. This noncompliance is linked to NR # OIJ3522102109N (#74) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the October 10, 2013 meeting.</p>
1325 7	P33900	NHH220610 5017N-1	10/16/2013	01D01	SPS Verification	C	<p>On the calendar date of October 16, 2013 at approximately 2358 hours while performing the Operational SSOP Review and Observation task, the following facility noncompliances were observed: I, CSI (B)(7)(C), accompanied by (B)(6), observed an excessive amount of water on the underside of several stainless drip pans, piping, and overhead structures above bird shackles in rooms 1, 2, and 3 in the further processing areas. Please be advised that product adulteration was observed and the findings were documented on a separate noncompliance record; please reference NR # NHH3605100717N/1. In addition, 6 live spiders and several spider webs were observed in various areas of the ceiling in the small bird box room. No packaging material or boxes were affected. Mr. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on July 16, 2013; please reference NR # NHH1203071216N-1. The establishment's response to NR # NHH1203071216N-1 of, - "The spider webs were taken down and spiders were killed." - failed to prevent recurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH360510 0717N-1	10/16/2013	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of October 16, 2013 at approximately 2358 hours while performing the Operational SSOP Review and Observation task, the following noncompliances were observed in further processing: Part 2 of the SSOP's states tha (B)(4)</p> <p>(B)(4), I, CS (B)(7)(C), accompanied by (B)(6) (B)(4), observed water dripping from the box chute (in the Rotisserie area) into a combo of WOGs. Water was also observed dripping from the underside of a stainless drip pan into a combo of ice (that was being collected to apply to product) in room 1. Mr. (B)(6) immediately retained the WOGs and Ice, and the combos were removed from the processing area. Please be advised that corrective actions were performed in my presence. In addition, Part 2 of the SSOP's states that (B)(4). At approximately 0104 hours (10/17/13) while observing operations in rooms 2 and 3, I observed blood specs and residue, fat particles, a black greasy substance, rust, and various debris on the inside and outside of several brown baskets used to hold bagged product. At the time of the findings, several baskets contained bagged product and visible stains were observed on the outside of the bags. The baskets were rejected with U.S. REJECTED tag #'s B40172390 and B40172389. Mr. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on October 15, 2013; please reference NR # NHH5005105216N-1. The establishment's response to NR # NHH5005105216N-1 is pending.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN280510 1815N-1	10/15/2013	03J02	Slaughter HACCP	C	<p>I noted the following non compliance during a verification check of the establishment's off-line reprocessing process.&nbsp;At 0101 hours I randomly selected ten carcasses from the off line after the final wash cabinet.&nbsp;Two of the ten carcasses had visible ingesta material, one at the&nbsp;inside of the tail area,the other carcass at the crop area.&nbsp;I stopped the reprocessing line and showed these findings to (B)(6).&nbsp;The Line was restarted at which time production personnel instituted corrective actions of adding two additional employees to the reprocessing line, one to conduct knife trimming and one to wash the carcasses.&nbsp;I performed a recheck at 0111 hours.&nbsp;During the ten random carcass verification I noted one carcass with visible ingesta material on the inside of the tail area.&nbsp;I stopped the line showed this finding to (B)(6).&nbsp;Mr. (B)(6) initiated the&nbsp;written corrective actions procedures for an off line contamination failure.&nbsp;These procedures included&nbsp;diverting carcasses off the line and&nbsp;then performing rechecks on the affected carcasses.&nbsp;(B)(6) performed the rechecks and then marked the chiller with a red net to identify the affected lot and initiated post chill checks on the affected lot.&nbsp;(B)(6) and (B)(6) where informed of the issuance of this non compliance report of the failure to meet the&nbsp;regulation cited above.</p>
1325 7	P33900	NHH500510 5216N-1	10/15/2013	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of October 15, 2013 at approximately 2340 hours while observing operations in room 2 of the further processing area, the following noncompliance was observed: Part 2 of the Sanitation SOP's states that (B)(4) I, CS(B)(7)(C), observed condensation dripping from the upper portion (toward the ceiling) of the stainless steel ice chute directly into a combo of ice. Employees in the area confirmed that the ice was going to be used in the packing of product, and the ice was immediately discarded. In addition, another part of the ceiling in close proximity to the ice chute exhibited a steady drip of water (which fell onto the floor), and corrective actions were immediately implemented. (B)(6) was shown the noncompliance as well and informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting.A similar noncompliance record was documented on July 25, 2013; please reference NR # NHH4717074025N-1. The establishment's response to NR # NHH4717074025N-1 failed to prevent recurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN160010 2214N-1	10/14/2013	01D01	SPS Verification	C	On 10/13/13 while performing pre-operational sanitation in the HPP department I observed noncompliance with SPS regulatory requirements 416.2(b)(1) & 416.4(b). At approximately 21:50 hours I observed two white hard plastic cuttings boards placed on a metal rack on the floor at the beginning of the HPP package boxing area; these two cutting boards are used to catch packages after they exit the HPP machines and the packaged product has recieved it's lethality step; both cutting boards, (Non food contact surfaces) had cuts and crevices on the boards' surfaces; upon closer observation it was determined that the boards may create an insanitary condition due to black unidentifiable foreign material in cuts/crevices; that may harbor bacteria which could in turn affect the cleaning and sanitizing of the cutting boards. (B)(6) and (B)(6) were shown and notified of the establishment's noncompliance with 9 CFR sections: 416.2(b)(1) & 416.4(b). This document serves as written notification of an SPS noncompliance; and also as a notification that failure to meet regulatory requirements can lead to enforcement actions as described in 9 CFR 500.4.
5308	M6137	BXL4516101 214N-1	10/14/2013	04A06	Poultry Finished Product Standards	C	On 10/11/2013 at approximately 1510 hours, a review of the Records for Post Chill Finished Product Standards , while writing down the check that I performed, I observed the following, the checks performed by Quality Control were: the first check performed was at 0855 hours (chiller 1) and 0858 hours (chiller 2). The second check was performed at 1004 hours (chiller 1) and 1005 hours (chiller 2). The third check was at 1306 hours (chiller 1) and 1308 hours (chiller 2), the last check was at 1505 hours (chiller 1) and 1501 hours (chiller 2). The birds finished coming out from the chiller that day at approximately 1850 hours. The gap between the second check and the third check was approximately three hours. The gap from the last check to the end of the shift was approximately three hours and fifty minutes. I also found while reviewing the records, that on 10/09/2013 the checks were performed as follow: (chiller 1) 0902 hours and 1127 hours and (chiller 2) 0858 hours and 1125 hours. The birds finished coming out from the chiller that day at approximately 1500 hours. The gap from the last check to the end of the shift was approximately three hours and thirty minutes. This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (e)(1)(i). I informed (B)(6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN441110 2114N-1	10/14/2013	01D01	SPS Verification	C	<p>On 10/14/13 at approximately 825 hours I observed the following while performing the SPS task in the packaging room . Observing the reprocessing station I noticed the nut and surrounding area on the handle were oxidized the fittings used to connected the brass shut off valve showed signs of oxidization (rust) also .Taking a regulatory control action I immediately applied US REJECTED/RETAINED tag # B43 303643 and contacted (B)(6) who was near . (B)(6) placed the establishments QC hold tag on the reprocessing station and contacted (B)(6) . (B)(6) notified maintenance immediately . The maintenance worker disassembled the plumbing on the back portion of the reprocessing station a new shut off valve was installed teflon tape was used on the smaller fittings. The unit was reassembled and rinsed with (b)(4) water .Sanitary conditions were restored at approximately 1030 hours and the area was released. (B)(6) was informed of the non-compliance. My findings indicate non-compliance with the following regulations 9CFR 416.1 Which states that each official establishment must be operated and maintained in a manner sufficient to prevent the creations of insanitary conditions and to ensure that product is not adulterated and 9CFR 416.4(d) which States that product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments .</p>
5309	P6137A	NJN090610 3813N-1	10/13/2013	03C02	Raw Intact HACCP	C	<p>At approximately 0322 hours; I asked (B)(6) , to check the temperature of twelve brown tubs of product, in the fillet cooler room. His thermometer (# 464) registered (B)(4) . I took regulatory control action and applied a U.S. Retention tag NO43303527 to the pallet containing the twelve brown tubs filled with tender breast and salvaged thigh. Mr (B)(6) , was notified of the noncompliance. The U.S. Retention tag was removed at 0335 hours and the product was released to production due to the plant's validation study on time and temperatures. The plant failed to maintain the product temperature constantly at (B)(4) ; that the product being staged on the cooler exceeded (B)(4) represent a noncompliance with 9 CFR 381.66 (c) (3). The establishment is required to comply with the chilling temperature requirements in 9 CFR 381.66(C) (3). The establishment HACCP plan II, Raw Not Ground for the 2nd Processing Department, process step Refrigerated Storage: (b)(4) (b)(4) (B)(4) .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN500610 4813N-1	10/13/2013	04B04	General Labeling	C	At approximately 0322 hour, while monitoring the temperature on fillet cooler, I observed a staged product of salvaged thigh mixed with tender breast in twelve brown tubs. The pallet had empty yellow label stamped Wednesday, and on the back a different date, 10/12/13, and the name (b)(6) was hand written in. The label did not identify the kind of poultry nor did it even have a code. Mr. (B)(6), and (B)(6), were notified of the noncompliance.
5568	M20923	XUM090010 1513N-1	10/13/2013	01D01	SPS Verification	C	On 10/12/2013 at approximately 2100 hours, while performing a routine Sanitation Performance Standards (SPS) inspection on the Raw Side Department on Line #2, the following noncompliance was noted: water and batter mixture flooding the drain which runs east to west adjacent to Line #2 creating insanitary conditions. At the time of my observation Line #2 was sorting breast meat. I took regulatory control by stopping the line and informing (B)(6) of the insanitary conditions and the forthcoming noncompliance. 3 combo bins of chicken breasts were removed from the area until the drain was cleared and sanitary conditions were restored and the line was released. During this task I also observed the floor drain next to Line #1 was flooded as well, no product was being processed in this area. The requirements of 9 CFR 416.1, 416.2(e)(4), 416.2(b)(2), and the establishments SSOP plan were not met. 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary condition and to ensure that product is not adulterated". 9 CFR 416.2(e)(4) states: "Plumbing system must be installed and maintained to provide adequate floor drainage in all areas where floors are subject to flooding type cleaning or where normal operations release or discharge water of other liquid waste to the floor". 9 CFR 416.2(b)(2) states: "Walls floors, and ceilings within establishments must be built of durable materials impervious to moisture and be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions". The establishments SSOP plan, Part 2 Operation Sanitation, Section 1 Raw Area, Subsection D Equipment and Facilities, Step #3 states: (B)(4).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH120110 0414N-1	10/13/2013	01C01	Operational SSOP Record Review	C	On the night of production which began on 10/13/2013, Inspection reviewed the SSOP Records generated for the night of production beginning on 10/10/2013 (Prod. Date 10/11/2013) and found them out of compliance. On that shift, Management had documented cardboard boxes in the SB (South Cooler) containing product with overspray on them and the Preventive Measure on the establishment's deficiency form stated that "Employee would be retrained not to overspray on 10/11/2013." No documentation was available for review by Inspection that this retraining was done, thus not meeting requirement's of 9CFR 416.16(a). (B)(6) was notified that a Noncompliance Record would be issued. Refer to NR #NHH2904083119N/1 (#125) dated 08/19/2013 for a similar Noncompliance.
1325 7	P33900	NHH510410 5014N-1	10/13/2013	03J02	Slaughter HACCP	C	On the night of production that began on October 13, 2103 while observing the start of operations in the evisceration department I noticed a new spray bar at the exit end of the PNT. Mr. (B)(6), informed me that the spray bar had been installed over the weekend to deliver acidified (B)(4) to the product. He also informed me that the acidified (B)(4) was in use at multiple other locations in the evisceration department. I proceeded to the HACCP office and asked Ms (B)(6), if the slaughter HACCP plan had been amended to show the use of acidified (B)(4) in the evisceration department. Ms (B)(6) informed me the HACCP plan had not been amended and that the acidified (B)(4) was not supposed to be in use until later in the week. Plant management elected to discontinue use of the acidified (B)(4) until the HACCP plan could be modified. The affected product, two combos of wogs, was retained with US tag B38075686. Ms. (B)(6) modified the HACCP plan and provided the necessary supporting documentation and proposed the affected product be rinsed with potable water. Inspection reviewed the HACCP plan changes and supporting documentation and concluded the establishment was in compliance and that the proposed corrective actions were reasonable. The regulatory control action was released after the product had been rinsed. Ms. (B)(6), was informed the noncompliance would be documented on a noncompliance record. The requirements of 9 CFR 417.5(a)(1) were not met.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1405100 812N-1	10/12/2013	01C02	Operational SSOP Review and Observation	C	<p>On 10/12/2013 at approximately 0035 hours while monitoring Operational Sanitation procedures at the rehang area of Plant #1 for product going into Packaging, I observed the following. There was product collecting on a rehang belt for birds going to the bag fryer line (b)(4) in Packaging. The carcasses at this point have already received their final microbial intervention. The carcasses at the end of the belt had varying amounts of a dark brown UFM(Unidentified Foreign Material) collecting on the carcass where the skin was in contact with the flexible belt. I contacted an employee who called (B)(6). Product was redirected to the cutup line. The line was stopped. A partial tank of carcasses were collected that were on the belt. The belt was sprayed with a sanitizer and rinsed with (b)(4) water. A review of the Establishments' SSOP Section 11-Operational Sanitation under Corrective Action: states (B)(4)</p> <p>(B)(4)</p> <p>There is no cleaning process described in the Operational Sanitation SSOP to be used to restore sanitary conditions. The dirtiest carcasses were condemned by production. I observed the reconditioning of the affected carcasses which were rinsed with (b)(4) water per establishment policy. A recheck was acceptable and the product was released at approximately 0130 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d) and 9 CFR 416.14.</p>
5308	M6137	BXL5211100 612N-1	10/12/2013	01C01	Operational SSOP Record Review	C	<p>On 10/10/2013 while performing an Operational Sanitation Records Review Task, I made this observation on the SSOP Daily Implementation and Monitoring Log for Packaging on 10/08/2013. There was no check documented on the Glove/Utensil Check at Start-up (if applicable). I asked (B)(6) on 10/11/2013 about the missing check and she informed me that it was the night shifts SSOP Log and she would send (B)(6) an e-mail asking him about it. On 10/12/2013 I spoke with (b)(6) and he informed me that the Glove/Utensil Check at Start-up had been done and written down. However, the check was done by one Quality Control person and when a different Quality Control person did an SSOP monitoring check in packaging, she used a different SSOP Log. (B)(6) and the Quality Control employees were unable to find the SSOP Log that contained the Glove/Utensil Check at Start-up on 10/08/2013. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.13(b) and 9CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN421810 3112N-1	10/12/2013	01D01	SPS Verification	C	<p>At approximately 0940 hours, in the packaging area, I noticed that the cooler door was covered with ice on its side and bottom. I immediately contacted Mr. (B)(6), and showed him the ice that was built-up on the door. Mr. (B)(6) checked the door and informed me that he will order some parts to fix the door. Also I informed him that the cooler door open into Fillet Department does not close properly. Later on, while performing an operational sanitation task in the packaging area, I noticed that the cooler door beside the spice room was open. So, I waited almost three minutes for some one to close it but, nobody came to close it. I went inside the cooler and noticed that the plastic curtain had heavy condensation to the point that it was dripping water. I showed Mr. (B)(6), the condensation and informed Mr. (B)(6), of the forthcoming noncompliance. Mr. (B)(6) then assigned an employee to wipe the condensation and to keep the door close. 9 CFR 416.2(d) states: "Ventilation adequate to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product and the creation of insanitary conditions must be provided." &nbsp; 9 CFR 416.2(b)(1) states:"their structures, rooms, and compartments must be of sound construction, be kept in good repair." &nbsp; 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated."</p>
5308	M6137	BXL1918104 811N-1	10/11/2013	03J02	Slaughter HACCP	C	<p>On 10/11/2013 while performing a Pre-Chill Finished Products Standards Task in Plant #2 on Line (B)(4), I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65(e) and 9CFR 417.2(c)(4).At approximately 1533 hours, I randomly removed a 10 bird sample from Line (B)(4). I found one out of the ten birds with visible fecal contamination below&nbsp;the right hock. The fecal material was approximately 7/16" in diameter in size, olive green in color and pasty in texture. I informed (B)(6) and the protocol for fecal failure was implemented. At approximately 1557 hours, Quality Control performed a recheck and passed.This is a violation of the critical limits of CCP-2B, (b)(4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2207100 611N-1	10/11/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 2000 hours while monitoring Operational Sanitation in the Plant #1 Cooler, I observed the following: A partial pallet of giblets with a white Dolly Tag marked Night Shift had a puddle of very dark brown blood on top of the lid. I opened the lid to see the condition of the giblets inside and found 3 uncut gizzards full of ingesta and several feet of intestines full of fecal material mixed in with the livers near the top of the product. The partial pallet of 5 tubs was placed under USDA Retained. At approximately 0030 hours I contacted (B)(6) and showed him the uncut gizzards and intestine in the livers. The 5 tubs on the pallet were from a previous days production and were condemned by Production. At approximately 0335 hours I observed the giblets that had come out of the giblet chiller just before lunch. The brown product tubs collecting the edible giblets were filled with a froth making it difficult to examine the contents. Moving the froth aside there were uncut gizzards full of ingesta and several feet of intestine full of fecal material in the livers. There was also a neck that was collected in the product container with the hearts that was coated with a thick layer of brown UFM (Unidentified Foreign Material). The giblets had already received their final microbial intervention. Giblets are placed back into the whole fryer carcasses as part of an unwrapped giblet pack. I contacted (B)(6) and showed him the product. All three tubs of product was condemned and placed into a gray inedible barrel. In the future (B)(6) will turn off the giblet collection conveyor belt during wash downs to prevent unsorted product from entering the giblet chiller. The UFM coated neck was provided to the establishment to aid in determining the content and source of the UFM. Ingesta and fecal material from the uncut gizzards and intestines will leach into the edible product during storage and handling contaminating the giblets. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2907100 711N-1	10/11/2013	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 1945 hours while monitoring Pre-Operational Sanitation processes in the Rotisserie Room, I observed the following. Sanitation personnel were starting to clean the room after PM shift production was completed. At approximately 2035 hours I returned and the (b)(4) Injection machine was being cleaned using the establishments' clean in place procedure. The machine is operated recirculating a cleaning solution. I returned at approximately 2100 hours the machine was stopped. At approximately 2145 hours the injection machine internal and external surfaces were being cleaned. At approximately 2230 hours the top of the Injection Machine was open and a sanitation employee was removing the needles that had been cleaned with the machine during the clean in place procedure. The top of the machine was rinsed and a second set of needles that are soaked in a solution of vinegar and water over night were inserted into the machine. I checked the injector needles that were removed after being cleaned with the clean in place procedure and observed that most of the needles were covered with a froth of product from the previous days production. The needles were rinsed with potable water and the water/vinegar solution was added. At approximately 2300 hours (B)(6) was starting her SSOP Pre-Operational Sanitation check in Rotisserie. I asked her how she inspected the injector needles listed on the form. She said that only the external surfaces of the injector needles installed in the machine were checked. At approximately 2345 hours I selected the Injection Machine for my Pre-Operational Sanitation Verification procedure in the Rotisserie Room. I spoke with (B)(6) about the frothy residue on the needles that were cleaned with the machine then asked for the Operators Manual with the manufactures recommended cleaning procedures. The manual was located in the Packaging Department Repair Office. The manual dedicated a chapter to the cleaning of the machine covering each piece i.e. piping, belts, screens etc. A note in the manual stated that the recommended cleaning procedure was to be used to address production for a shift. I told (B)(6) to fill the machine and run it so I could see if it was clean. Upon running the machine numerous pieces of fat, tissue, and coagulated blood from very small to approximately 1/2" in size came out of the drain line from the upper collection tank under the injection needles. The fluids drains into a lower tank that filters the fluid and returns it to the injection needles. The unit was drained, recleaned and released at approximately 0020 hours after a steady stream of water flowed from the injection needles and the water flowing into the collection tank was clear.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.12(a), 9 CFR 416.13(c) and 9 CFR 416.14.

[illegible]

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ2118103 815N-1	10/11/2013	03J02	Slaughter HACCP	C	<p>At 2042 I, Dr. (B)(7)(C), began performing a routine Pre-Chill Finished Product Standards PHIS task. At 2053 I identified fecal material on the eighth bird located on the internal surface of the right ventral body cavity just medial to the ventral fat pad and approximately 1.5 inches (4cm) inside the bird. It was light brown, semi-solid, creamy consistency with no plant material contained therein and was approximately ¼ inch (6mm) diameter. There were no establishment employees between the final wash cabinet and the carcass chiller therefore it is reasonable to believe the carcass would have entered the chill system (B)(6)</p> <p>(B)(6) was immediately notified and observed the noncompliance at 2054. Dr. (B)(7)(C), confirmed it was fecal matter at 2057. At 2058 the establishment implemented its written fecal failure procedure including a five minute live hang skip beginning at 2058. The cause of the zero tolerance fecal failure was identified by (B)(6) and (B)(6)</p> <p>(B)(6) at 2140 during scheduled establishment break. It was determined that on the (b)(4) In/Out bird wash two nozzles were not working properly and on the (b)(4) In/Out bird wash two leaf fat lifters had two nozzles that were missing extenders to increase the opening of the birds. Preventative measures implemented included maintenance on the offending machines (all lifters on the (b)(4) were changed by maintenance at break) and increased monitoring of the (b)(4) and (b)(4) three times per shift during company breaks and lunch. To verify the process was back under control after preventive measures were taken, the establishment completed a successful zero tolerance at 2120. This was followed by tests done every thirty minutes for the next two hours totalling four tests without any documented visible fecal contamination. To verify all possibly affected carcasses entering the chiller system were not contaminated by visible fecal material the establishment began a series of zero tolerance tests of carcasses exiting the chiller. The tests began at 2130, consisting of 32 birds for each rake (approximately five minutes) of the chiller system, ending at 2245 with last of the affected group exiting the chiller. There was no documented visible fecal contamination Post Chill. All affected carcasses were sprayed with (b)(4). This NR is linked to NR# OIJ3522085229N issued on swing shift 8/29/13. Including this NR there are three linked NRs issued in the last ninety days. Zero tolerance NRs were most recently discussed and documented during an Establishment meeting on 9/5/13.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2422102 710N-1	10/10/2013	01C02	Operational SSOP Review and Observation	C	<p>On 10/10/2013 at approximately 1005Hrs, I observed UFM (unidentified foreign material) on the Chiller B exit food contact belt. The UFM was very black in color; thick/smear grease type when touched/rubbed. The thick UFM was smeared approximately 8" x 3" in size on the belt. The food contact chiller belt was full of whole body heavy tom turkeys at this time. I saw&nbsp;(B)(6), Boning Room personnel, who was near the Boning Room Wings area. I waved to him for help and notified him of the UFM&nbsp;on the belt. Mr. (B)(6) called (B)(6) r. He removed the whole body turkey's from the affected belt. U.S. Retain Tag NO:B39554699 was applied to the affected chiller exit belt. Mr. (B)(6) was showed the UFM on the&nbsp;conveyor belt. He restored sanitary conditions by stopping the conveyor and removing all of the UFM from the belt with a sanitized cotton glove. The belt was&nbsp;sanitized and reinspected.&nbsp;The conveyor was released for operations at approximately 1010Hrs. U.S. Retain Tag&nbsp;No's: B39554697 & 98 was applied to the one and 1/4 tanks of whole body turkeys which were on the affected conveyor belt. At approximately 1110Hrs the&nbsp;(2300 pounds) of heavy tom turkeys were released back to production flow after verifying the plant's implemented reconditioning by (b)(4) water spraying/trimming and reinspection.&nbsp;One Turkey was found with UFM. This observed incident of UFM on a food contact surface during food products processing operations is in violation to 9 CFR 416.4(a); 416.4(d) and monitoring of the plant's operational sanitation 416.13(c). This noncompliance JDD2422102710N/1 is being linked to noncompliance (#119) JDD1922091518N/1 dated 9/17/2013 and &nbsp;(86) JDD1419071502N/1 dated 7/2/2013 for the same cause respectively.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2422102 710N-2	10/10/2013	01C02	Operational SSOP Review and Observation	C	<p>On 10/10/2013 at approximately 1340Hrs, I observed iniesta spilling out of a whole body heavy hen turkey's crop. The turkey was on the chiller B exit conveyer with other whole body turkeys. I pulled the turkey from the food contact conveyer onto the food contact chiller B inspection table. The iniesta was still spilling out of the broken open crop. As the contamination was extensive, U.S. Retain Tag NO:B39554114 was applied to the turkey and table. The Evisceration Line was at lunch break, I went to the Supervisor's office and notified (B)(6). Ms. (B)(6) immediately had the affected turkey carcass which did not have its crop properly removed taken to the Evisceration reprocessing room. She had the iniesta contamination on the food contact surfaces removed by (b)(4) water spraying (b)(4) ppm. She had the crop properly removed by trimming and washing with (b)(4) ppm spraying. The turkey was reinspected by Q.C.. The turkey was released back to production flow after verifying the plant's implemented appropriate corrective actions. This observed incident of turkey food product and food contact surfaces adulteration is in violation to 9 CFR 416.4(a); 416.4(d) and monitoring of the plant's operational sanitation 9 CFR 416.13(c). Ms. (B)(6) and Ms. (B)(6) were notified of the noncompliance.</p>
5308	M6137	BXL2414103 510N-1	10/10/2013	04A06	Poultry Finished Product Standards	C	<p>On 10/10/2013 while monitoring the Establishments' Reprocessing Procedures on Line (B)(6) in Plant #2, I observed the following noncompliance. At approximately 1032 hours, with a line speed of (B)(4) and two House Inspectors, I randomly removed a 10 bird sample and found one split tail bird with airsacculitis exudates and one split tail bird with partial lung remaining in the bird. I took regulatory control action by stopping the line and I informed (B)(6). The line was started back up with a line speed of (B)(4) and three House Inspectors and product was retained in a tank. I performed a recheck at approximately 1043 and failed with one split tail bird containing airsacculitis exudates. I informed (B)(6) and the line remained running with all split tail and missing tail birds being retained. I performed a recheck at approximately 1054 hours and passed, bringing the process back into control. I tagged the tank of retained birds with U.S. Retained/Rejected Tag #B31408095 pending rework of the product and I informed (B)(6) of the noncompliance. I performed a recheck of the held product at approximately 1345 hours and it passed. I removed my tag and released the product back to production at that time. My findings indicate a noncompliance with regulatory requirements 9CFR 381.76(b) and 9CFR 381.84.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN491110 1810N-1	10/10/2013	01D01	SPS Verification	C	<p>On Tuesday October 8th at approximately 12 O'clock, I observed that the drain of the offal area was clogged, and the area around the drain, approximately 20 feet by 20 feet, was covered with bloody water. I immediately asked one of the plant maintenance to inform management about the drain in order to take care of the problem. The following day, at approximately 0910 hours, I went to check the area and found that the drain still clogged and covered with smelly stagnant water. At this time the plant supervisors were in a meeting so, I informed Ms. (B)(6), of my observation and the forthcoming NR. Also, later in that day I informed MR. (B)(6), of the noncompliance documentation. Mr. (B)(6) informed me that he will take care of the Problem. At approximately 1600 hours, the area was found acceptable. 9 CFR 416.2(e)(1)(2)(3)(4) states: "Plumbing systems must be installed and maintained to: (1) Carry sufficient quantities of water to required locations throughout the establishment; (2) Properly convey sewage and liquid disposable waste from the establishment; (3) Prevent adulteration of product, water supplies, equipment, and utensils prevent the creation of insanitary conditions throughout the establishment; (4) Provide adequate floor drainage in all areas where floors are subject to flooding-type cleaning or where normal operations release or discharge water or other liquid waste on the floor."</p>
5309	P6137A	NJN581610 1910N-1	10/10/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1430 hours, while performing an operational sanitation inspection in the new room, I observed the following noncompliance: There was a pallet of returned boxed rotisseries placed in the new room for rework (cut up). The boxes were damaged not clean and wet. A plant employee started to process the first box, she moved her gloved hands on the surfaces of the box to open it, and then she took a pair of scissors to open the plastic bag containing the rotisseries, after that, she proceeded to take the carcasses out of the bag without washing or sanitizing her gloves, creating an insanitary condition and cross contaminating the product. I showed Ms. (B)(6), my finding, also, Mr. (B)(6) (day), was informed of the noncompliance and the forthcoming NR. 9 CFR 416.5(a) states: "All persons working in contact with product, food-contact surfaces, and product-packaging materials must adhere to hygienic practices while on duty to prevent adulteration of product and the creation of insanitary conditions." 9 CFR 416.4(d) states: "Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments."</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ2522103 210N-1	10/10/2013	06D02	Other Inspection Requirements	C	At approximately 1648 on 10-10-13, I, CSI (B)(7)(C), performed the missing viscera test component of the regularly scheduled Other Inspection Requirements task. The maximum allowed missing viscera at the line speed of (B)(4) is (B)(4) and I observed 15 (B)(6), witnessed the test and I verbally informed her of the failed test results. At approximately 1730, I performed the retest for missing viscera and I observed 15 (B)(6). (B)(6) witnessed the retest. I immediately notified him of the failed test results, that I was taking the regulatory control action of slowing the line to (B)(4) as per (b)(4) requirements, and that a NR would be issued to document the noncompliance. At approximately 1747, I performed a missing viscera retest requested by (B)(6) to verify process control at the line speed of (B)(4). The maximum allowed missing viscera at the line speed of (B)(4) is (B)(4) and I observed 11. The line speed was increased to (B)(4). At approximately 1829, I performed the missing viscera test to verify process control at the line speed of (B)(4) and I observed 10. This NR is linked to NR # OIJ4713094919N issued on day shift, 09-19-13. Including this NR, there have been five linked Other Inspection Requirements NRs issued in the last 90 days for the same root cause. Maintenance adjustments in response to previous Other Inspection Requirements NRs were not effective in preventing this NR. Other Inspection Requirements NRs were most recently discussed and documented during a weekly Establishment Awareness Meeting on 10-03-13.
5308	M6137	BXL0004102 109N-1	10/09/2013	01D01	SPS Verification	C	On 10/09/13 at approximately 0135 hours while performing SPS Verification task in plant 2 at the giblet chiller exit area I observed the following non-compliance to 9CFR 416.4(a) and 9CFR416.1. I observed black specks of foreign material in 2 brown tubs that were stationed to be used for storage of chicken giblets coming from plant 2 giblet chiller. Black specks foreign material was also observed on the last chicken sorter exit shoot nearest to the giblet chiller and in a stainless steel cart that was next to the brown tubs. All the specks that were found were on product contact surfaces. No product was involved. I immediately took regulatory control action by applying U.S.Reject tag # B31407337 to the tubs and area and informing (B)(6) and (B)(6) of my findings. Mr.(B)(6) took immediate corrective action by having the tubs removed and cleaning the area.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5004105 509N-1	10/09/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On 10/08/2013 at approximately 2210 hours while monitoring Pre-Operational Sanitation cleaning procedures in the Rewrap Room, I observed the following. A sanitation worker was using an air hose to blow down the conveyor belt, Stainless Steel table, product table and finally the floor until approximately 2230 hours. He swept up the big pieces of paper then blew the rest of the dust and dirt out into the packaged products storage area. He then sprayed some hand sanitizer on the tables and belt then wiped it off with brown paper towels. The employee left at approximately 2244 hours. I checked back several times and I observed no further cleaning in the Rewrap Room. A review of the establishments' Pre-Operational Sanitation 'Daily Procedures' states (B)(4)</p> <p>" under Wet Clean-Up (food contact surfaces) it states in part (B)(4)</p> <p>" At approximately 2355 hours when my Pre-Operational Sanitation Verification procedure started, I selected the Rewrap Room. There was black UFM (Unidentified Foreign Material) on the belt and belt stainless steel support bracket, on the stainless steel table, on the stainless product table, and on the majority of the floor. I discussed the cleaning procedures with (B)(6) who said they only use soap on Saturdays when the area is cleaned at the same time that the stair well that goes down into packaging is cleaned. There is no floor drain in the Rewrap Room to facilitate a normal cleaning process. The Establishments' SSOP Implementation and Monitoring Log for the Rewrap Room lists the (b)(4)</p> <p>. These areas are treated as product contact surfaces that should be addressed on a daily basis using the Establishments' Wet -Cleanup (food contact surfaces) Pre-Operational SSOP procedure. The General sanitation log was completed at approximately 2248 hours by (B)(6), and a QC according to the SSOP implementation and Monitoring Log for the shift found the area to be acceptable at 2337 hours. The Rewrap Room routinely unwraps and rewraps consumer packaged products that were dumped on the floor in the Weigh & Price cooler and are highly contaminated. The Establishment uses a Bio-Trace test for organic material on product contact surfaces to check the effectiveness of the cleaning process. According to (B)(6) Bio-Trace testing is not used on product contact surfaces in the Rewrap Room. My findings indicated a noncompliance</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.12(a), 9 CFR 416.13(c), 9 CFR 416.14, and 9 CFR 416.2(e)(4).
5310	M6137B	FFA3316103 409N-1	10/09/2013	01C01	Operational SSOP Record Review	C	On October 9, 2013 at approximately 0430 hours, while performing my operational record review for 10/08/2013. I observed that the operational records (Sanitary Practice Log) record for the night shift Raw side was not available for review. I informed (B)(6) of the noncompliance.This does not comply with establishment Monitoring and Record keeping: which states; The Qa Manager/ designee has the responsibility for the daily monitoring of the Sanitation-SOP and recording the findings and corrective action that have to be taken. Results are recorded on Establishment P-6137B Sanitary Practice Log Form B.This also does not comply with 416.16(a); which states in part "Each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the Sanitation SOP's and any corrective action taken". " Daily records required, responsible individual, initialed and dated.This document serves as written notification that failure to comply with regulatory requirement(s) of 9CFR Part 416 could result in additional regulatory or administrative action.
6036	P6164A	OIJ3522102 109N-1	10/09/2013	04A06	Poultry Finished Product Standards	C	On October 9, 2013 at 1551 I, Dr. (B)(7)(C) preformed a pre-chill Finished Product Standard (FPS) test in order to verify finished product standards were being met for ready to cook poultry prior to entry into the chiller. The absolute limit allowed for processing nonconformance is (B)(4) points, I observed 47 points. Nonconformances observed were as follows: 7 oil gland remnants (7pts), 1 whole oil gland (2pts), 2 partial lungs (2pts), 4 whole lungs (8pts), 1 Bursa of Fabricius (2pts), 1 partial crop (2pts), 3 tracheas &1" (6pts), feathers or pin feathers (9pts), feathers &1" (3pts), and 3 long shanks (6pts). (B)(6) was verbally notified of the USDA failure and preformed a retest at 1602. The tightened nonconformance standard for a retest is (B)(4) pts, (B)(6) observed 34. The nonconformance observed by (B)(6) were as follows: Extraneous material &1" (2pts), 5 partial oil glands (5pts), 2 partial lungs (2pts), 3 whole lungs (6pts), 3 Bursa of Fabricius (6pts), 1 partial crop (2pts), 2 trachea &1" (4pts), feathers &1" (2pts) and 2 long shanks (4pts). Plant immediately implemented their FPS failure procedures. (B)(6) had a passing test at 1620 (25pts) and 1641 (22pts) bringing the plant back into compliance. Auto out at post chill was 1810. Post chill documentation showed no failing tests. I verbally informed (B)(6) of the failing prechill FPS tests and that a noncompliance report would be issued. This noncompliance report is linked to OIJ0416100007N which was issued on 7 October 2013 for processing FPS noncompliance. It remains unanswered at this time. Linked FPS noncompliance was last discussed at the plant meeting on 3 October 2013.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH460410 3809N-1	10/09/2013	01D01	SPS Verification	C	<p>On the calendar date of October 9, 2013 (for the shift beginning on 10/8/13) at approximately 0118 hours while performing the Operational SSOP Review and Observation task, the following facility noncompliance was observed in the Breast Cone line processing area: Part 2 of the Sanitation SOP's states that (B)(4)</p> <p>(B)(4), CSI (B)(7)(C), observed multiple beads of condensation on the ceilings above the tender and frame conveyors. At the time of the findings, tenders and frame were on the conveyors; however, no product adulteration was observed. Also, while in the area, I observed larger droplets of condensation on the ceiling near the light fixture (yellow cord attached). (B)(6), was shown the noncompliance and he confirmed the findings. Mr. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on September 18, 2013; please reference NR # NHH0703094920N/1. The establishment's response to NR # NHH0703094920N/1 of - "The condensation was removed." - failed to prevent recurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3621100 708N-1	10/08/2013	01D01	SPS Verification	C	<p>On 10/8/2013 at approximately 1420Hrs, I observed the establishment's six restrooms. The Evisceration Live Hanging restroom had standing brownish water at the floor drain which appeared to be plugged. The toilet bottom was leaking onto the floor around the floor seam. 2.) In the women's Evisceration restroom seven toilets had water coming out through the pipes connected to the flush handles. The water was going onto the floor. 3.) The men's Evisceration restroom had 2 sinks dripping at the back wall pipes onto the floor. Two toilets had water coming out through the pipes connected to the flush handles which was going onto the floor. 4.) The women's Boning Room restroom had two toilets leaking through the pipes at the flush handles and one broken towel dispenser. 5.) The men's Boning Room restroom had a puddle of brownish/yellow fluids on the floor near a urinal and one towel dispenser was broken. (B)(6) was notified of the Evisceration restrooms and showed the leaking toilets and standing water at the floor drain. (B)(6) was notified and showed the Boning Room's men's restroom. Ms (B)(6) and Mr (B)(6) ensured inspection the observed issues will be addressed. Ms. (B)(6) and Mr (B)(6) were notified of the noncompliance. This observed incident of restroom not in good repair is in violation to (facilities) 9 CFR 416.2(h)(1) which states in part; "Dressing rooms, toilet rooms, and urinals must be maintained in a sanitary condition and in good repair at all times to ensure cleanliness of all persons handling any product." The floors with standing water and fluids is in violation to 9 CFR 416.4(b) non-food contact surfaces, cleaned and sanitized.</p>
5112	M18909	JDD5122103 208N-1	10/08/2013	01D01	SPS Verification	C	<p>On 10/8/2013 at approximately 1050Hrs while performing sanitary operations (food contact utensils). I saw several (b)(4) staged at the blender in the Raw Fabrication Room. The establishment was refilling them with ground turkey blends. I looked inside one (b)(4) and saw an approximately 1" crack/split. The crack was open and sharp to the touch. U.S. Retain Tag NO:B39554113 was applied to the (b)(4) to prevent it's use. (B)(6) was notified of the noncompliance and showed the crack/split. This observed incident of a food contact container not maintained in good repair was creating insanitary conditions and a potential food products adulteration which is in violation to the relevant regulations cited above. The (b)(4) remains on hold for repairs.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0423102 508N-1	10/08/2013	03C02	Raw Intact HACCP	C	<p>On 10/07/2013 at approximately 1945 hours while monitoring Packaging at the end of the PM shift, I observed the following. Packaged product was backed up&nbsp;outside the Crust Tunnel. There were numerous racks of packaged product in the bulk product storage side of the Crust Tunnel some with a packaging time on the Dolly Tags from 11 AM. I went to the exit end of the crust tunnel which was full of crusted product as the elevators were not functioning. The elevators take the crusted product to the Weigh&nbsp;& Price Cooler for shipping.&nbsp;I checked the&nbsp;Establishments computer to see if there was anyone monitoring the product exiting the crust tunnel or the product being stored&nbsp;in the bulk storage side of the crust tunnel. The&nbsp;last entries were made for Crust Tunnel Temperatures at approximately 1940 hours. There were no entries for product monitoring in the Bulk Storage Area. &nbsp;The crust tunnel is normally approximately (B)(4) and the bulk product storage side is normally approximately (B)(4).&nbsp;At approximately 2130 hours .using a&nbsp;company calibrated thermometer,&nbsp;&nbsp;the&nbsp;temperature of&nbsp;one item labeled 'Fresh'&nbsp;in the bulk storage side of the crust tunnel&nbsp;was found to be satisfactory. The temperature of&nbsp;a packaged&nbsp;product exiting the Crust Tunnel was warmer then usual at approximately (B)(4). A rack of bulk product exiting the Crust Tunnel was at approximately (B)(4). With the elevators broken the crust tunnel&nbsp;had been turned off. I contacted (B)(6) in the QC Office&nbsp;and informed her that the last check in the&nbsp;Crust tunnel&nbsp;was at 1940 hours. I returned later to let her know that the last product exiting the&nbsp;Crust Tunnel was loaded&nbsp;onto the elevators at approximately 2207 hours and that no temperatures had been taken for over two and one half hours. There were&nbsp;no Supervisors or QC personnel&nbsp;monitoring the process. I contacted (B)(6) on 10/08/2013 and was told there&nbsp;are no procvedures written&nbsp;for&nbsp;when the&nbsp;Crust Tunnel or associated elevator fail.&nbsp;A review of the establishments' HACCP plan - Raw not ground - Packaging under Step #9, states in part: Crust Tunnel (B) Pathogens, i.e. Salmonella. Is the Hazard Significant? NO.&nbsp;'Justification for Decision' Refrigerated temperatures will prevent the growth of pathogens, such as salmonella. Temperatures are monitored as part of the plant program. Supplement #35, CP-14 (b)(4), states in part that:</p> <p>(B)(4)</p> <p>" No temperatures were taken from approximately 1940 hours to approximately 2207 hours as required by CP-14</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							which is used to support the Hazard Analysis. My findings indicated a noncompliance with 9 CFR 417.5(a)(2).
5309	P6137A	NJN002110 4108N-1	10/08/2013	04A06	Poultry Finished Product Standards	C	At approximately 0920 hours, while performing finished product standards check on the reprocessing line I noticed the following: the plant employee assigned to check the bird starts to pull the bird out of the line and retain them either by hanging them behind him or retain them in a metal container, in spite of that I found three birds with cellulitis trim defect and that require a re-check. I immediately informed Mr. (B)(6) , of my findings and asked him to inform the QC(B)(6) to perform the re-check. The recheck pass at approximately 0930 hours, with one trim defect. At approximately 0945 hours, I noticed that the reprocessing line was full so I elected to perform another check to make sure that the reprocessing line is incompliance and the product is wholesome. In the 10 birds ample I found three birds with contamination in various areas of the carcasses, and three birds with trim defect. I immediately took control action and stopped the line, and informed Mr. (B)(6) , of my findings and the forthcoming noncompliance. The plant failed to keep the reprocessing line in control and comply with the regulations cited.9 CFR 381.91(b)(1) states: " Any carcass of poultry accidentally contaminated during slaughter with digestive tract contents shall not be condemned if promptly reprocessed under the supervision of an inspector and thereafter found not to be adulterated adulterated. Contaminated surfaces that are cut shall be removed only by trimming. Contaminated inner surfaces that are not cut may be cleaned by trimming alone, or at an approved reprocessing station away from the main processing line, by any method that will remove the contamination, such as vacuuming, washing, and trimming, singly or in combination. All visible specks of contamination must be removed, and if the inner surfaces are reprocessed other than solely by trimming, all surfaces of the carcass shall be treated with (b)(4) water containing ^{(b)(4)} ppm available (B)(4)" 9 CFR 381.86 states: "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned."

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5106103 107N-1	10/07/2013	01D01	SPS Verification	C	<p>On 10/06/2013 I observed the Giblet Chiller Tank. Chilled water circulates around numerous stainless steel pipes that contain the Giblets on the interior of the pipes. The Exterior of these pipes in the chilling tank are black in color, greasy, grimy with UFM. Mr (B)(6), Mr (B)(6) and Mr (B)(6) were shown or were verbally notified. This is a violation of the following 9 CFR's: §416.3 Equipment and utensils. (a) Equipment and utensils used for processing or otherwise handling edible product or ingredients must be of such material and construction to facilitate thorough cleaning and to ensure that their use will not cause the adulteration of product during processing, handling, or storage. Equipment and utensils must be maintained in sanitary condition so as not to adulterate product. (b) Equipment and utensils must not be constructed, located, or operated in a manner that prevents FSIS inspection program employees from inspecting the equipment or utensils to determine whether they are in sanitary condition. §416.4 Sanitary operations. Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0416102 007N-1	10/07/2013	01C02	Operational SSOP Review and Observation	C	<p>On 10/07/2013 at approximately 1225 hours while walking past the packaging&nbsp;re-hang area in Plant #2, I observed the following noncompliance. An&nbsp;employee was throwing whole breasts with wings attached&nbsp;into a brown tub that was designated for fillet pack out.The employee threw a breast&nbsp;but&nbsp;missed the tub and it&nbsp;landed on the floor. The employee picked up the breast&nbsp;and sprayed it with water from a red hose and then put it into the brown tub. The Establishments&nbsp;SSOP states in part that (B)(4)</p> <p>(B)(4)</p> <p>.&nbsp;I tagged the tub with U.S. Retained tag #B31 408090 and asked the lead person to call (B)(6).</p> <p>The lead person dumped the brown tub of&nbsp;breasts into a&nbsp;stainless steel mesh cart. The production employee responsible for reconditioning started washing the product&nbsp;and&nbsp;putting them into&nbsp;another stainless steel cart. I applied the retain tag to the cart and I started inspecting the product. (B)(6) came over and I informed him of the noncompliance. While inspecting the product I found two breasts&nbsp;with some&nbsp;black specks, UFM (Unidentified Foreign Material)&nbsp;on them. I showed them to (B)(6) and he told the employee responsible for reconditioning to condemn the product in the cart. I followed the employee to the edible dump room where I removed the tag and the product was condemned.My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.4(d), 9CFR 416.13(c), and 9CFR 416.1.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1818103 907N-1	10/07/2013	01C02	Operational SSOP Review and Observation	C	While monitoring the Establishments' Operational Sanitation Procedures at the start of the shift at the Re-wrap Room, at approximately 0910 hours, I found the following there: at the area just outside of the Re-wrap Room, at the end of the line for re-wrap product, there was two gray baskets stack on top of each other. The baskets were covered with blue plastic and were full of product. The product was uncovered, dry and had some black specks UFM (Unidentified Foreign Material) on them. Also on the first basket was a pair of green rubber gloves and a ball of already used (b)(4) wrap plastic. The product was from the previous day production (Saturday 10/05/2013). I immediately tagged the gray baskets with U.S. Rejected/Retained Tag # B31 406280. Since no Supervisor was there, I informed (B)(6) of my findings. At approximately 1045 hours CS (B)(7)(C) removed the tag and observed when a company employee from the Re-wrap Room, took the product to the edible dump room and condemned it. This is a noncompliance with the following regulatory requirements of regulation 9CFR 416.1 and 9CFR 416.4 (d).
6036	P6164A	OIJ0416100 007N-1	10/07/2013	04A06	Poultry Finished Product Standards	C	On October 7, 2013 I, CSI (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is 45 points. My test at 0900 resulted in 45 points. Plant records showed a failure within the last 10 tests and a CuSum above the start number of 19. Specifically the test at 0648 resulted in 44 points and a CuSum of 19. The plant implemented the required procedures for FPS failure. I verbally notified (B)(6) that I would be issuing a NR. Plant records show no failures occurred at Post chill and the plant achieved two passing tests at Prechill at 0945. No further failures occurred for the remainder of the shift. The Prechill nonconformances I observed were: 1 ingesta < 1/16" (1 pt), 3 partial oil glands (3 pts), 2 partial lungs (2 pts), 5 whole lungs (10 pts), 1 bursa (2 pts), 3 small feathers (3 pts), 4 large feathers (4 pts), and 9 long hocks (18 pts). On September 25, 2013 NR # OIJ3321093125N (#72) was issued for processing noncompliance. This noncompliance is linked to NR # OIJ3321093125N (#72) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the September 26, 2013 meeting.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1605100 305N-1	10/05/2013	03J02	Slaughter HACCP	C	On 10/05/2013 at approximately 0108 hours while conducting a Pre-Chill Finished Products check on line (b)(4), I observed the following. After taking a standard 10 bird random sample, I observed one carcass with visible fecal contamination. There was a small cut at the base of the tail at the junction with the saddle on the left side of the carcass. The fecal material was in that tissue tear. The fecal material was olive green in color, pasty in texture and measured approximately 1/8" by 1/4". This exceeded the Zero Tolerance for the process to be in control. I contacted (B)(6) and the protocol for fecal failure was implemented. A QC recheck passed at 0135 hours. My finding indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the CCP-2B (b)(4) of the Plant's HACCP Plan for Slaughter.
5112	M18909	JDD2712102 406N-1	10/04/2013	01C02	Operational SSOP Review and Observation	O	On 10/04/2013 at approximately 1320Hrs, Dr (B)(7)(C) and I observed the plant personnel touching the outside (non food contact) and inside of the (food contact) casings in the Raw Fabrication Cooler 9 Department. The plastic casing were being filled with 95559 ground turkey products. The casings were blowing open inside the machine as they were being filled. The meat was exposed through the openings approximately 8" to 4". The exposed meat open casings were dropping onto a food contact table. The open casings were landing on top of each other on the table. The meat coming out of the casings was touching the outside plastic casings. The personnel was touching the turkey products as she struggle to remove the meat from the open rolls. She scooped the meat out with her gloved hands and put the affected 95559 turkey into a food contact (b)(4) next to the table. She did not change her gloves or sanitize her hands. She did not sanitize the affected rolls or table. U.S. Retain Tag NO:B39554112 was applied to the affected product in the (b)(4). (B)(6) was notified of the noncompliance. Mr. (B)(6) immediately sanitized another table and separated the rolls. The affected exposed meat rolls were opened and put into the (b)(4). The not open plastic casing were sanitized and put on the clean table for rework because the did not meet the net weight.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2105102 704N-1	10/04/2013	01D01	SPS Verification	C	<p>On 10/04/2013 at approximately 0100 hours while performing a scheduled SPS Verification procedure in Plant #2, I observed the following. There were loose stainless steel splinters at three locations on a guide bar located behind the mirror at the middle inspection station on line (B)(6). The guide bar is approximately 2' in length. Two splinters were attached to the top of the bar and one was attached to the bottom. The splinters were approximately 4mm and (2) 12mm in length. The Guide Bar is approximately 1/4" thick with the wear process caused by the metal to metal contact between the Guide Bar and the stainless steel carcass shackles. Approximately 1/2 of the guide bar has worn away. With the guide bar directly above the carcasses metal splinters flaking off are creating a Physical Hazard condition. Metal of any size on or in a carcass would be considered a contaminant by USDA. I contacted (B)(6) who called a mechanic. The guide bar had raised flattened edges that were the source of the splinters. Mechanics scraped off the raised edge removing pieces of varying size from 1mm to over 2" in length and up to approximately 2mm wide. A piece of emery cloth was used to remove any remaining loose pieces. The area was rinsed with potable water and released by approximately 0115 hours. The establishment has no metal detectors.</p> <p>I gave a sample to (B)(6). The metal to metal contact creating a Physical Hazard has been occurring for sometime. A review of the Establishments' Haccp Plan - Slaughter Plant 2 which was last revised on July 9, 2013 states under (B)(4)</p> <p>(B)(4)</p> <p>This issue has been discussed at several weekly meetings with the Plant Management. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3818105 904N-1	10/04/2013	03J02	Slaughter HACCP	C	<p>At approximately 1500 hours while performing a HACCP Slaughter Record Review Task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.2 (c)(4).1.-The HACCP Monitoring Log -CCP 1B- (b)(4))&nbsp;for Line (b)(4) dated on 09/27/2013 AM shift had the following Zero Tolerance checks times: One check at 0518 hours and the following&nbsp;check at 0637 hours. The gap between these two checks&nbsp;was 1 hour and 19 minutes.2.-The HACCP Monitoring Log -CCP1B- (b)(4) for Line (b)(4), dated on 10/02/2013 AM shift&nbsp;had the following&nbsp;Zero Tolerance&nbsp;checks times: One check at 0520 hours and the&nbsp;following check at 0636 hours.&nbsp;&nbsp; The gap between these two checks was 1 hour and 16 minutes. The&nbsp;HACCP Plan states in part under monitor procedures that &nbsp;(B)(4) ".* A unit may be a carcass or a part.&nbsp;&nbsp; "Approximately is defined as 15 (-)(+) minutes".&nbsp; I notified (B)(6) &nbsp;of the noncompliance.</p>
1325 7	P33900	NHH310410 0104N-1	10/04/2013	01C02	Operational SSOP Review and Observation	C	<p>On the night of production that began on October 3, 2013 at approximately 2150 hours while observing the start of operations in the evisceration department I observed an unlabelled plastic spray bottle hanging on a hook used to hang birds at the line 1 mirror station.&nbsp;The outer surface of the bottle including the handle was greasy and dirty thereby contaminating the hook (product contact surface).&nbsp;The bottle was approximately one fourth full of an unidentified liquid.&nbsp;The hook and the bottle were rejected with US tag B38075936.&nbsp;At the time, no product was on or near the hook.&nbsp;Mr. (B)(6), was notified of the noncompliance.&nbsp;The establishment elected to discard the bottle and cleaned and sanitized the hook.&nbsp;As a verbal preventive measure, Mr. (B)(6) stated maintenance employee would be retrained to properly label containers and not to hang them on product contact surfaces.&nbsp;The regulatory control actions were then released.&nbsp;The establishment's SSOP plan states (B)(4) The requirements of 9 CFR 416.4(c) and 416.13(c) were not met. For a similar noncompliance refer to NR NHH5202082501N dated July 31, 2013.&nbsp;The preventive measure for this noncompliance was pipes would be removed from the production area prior to the start of production.&nbsp;These measures may have been implemented incorrectly or may have been ineffective at preventing recurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1911101 703N-1	10/03/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>While performing PRE-OP this date 09/30/2013 at 0400 H PST above the south end of Chiller B is a fan with flaking rust over the Carcass Chiller B. The following noted in Boning: 1): Product residue in the Tendon Puller. 2): Shrouds on the Frame Work of the MDP Motor was not disassembled an much product residue was noted. 3): Pallet Jack had product residue on it. 4): Two incidences of product residue in the Spiral Belt. 5): Belt Cog on the Thigh Skinner had product residue in it. 6): Cooler Ten: Three SS Tanks from sister facility has product residue in it. 7): The Door to (B)(4) Room by the Rosier is rusty. 8): Motor, Piping & Etc. under the Injector in Bagging needs reconditioning as it is rusty with flaking paint. Items noted were corrected by Sanitation, Maintenance or are programmed to be fixed. Ms. (B)(6) was notified by e-mail. This is linked to NR 122-2013, Dated 09/27/2013, JDD00080955127N/1 and Seven other JDD # numbers listed on NR 122-2013. This is a violation of the Establishment's written SSOP Procedures and the following 9 CFR's:</p> <p>§ 416.4 Sanitary operations. (a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. (b) Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. (d) Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments.</p> <p>§ 416.14 Maintenance of Sanitation SOP's. Each official establishment shall routinely evaluate the effectiveness of the Sanitation SOP's and the procedures therein in preventing direct contamination or adulteration of product(s) and shall revise both as necessary to keep them effective and current with respect to changes in facilities, equipment, utensils, operations, or personnel.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN251210 4903N-1	10/03/2013	01802	Pre-Op SSOP Review and Observation	C	At approximately 0540 while performing hands on Pre-Operational Sanitation after company Pre-Operational Sanitation and before the start of production I observed the following noncompliance's in Zone D, Catering-rapid pack #1. Observed 1 knife holder on the side of the production belt with meat particules from the previous days production inside the knife holder all around the inside at the bottom. Also observed build up of material from previous days production on 5 rubber strips (5"highX6"long) which make up the steam guard at the front of the shrink tunnel. There were 2 rubber strips with buildup from the previous days production (1/2"wideX 5"long) at the exit of the shrink tunnel. The knife holder is a direct product contact surface, and the rubber strips on the shrink tunnel are product contact surface which could create cross contamination. This is a noncompliance of Regulations 416.4(a), 416.13(c) and a failure of the company SSOP Plan Pg 2, I (B)(6), and (B)(6) were notified and observed the noncompliance's. Immediate corrective action was implemented to restore sanitary conditions in my presence. This NR is being linked to NR LQN3314090018N/1 dated 09/18/2013. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
1325 7	P33900	NHH270310 4603N-1	10/03/2013	03J02	Slaughter HACCP	C	On the night shift that began on 10/02/2013, from 2245 until 2305, while giving relief breaks to the line inspectors, Dr. (B)(7)(C) and I observed a large amount of carcasses that displayed cloacae and intestines attached to the carcasses. At approximately 0100 I went to the exit end of the chiller system to verify that all of these cloacae and intestines had been removed. I inspected approximately 20 carcasses and found 4 with cloacae and intestines still attached to them. On the fourth carcass that still displayed an intestine, I observed feces on the inside of the carcass. The fecal material was tanish brown in color and smeared easily to the touch. The two spots of feces were each approximately 1/8 inch in size. Two of the (b)(6) in the area (Mr. (B)(6) and Mr. (B)(6)) were shown the feces at this time. I had randomly selected the carcasses to sample from the designated Post chill collection point, located at the station designated by the Establishment. There are no other check points and/or employees stationed between where the carcass was selected from the line and the point where they enter the rehang area. The carcass was also shown to Mr. (B)(6). Mr. (B)(6) was also notified. The establishment failed to meet the requirements of 9 CFR 417.2 (c)(4) and 9 CFR 381.65 (e). For similar noncompliance refer to NR #NHH4104053703N /1, dated 05/03/2013.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN251510 2502N-1	10/02/2013	01D01	SPS Verification	C	At approximately 13:10 while performing SPS verification I observed light from the outside coming in under the left corner (2inchX2inch) of the exit door between pest boxes 28&29 and over the doors top right hand corner (12 inches long) The door is in the raw oven staging area behind the weighing scale. This is a non compliance of Regulation 416.2(b)(3).Also observed peeling paint (3inchX 4inch), (2inchX 2inch) on the wall behind the salt(B)(4) mixing tank, and several places up the wall. I observed small pieces (1/4") of white peeling paint on the walls behind the guard rails (24 plus feet in lenght) on both sides of the hallway just inside the swinging doors from cooler #3, leading to the raw side oven area.This is a non compliance of Regulation 416.2(b)(2).Also observed 2 holes- 1 (12"X 8") and 1 (3"X4") in the floor topping in Raw Cooler #2 in a high traffic area. This is a non compliance of Regulation 416.2(b)(1).These non compliances are a noncomplianc of Regulation 416.1 (B)(6) and (B)(6) were notified and observed the noncompliances.This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions.
5308	M6137	BXL2713104 402N-1	10/02/2013	04A06	Poultry Finished Product Standards	C	On 10/02/2013 at 1050 hours, while monitoring the Establishments AQL Procedure in Plant #1, I randomly selected ten livers. Three out of the ten livers had whole spleens attached and one liver had a whole gall bladder attached. This exceeds the limit of (b)(4) incomplete trim-major defects for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. Quality Control performed a recheck at 10:53 hours and failed with four incomplete trim-major defects and two incomplete trim-minor defects.Quality Control retained three tubs of livers. A recheck passed at 1112 hours, bringing the process back into control. The three tubs of livers were reworked and released by Quality Control.This is a noncompliance with regulations 9CFR381.65(a) and 9CFR381.1 "Giblets".

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1905105 301N-1	10/01/2013	06D02	Other Inspection Requirements	C	<p>At approximately 0139 hours, I performed a presentation check in Plant 1 on Line 2 at a line speed of (B)(4) (B)(4). Station #5 had 4- viscera not uniformed, and 2- opening cut for a total of 34 nonconformance points. Station #6 had 3- viscera not uniformed, 2- viscera attached to carcass, and 1- opening cut for a total of 49 nonconformance points. Station #7 had 2- viscera not uniformed, 2- viscera attached to carcass, 2- opening cut, and 1- parts inside for a total of 43 nonconformance points. This exceeded the limit of (B)(4) nonconformance points or 2 occurrences for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance, the line speed was reduced to (B)(4). At approximately 0205 hours I performed a recheck with the line speed at (B)(4). Station #7 failed with 3- viscera not uniformed, and 1- opening cut for a total of 25 nonconformance points. I informed (B)(6) of the noncompliance, the line speed was reduced to (B)(4). Rechecks at approximately 0231 hours, at a line speed of (B)(4) again at approximately 0349 hours at a line speed of (B)(4) and again at approximately 0439 hours at a line speed of (B)(4). All rechecks passed bringing the process back in control.</p>
5308	M6137	BXL2211104 201N-1	10/01/2013	03J02	Slaughter HACCP	C	<p>At approximately 0914 hours while performing scheduled Pre-Chill Finish Product Standards task I observed the following noncompliance. After taking a random 10 bird sample from Line (B)(4) in Plant #2, I observed one carcass with visible fecal contamination. There were two spots of fecal material on the leaf fat on the right side of the carcass, both pieces measuring approximately 1/4" x 1/8" in size. The fecal material was brownish green in color and thick and pasty in texture. I immediately informed (B)(6) and (B)(6) of the noncompliance. The Protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0946 hours which passed, bringing the process back into control. My findings indicate a noncompliance with 9CFR 381.65(e), 9CFR 417.2(c)(4) and the critical limits of CCP2B, (b)(4) of the Plants HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2708101 801N-1	10/01/2013	04A06	Poultry Finished Product Standards	C	On 10/01/2013 at approximately 0217 hours while monitoring Pre-Chill Finished Product Standards on line (B)(4) I observed the following. After taking a standard 10 bird sample I accumulated 50 nonconformance points. 30 points were from whole lungs. At this point CUSUM exceeded the Action Number allowed (22) so the process is judged to be out of control. I contacted (B)(6) who slowed the line to (B)(4) birds per minute. Normal line speed is (B)(4) birds per minute. Three extra personnel were placed at the end of the line to manually remove the lungs as there is no vacuuming facility available at that location. A QC recheck passed at 0226 hours. As product from lines (B)(4) & B are mixed coming out of the chiller, Post-Chill checks passed at 0321 hours and 0336 bringing the process back into control. The line was repaired and the line speed was returned to (B)(4) birds per minute at approximately 0420 hours. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv)(e)(3).
5568	M20923	XUM021210 0401N-1	10/01/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 0725 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 2, Cook side of the establishment: I found few pieces of food crumbs on blue add back conveyor belt and the also on the back stainless plate from the previous day of production. Upon continuing my inspection Line (B)(4) found few pieces of food particles on takeaway and transfer conveyor belt also from the previous day of production. I took a regulatory control action and applied USDA retain/rejected tag# B24829895. I informed (B)(6) and (B)(6) and (B)(6) of the non-compliance. The finding described in the non-compliance was on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0800 hours. Plant SSOP Section1, page1, states: (B)(4) ". 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH460010 4801N-1	10/01/2013	06D02	Other Inspection Requirements	C	<p>On the night shift that began on 09/30/2013, at approximately 2115 hours I asked the Evisceration supervisor, Mr. (B)(6), to perform a test in the picking room of the establishment. This Establishment uses a batching system of inspection, if the carcass is condemned or hung back for re-inspection the paw condemn button is pressed and a batch of paws are condemned. This insures that all paws from condemned carcasses are also condemned.</p> <p>The result of the test was that the establishment could not collect but three of the paws that are marked to show that all condemned paws would be captured and condemned on line #2. Mr. (B)(6) diverted all paws from this system to the drain so no Regulatory Control Action was taken. Line #1 segregated and condemned all 4 of the marked paws, so this line was allowed to collect paws from this system. At approximately 2230 another test was performed on the line #2 system and the results were that all the paws were segregated and condemned. This allowed the Establishment to begin collecting paws from that line also. The requirements of Regulation 381.76(b) were not being met. Refer to NR NHH4620090922N / 1 dated 09/22/2013 for similar noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4305093 430N-1	09/30/2013	01D01	SPS Verification	C	<p>On 09/30/2013 at approximately 0100 hours while performing an SPS Verification task in Plant 2, I observed the following. There was rust on the painted support brackets for the kickout assembly on the first inspection for Line (b)(4). There was rust on the support brackets for the motor assembly for Line (b)(4) at the same location. There was rust and peeling paint on a section of a dead end electrical conduit over the IOBW (inside/outside bird washer) over line (b)(4) that extends over the presenters area through line (b)(4) and (b)(4). At the second inspection station of line (b)(4) the light support bracket that measures approximately 2" by 15' has peeling paint. Mounted on the ceiling over the Liver & Heart machine are two support brackets for the rail that each measure approximately 3" by 15' both are rusted. At the third inspection station for line (b)(4) over the gray wing salvage container there is a support bracket that measures approximately 2" by 20' that has peeling paint. Over the Liver & Heart machine on line (b)(4) is a bracket that measures approximately 2" by 6' that is rusted. Over the Gizzard Puller for line (b)(4) a bracket that measures approximately 2" by 3' is rusty. At the backup gizzard pullers station a pipe holder that measures approximately 2" by 20' is rusted. Near the Liver & Heart machine for line (b)(4) is a pipe hanger that measures approximately 2" by 2' that has rust and peeling paint. Over the backup gizzard pullers station there was a bracket measuring approximately 2" by 10' that is rusty. Over the Lung for line (b)(4) a bracket that measures approximately 4" by 4' is rusty. A 4" dead end pipe near the ceiling at the same location is rusty. Two brackets over the (b)(4) bird washer for line (b)(4) are rusty. On line (b)(4) there are two support brackets over the (b)(4) bird washer that are rusted. A 4" air pipe over the Liver & Heart machine has peeling paint. At the third inspection station there was rust on the painted brackets for the kickout. The painted surfaces of the kickouts for line (b)(4) & (b)(4) at all three inspection stations are rusty/peeling paint. Over the Gizzard Puller backup station for line (b)(4) there are three pipe hangers that are rusted. A support bracket measuring approximately 3" by 10' over the (b)(4) bird washer for line (b)(4) is rusty. Rust and corrosion and peeling/flaking paint directly over exposed product passing down the Evisceration line is creating an insanitary condition. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN241609 1630N-1	09/30/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 9/30/13 at approximately 1445 hours I observed the following while performing the Zero Tolerance procedure on line # 2 at the FPS station . After pulling a ten bird &nbsp;random sample I&nbsp;noticed the back side of&nbsp;one bird&nbsp;with dark green spots were the oil gland had been removed . &nbsp;The area was approximately 1 sq inch size . I immediately reported my findings&nbsp;to (B)(6) who observed the bird and contacted Evis/Pkg. Dept. (B)(6) &nbsp;while (B)(6) &nbsp;performed a &nbsp;recheck (B)(6) requested further disposition &nbsp;from Dr.(B)(7)(C) . After confirmation by &nbsp;Dr.(B)(7)(C) the establishment was informed of the noncompliance. My finding indicate noncompliance with regulation 9CFR 381.65(e) which states that carcasses contaminated with fecal material shall be prevented from entering the chiller tank the establishments, the criteria for &nbsp;CCP 1B was also compromised . &nbsp;</p>
5568	M20923	XUM542209 5830N-1	09/30/2013	01D01	SPS Verification	C	<p>On 9/30/13, at approximately 2028 hours, while performing a routine scheduled Sanitation Performance Standard (SPS) inspection task on the Cook Area Line^{(B)(6)} by the north portion of the Oven Room, I observed the following noncompliance: leaking water from piping to the belt wash pump creating insanitary conditions of flooded standing waste water on the flooring by the electrical room door a noncompliance per 9 CFR 416.1 and 416.2(e)(2). This type of environment can possibly grow and spread food borne pathogens such as Listeria Monocytogenes. I took regulatory control by rejecting the area with US Tag # 147503. I showed and informed Mr. (B)(6) of the forthcoming noncompliance. After corrective actions were performed by production and sanitary condition were restored, I relinquished the US Tag at 2048 hours. The requirements of 9 CFR 416.1 and 416.2(e)(2) were not met. A similar noncompliance XUM5919094917N/1 was documented on 09/17/2013.</p>
5568	M20923	XUM542209 5830N-2	09/30/2013	01D01	SPS Verification	C	<p>On 9/30/13, at approximately 2036 hours, while continuing my Sanitation Performance Standards (SPS) inspection check, on the Cook Area Cooling Line^{(B)(6)} Mezzanine, I observed the following noncompliance: two plumbing pipes that provide water&nbsp;for the upper mezzanine leaking water creating insanitary conditions, a noncompliance per&nbsp;9 CFR 416.2(e)(3) and 416.1. This condition was leaking water to the mezzanine floor causing standing water. I showed and informed Mr. (B)(6) of the forthcoming noncompliance. The requirements of 9 CFR 416.2(e)(3) and 416.1 were not met.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5769	M6492	DIO4902091 230N-1	09/30/2013	01802	Pre-Op SSOP Review and Observation	C	At approximately 2315 hours I started my Pre-operational Review and Observation task upon learning from the QC that the area (Raw Processing) is ready for Inspection. I noticed at kettle number 7 that there are specks of debris of unknown origin which is black and hairlike of about 1/16"x1/8" to 1/16"x3/8" of an inch scattered at the center of the kettle which numbered to approximately 100 specks. I called the attention of (B)(6) and he immediately called the Sanitation worker to clean up the said debris. Had this contaminant not been found, it will potentially contaminate and adulterate the product that will be produced in that kettle. This is in violation of Title 9 CFR 416.4(a) and 9 CFR 416.13(c) 9 CFR 416.4(a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. 9 CFR 416.13(c) Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's.
1325 7	P33900	NHH411109 2330N-1	09/30/2013	01D01	SPS Verification	C	At 0952 hours while performing a Sanitation Performance Standard task I came across 11 combos of product that were labeled "Inedible" and placed in the inedible section of the back cooler that did not have denaturant applied. There were 8 combos of livers and 3 which contained bones. Management was notified and shown the combos. CFR 381.95 states that denaturing shall be accomplished by liberally applying it to all of the carcasses and parts. These requirements were not met; therefore, US reject tag #B36322955 was applied to the cooler. The same noncompliance was reported in Noncompliance Records NHH4811092411/1 on 09/11/2013 and NHH4612063721/1 on 06/21/2013. Efforts to prevent the recurrence of this noncompliance either have not been made or have not been effective.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN241609 1630N-1	09/30/2013	03J04	Poultry Zero Tolerance Verification	O	<p>On 9/30/13 at approximately 1445 hours I observed the following while performing the Zero Tolerance procedure on line # 2 at the FPS station . After pulling a ten bird random sample I noticed the back side of one bird with dark green spots were the oil gland had been removed . The area was approximately 1 sq inch size . I immediately reported my findings to (b) (6) who observed the bird and contacted (b) (6) while (b) (6) performed a recheck (b) (6) requested further disposition from Dr. (b) (7)(C) . After confirmation by Dr. (b) (7)(C) the establishment was informed of the noncompliance. My finding indicate noncompliance with regulation 9CFR 381.65(e) which states that carcasses contaminated with fecal material shall be prevented from entering the chiller tank the establishments, the criteria (b) (4) was also compromised . .</p>
5308	M6137	BXL5322094 125N-1	09/25/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 09/24/2013 at approximately 2225 hours while monitoring Pre-Operational Sanitation Procedures in Plant #1, I observed the following. There was Black/Brown UFM(Unidentified Foreign Material) on the metal brackets associated with the Check/Weight unit that the shackle wheels run on for lines 1& 2. The area was washed but upon reinspection the flakes of UFM washed from the unit had migrated to a puddle of water directly in front of the (b) (4) wash cabinet. The drip tray at this location drains back into the (b) (4) unit. The drip tray and (b) (4) unit are considered product contact surfaces. The UFM buildup is coming from the chain which is very rusty and will be acid washed along with the Check/Weight Unit on Saturday. There was a brown film residue along approximately a 20' section of the drip tray associated with (b) (4) Unit for lines (b) (4) The drip pans are near the ceiling and only partially accessible with a ladder for cleaning. A sanitizer was applied. The brown film is rust as it returns when the surface of the drip pan dries. The area was released at approximately 2250 hours. At approximately 2355 hours in Packaging Area #1 there were several areas of black UFM that appeared to be mold on the white nylon portion of the support brackets associated with the tray lines for product lines (b) (4) The areas affected by the UFM varied in size from approximately 1' to 6' in length. The center product collection belt for leg processors 7-9 that collects the legs was covered with black UFM that smeared like grease. The block of leg processors is not being used as Plant #2 is closed. The cracked surfaces and frayed edges of the belt were extensive so instead of cleaning the belt a work order was placed to replace the belt. Sanitary conditions were restored be approximately 0015 hours. My findings indicated a noncompliance with 9 CFR 461.1, 9 CFR 416.4(a) & (b), 9 CFR 416.2(b)(1) and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1109091 021N-1	09/21/2013	01D01	SPS Verification	O	<p>On 09/20/2013 at approximately 0520 hours while monitoring Operational Sanitation, I observed the following. Packaging workers were leaving the Plant #2 restroom/break room area after lunch. There was a thick layer of black UFM (Unidentified Foreign Material) on the floor in the hallway outside the mens restroom and on the floor inside the Weigh & Price packaged products storage area that Packaging employees were using to return to the Packaging area. I went inside the restroom area that consists of three sections. A space to hang aprons and smocks, the hand washing area, and the toilet and urinal area. The entire floor was wet with potable water leaking from a cleaning unit mounted on the wall, from a water supply valve for one of the toilets, and from the supply valve for one of the hand wash sinks. There was a strong odor of urine. There is only one floor drain. The floors are not sloped toward the drain. There was black UFM covering virtually the entire floor area with the heaviest concentration in the front of each urinal, toilet and along both hand wash sinks. In the toilet stalls there were numerous pieces of tissue on the floor some that has been there for some time as the tissue was dissolving into the liquified black UFM. The establishment has no boot scrubbers so the UFM is being collected on employees boots to be deposited onto the Packaging floor. The majority of the UFM is coming from the Weigh & Price cooler floor as the 'A' side is covered with brown liquified UFM. There are no Sanitation Supervisors available so I contacted (b) (6) and showed him the insanitary condition. Building maintenance was called to fix the leaks. The employee that 'Cleans' the space during Operations was contacted. The employee does not know how to use the cleaning station equipment mounted on the wall, so she used a spray bottle of degreaser and a bottle of toilet bowl cleaner which did little to clean the floor. Until the leaks were fixed cleaning the floor was wasted effort. The exhaust fan does very little to help dry up the area. A review of the establishments' SSOP Pre-Operational Sanitation under daily cleaning states (b) (4)</p> <p>(b) (4). I talked to (b) (6) who said restrooms are cleaned (b) (4). The establishments' General Sanitation records do not include 'restrooms' so it is unlikely that a Supervisor observes that the spaces are satisfactory prior to operations. The Establishment's SSOP under Operational Sanitation does not reference how restrooms are maintained to prevent the creation of an insanitary condition during operations as required by 9 CFR 416.4(b). The Establishment's SSOP (b) (4) for product that comes in contact with an insanitary condition i.e. a Cooler Floor that the product will be (b) (4)</p> <p>(b) (4). My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1) and 9 CFR 416.2(b)(2).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1206094 021N-1	09/21/2013	01C02	Operational SSOP Review and Observation	O	<p>On 09/21/2013 at approximately 0035 hours while monitoring Operational Sanitation at startup in Packaging, I observed the following. There was numerous specks and streaks of black and brown UFM (Unidentified Foreign Material) that smeared like grease on the center product belt that collects the cut legs and leg quarters from leg processors #4-6. The largest area of UFM was over 1 foot long and approximately 1" wide. (b) (6) was nearby so I showed him the UFM. No product was yet on the belt. (b) (6) was called and he stopped the line. Sanitation workers were called and (b) (6) brought an unmarked bottle with a clear liquid, a green scouring pad and some paper towels. (b) (6) applied the fluid from the spray bottle. The belt was scrubbed and wiped for several minutes until the UFM no longer appeared. Flushing the belt would have washed contaminants onto the main product belt for line 2nd. The line was released at approximately 0045 hours. As the cleaning solution bottle was not labeled, I asked (b) (6) what was in the bottle. He said he was not sure. I sprayed the fluid onto my hand. It gave off no soap, chlorine or sanitizer odor but the fluid did have an oily texture. I asked (b) (6) if he knew what the fluid was, he said no. I took the bottle to the mechanics office in plant #1 and showed it to the lead mechanic who said it was mineral oil used to lubricate equipment at startup and that someone had likely grabbed the wrong bottle. I returned to Packaging and informed (b) (6) of the oil. A review of the Establishments' SSOP for Operational Sanitation states (b) (4)</p> <p>(b) (4) The Operational SSOP does not mention that mineral oil can be used to clean or sanitize any product contact surfaces. Under Corrective Action the SSOP states (b) (4)</p> <p>(b) (4) but it does not say how. A review of the Establishments' Hazard Analysis - Raw Not Ground - (b) (4)</p> <p>(b) (4) My findings indicated a noncompliance with 9 CFR 461.1, 9 CFR 416.12(a), 9 CFR 416.14 and 9 CFR 416.15(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4704091 421N-1	09/21/2013	01C02	Operational SSOP Review and Observation	C	<p>On 09/20/2013 at approximately 0500 hours while performing the weekly AQL Finished Products Standards check on giblets exiting chiller #4, I observed the following. I placed the lid from a brown product tub under the exit end of the giblet chiller to capture a random sample of livers. One of the livers exiting the chiller had visible fecal material measuring approximately 3/8" by 1/8", olive green in color and pasty in texture. I called (b) (6) and showed him the fecal material. The brown tub of livers being collected from the giblet chiller was condemned and placed into a gray inedible container. The livers are finished product having received final microbial intervention with up to (b) (4) while being chilled. The livers are normally used as part of the giblet pack placed unwrapped back into whole frying chickens. A review of the establishments' HACCP Plan - (b) (4)</p> <p>My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).</p>
5333	P7632	HYE120809 2921N-1	09/21/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0436 hours in the Evisceration department I, CSI (b) (7)(C), observed that the heart harvester for line #2 had overflowed to the point that a large pile of hearts were on the floor. Also the viscera condemn chutes for USDA inspection stations #3 and #4 were clogged overflowing with condemned parts and viscera. With the drain being clogged in two spots water flooded the area between lines #1 and #2 from station #2 to #4. I showed my findings to (b) (6)</p> <p>then notified them of the noncompliance for the failure to meet the regulatory requirements cited above. (b) (6) took a immediate corrective action by having one lead person unclog the drain and a mechanic unclog the heart harvester. The maintenance employee used the stainless steel lid of the harvester to unclog the harvester, the lid was covered with water, meat, and fat particles from the days production. (b) (6) stopped the pump to the harvester then instructed the employee to empty and sanitize the equipment. Sanitary conditions were restored at 0455 hours.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4808095 320N-1	09/20/2013	04A06	Poultry Finished Product Standards	C	<p>On 09/20/2013 at approximately 2335 hours while conducting the weekly AQL Finished Product Standards check in Plant #2 from product exiting Giblet Chiller #3, I observed the following. There were numerous pieces of ingesta on all 10 necks taken as part of the sample. I counted 50 nonconformance points (minors) from ingesta and 2 majors. The limit for the process to be in control is 5 majors and 14 total nonconformance points. This is finished product that is normally treated with up to (b) (4) during chilling. The establishment places the necks back into the whole carcasses as part of an unwrapped giblet pack in Packaging prior to the carcasses being bagged. I contacted (b) (6) who checked the product being collected in the neck collection tank. The entire tank of product was condemned and taken to the edible dump room for disposal. An employee was assigned temporarily to sort the necks from chiller #3. The AM shift does not normally have a person that sorts out the contaminated product full time but uses the employee that scales the tubs of giblets to sort product when time allows. A review of the Establishments' HACCP Plan - (b) (4)</p> <p>My findings indicated a noncompliance with 9 CFR 381.76(b) and 9 CFR 381.65(a).</p>
5333	P7632	HYE440809 1620N-1	09/20/2013	01D01	SPS Verification	C	<p>While in the Evisceration department at approximately 0052 hours on September 20, 2013 I, CSI (b) (7)(C), and CSI (b) (7)(C) observed the following noncompliance. Between Evisceration line #1 and the South Chiller I observed black mold and fat residue on the South Chiller's splash guards (clear plastic curtains) and on the orange handle of the long hook utensil used to unclog the neck separator. On the chiller's splash guards I found holes in the plastic curtains for the purpose of tying them together and also cracks from wear and tear. In these holes and cracks black mold and fat residue had build up from the previous days productions. Upon further inspection I observed that the unused post chill evaluation station's overhead light also had black mold forming on it. I showed my findings to (b) (6) and notified them of the failure to meet the regulatory requirements cited above. (b) (6), was also notified of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3014095 719N-1	09/19/2013	01C02	Operational SSOP Review and Observation	C	At approximately 0842 hours while I was walking from the end of Chiller #1 in Plant #1 to Chiller #2, to perform my Post Chill task, I observed the following noncompliance. While I was walking by the Sizing Lines Drop #1 I happened to look inside the large grey bin lined with blue plastic that was staged there for product and observed a carcass on top of the pile of birds in the bin that had numerous pieces of black UFM (unidentified foreign material) on the thigh of the left leg. The pieces of UFM measured anywhere from approximately 1/4" in length x 1/8" in width to small tiny specks. On further investigation I found one more bird near the top of the pile that had a small speck of black UFM located on the breast at the opening cut. I immediately took regulatory control action and tagged the bin with USDA Retain tag #B31 408085 and informed (b) (6) and (b) (6) of the noncompliance. (b) (6) immediately had a company employee remove the bin of carcasses from the end of the sizing belt and washed it, restoring sanitary conditions to the belt. The bin was taken to have the carcasses reworked. USDA was notified that the carcasses had been reworked and CSI (b) (7)(C) went to check the carcasses and found them to be clean, restoring sanitary conditions. CSI (b) (7)(C) then removed my tag at approximately 1000 hours. My findings indicate a noncompliance with the regulatory regulations of 9CFR 416.1 and 9CFR 416.4(d).
5308	M6137	BXL4508093 119N-1	09/19/2013	04A06	Poultry Finished Product Standards	C	On 09/19/2013 at approximately 0407 hours while monitoring Post-Chill Finished product standards from product exiting Chiller #3, I observed the following. After taking a standard 10 bird sample, I accumulated 14 nonconformance point from ingesta. This exceeded the Subgroup Absolute Limit of 10 points. I contacted (b) (6). A Quality Control recheck failed at 0408 hours failed with 7 nonconformance points which exceeded Tolerance the (5) points allowed for a recheck. At this point the process is judged to be out of control. Product was tanked until rechecks at 0410 and 0415 hours brought the process back into control. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv)(e)(3).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4808091 219N-1	09/19/2013	06D02	Other Inspection Requirements	C	On 09/19/2013 at approximately 0451 hours while conducting a Presentation check on Line (b) (6) in Plant #2, I observed the following. The first Station had (4) viscera on the shackle, (3) not reflective and (3) parts inside for a total of 41 nonconformance points. This exceeded the limits of 24 points or 2 occurrences for one error for the process to be in control. A total of over 40 nonconformance points requires an immediate reduction in line speed. I contacted (b) (6) and informed him of the process being out of control. The line was slowed to 81 birds per minute. The second station had (1) viscera not uniform, (2) viscera on the shackle and (2) membranes for a total of 28 nonconformance points. The third station had (1) viscera not uniform, (2) viscera on the shackle, (5) membranes and (4) not reflected for a total of 42 nonconformance points. (b) (6) was informed and retraining was conducted. Quality Control rechecks 0503 at 81 birds per minute and 0509 hours at (b) (6) birds per minute brought the process back into control. According to the establishments (b) (4) log for the shift the (b) (4) birds being run at the time of the Presentation check had an average weight was (b) (6) pounds. My findings indicated a noncompliance with 9 CFR 381.76(b).
5308	M6137	BXL4914091 719N-1	09/19/2013	04A06	Poultry Finished Product Standards	O	While performing the Establishments' AQL procedure at the exit end of Gib Chiller #4 in Plant #2, I observed a noncompliance with the following regulatory requirements of 9CFR 381.65 (a) and 9CFR 381.76 (b). At approximately 0848 hours, I took a sample of 10 necks coming out of the Gib Chiller #4, I found three necks out of the ten, full of ingesta and counts three minors points each one. I found another two necks with some pieces of ingesta and counts two minors points each one, I found one windpipe and one incomplete trim that counts one major point each one. The total was 13 minor points and 2 major points total of 15 points. The limit for the process to be in control is 5 majors and 14 total nonconformances points. My findings indicate that the process is out of control. I immediately tagged the tank of necks with U.S. Retained/Rejected Tag # B31 407917 and informed Quality Control Personnel and (b) (6) of the noncompliance. I released the product to Quality Control and she placed a red hold tag # 39833 to the tank. At approximately 0901 hours Quality Control did a recheck and passed. The retained product was send to the edible dump room to be condemned.
5308	M6137	BXL2316094 018N-1	09/18/2013	01C02	Operational SSOP Review and Observation	O	At approximately 1250 hours, while performing post-mortem inspection on Line (b) (4), Station (b) (4) in Plant #2, Line Food Inspector (b) (7)(C) observed a live fly inside a bird. She put the viscera inside the bird to catch the fly. She contacted SCSI (b) (7)(C) and CSI (b) (7)(C) and showed them her findings. We contacted (b) (6) and showed her the bird with the fly inside. the bird was condemned. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.2 (a) and 9CFR 416.4 (d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4003093 118N-1	09/18/2013	01C02	Operational SSOP Review and Observation	C	On 09/17/2013 at approximately 01:27 hours, while performing a Operational Sanitation task, I observed the following. At the exit end of chiller #2 in plant 1, a drain pan over the production belt had large beaded condensation dripping directly onto the product of whole body chickens. (b) (6) was informed of the non compliance. The drip pan was immediately wiped off product was reconditioned and sanitation conditions restored at 01:40 hours. My findings indicate a noncompliance in regulations 416.4(d), 416.1, and 416.2(d).
5308	M6137	BXL1208095 317N-1	09/17/2013	04A06	Poultry Finished Product Standards	O	On 09/17/2013 at approximately 0200 hours while monitoring Facilities in Plant #2, I observed the following. Line (b) (6) was stopped and carcasses were collecting at the auto-rehang station. I started my stop watch and proceeded to the Paw Collection room to see if the automated paw rejection system was functioning. I observed the equipment for 10 minutes and not a single paw was being condemned. With the system operating properly and the line stopped some paws should have been rejected. I contacted (b) (6) and informed him of my observations. I reset my stopwatch, pressed the calibration/paw condemnation button at the backup body openers station and we proceeded to the paw collection room. We observed the function for another 6 minutes and again no paws were rejected. (b) (6) was called and I detailed my observations. A mechanic was called. The mechanic opened a cabinet mounted on the wall for Line (b) (6). In the cabinet the air pressure gage read zero PSI. The mechanic removed the air supply hose, cleared it and reconnected it. The air pressure gage returned to a normal range and the paw rejection process started immediately. The paws that had collected from line (b) (6) were condemned and taken to the PC plant by 0235 hours. The paw automatic reject system is monitored (b) (4) by the establishment. According to the Establishments' computer records the checks passed at (b) (4). My findings indicated a noncompliance with 9 CFR 381.65(a) and 9 CFR 381.78(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3000091 917N-1	09/17/2013	01D01	SPS Verification	O	On 09/16/2013 at approximately 1940 hours while monitoring Operational Sanitation in the Plant #1 Cooler, I observed the following. The (b) (4) unit mounted near the ceiling (W-2) was defrosting. Condensates were dripping from the front drip tray associated with the unit onto a pallet of brown tubs and a portable conveyor belt located directly under the (b) (4) unit. I contacted (b) (6) and showed him the noncompliance. The tops of the brown tubs had numerous specks to approximately 1/8" in size of black UFM (Unidentified Foreign Material) . An employee was called to move the pallet of product to a dry location. Sanitation employees removed the conveyor belt, cleaned it, covered it and returned it to the cooler location. The brown tubs, a partial pallet of salvaged parts, were rinsed thoroughly with warm potable water and restacked. A mechanic arrived and said the problem with the (b) (4) unit was that the door was open allowing too much warm moist air into the cooler. Sanitary conditions were restored by approximately 2000 hours. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).
5308	M6137	BXL5903091 717N-1	09/16/2013	01D01	SPS Verification	C	On 09/16/2013 at approximately 2326 Hrs. while monitoring the overhead structure in plant #1 for condensation I observed the following. Line #1 at inspection station #3 I noticed that one of two stainless steel drip pans which is hanging below several stainless steel pipes, was covered with beaded condensation that is directly over the slaughter line, and the salvage line (b) (6) which is carrying exposed edible chicken carcasses to and from inspection stations. I notified the (b) (6), and the deficiency was corrected. Sanitary conditions were restored at approximately 2330 Hrs. (b) (6) was notified of this deficiency. My finding indicates noncompliance with regulations .416.1: Operate in a manner to prevent insanitary conditions 416.2(d): Ventilation

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0209092 314N-1	09/14/2013	04B04	General Labeling	O	<p>On 09/13/2013 at approximately 2000 hours while monitoring Operational Sanitation in Packaging at the end of the PM shift, I observed the following. There was a partial rack consisting of 4 baskets of packaged product in the Crust Tunnel and numerous packages of product on the floor. The product included packages of Foster Farms and Organic product including whole body and various cutup items labeled 'Fresh'. Using a company calibrated thermometer I took the temperature of a couple of packages of with the coldest to approximately 19 degrees. I contacted (b) (6) and showed him the noncompliance. He said it was not an issue as he (b) (4). I informed him that I had previously seen similar product in the Weigh & Price cooler. I informed (b) (6) that I would contact (b) (6) and if a procedure was not available as to how the Establishment handles this product a noncompliance would be issued for the product temperature being labeled as fresh while being below 25 degrees. The product was collected and placed in gray product baskets under USDA Retained. At approximately 2200 hours in the Weigh & Price Cooler there was a partial rack of four baskets near the elevators that was very frosty. My thermometer registered temperatures below 25 degrees, I placed the partial rack under USDA Retained. At approximately 2300 hours, I contacted (b) (6), the product was to solid to accurately temp but using a company calibrated thermometer I show him the thermometer registered approximately 16 degrees. Again the product consisted of whole body and miscellaneous packed items both Foster Farms and Organic labeled 'Fresh'. I checked and the other product was still in the Crust Tunnel. The Establishment does not affix a Kill Date or Packaged Date on its product but relies on a label that is placed on each rack before it enters the 'Crust Tunnel'. The product was not labeled in any manner nor was it marked as being frozen. I proceeded to the QC Office and talked to (b) (6) who said there was no written procedure and that the product did not have to be condemned for being to cold. As a temporary corrective action (b) (6) had a label fixed to the three partial racks of product, approximately 200 packages. The product was sent to the rewrap room in Weigh & Price for down grade and rewrapping into (b) (4). There are varying amounts of frozen product in the crust tunnel daily. However, a review of PHIS 'Establishment Reporting' of daily Poultry Lot Information from FSIS Form 6510.7 revealed that the establishment only 'Certifies Fresh' product. My findings indicated a noncompliance with 9 CFR 381.129(b)(6)(i) and 9 CFR 381.145(b).</p>
5308	M6137	BXL0821090 214N-1	09/14/2013	01D01	SPS Verification	O	<p>At approximately 1355 hours, I observed a live juvenile cockroach on the floor between the liver tumbler/ belt and the wall in Plant #1. I caught the cockroach and immediately showed it to the (b) (6). She immediately called (b) (6) and informed him about my findings. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.2(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4820092 114N-1	09/14/2013	06D02	Other Inspection Requirements	C	While monitoring the Establishments' Reprocessing Procedures on Line 94 in Plant #1, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.91 (b). At approximately 0836 hours, I randomly removed a 10 bird sample for my reprocessing test, I found one out of ten birds with numerous pieces of ingesta by the neck area. I performed a recheck at approximately 0840 hours, in which two out of the ten birds sample contained ingesta, one had numerous pieces of ingesta by the tail area and the other had some pieces of ingesta by the neck and breast area. I immediately stopped the Line and informed (b) (6) of the noncompliance. They started the line and retained the product into a tank. At approximately 0857 hours, Quality Control performed a recheck and it passed. I released the retained product to Quality Control. The retained product was reworked and released by Quality Control.
5333	P7632	HYE510809 3614N-1	09/14/2013	03J04	Poultry Zero Tolerance Verification	C	While performing a Zero Tolerance verification task in the Evisceration department on Evisceration line #1 I, observed the following noncompliance. At approximately 0555 hours I randomly selected ten chicken carcasses. The tenth carcass of the ten had a greenish brown fecal smear approximately 1 inch in length and 1/4 of an inch in width located on the left leaf fat. I took regulatory control of the product by applying U.S. retain tag B38495430 to the product. I then showed (b) (6), my findings and informed them of the noncompliance. (b) (6), performed the recheck as per the establishment's corrective actions passing two consecutive ten carcass checks and the carcass was released to (b) (6). This failure represents a noncompliance with regulation 9 CFR 381.65(e), which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." The failure also represents a deviation with the establishment's written HACCP plan, regulatory requirements of 9 CFR 417.2(c)(4), which states: "List the procedures, and frequency with which those procedures will be performed, that will be to monitor each of the critical control points to ensure compliance with the critical limits."

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0505091 313N-1	09/13/2013	01C02	Operational SSOP Review and Observation	O	<p>On 09/13/2013 at approximately 0025 hours while monitoring the Establishments' Post-Chill Finished Products Standards from product exiting Chiller #2 in Plant #1, I observed the following. After taking a standard 10 bird sample I accumulated 16 nonconformance points. This exceeded the subgroup absolute limit of 10 points. (b) (6) arrived so I showed her the brown residue on the carcass in her hand and told her that my Post-Chill check had failed and that her check would be a recheck. (b) (6) arrived and was instructed by (b) (6) to tank the product exiting the chiller. I took a carcass to (b) (6) and showed him the brown/black residue on the bird. I proceeded to Chiller #2 and at approximately 0032 hours after taking a standard 10 bird sample I accumulated 25 nonconformance points. I told (b) (6) that the carcasses exiting Chiller #1 also had the brown/black residue. QC rechecks started at (b) (4) hours on Chiller #2 and at (b) (4) hours on Chiller #1 passed bringing the process back into control. 9 tanks were placed under QC hold pending reconditioning. The brown/black residue on the carcasses is an ongoing issue identified by the establishment as high Manganese in the city water. A review of the establishments' SSOP Correcting Action Logs under 'What actions were taken or are being taken to prevent recurrence...' has consistently stated "Product will continue to be monitored by Supervision prior to being put into production." or Maintenance and Refrigeration are working on a filtration system. There were no production or QC Supervisors at the chiller exit monitoring the carcasses exiting the chillers. The filtering system had worked properly Monday thru Wednesday but failed to prevent product contamination on Thursday indicating a need for more frequent maintenance. This issue was discussed with (b) (6) in Production. My findings indicated a noncompliance with 9 CFR 381.76(b), 9 CFR 416.4(d), 9 CFR 416.12(a), 9 CFR 416.14 and 9 CFR 416.15(b).</p>
5308	M6137	BXL0907091 613N-1	09/13/2013	03J02	Slaughter HACCP	C	<p>On 09/13/2013 at approximately 0354 hours while conducting a Post-Chill Finished Product Standards check from product exiting chiller #1 in Plant #1, I observed the following. After taking a standard 10 bird sample, I observed one carcass with visible fecal contamination. I had the lead person at the chiller exit tank product exiting the chiller and instructed the establishment personnel at the rehang station to stop hanging product entering packaging. I contacted (b) (6) and showed him the fecal material. The fecal material was located approximately 2" inside the carcass on the right side near the kidneys. The fecal material was olive green in color, pasty in texture and measured approximately 1/4" by 1/8". This exceeded the Zero Tolerance for the process to be in control. There were no QC personnel available so I performed a recheck that passed at 0400 hours. Three tanks of carcasses were placed on QC hold pending reinspection. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and CCP-2E (b) (4) of the Plant's HACCP plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4222090 413N-1	09/13/2013	04A06	Poultry Finished Product Standards	O	<p>On 09/13/2013 at approximately 0030 hours while monitoring (b) (6) performing the Paw Verification procedure on Line 1 in Plant 1, I observed the following. The marked carcass was coming out of the Venting Machine when the line stopped. The carcass and paws are no longer associated at this point as the kill line continues on with the paws while the Eviscerating Line with carcasses is stopped. The verification procedures which requires the monitoring at the Paw Harvester for the tagged shackle is invalid as the paw shackle and the carcass is no longer synchronized. (b) (6) found the procedure started at 2329 hours as being acceptable as recorded in the establishments computer records. When the line stopped the process should have been started over with a new carcass being tagged prior to the auto re-hang. A review of the establishments procedure on file as written does not state what to do if the line stops and the paw and carcass are separated. The Paw Verification process is conducted twice per shift to verify that the system is condemning the paws associated with the condemned carcass. Failure to conduct the procedure properly would allow condemned paws and adulterated product to enter commerce creating a food safety hazard. I contacted (b) (6) and detailed my observations. (b) (6) discussed the issue with (b) (6) who had (b) (6) perform the procedure a second time. My findings indicated a noncompliance with CFR 381.65(a) and 9 CFR 381.78(a).</p>
5308	M6137	BXL3408094 512N-1	09/12/2013	01C02	Operational SSOP Review and Observation	O	<p>On 09/12/2013 at approximately 0040 hours while monitoring Operational Sanitation in Packaging at startup, I observed the following. There were a few specks to approximately 1/8" of black UFM (Unidentified Foreign Material) that looked and smeared like grease on the white product cones on (b) (4) Deboning line #1. Production had just started and the plant runs for (b) (4). I contacted (b) (6) and showed him the contamination. They stopped hanging front halves (breasts & wings) on line #1 and emptied off the product on the line. Production was moved to line #2. The flow of water in the spray cabinet that washers the modules was increased. The spray cabinet is on continuously during production as the water is used to lubricate the chain. Line #1 was stopped and restarted as sanitation personnel removed the modules with the visible black UFM. As the line continued to run more and more modules were being contaminated with the UFM. After approximately 5 minutes of run time there was water with numerous specks of the UFM flowing down the inside and outside surfaces of the white product cones. (b) (6) was called and the line was cleaned and released for use by approximately 0250 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1) and 9 CFR 416.4(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2722094 911N-1	09/11/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 09/11/2013 at approximately 0010 hours while monitoring the establishments' Pre-Operational Sanitation Procedures in Packaging Area #1, I observed the following. There were numerous pieces of fat and tissue on the top of the belt to approximately 1/2" at the base of the blue incline belt that transports breast fillets from the x-ray machine to a trim station. There were also numerous pieces of fat and tissue to approximately 3" on the white nylon support brackets for the belt at the same location. The tissue on the support brackets on the inside the belt gave off a extremely strong rancid odor. The area was recleaned and released by approximately 0025 hours. In Packaging Area #2, the (b) (4) Room, at approximately 0030 hours on line #1 there was a thick layer of pink pasty tissue on both stainless cutting wheels associated with the machine that makes the first cuts on the wings. There was a piece of tissue inside a white product cone that measured approximately 4" by 1/4". A second cone had a semi-dried piece of blackened connective tissue measuring approximately 1" by 1". Approximately a 1 foot section adjacent to the spray nozzle of the pink hose at the loading end of the line had black UFM(Unidentified Foreign Material) that appeared to be mold. The hose is used during production to rinse down the line. The stainless cutting wheels on the machines that make the first cuts along the keel bone on lines 1 & 2 had rust developing. The rust was cleaned off temporarily with a green pad until the wheels can be replaced. Sanitary conditions were restored by approximately 0050 hours. My findings indicated a noncompliance with 9 CFR 416.4(a), 9 CFR 416.2(b)(1), and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE261309 2211N-1	09/11/2013	01C02	Operational SSOP Review and Observation	C	<p>While I was observing the process in the packaging department I observed a deficiency noncompliant with the 9 Code of Federal Regulations, Sections 416.1, 416.4(a), 416.5(a) and 416.13(c). At approximately 1030 hours an employee was pushing a cart with 2 bags containing 15" by 8" Styrofoam trays; than I noticed that two trays fell on the floor and the employee pushing the cart picked them up and carried them along, once the cart was unloaded the employee placed the contaminated trays on top of a stack of clean trays that were on a table along with more stacks of trays. I took regulatory control action by stopping the employees from using the affected trays before being placed on the tray belts, Ossid#1(Area IV, Unit 2) and be packed with edible product. I informed (b) (6).</p> <p>(b) (6) implemented immediate corrective actions by disposing of the contaminated trays and washing and sanitizing the table assigned to place the trays which are product contact surface. Approximately one hour earlier I noticed a similar incident. At the Thigh Drop Chute, Traypack line# , Thigh meat belt (Area IV, Unit 16) I observed a employee opening the primary bag of styrofoam trays then opened the secondary bag and handled the trays and placed them on a rack that was wrapped with a blue plastic liner without washing nor sanitizing her hands. The primary bag is exposed to the elements (dirt, dust, etc.) in the storage area. I informed (b) (6). (b) (6) condemned the affected trays as immediate corrective action and instructed the employee to sanitize her gloves. The establishment has the responsibility to ensure that employees are engaging in personal hygienic practices and product handling practices that prevent insanitary conditions and reduce the likelihood of contaminating product, food-contact surfaces, and product-packaging materials. Section 416.5(a) of the 9 Code of Federal Regulation requires that all persons working in contact with product, food-contact surfaces, and product-packaging materials must adhere to hygienic practices while on duty to prevent adulteration of product and the creation of insanitary conditions. (b) (6) was informed of the forthcoming documentation for the failure to comply with regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0423095 710N-1	09/10/2013	03C02	Raw Intact HACCP	O	<p>On 09/10/2013 at approximately 2000 hours while monitoring Operational Sanitation in Packaging at the end of the PM shift, I observed the following. The leftover product on the Salvage Parts Table was being placed in brown product tubs. Some of the product at the wing line side of the table was off colored as if it had been there for some time so I took the temperature of the legs and found temperatures over 70 degrees. There were no Quality Control or Supervisors present to assist the employee clearing off the line so I sorted out the legs over 60 degrees and placed them onto a brown tub lid and contacted (b) (6) Using a company calibrated thermometer temperatures registered in the high 60's to approximately 76.8 degrees. The product, 28 legs(drums) were condemned by (b) (6) and placed into a gray inedible barrel. The room temperature at the location was approximately 79.3 degrees. A review of the Establishments' HACCP Plan-Raw Not Ground-Packaging step #8 (b) (4) There are no supplemental supporting documents listed under 'Justification for Decision'. However, CP-12 (b) (4) is used by the establishment to monitor temperatures in the processing areas on product being packaged. CP-12 temperatures are taken approximately (b) (4) A check of the establishments' computer showed that the last temperatures were taken at approximately (b) (4) hours. The procedure states under Corrective Action Procedure that (b) (4) The establishments' HACCP Plan-Raw Not Ground-Packaging Step #1 (b) (4)</p> <p>This is a reoccurring loss of process control. The product was being collected into edible product containers, iced and saved for further processing creating an insanitary condition. My findings indicated a noncompliance with 9 CFR 381.66(b), 9 CFR 381.1(b)(iv), 9 CFR 381.145(b), 9 CFR 417.2(c)(4), 417.2(a)(1), 9 CFR 417.5(a)(2) and the establishments' SIP Protocol.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4918094 309N-1	09/09/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>While monitoring the Establishments' Pre-operational Sanitation Procedures in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4 (a) and 9CFR 416.13 (c). At approximately 0652 hours, while inspecting Area #3, Unit #10, I found the chute that catches and transfer the birds that falling down from the automatic re-hang machine to the transfer table for Line #1, with numerous pieces of black specks (UFM) Unidentified Foreing Material and dried feathers on it. I informed (b) (6). He had a sanitation employee, rewashed the entire area. At approximately 0655 hours the area was released. At approximately 0706 hours in the Area #4, Unit # 16 Final Trim Station Line #1 and Line #2 and (b) (6) Cabinets, I found the recycle water tank with numerous pieces of dried and semi-dried fat from the previous day production. The trays that the trimmers used to hold the birds in Line #1 and Line #2, had numerous pieces of blacks specks (UFM) on it. The drip pans from both lines that are attached to the (b) (6) cabinets and are a food product contact surface had several spots of black material that appeared to be grease measuring approximately 1/4" diameter in size and also residue on the entire drip pan of the same material. I informed (b) (6) and he had an employee scrub and rinse the area. Sanitary conditions were restored at approximately 0716 hours. I informed (b) (6) of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4508093 907N-1	09/07/2013	03C02	Raw Intact HACCP	C	<p>On 09/07/2013 at approximately 0305 hours while monitoring Operational Sanitation in Packaging, I observed the following. There were a row of legs(Drums) in the space between the conveyor product belt and the stainless support assemble on line (b) (6). Using a company calibrated thermometer I collected several of the legs and the temperatures of the product registered to approximately 64.2 degrees. I contacted (b) (6) and showed him where I found the legs and that all 9 legs registered at temperatures over 60 degrees. The last QC temperature check of line (b) (6) according to the establishments computer records was taken at (b) (4) hours at 47.3 degrees. The room temperature at that location was approximately 65.2 degrees. A sample of temperatures of product moving down the line registered between approximately 45.6 to 52 degrees. A review of the Establishments' HACCP Plan-Raw Not Ground-Packaging Step #8 (b) (4) (b) (6) There are no supplemental supporting documents provided under 'Justification for Decision'. However, CP-12 Processing Temperature Verification is used by the establishment to monitor temperatures in the processing areas on product being packaged. The procedure states under Corrective Action Procedure that "Product >60 degrees will be condemned." CP-12 temperatures are taken approximately (b) (4) (b) (6). The establishments' HACCP Plan -Raw Not Ground-Packaging Step #1 (b) (4) (b) (6) My findings indicated a noncompliance with 9 CFR 381.66(b) and 9 CFR 417.2(c)(4).</p>
5308	M6137	BXL1504094 206N-1	09/05/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 9/5/13 at approximately 0030 Hrs. while performing Pre-Operational Sanitation Verification Review and Observation Task, beginning with Pre-Op record review. Plant employee indicated the equipment and area was ready to begin processing, records indicated that all machines were ready for use. During sanitation verification I observed the following deficiencies: (b) (4) Room, line #1 Fillet Halving Machine, the first set of circular blades, approximately half of one blade was covered with fat residue (smeared) from previous shift's production. The motor housing's cooling fins had several small pieces of fat and meat tissue, 1/8" and smaller. The Tendon Cutting Machine had one side of one blade completely covered with fat residue. And The Backmeat Harvesting Machine, at the rear of the rotating portion of this machine used to strip meat and fat tissue from bone, had stringy tissue wrapped around and hanging from machine parts. These three machines are direct product contact surfaces. All affected areas were scrubbed and washed and reinspected, and released at approximately 0045 Hrs.. (b) (6) (b) (6) was aware of the noncompliance. My finding indicate noncompliance with Regulations 416.4(a): Food contact surface, cleaning & sanitizing as frequency 416.4(b): Non-food contact surface, cleaning & sanitizing</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2207090 805N-1	09/05/2013	04A06	Poultry Finished Product Standards	O	On 09/05/2013 at approximately 0150 hours while monitoring the Establishments' Post-Chill Finished Product Standards from product exiting Chiller #4, I observed the following. After collecting a standard 10 bird sample, I accumulated 14 nonconformance points from specks and smears of black/brown UFM(Unidentified Foreign Material). This exceeded the subgroup absolute limit of 10 points. I contacted (b) (6). I showed the carcasses that I retained from the sample to (b) (6) in Packaging. The first birds exiting the chiller were being tanked by production. A recheck by Quality Control failed at 0205 hours with 11 nonconformance points. The limit for a recheck is Tolerance (5) points. At this point the process is judged to be out of control. Production continued to tank product which was placed on QC hold pending rework. Quality Control rechecks passed at 0252 and 0259 hours bringing the process back into control. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv)(e)(3).
5308	M6137	BXL1619092 703N-1	09/03/2013	03J04	Poultry Zero Tolerance Verification	O	On 09/03/2013 at approximately 1242 hours, while performing the Zero Tolerance Task in Plant #1 on Line #1, I found visible fecal contamination on one of the ten birds I randomly removed. The fecal was located inside the bird on the right side close to the tail. The fecal material measured approximately 1/8" in diameter, olive green in color and pasty in texture. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (b) (6) of the noncompliance and the protocol for fecal failure was implemented. Quality Control performed the recheck at approximately 1306 hours and it passed. My findings indicate a noncompliance with 9CFR 381.65(e), 9CFR 417.2(c)(4), and the critical limit of CCP2B (b) (4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2308090703N-1	09/03/2013	01C02	Operational SSOP Review and Observation	O	<p>On 08/31/2013 at approximately 0024 hours while monitoring Post-Chill Finished Product Standards from product exiting chiller #2 in Plant #1, I observed the following. After taking a standard random 10 bird sample I accumulated 19 nonconformance points. Eight of the ten carcasses had black/brown residue that has been previously identified by the Establishment as high Manganese in the city water. I contacted (b) (6) and showed him the carcasses. As carcasses were already entering Packaging I had (b) (6) called. A QC Post-Chill check on Chiller #2 at 0022 hours had passed with 4 nonconformance points. A QC recheck of the USDA failure also passed at 0037 hours. The first carcasses coming out of the chillers are tanked and are normally the dirtiest as they tend to sweep out the contaminants. I placed the first tank of carcasses from chiller #2 on hold. I proceeded to Chiller #1 and performed a Post-Chill Finished Products check on the first tank of carcasses from the chiller and accumulated 12 nonconformance points for the same black/brown residue. I placed that tank of carcasses on hold. A QC Post-Chill check on Chiller #1 passed at 0027 hours with 2 nonconformance points. The residue was originally documented on NR# BXL0809113523N/1 written on 11/23/2012. The issue with the water has been occurring on a periodic basis since. A review of the establishments' SSOP Corrective Action logs under 'What actions were taken or are being taken to prevent recurrence...' has consistently stated "Quality Control and Production Supervisors will continue to monitor carcasses exiting the chillers." or "Maintenance and refrigeration are working on a filtration system." With dirty carcasses entering packaging and with no Supervisors monitoring product exiting the chillers this a failure of the establishments' SSOP Corrective Action procedure to prevent recurrence. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.12(a), 9 CFR 416.14 and 9 CFR 416.15(a).</p>
5308	M6137	BXL3403095103N-1	09/03/2013	03J02	Slaughter HACCP	O	<p>On 09/03/2013 at approximately 0008 hours while monitoring Pre-Chill Finished Product Standards on line (b) (4) in Plant #2, I observed the following. After taking a standard random 10 bird sample, I observed one bird with visible fecal material. I informed (b) (6) who implemented the protocol for fecal failure. The fecal contamination was a smear on the inside of the carcass on the left side under the fat flap adjacent to the kidneys. The fecal material measured approximately 1" by 1" , was olive green in color and pasty in texture. A QC recheck passed at 0028 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4304092 803N-1	09/03/2013	01C02	Operational SSOP Review and Observation	C	On 9/2/13 at approximately 0048 hrs. while performing Operational Sanitation Task, I observed the following. Packaging area: Located at the end of the bag line (Line (b) (4)) there are two stainless steel tables used to process salvaged leg quarters, I observed a plant employee picking up a brown edible container from a handcart placing the bottom of brown containers on top of two open containers that were partially filled, with edible product, causing the product to cross contaminate with environmental contamination from the bottom of the container. Stainless steel handcarts are used to move containers with edible product from one place to another. These carts are primarily a square shaped angle iron frame without a bottom or protection to prevent the wheels from slinging contaminated water from the floor to the bottoms of the containers. These carts are used in high traffic areas with no means of foot or floor sanitation to control floor contamination. I immediately notified (b) (6) who was close by. She took control of the contaminated product, and had it re washed at that time. Sanitary conditions were restored at 0100 hrs.. (b) (6) was made aware of the deficiency . My findings indicate noncompliance with regulations 416.1, and 416.4(d) 416.1: Operate in a manner to prevent insanitary conditions 416.4(d): Product processing, handling, storage, loading, unloading, and during transportation must be protected
5309	P6137A	NJN401509 1703N-1	09/03/2013	01D01	SPS Verification	O	At approximately 1055 hours, while verifying the plant compliance with the sanitation performance standard on the kill floor, I observed accumulations of black pasty material mixed with feathers on several areas of line (B) guide bar, on the lower surface. The most affected part of the bar was close to the oil gland removing machine. The formation of this black pasty matter is due to the friction between the metal shackles and guide bar, and the fat residue from the birds. This pasty black material increased and with the presence of water there is high probability that this accumulations of contaminant to fall on the carcasses cross contaminating them. I immediately showed Ms. (b) (6) , and Mr. (b) (6) , my finding and informed them of the forthcoming noncompliance documentation. The plant failed to comply with their procedure which states: (b) (4) 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated."

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE151109 4603N-1	09/03/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 0752 hours I was performing the Review and Observation of a Zero Tolerance verification PHIS task. To perform this task I collected a sample of ten carcasses at Line 2 FPS Inspection Station located after the (b) (4) cabinet and before the carcasses enter the North chiller. I observed in the fifth carcass a material with a paste consistency brownish/green in color consistent with fecal material. The fecal Material was located inside the carcass cavity right below the tip of the keel bone with an approximate measurement of ½ inch long by 1/8 inch wide. I took regulatory control action by stopping the line and applying Retain Tag # B38495417 to the affected carcass. I showed my finding to (b) (6) (b) (6) began corrective actions as prescribe in the establishment's HACCP plan. The affected carcass was reprocessed on the reprocessing line. The establishment failed to prevent fecal material from reaching the Line 2 FPS inspection station with the potential of entering the chiller. Section 381.65(e) from the 9 Code of Federal Regulations requires that the establishments shall prevent contaminated carcasses with visible fecal material from entering the chiller. The finding of fecal material did not meet the requirements of the establishment's HACCP plan. (b) (6) was informed of the forthcoming documentation for failure to comply with the regulatory requirements cited above. Similar noncompliances were documented on 8/25/13 and 8/27/13. Previous preventive measures failed to prevent recurrence of fecal material reaching the FPS station.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5004080 731N-1	08/31/2013	01D01	SPS Verification	C	<p>On 08/30/2013 at approximately 2205 hours while monitoring Pre-Operational Sanitation conditions in Plant #1, I observed the following. There were numerous pieces of stainless steel flaking off the guide bars associated with the venter/body opener on line #1. There were flakes loose on the guide bar that wraps around the unit and also on the guide bar that guides the carcasses out of the unit. The carcasses are being opened at this point in the slaughter process. The carcasses hang from shackles as they pass through the machine. The open carcasses when passing through the machine are just below the guide bars. Metal flakes of any size on or in a carcasses would be considered a contaminant by USDA. (b) (6) was called and I showed him the material defect. The wear on the guide bars is caused by metal to metal contact between the guide bars and the carcass shackles. Mechanics used pieces of emery cloth to removed the loose metal pieces. The venter/body opener on line #2 was in a similar condition with several metal flakes on the outflow guide bar associated with the unit. I collected several of the flakes and they measured up to approximately 3mm by 5mm in size. The units were rinsed with potable water restoring sanitary conditions by approximately 2220 hours. The guide bars are made of stainless strips that are approximately 1 1/4 and 3/4 inches in width and up to approximately 1/4" thick. The weight of the carcasses is putting pressure on the guide bars causing the metal to flatten out forming a shape brittle edge on both the top and bottom sides, it then cracks into varying sized pieces before flaking off. All the guide bars associated with both units have the sharpened edges. I showed the mechanic that maintains the unit the wear spots on the guide bars with the worst spot worn almost completely in half with a large crack that extended almost its entire length. He said he had just replaced the bars the previous month. The establishment has no metal detectors. A review of the establishments HACCP Plan- Slaughter Plant #1 under (b) (4) ' My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).</p>
5308	M6137	BXL2204085 430N-1	08/30/2013	01C02	Operational SSOP Review and Observation	C	<p>On 08/30/13 at approximately 0147 Hrs. while performing Operational Sanitation task, I observed the following. At the exit of chiller #2 the conveyor end used to divert product from the rehang area to tanks, I noted a full tank of exposed edible product (Whole body chicken) that was placed under a section of overhead drip pan covered with beaded condensation that was dripping on to the product. Chiller #1 at the front portion of the rehang table, closest to the chiller exit, I noted approximately 5-6 feet of overhead drip pan covered with beaded condensation creating the potential to contaminate exposed product on the conveyor. Drip pans are not a considered a direct product contact surface. (b) (6) was made aware of the deficiencies. Both areas were immediately wiped down, and the tanked product was rewashed, sanitary conditions were restored. My findings indicate a noncompliance with regulations 416.4(d), 416.1, 416.2(d)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3120081 629N-1	08/29/2013	01C01	Operational SSOP Record Review	O	<p>On 08/27/2013 at approximately 1900 hours while performing Operational Sanitation Records Review Task, I noticed that the SSOP Log for 08/24/2013 "Dock" Loading Dock Area was missing. The next day I asked (b) (6) about the missing log. She informed me later that the SSOP Procedure was performed but not documented. The SSOP plan states in part that QA inspector or designee (b) (4) This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.13(b) and 9CFR 416.13(c).</p>
5308	M6137	BXL5120084 629N-1	08/29/2013	01C02	Operational SSOP Review and Observation	O	<p>At approximately 1525 hours, while performing Raw Non-intact HACCP task in Rotisserie Room, I found the following, I was taking temperatures on the birds that were in the tanks staged there for dumping into the belt for the cones lines, when I observed in one tank a bird that had several small pieces of blue plastic on it. When I looked in another nearby tank, I found a couple birds with numerous black specks, UFM (Unidentified Foreign Material) on them. In a third tank more birds with UFM on them. The tanks were covered with blue plastic. I informed (b) (6) and she tagged the tanks. I inspected another two tanks that were coming from the Cooler in Plant#1 and found more birds with UFM on them. Quality Control tagged five tanks total. I informed (b) (6) and (b) (6) of the issue. I went to the Plant #1 Cooler to inspected the tanks with product covered with a blue plastic and found more birds with UFM. I Tagged four tanks total with U.S. Retained/ Rejected Tag # B31 407940, B31 408051, B31 408052 and B31 408053 and one more was tagged with the QC red hold tag. (b) (6) was informed of the noncompliance. At approximately 1635 hours, I released the product to (b) (6) I removed my tags and Quality Control placed a red hold tags on the tanks. (b) (6) informed me that (b) (6) was going to inspected every (b) (4) the product that the company employee was reworking. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.4 (d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5708084 229N-1	08/29/2013	04B04	General Labeling	C	On 08/28/2013 at approximately 2220 hours while monitoring Facilities in Plant #2 Aged Breast Cooler, I observed the following. There were 4 brown tubs of product that were not labeled. The product was changing color, and the bloody fluids present were slimy and smelled old. As Packaging production personnel were not available, I placed the product under U.S. Retained. At approximately 0100 hours I contacted (b) (6) and showed him the noncompliance. Three tubs totalling approximately 200 pounds of front halves (breast & wings) and 2 packages of (b) (4) saddle packaged half breasts were condemned and placed into a gray inedible container before dumping in the edible dump room. The establishment does not apply a 'Pack Date' to its product when packaged. Product needs to be identified in some manner (not full label) such that inspection program personnel can reinspect at any time or as often as they deem necessary to assure the products are not adulterated or misbranded. My findings indicated a noncompliance with 9 CFR 9 CFR 381.145(b) and 9 CFR 381.180(a).
5308	M6137	BXL5908081 529N-1	08/29/2013	01C02	Operational SSOP Review and Observation	O	On 08/29/2013 at approximately 0015 hours while monitoring Packaging Department Operational Sanitation at startup in Plant #1, I observed the following. Three bins were staged at the Check Weight lines with plastic liners installed ready for use. The birds were just about to start to come out of the chillers. I lifted one of the plastic liners from a bin and observed a large area of brown UFM (Unidentified Foreign Material) in the bottom and several black specks on the sides. I checked the other bins and found more black and brown UFM including several flakes measured approximately 1/2" by 3/4" by 1/8". Although the bins have a plastic liner the UFM will be added to the product during dumping. I contacted the lead person nearby and asked him to contact a Production Supervisor. The employee who does bin staging asked if there was a problem. I showed him the bins and he removed the plastic liner, rinsed the bin with cold potable water and replaced the liner. I asked him where the bins that were staged for used had been brought from. He showed me the truck on the loading dock that still had 9 bins that were stacked inside each other. The establishments' marking system uses a blue plastic cover which identifies that the bin is clean and ready for use. None of the bins on the truck were covered. I returned to the Check Weight lines and showed (b) (6) the bins. (b) (6) contact a Sanitation Supervisor for assistance. A review of the SSOP Part 1 (b) (4) under (b) (4) A review of SSOP Section 2 (b) (4) My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.11 and 9 CFR 416.12(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE271608 0229N-1	08/29/2013	01D01	SPS Verification	C	<p>At approximately 1346 hours the following noncompliance was observed in the packaging department; By the Brine tank of the injection line 1, and north of Dark Meat Conveyor, a combo bin with a blue liner was being used to hold thigh segments. Three holes were observed in the liner approximately 1 inch square to 3 inch square. U.S. Rejected tag # B38495413 was placed on the bin and (b) (6) was informed. The product was below the holes, so no product was adulterated by coming in contact with the exposed noncontact surface of the bin. (b) (6) removed the product from the bin and had the liner removed and discarded. Product was released at 1350. Quality Control SSOP records for 08/09/2013 show a similar occurrence that happened at 1217 hours with a bin of whole birds used for the rotisserie line. My findings indicate a noncompliance with regulations 9CFR 416.1 each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated. 9CFR 416.3(a) Equipment and utensils used for processing or otherwise handling edible product or ingredients must be of such material and construction to facilitate thorough cleaning and to ensure that their use will not cause the adulteration of product during processing, handling, or storage. Equipment and utensils must be maintained in sanitary condition so as not to adulterate product. 9CFR 416.4(d) Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2514080 128N-1	08/28/2013	01C02	Operational SSOP Review and Observation	O	<p>At approximately 1057 hours while conducting scheduled Operational SSOP Review and Observation task in the Packaging area I observed the following noncompliance. While I was walking by Line (b) (6) I observed heavy beaded condensation on the large drip pan that is between Line (b) (6) and the hand wash sinks, I showed the condensation to (b) (6) and (b) (6) and expressed my concerns to them as there were two full racks of product directly under it. He immediately got a sanitation employee to start wiping down the drip pan. On further investigation I walked between Lines (b) (6) and (b) (6) to look at the drip pans that run the length of the lines as I noticed condensation on them also. When I got to the end of the lines I saw that the drip pan that crosses over the top of Line (b) (6) had heavy beaded condensation on it that was right over the top of product. (b) (6) instructed the sanitation employee to wipe down the drip pan and as he did so numerous drops of condensation fell onto the product on the line. I immediately took regulatory control action and applied USDA retain tag #B31 407791 to the line (b) (6) immediately stopped the line and removed the product placing it in a brown tub while he washed the line, restoring sanitary conditions to the line at approximately 1105 hours at which time I removed my tag. At that time I accompanied (b) (6) to the scale and edible dump room where he condemned approximately 72 pounds of leg quarters at approximately 1112 hours restoring sanitary conditions. My findings indicate a noncompliance with the regulatory requirements of 9CFR 416.1, 9CFR 416.2(d), 9CFR 416.4(b) and 9CFR 416.4(d).</p>
5308	M6137	BXL5110083 928N-1	08/28/2013	01D01	SPS Verification	C	<p>On 08/28/2013 at approximately 0834 hours, after performing a Finished Products Standards task on the giblets in Plant #2, I observed the following. The drip pan that runs under Line #2 in the re-hang area was dripping condensation at the point where the drip pan slopes down, next to the USDA graders table. There were clean brown tubs staged for the gibbs right next to the drip pan that was dripping condensation, and the uncovered finished tanks of necks are brought through under that drip pan. I informed (b) (6) that I was issuing a noncompliance for the insanitary condition. (b) (6) had the clean brown tubs moved into the cooler and had the condensation wiped off. At approximately 1030 hours as I was about to perform a Finished Products Standards task on Line (b) (4) I again observed condensation dripping from the same drip pan. I informed (b) (6) and (b) (6) that I would add this information to the noncompliance that I had observed at approximately 0834 hours and that the corrective action from earlier was insufficient. The condensation was wiped off restoring sanitary conditions. My findings indicate a noncompliance with regulatory requirements of regulations 9 CFR 416.1 and 416.2(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1919080 127N-1	08/27/2013	03C02	Raw Intact HACCP	C	<p>On 08/24/2013 at approximately 1500 hours, I went to review the company results in the computer for that day. I noticed that the last check performed for temperatures in the crust tunnel was for AM Shift at (b) (4) hours. Day shift has no records for temperatures performed by Quality Control. The End of the Shift for that day was at approximately (b) (4) hours. On Monday 08/26/2013, I asked (b) (6) about the records and she informed me that no temperatures were performed that day in the Crust Tunnel. The HACCP Plan -Raw not ground- Packaging under Step #9, states in part: (b) (4)</p> <p>(b) (4)</p> <p>ram. Supplement 6,21,35. HACCP Supplement # 35, CP-14 (b) (4), states in part that: (b) (4)</p> <p>(b) (4)</p> <p>No temperatures were taken for the Dayshift (b) (4) which is used to support the Hazard Analysis. This is a noncompliance with the following regulatory requirements of regulation 9CFR 417.5(a)(2). I informed (b) (6)</p> <p>(b) (6)</p>
5308	M6137	BXL3203082 027N-1	08/27/2013	06D02	Other Inspection Requirements	C	<p>At approximately 0049 hours, I performed a presentation check in plant 2 on line (b) (4) at a line speed of (b) (4) BPM (birds per minute). Station #2 had 2- viscera on shackles, 2- membranes, 2- not reflected, and 1- contamination inside bird for a total of 30 conformation points. This exceeded the limit of 25-39 conformation points for the process to be in control. I informed (b) (6)</p> <p>(b) (4) Quality Control performed a recheck at approximately 0102 hours and station #3 failed with 2- viscera not uniformed, 1- not reflected, 1- parts inside, and 1- contamination inside bird for a total of 25 conformation points. This exceeded the limit of 25-39 conformation points for the process to be in control. (b) (6)</p> <p>(b) (4) was again informed of the failure and the line speed was reduced to 81 BPM. At approximately (b) (4) hours a QC recheck passed with a line speed of 81 BPM and again at approximately (b) (4) hours with a line speed of (b) (6) BPM, bringing the process back in control.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4207084 227N-1	08/27/2013	03J02	Slaughter HACCP	O	<p>On 08/27/2013 at approximately 0023 hours while conducting a Post-Chill Finished Products Standards procedure on product exiting Chiller #2 in Plant #1, I observed the following. After collecting a standard 10 bird sample, I observed one carcass with a shiny metal flake approximately 2mm by 5mm in size attached to the connective tissue on a piece of untrimmed neck tissue approximately 1/2" long. I informed (b) (6) of the noncompliance. According to PDD FSIS considers metal flakes of any size on a carcass to be an unacceptable contaminant that should be addressed by the establishments' Hazard Analysis. The Establishments' HACCP Plant - (b) (4) states (b) (4). The product was on a chiller exit conveyor belt just prior to hanging for final microbial intervention and packaging. The issue of metal contamination has been discussed at previous morning meetings with the establishment. My findings indicated a noncompliance with 9 CFR 416.4(d), 9 CFR 417.3(b)(1), 9 CFR 417.3(b)(2), 9 CFR 417.3(b)(3) and 9 CFR 417.3(b)(4).</p>
5333	P7632	HYE501208 4727N-1	08/27/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 0839 hours I was performing the Review and Observation component of a Finish Product Standards Task at Line 1 FPS (inspection station) prior to the carcasses entering the South chiller. While I was performing my verification task, I observed on the seventh carcass from the ten carcass sample a smear dark green in color with a paste like material consistent with fecal material (FSIS Directive 6420.2 Attachment 1). The fecal material was located on the tail bone/ oil gland area. The approximate measurement was 10 mm long and 3 mm wide. I took regulatory control action by stopping the line and retaining the affected carcass with U.S. Retain tag# B38495416. The production was resumed after I showed my finding to (b) (6). (b) (6) initiated corrective actions as stated in the establishment's HACCP plan. Mr. (b) (6) respectfully requested a second opinion from the IIC. At approximately 0915 hours SPHV, Dr. (b) (7)(C) confirmed that the material smeared on the tail bone was fecal material. The affected carcass was reprocessed. The establishment failed to prevent fecal material from reaching the Line 1 FPS inspection station with the potential of entering the chiller. Section 381.65(e) from the 9 Code of Federal Regulations requires that the establishments shall prevent contaminated carcasses with visible fecal material from entering the chiller. The finding of fecal material did not meet the requirements of the establishment's HACCP plan. Mr. (b) (6) was informed of the forthcoming documentation for failure to comply with the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1921080 226N-1	08/26/2013	03J02	Slaughter HACCP	C	<p>On 08/22/2013 at approximately 1830 hours while performing a HACCP Slaughter Record Review Task, I found the following: The Pre-shipment Record Review for the End of the shift for CCP-2B (b) (4), Zero Tolerance for Line #2 in Plant #1 dated on 08/21/2013 PM Shift was signed at (b) (4) hours. The Pre-shipment Record Review for the End of the Shift for CCP-1B (b) (4) Zero Tolerance for the Reprocessing Line (b) (4) in Plant #1 dated on 08/21/2013 was signed at (b) (4) hours. The Pre-shipment Records Review for the End of the Shift for CCP-1B (b) (4) dated on 08/21/2013 PM Shift was signed at (b) (4) hours. I observed that at 1738 hours the birds were finished at the first inspector station (station #5), from there to after the (b) (4) cabinet at the Zero Tolerance collection Area CCP-2B, it is approximately (b) (4). Generally at the end of the Shift the Line (b) (4) Supervisor has Inspector helpers hang back birds on the hang back rack. The Supervisor collects the birds on a portable rack and transfers them to Line (b) (4) before the neck cracker. The time from the neck cracker to after the house inspection employee at the Zero Tolerance collection Area CCP-1B, it is approximately (b) (4). The End of the Shift for that day of 08/21/2013 was at approximately (b) (4) hours for Line #2 and (b) (4) hours for Reprocessing Line (b) (4) and Salvage parts. The signed document certifies that the product is ready to be shipped. The Pre-shipment Record Review was signed before the End of the Shift. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 417.5 (c). I informed (b) (6) about the noncompliance.</p>
5333	P7632	HYE100308 2726N-1	08/25/2013	03J04	Poultry Zero Tolerance Verification	O	<p>While performing a Zero Tolerance verification task in the Evisceration department on Evisceration line #2 I, observed the following noncompliance. At approximately 0001 hours I randomly selected ten chicken carcasses. The fourth carcass of the ten had a greenish brown fecal smear approximately 1 inch in length and 1/4 of an inch in width located inside the cavity on the breast plate. I took regulatory control of the product by applying U.S. retain tag B43249968 to the product. I then showed (b) (6) my findings and informed them of the noncompliance. (b) (6) performed the recheck as per the establishment's corrective actions passing two consecutive ten carcass checks and the carcass was released to (b) (6) at 0005 hours. This failure represents a noncompliance with regulation 9 CFR 381.65(e), which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." The failure also represents a deviation with the establishment's written HACCP plan, regulatory requirements of 9 CFR 417.2(c)(4), which states: "List the procedures, and frequency with which those procedures will be performed, that will be to monitor each of the critical control points to ensure compliance with the critical limits."</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE100308 2726N-2	08/25/2013	03J04	Poultry Zero Tolerance Verification	O	<p>While performing a Zero Tolerance verification task in the Evisceration department on Evisceration line #2 I observed the following noncompliance. At approximately 0001 hours I randomly selected ten chicken carcasses. The fourth carcass of the ten had a greenish brown fecal smear approximately 1 inch in length and 1/4 of an inch in width located inside the cavity on the breast plate. I took regulatory control of the product by applying U.S. retained tag B43249968 to the product. I then showed (b) (6) _____, my findings and informed them of the noncompliance. (b) (6) _____, performed the recheck as per the establishments corrective actions passing two consecutive ten carcass checks and the carcass were released to (b) (6) _____ at 0005 hours. This failure represents a noncompliance with regulation 9 CFR 381.65(e), which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." The failure also represents a deviation with the establishment's written HACCP plan, regulatory requirements of 9 CFR 417.2(c)(4), which states: "List the procedures, and frequency with which those procedures will be performed, that will be monitor each of the critical control points to ensure compliance with the critical limits.</p>
5309	P6137A	NJN331608 3524N-1	08/24/2013	01D01	SPS Verification	O	<p>On Saturday 8/24/13 at approximately 1432 hours, I observed the following in the offal area while performing the SPS task . The over head auger had guts dangling, a hole bird hanging on the angle iron support bracket, a large pile of guts on the floor, flies circling the area with a foul odor in the room .Similar finding were observed on Saturday July 27th and also on Saturday August 3rd . The establishment was notified at the weekly on Tuesday August 6th . My findings are violation of regulations 9 CFR 416.1 which states " each official establishments must be maintained in a manner sufficient to prevent the creation of insanitary conditions and ensure that product is not adulterated " .</p>
5308	M6137	BXL1009082 223N-1	08/23/2013	03J02	Slaughter HACCP	C	<p>On 08/23/2013 while performing Pre-Chill Finished Products Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65(a) and 9CFR 417.2(c)(4). At approximately 0638 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1. I found one out of the ten birds with visible fecal contamination inside the bird under the leaf fat on the right side close to the tail. The fecal material was approximately 5/16" in diameter in size, olive green in color and pasty in texture. I informed (b) (6) _____ of the noncompliance and the protocol for fecal failure was implemented. At approximately 0700 hours, Quality Control performed a recheck and passed. The cause of the deviation was the first bird turner. This is a violation of the critical limits of CCP-2B, (b) (4) _____ of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5700084 122N-1	08/22/2013	01B02	Pre-Op SSOP Review and Observation	C	On 08/21/2013 at approximately 2214 hours while monitoring the establishments Pre-Operational Sanitation procedures in Plant #2, I observed the following. In Area 2 Unit 30, Line (b) (4) drip pan that runs from the Picking Room to Area 3, had a piece of fat approximately 1" in diameter on the side of the drip pan. The inside of the drip pan was covered with numerous feathers and bits of fat. I informed (b) (6) of the noncompliance and he rewashed the drip pan. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.1, 9CFR 416.13(c), and 9CFR 416.4(b).
5308	M6137	BXL5020081 420N-1	08/20/2013	03C02	Raw Intact HACCP	C	At approximately 1742 hours, using a company calibrated thermometer # 32 from Quality Control Day Shift, I was taking the temperatures on product in Main Packaging Area. On Line (b) (4) Bag fryer line, I took the temperature on the gizzards and the temperatures ranged from 60.1 degrees to 65.1 degrees. (b) (6) was close and I showed him my findings and informed him about the noncompliance. He immediately stopped the line and sent a company employee to take the product to be condemned. The product was approximately a 1/4 of a gray inedible barrel. A review of the Establishments temperatures records on Line (b) (4) under giblets temperature at 1710 hours revealed that the temperature was 46.3 degrees by Quality Control. The HACCP Plan -Raw Not Ground- Packaging Step #8 states in part, (b) (4) HACCP Supplements #33, CP-12 (b) (4), states in part that (b) (4). The Establishments' HACCP Plan -Raw Not Ground- Packaging Step #1 (b) (4) This is a noncompliance with the following regulatory requirements of regulations 9CFR 381.66 (b) and 9CFR 417.2 (c)(4).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE340808 0420N-1	08/20/2013	01C02	Operational SSOP Review and Observation	C	<p>At 0454 hours in Area III (chiller rehang) on August 20, 2013, while performing an operational sanitation inspection procedure I observed the reprocessing station had two additional brown tubs that were full of product (whole body carcass) tagged by Q.C. rep to be reconditioned. These two tubs were being used because the reprocessing cart had approximately twenty-five carcasses piled on top of it leaving no room for any other product. Carcasses were observed on overhead drip pans, under employee work stations and product conveyors. I, CSI (b) (7)(C), informed (b) (6), of the product on the floor and drip pans. The product was removed from the drip pans, floor and work stations to be reprocessed as per establishment procedure. At 0619 hours in the chiller rehang area the reprocessing station cart had approximately thirty carcasses piled on top of each other. The two additional brown tubs were piled up to the point of overflowing. At the chiller rehang table product was overflowing off the table onto the employee's boots and piling up on the platform. On the employee platform there were two piles of product that was impeding establishment employee work space totaled approximately twenty carcasses. One establishment employee was removing product as product continued to repeatedly falling from the table to the platform and floor, I then informed (b) (6) of the non compliance for the failure to meet the regulatory requirements cited above. The product was removed from the floor and employee platform and was reprocessed as per establishment procedure.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE340808 0420N-2	08/20/2013	01C02	Operational SSOP Review and Observation	C	<p>Due to a noncompliance generated during nightshift by CSI, (b) (7)(C) for product falling on the floor at the Rehang area, North chiller exit, I decided to walk through the rehang area to verify that the establishment implemented immediate corrective actions to prevent recurrence of product falling on the floor creating pile ups or carcasses falling constantly on the floor through the rehang area. At 0708 hours I observed approximately 15 carcasses dispersed on the stand located at the north side of the rehang belts where some of the carcasses were leaning on the employees' shoes. A pile of approximately 15 carcasses on the floor around the carcass catcher located under the incline conveyor was also observed. I showed the insufficiency to (b) (6). While the carcasses that were on the floor were being picked up more carcasses were observed falling on the stand because the rehang belts were overflowing; resulting in more carcasses to be reconditioned to the point where the employee reconditioning the carcasses could not keep up. At approximately 0719 hours the affected carcasses were reconditioned and sanitary conditions were restored. The 9 Code of Federal Regulations sections 416.15 (a) and 416.15 (b) require that the establishment implement corrective actions when Sanitation SOP's failed to prevent product contamination and implement corrective actions to prevent recurrence of product contamination. Mr. (b) (6) was informed of the forthcoming documentation for the failure to comply with regulatory requirements cite above.</p>
5308	M6137	BXL1008085 816N-1	08/16/2013	01C02	Operational SSOP Review and Observation	C	<p>On 08/16/2013 while performing a Post Chill Finished Products Standards Task, I found a noncompliance with the following regulatory requirements of regulations 9CFR 416.4 (d) and 9CFR 416.12 (a). At approximately 0350 hours while performing the FPS check, I observed a pile of birds on the floor between Chiller #1 and Chiller #2 in Plant #1, approximately 20 to 25 birds. I finished my FPS check and went to do another task. I was around the Area and the birds had not been picked up. At approximately 0430 hours I went to see the birds closer and they were getting dry. I contacted Quality Control and she called the Supervisor for that Area. (b) (6) came and I showed him my findings. The SSOP Plan states in part (b) (4). At approximately 0440 hours, (b) (6) picked up the birds, put them on a cart and took them to the condemned room. I informed him about the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1814081 115N-1	08/15/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0901 hours while performing scheduled Operational SSOP Review and Observation task I observed the following noncompliance. While walking through the packaging area I observed heavy beaded condensation on the drip pan located at the Breast Halver machine that is directly across from the Bag Fryer line. The drip pan was directly above a tank full of ice that was being used on the product being put in brown tubs. As no Supervisor was immediately available I showed the employees working there my concerns about the condensation. An employee started to wipe down the condensation with a squeeze sponge mop and as he was cleaning the drip pan numerous drops of water fell all over the ice in the tank. I immediately took regulatory control action by telling them not to use the tank of ice and attached USDA Retain tag #B31407792 to the tank. As I was attaching my tag (b) (6) arrived. I accompanied (b) (6) to the edible dump room where he emptied and washed the tank, restoring sanitary conditions at approximately 0918 hours, at which time I removed my tag. My findings indicate a noncompliance with 9CFR 416.4(d), 9CFR 416.2(d), 9CFR 416.4(b) and 9CFR 416.1.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2907084 415N-1	08/15/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 08/14/2013 while monitoring the Establishments' Pre-operational Sanitation Procedures in Plant #1 and Main Packaging, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4 (a) and 9CFR 416.13 (c). At approximately 2220 hours, while inspecting Area # 3, Unit #20 and Unit #21 (Inspector Stations #5 and #6), I found on the viscera shackles, semi-dried brown and red residue from the previous day production. I went to Inspectors stations #7 and #8 and found the viscera shackles with the same brown and red residue. I tagged the Line with U.S. Rejected/Retained Tag # B31 407939 and informed (b) (6) of the noncompliance. (b) (6) had sanitation employees scrubbed and rewashed the viscera shackles from Inspector Station #5 to Inspector Station #8. I continued performing Pre-operational Sanitation Procedures on Area #4 and Area #5 and then I came back to reinspected the Area, at approximately 2240 hours sanitary conditions were restored, I then released the area. At approximately 2348 hours, I went to performed Pre-operational Sanitation Procedures in Main Packaging, I was waiting in the Rehang Area in Plant #1 to start my inspection when I observed a company employee bringing a stainless steel tank into Rehang Area from the Cooler in Plant #1 to catch the ice. I decided to inspect the tanks that were covered with blue plastic and found one with numerous pieces of fat from the previous day production. I went inside the Cooler and found eleven tanks that were not covered with blue plastic and had numerous pieces of fat and meat from the previous day production . I contacted (b) (6) and informed him about the noncompliance. The SSOP states in part "(b) (4) (b) (6) instructed sanitation employees to (b) (4) as per company procedure. At approximately 0010 hours, I reinspected the tanks and released to production.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3622082 515N-1	08/15/2013	03J02	Slaughter HACCP	C	<p>On 08/14/2013 at approximately 2000 hours while performing a HACCP Slaughter Record Review Task, I found the following: 1.- The Pre-shipment Record Review for the End of the Shift for CCP-1B (b) (4) for Plant #1 dated on 08/10/2013 AM shift was signed at 0725 hours. The Pre-shipment Record Review for the End of Shift for CCP-1B (b) (4) Zero Tolerance for the Reprocessing Line (b) (4) in Plant #1 dated on 08/10/2013 AM Shift was signed at (b) (4) hours. The Pre-shipment Records Review for the End of the Shift for CCP-2B (b) (4), Zero Tolerance for Line #1 and Line #2 in Plant #1 dated on 08/10/2013 AM Shift was signed at (b) (4) hours. The signed document certifies that the product is ready to be shipped. The end of the shift for that day of 08/10/2013 AM Shift was at (b) (4) hours. My findings indicate a noncompliance with the following regulatory requirements of regulation 9CFR 417.5 (c). 2.- The HACCP Monitoring Log -CCP 2B-(b) (4) (Plant 2) for Line (b) (4) and Line (b) (4) Organic Birds dated on 08/13/2013 AM Shift had the following Zero Tolerance Checks times: first check at (b) (4) hours and (b) (4) hours, second check at 0001 hours and 0007 hours, third check at 0123 hours and 0128 hours. The HACCP Plan states in part under monitor procedures (b) (4) . The second and the third Zero Tolerance check had a gap of (b) (4) on Line (b) (4) and (b) (4) on Line (b) (4). My findings indicate a noncompliance with the following regulatory requirements of regulation 9CFR 417.2 (c)(4). I notified (b) (6) of the noncompliance.</p>
5308	M6137	BXL3720085 815N-1	08/15/2013	01C02	Operational SSOP Review and Observation	C	<p>On 08/15/2013 while walking through the packaging department I observed the following noncompliance. At approximately 1746 hours at the bag fryer line (b) (4), I observed that an employee was using scissors to cut open bagged whole birds that were in a grey plastic basket. The gray plastic baskets are not a product contact surface. The outside of the bags were not being washed before cutting them open with the scissors, and the scissors were not being washed after cutting open each bag. The Establishments SSOP states in part that (b) (4) . I informed (b) (6) and (b) (6) of the noncompliance. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.14, 9CFR 416.12(a), and 9CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN061408 1415N-1	08/14/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1814 hours, while verifying the plant compliance with the operational sanitation procedures, I observed the following; there were three groups of plant employee's unwrapping rework pouches of breast fillet. Each group had a plastic covered basket containing the wrapped product; which they were opening and emptying out over other wrapped products. The exterior of these pouches is not a food contact surface due to their unsanitary contact with the conveyors, which possibly had particles of chicken meat or juice, and cross contamination between the basket and actual pouch surface during the transportation process. Also I observed a plant employee with unwashed or gloved hands, was covering a basket with a plastic bag, and then touch the inner surface of the bag, which suppose to be a food contact surface. I immediately informed the (b) (6) of the noncompliance, and tagged the affected product with the U.S. retain tag # B43303598. At approximately 1930 hours, I checked and released the product after the plant corrective actions were found acceptable.
5309	P6137A	NJN561808 2413N-1	08/13/2013	06D02	Other Inspection Requirements	C	At 1336 hours, while performing a Presentation check on B-Line. At station # 3 the score was 67 points; this score represents two carcasses with viscera on shackle (16 points), one carcass not hung by 2 legs (9 points), two carcasses has no viscera (40 points) and one carcass not reflected (2 point). The establishment was running at the allowable line speed (b) (6) BPM (Birds per minute). I immediately informed Mr. (b) (6) of the non-compliance and had him reduce the line speed (b) (6). The line speed kept on (b) (6) BPM until the QC re-checks passed. The establishment failed to keep the conformance score with the allowable score, exceeding the score above 40 represent a non-compliance with 9 CFR 381.76 (a) and b. 9 CFR 381.76 (a) states : "A post-mortem inspection shall be made on a bird-by-bird basis on all poultry eviscerated in an official establishment. No viscera or any part thereof shall be removed from any poultry processed in any official establishment, except at the time of post-mortem inspection, unless their identify with the rest of the carcass is maintained in a manner satisfactory to the inspector until such inspection is made. Each carcass to be eviscerated shall be opened so as to expose the organs and the body cavity for proper examination by the inspector and shall be prepared immediately after inspection as ready-to-cook poultry. .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE110808 4412N-1	08/11/2013	01C02	Operational SSOP Review and Observation	C	At 0445 hours while performing Operational SSOP Review and Observation task in the Evisceration Department at the rehang area, I observed two large piles of birds approximately 150 total on the floor. There were no employees picking up the birds off the floor. I called (b) (6) and informed him of the forthcoming non-compliance. Mr (b) (6) had the two black hat leads to pick up and wash all the birds that were on the floor. No US Retained tag was applied. The establishments failure to meet the following regulations as stated constitute this non-compliance. 9CFR 416.4(d) states: "Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments." 9CFR 416.13(c) states: "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's."
5308	M6137	BXL3108083 210N-1	08/10/2013	04A06	Poultry Finished Product Standards	C	On 08/09/2013 at approximately 0030 hours while monitoring Post-Chill Finished Product Standards from product exiting Chiller #3 in Plant #2, I observed the following. After collecting a standard 10 bird sample, I accumulated 13 nonconformance points from ingesta and black/brown specks and smears which exceeded the subgroup absolute limit of 10 points. I contacted (b) (6) and informed him of the noncompliance. A Quality Control recheck at 0036 hours failed with 12 nonconformance points. The limit for a recheck is Tolerance, 5 points. At this point the process is judged to be out of control. Product exiting the chiller was tanked and placed under QC hold pending rework. Quality Control rechecks at 0047 and 0100 hours passed bringing the process back into control. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv)(e)(3).
5308	M6137	BXL3408081 810N-1	08/10/2013	01C02	Operational SSOP Review and Observation	C	On 08/10/2013 at approximately 0038 hours while monitoring Operational Sanitation Procedures in Packaging line (b) (6) I observed the following. Several of the first Organic carcasses arriving for cutup had black UFM (Unidentified Foreign Material) on the skin and connective tissue near the neck area of the carcasses. The specks and streaks measured up to approximately 1/2" by 3/8". From the location of the UFM on the carcasses the carcasses had been dragged across an insanitary surface. I contacted (b) (6) who stopped the line. A section of the drip pans after the (b) (4) unit was covered with a piece of plastic as a temporary corrective action. A tub of front halves (breast and wings) and a partial tub of half breasts were placed under QC hold until reconditioned. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2409081308N-1	08/08/2013	04A06	Poultry Finished Product Standards	C	<p>On 08/08/2013 at approximately 0440 hours while monitoring facilities in Plant #2, I observed the following. Line (b) (4) broke down repeatedly and the carcasses at the kill/evisceration line rehang station were being collected on the transfer table and into tanks. I went to the paw collection room approximately 10 minutes later to see how many paws were being condemned. The establishment has an automated paw condemnation system that automatically condemns paws when a corresponding carcass at any inspection station is condemned and for tanked carcasses caused by break downs. The paws for Line (b) (4) take approximately 10 minutes to get to the collection station. Although the carcasses were being dropped no paws were being dropped in the paw room. I contacted (b) (6) and asked why the system was not dropping any paws. Line (b) (4) repairs were going to take some time so the slaughter process was switched to line (b) (4). Before line (b) (4) was emptied it also broke down. We watched the paw condemnation process for several more minutes until the line (b) (4) was empty and line (b) (4) paws had arrived at the collection station. Although both lines (b) (4) were broken no paws were being condemned by the system. All the paws were being collected into a plastic lined bin as edible product. I placed the bin of paws being collected when I first arrived and a second bin on hold. The paws were condemned by production and dumped into the condemned products room. On 08/10/2013 at approximately 0240 hours the birds on line (b) (4) had a high rate of disease resulting in multiply line stoppages and finally a line slowdown. Line (b) (4) was stopped so I went to the paw room to observed the paw system for 15 minutes. Although it takes approximately (b) (4) for the affected paws to get to the paw collection room no paws were condemned. I contacted (b) (6) and told him of the paw system malfunction and that the tank of paws being collected was being tagged as US Retained product. The system was worked on by mechanics during the lunch break and appeared to be functioning normally after the lunch break. The bin of paws from before the lunch break was condemned by production and take to the PC plant for disposal. My findings indicated a noncompliance with 9 CFR 381.65(a) and 9 CFR 381.78(a).</p>
5308	M6137	BXL3003082008N-1	08/08/2013	04A06	Poultry Finished Product Standards	C	<p>On 08/08/2013 at approximately 0020 hours while monitoring Post-Chill Finished Product Standards from product exiting Chiller #3 in Plant #2, I observed the following. After collecting a standard 10 bird sample, I accumulated 19 nonconformance points from ingesta and black/brown specks and smears which exceeded the subgroup absolute limit of 10 points. I contacted (b) (6) and informed him of the noncompliance. A Quality Control recheck at 0030 hours failed with 12 nonconformance points. The limit for a recheck is tolerance, 5 points. At this point the process is judged to be out of control. Product exiting the chillers was tanked and placed under QC hold pending reconditioning. Quality Control rechecks at 0038 and 0105 hours passed bringing the process back into control. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv)(e)(3).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3303083 408N-1	08/08/2013	01B02	Pre-Op SSOP Review and Observation	C	On 08/07/2013 at approximately 2217 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Plant #2, I observed the following. There was peeling paint on the guide bars on line (b) (4) and (b) (4) from the oil gland remover to past the backup eviscerators station. The guide bars are considered a non-product contact surface but are located directly above the carcasses. The carcasses are being opened at this location during production. At approximately 2218 hours the auto drawer for line (b) (4) had black UFM(Unidentified Foreign Material) and wear marks on the arms of the spoons that draw the contents from the abdominal cavity. There was also a thick layer of black UFM to approximately 1/8" on the inside of the metal and white nylon guide bar above the spoon assembly. The metal to metal contact between the arm and the guide bar is the source of the UFM. Sanitary conditions were restored by approximately 2224 hours. Also on line (b) (4) there was black UFM and wear marks on the arms of the suction assembly of the Lunger that when inserted into the carcass during production extracts the lungs. The UFM was also on the inside metal portion of the metal and white nylon portion of the guide bar above the arms. The UFM is being caused by the metal to metal contact between the guide bar and the stainless arms. Sanitary conditions were restored by approximately 2230 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.2(a) & (b) and 9 CFR 416.13(c).
5309	P6137A	NJN060508 1808N-1	08/08/2013	01D01	SPS Verification	C	At approximately 0015, while performing a pre-operational inspection of the packaging area, the following noncompliance was noted. While inspecting the underside of the (b) (4) degree conveyor located in Area 2, Section C (Packaging: Segment Line & (b) (4)), I noticed fat pieces from previous usage hanging from the surface of the (b) (4) conveyor belt (non-product contact surface). After noticing the deficiency, I notified and showed the affected area to Mr. (b) (6) . I then applied US Reject tag B40191982 to the conveyor belt pending the implementation of corrective actions by the establishment. At approximately 0025, I was notified by Mr. (b) (6) that the corrective actions were completed and the equipment was ready for re-inspection. I re-examined the belt and determined that the equipment was acceptable for use. The establishment did not meet the requirements 9 CFR 416.4(b) which specifies that non-food-contact surfaces of equipment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0008084 207N-1	08/07/2013	03C02	Raw Intact HACCP	C	<p>On 08/07/2013 at approximately 0230 hours while monitoring Operational Sanitation procedures in Packaging, I observed the following. (b) (6) was taking the (b) (4) temperature of product on Line (b) (4). I asked her for her thermometer and took the temperature of product on the inflow side of the line. The product temperatures registered to 64.2 degrees. The breast tenders and fillets were at the edge of the belt adjacent to the stainless portion of the line and on the end of the transfer belt caught in the space between the belt and the stainless chute. (b) (6) called (b) (6) who was informed of the noncompliance. Approximately 12 pieces of product were involved. The product was placed into a gray inedible container. A check of the establishments' computer revealed that the last check on Line (b) (4) was at (b) (4) hours and the product was found to be at 43.7 degrees. The room temperature at the inflow side of line (b) (4) was approximately 64.2 degrees. After break a check of product arriving at line (b) (4) from the (b) (4) Room showed temperatures consistently at approximately 45 degrees. A check of the Establishments' HACCP Plan - Raw Not Ground - Packaging Step #8 (b) (4)</p> <p>However, CP-12 (b) (4) is used by the establishment to monitor temperatures in the processing areas on product being packaged. The procedure states under Corrective Action Procedure that "Product >60 degrees will be condemned." The Establishments' HACCP Plan - Raw Not Ground - Packaging Step #1 (b) (4)</p> <p>" My findings indicated a noncompliance with 9 CFR 381.66(b) and 9 CFR 417.2(c)(4).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3207081 106N-1	08/06/2013	01C02	Operational SSOP Review and Observation	C	On 08/06/2013 at approximately 0340 hours while monitoring the establishments' Operational Sanitation procedures in Plant #2, I observed the following. Line (b) (6) was stopped due to a breakdown. I walked to the kill/evisceration auto transfer area and observed a large pile of birds on the floor, approximately 200. As birds continued to fall on the floor (b) (6) was near the pile of birds rinsing them and returning them to production. The modified tank used with the reverse feature on the rehang belt was sitting nearby empty. The catch tray that captures birds that are not rehung and directs the rehang belt was full. The carcasses were falling from the top of the catch tray onto the floor. The tank normally located under the catch tray to catch the carcasses was adjacent to the pile of carcasses that were collecting on the floor. The tank was also empty. The modified tank and reverse feature on the rehang belt were used at approximately 0349 hours at about the same time that line (b) (6) restarted. There was varying amounts of blood and other contaminants on the floor at this location from the kill process creating an insanitary condition. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).
5308	M6137	BXL3422083 906N-1	08/06/2013	03C02	Raw Intact HACCP	O	On 08/06/2013 at approximately 0024 hours while conducting a Post-Chill Finished Products Standards check on Chiller #3 in Plant #2, I observed the following. After collecting a standard 10 bird sample, I observed one carcass with a shiny metal flake approximately 1mm by 3mm in size attached to the connective tissue near the junction of the wing and breast. I contacted (b) (6) and showed him the metal. I informed (b) (6) of the noncompliance. The metal flake was given to (b) (6). Organic birds were exiting the chiller. According to PDD FSIS considers metal flakes of any size on a carcass to be an unacceptable contaminant that should be addressed by the establishments' Hazard Analysis. The Establishments' HACCP Plan - Raw Not Ground Packaging Step #1 states (b) (4). The carcass contaminated with the metal flake had received its final microbial intervention and was on a rehang belt going into Packaging. There are no metal detectors in Packaging. The issue of metal contamination has been discussed at previous morning meetings with the establishment. My findings indicated a noncompliance with 9 CFR 416.4(d), 9 CFR 417.3(b)(1), 9 CFR 417.3(b)(2), 9 CFR 417.3(b)(3) and 9 CFR 417.3(b)(4).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN441708 2006N-1	08/06/2013	01D01	SPS Verification	C	At approximately 1055 hours, while verifying the plant compliance with the sanitation performance standard on the kill floor, I observed accumulations of black pasty material mixed with feathers on several areas of line (B) guide bar. The formation of this black residue is due to the friction between the metal of the shackles and the metal guide bar. This pasty black material increased and with the presence of water there is high probability that this accumulations of contaminant to fall on the carcasses cross contaminating them. I immediately showed Mr. (b) (6) [REDACTED], my finding and informed him of the forthcoming noncompliance documentation. 9 CFR 416.1 states: Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated.
5308	M6137	BXL1317080 703N-1	08/03/2013	03C02	Raw Intact HACCP	C	On 08/03/2013, at approximately 0925 hours while performing Raw Intact Task in Main Packaging, I found a noncompliance with the following regulatory requirements of regulations 9CFR 381.66 (b) and 9CFR 417.2 (c)(4). Using a company calibrated thermometer # 27 from Quality Control nightshift, I took a product temperature on Line (b) (4). The first temperature on a whole wing was 60.2 degrees. Since Quality Control was doing her temperature check, I showed her my findings. She called an employee and told him to add ice to the product, then she left. I took more product temperatures. The temperatures ranged from 60.2 degrees to 64.5 degrees. I called (b) (6) [REDACTED] and showed her my findings. She stopped the line and condemned the product due to high temperature failure, into a blue inedible barrel. The condemned product was approximately a half of a barrel. A review of the Establishments temperatures records on Line (b) (4) at (b) (4) hours revealed that the temperature was 53.1 degrees by Quality Control. The HACCP Plan -Raw Not Ground - Packaging Step #8 states in part (b) (4) [REDACTED] [REDACTED]". HACCP Supplements # 33 CP-12 (b) (4) [REDACTED], states in part that (b) (4) [REDACTED]. At approximately 0933 hours the Line was released back into production.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0012082 402N-1	08/02/2013	03C02	Raw Intact HACCP	C	<p>While performing the Review of Establishment Data Task on 07/30/2013 and 7/31/2013, I observed the following noncompliance. On the Thermometer Checkout Log dated 07/27/2013 there was an entry of thermometer #13 that had been checked out and returned by a Quality Control representative. On the Thermometer Calibration Log dated 07/27/2013 there was no calibration entry for thermometer #13. On further investigation I saw that on 07/30/2013 thermometer #35 had also been checked out and returned, however there was no record of it being calibrated on the Thermometer Calibration Log. The HACCP Plan - Slaughter - Plant #1 and Plant #2, (b) (4) - Step #38 and #37, also (b) (4) - Step #46 and #45 for (b) (4)</p> <p>One of the Supplements listed is #20 CP-11 (b) (4), which lists under (b) (4). My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 417.4(a)(2)(i) and 9CFR 417.5(a)(3). I informed (b) (6) of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5808080 202N-1	08/02/2013	01D01	SPS Verification	O	<p>On 08/02/2013 at approximately 0015 hours after completing Pre-Operational Sanitation in Packaging Area #1, I observed the following. Production was setting up in Packaging at the start of the shift. The dollies and baskets being removed from the elevator and the bulk products storage side of the crust tunnel and were being distributed to all the packaging lines. The wheels on the dollies being removed from the elevator were leaving a trail of brown UFM (Unidentified Foreign Material) on the floor. Hundreds of dollies are used during the shift and are brought down from the Weigh & Price Cooler on the elevator. The floor is normally not rinsed until lunch break at approximately 0430 hours. The heavy traffic will spread the UFM all over Packaging. The casters on the dollies are severely rusted with decaying product material adhering to the rust. The Dollies are a non-product contact surface and have not been cleaned for some time. I contacted (b) (6) and showed him the condition of the dollies and the insanitary condition they were creating. The dollies were collected and given a cold water rinse that had little effect. The dollies and baskets were placed into the elevator and storage side of the crust tunnel by sanitation to get them out of the way to facilitate Pre-Operational Sanitation cleaning procedures. Per a discussion at the morning meeting on 07/24/2013 available dollies and baskets are cleaned nightly as part of Pre-Operational sanitation. (b) (6) was called and stated that there is only time to rinse the dollies daily but that 300 dollies were cleaned on 07/27/2013. An acid cleaner is used that is not compatible with the daily sanitizer, so sanitation only uses the acid on Saturdays. He showed me several of the clean dollies and it was clear that the tops of the frame was cleaned and virtually free of the brown UFM but the bottoms of the frame and casters were still brown and rusted. I then showed (b) (6) the Crust Tunnel where the product racks made of the dollies and baskets are used to hold product during chilling. The tracks that the dollies run on are severely rusted. The crust tunnel is seldom cleaned as the floor is severely deteriorated. We proceeded to the Weigh & Price Cooler where the product is held in the racks until shipped. The cooler floor has a large area covered with liquefied brown UFM. The 'A' side of the cooler where the large liquefied brown area is located was cleaned on 7/27/2013 and will not be cleaned for another month. The floor in the elevator that is used to bring the dollies down stairs to Packaging is also cover with a similar brown UFM. At approximately 2000 hours on 08/02/2013 I had (b) (6) clean a dolly using the foam cleaner available nightly. The cleaning process using the foam cleaner did not significantly reduce the brown UFM on the dolly. The establishments' SSOP states that (b) (4)</p> <p>" No brushes are being utilized by</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							sanitation to clean the dollies or baskets. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), ad 9 CFR 416.4(b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN581308 2202N-1	08/02/2013	04A06	Poultry Finished Product Standards	C	At approximately 0910 hours, I was performing a post-mortem inspection on line (A) when I observed a carcass which had already been marked with a vertical slash across the back. The carcass was re-hung on the line after it was taken down, rather than taken to the salvage station. I immediately showed Mr. (b) (6) , my finding and informed him of the forthcoming noncompliance documentation. 9 CFR 381.84 states: "Carcasses of poultry with evidence of extensive involvement of the air sacs with airsacculitis or those showing airsacculitis along with systemic changes shall be condemned. Less affected carcasses may be passed for food after complete removal and condemnation of all affected tissues including the exudates."
5333	P7632	HYE091308 5202N-1	08/02/2013	03J04	Poultry Zero Tolerance Verification	C	At approximately 0940 hours, I was performing the Review and Observation component of a Zero Tolerance Task at Line 1 FPS (inspection station) prior to the carcasses entering the South chiller. While I was performing the Zero Tolerance verification, I observed a cloaca with a piece of intestine approximately 3 inches long attached to the tenth carcass from the ten carcass sample. After a closer observation, I noticed that the cloaca was draining a whitish paste like material consistent with fecal material (FSIS Directive 6420.2 Attachment 1). I took regulatory control action by retaining the affected carcass with U.S. Retain tag# B43303554. I showed my finding to (b) (6) . Ms. (b) (6) initiated corrective actions as stated in the establishment's HACCP plan. Mr. (b) (6) respectfully requested a second opinion from the IIC. At approximately 1040 hours SPHV, Dr. (b) (7)(C) , confirmed that the material draining out of the end tip of the cloaca was fecal material. The affected carcass was reprocessed. The establishment failed to prevent fecal material from reaching the A line FPS inspection station with the potential of entering the chiller. Section 381.65(e) from the 9 Code of Federal Regulations requires that the establishments shall prevent contaminated carcasses with visible fecal material from entering the chiller. The finding of fecal material did not meet the requirements of the establishment's HACCP plan. (b) (6) was informed of the forthcoming documentation for failure to comply with the regulatory requirements cited above. Two fecal failures occurred on 7/29/13 and 8/01/13 . Previous preventive measures failed to stop reoccurrence of fecal material reaching the FPS station.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE240308 3501N-1	08/01/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 7/31/13 at approximately 2202 while performing the Pre-Operational SSOP Review and Observation task I, CSI (b) (7)(C), observed the following noncompliance. In Area #1 (B Line kill machine) I observed one fly, alive, on the product contact surface of the neck guide bar. The equipment was retained with the application of U.S. retain tag B38495422. (b) (6) killed the insect and showed me the remains. While the equipment was being washed and sanitized I investigated the kill room area further and found that the door to the live hang area was open and the air curtain machine was not working properly. After the equipment was washed and sanitized it was released at 2209 hours. (b) (6) were both informed of the noncompliance. Continuing my Pre-Operational Review and Observation task in Area IV, I inspected Unit #6 (Main Dark Meat Conveyors incline and decline belts. The Dark Meat Decline portion of the white conveyor had a greenish foreign material, with the consistency of machine grease, on the belt along with fat particles and a small winged insect. Also the white hard plastic guides that are bolted to the stainless steel frame of the conveyor had a gap between it and the frame of approximately 1/4 of an inch. This gap revealed a meat and fat residue built up on the white plastic guides. The conveyor was retained with the application of U.S. retain tag B38495429. I requested from (b) (6) a Bio Trace reading to be taken while waiting for maintenance employees to arrive to disassemble equipment, the reading was 774 bacteria count. (b) (6) had Establishment maintenance employees remove the guides for the purpose of thorough cleaning of the product contact surfaces. The backside surface of the guides had black mold on them, these findings were shown to (b) (6). After all equipment of was washed, sanitized and reinspected the equipment was released at approximately 0042 hours. Upon reviewing the establishment's Pre-Operational SSOP records for the night in question I noted that Section #4 Segment Line 1, (b) (4) Unit #12 (b) (4) incline conveyor belts was inspected and passed by the Establishment Q.C. personnel. (b) (6) were informed of the noncompliance for the failure to meet the regulatory requirements stated above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE580708 1001N-1	08/01/2013	03J04	Poultry Zero Tolerance Verification	C	<p>While performing a Zero Tolerance verification task in the Evisceration department on Evisceration line #1 I, CSI (b) (7)(C), observed the following noncompliance. At approximately 0546 hours I randomly selected ten chicken carcasses. The tenth carcass of the ten had two greenish brown fecal globs 1/4 of an inch in it's greatest diameter located inside the cavity on the left thigh. The fecal material smeared from inside to the left side leaf fat covering approximately 1 inch in length and 3/4 of an inch in width of the leaf fat. I took regulatory control of the product by applying U.S. retain tag B38495426 to the product. I then showed (b) (6) [REDACTED], my findings and informed them of the noncompliance. (b) (6) [REDACTED], performed the recheck as per the establishment's corrective actions passing two consecutive ten carcass checks and the carcass was released to (b) (6) [REDACTED] at 0550 hours. This failure represents a noncompliance with regulation 9 CFR 381.65(e), which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." The failure also represents a deviation with the establishment's written HACCP plan, regulatory requirements of 9 CFR 417.2(c)(4), which states: "List the procedures, and frequency with which those procedures will be performed, that will be monitor each of the critical control points to ensure compliance with the critical limits. A fecal failure occurred on 7/29/13, previous preventive measures failed to stop reoccurrence of this noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1205074 131N-1	07/31/2013	06D02	Other Inspection Requirements	C	<p>On 07/31/2013 at approximately 0204 hours while performing the monthly Presentation procedure in Plant #1 Line #2, I observed the following. At a line speed of (b) (4) bpm (birds per minute) the third station had (1) viscera not uniform, (1) viscera attached to the carcass, (3) opening cuts, (3) parts inside and (1) contamination inside bird for a total of 32 nonconformance points. The fourth station had (1) viscera not uniform, (3) opening cut and (3) parts inside for a total of 14 points. This exceeded the limits of 2 occurrences or 24 points for the process to be in control. A no viscera check as part of the Presentation check also failed with 18 no viscera. At a line speed of (b) (4) bpm 13 no viscera are allowed. (b) (6) was informed. A recheck at approximately 0224 hours at a line speed of (b) (4) bpm the second station had (2) viscera attached to the carcass, (1) viscera swinging and (2) opening cut for a total of 34 points. The third station had (1) viscera not uniform, (1) viscera attached and (3) opening cut for a total of 23 points. The fourth station had (2) viscera not uniform, (1) viscera attached to carcass, (3) opening cut and (2) parts inside for a total of 33 points. (b) (6) was informed and the line was slowed to 126 bpm. Adjustments were made to the giblet turner during lunch. After lunch break a recheck at approximately 0339 hours the third station had (2) viscera not uniform and (2) viscera attached to carcass for a total of 40 points. The fourth station had (2) viscera not uniform, (1) viscera attached to carcass, (1) viscera swinging and (1) opening cut for a total of 39 points. (b) (6) was informed and the line was slowed to 113 bpm. Rechecks at approximately 0357 and 0521 hours passed except for the no viscera portion of the Presentation check with the line speed being returned to 126 bpm. To pass the Presentation rechecks the establishment condemned the viscera attached to the carcass or on the shackles prior to the carcass being inspected throwing the viscera into the trough at the backup eviscerators station. Quality Control rechecks for no viscera failed at 0428 and 0639 hours so the line speed was kept at 126 bpm for the remainder of the shift. Three consecutive no viscera checks is an indication of a loss of process control. My findings indicated a noncompliance with 9 CFR 381.76(a) & (b).</p>
5308	M6137	BXL2914075 431N-1	07/31/2013	01C02	Operational SSOP Review and Observation	O	<p>On 07/31/2013 at approximately 0933 hours, as I was about to perform a Post-Chill Finished Product Standards check on Chiller #4 in Plant #2, I observed the following. I took the USDA stainless steel cart that was located next to Chiller #4, and I saw that there was a dead adult cockroach lying in it. I immediately tagged the cart with U.S. Rejected, U.S. Retained Tag # A 5324458. I showed (b) (6) my findings and informed him of the noncompliance. I removed the tag and (b) (6) took the cart and washed it and returned it to me. This restored sanitary conditions. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.2(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4020071 931N-1	07/31/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1525 hours, I was walking to the Rehang Area to perform the Post Chill Finished Product Standards Task, when I observed at the end of the Chiller #1 a stainless steel tank full of whole birds partial covered with a blue plastic. I saw one bird with numerous blacks specks UFM (Unidentified Foreing Material), I uncovered the entire tank and inspected several more birds and found more UFM on them. I immediately tagged the tank with U.S. Retained/Rejected Tag # B31 406696 and informed (b) (6) and (b) (6) of my findings. Since Quality Control was there I released the retained tank of product at approximately 1532 hours to her. I removed my tag and Quality Control placed a red hold tag to the tank. At approximately 1625 hours, the birds where hung on Line (b) (6) in packaging for reprocessing. The birds went through the (b) (4) sprayers, rinse water sprayers and at the beginning of the line a company employee was spraying the birds with (b) (4). Quality Control inspected the tubs with the reworked parts and found them to be acceptable. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.4 (d).
5308	M6137	BXL5018070 930N-1	07/30/2013	01C02	Operational SSOP Review and Observation	C	On 07/25/2013 while performing Operational SSOP Review and Observation Task in Main Packaging and (b) (4) Room, I found a noncompliance with the following regulatory requirements of regulations 9CFR 416.2 (c), 9CFR 416.12 (a) and 9CFR 416.13 (b). At approximately 1500 hours, I was inspecting product at the Reconditioning Station in the (b) (4) Room, I noticed that it was difficult to inspected the parts that were in a brown tub because one of the light tubes was off. I left to check the SSOP program to see if there was a requirement for lighting. The SSOP Plan (b) (4) stated in part that (b) (4). At approximately 1525 hours, I returned and there was new reconditioning product ready for inspection. I contacted (b) (6) and notified him of the SSOP requirements and asked him to have an electrician check the lighting. The electrician came and measure the foot candles of light at the Reconditioning Station. It was 107 foot candles of light intensity. I tagged the Reconditioning Station with U.S. Rejected/Retained Tag # B31 407099 and informed (b) (6) that it was a noncompliance. He sent the product to another Reconditioning Station for rework and had an electrician work on the light. At approximately 1605 hours SCS (b) (7)(C) and the electrician measured the light intensity and it was 207 foot candles, he then released the area.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN170707 5530N-1	07/30/2013	01D01	SPS Verification	O	<p>At approximately 0059 hours, while entering the new room department through the east side entrance I observed the following non compliance: a beaded condensation on the ammonia pipes dripping on the entrance floor where the product passes through this entrance. I immediately rejected the area by applying U.S. Rejected tag No B38494918. (b) (6)</p> <p>_____ were showed my finding and informed with the forthcoming noncompliance record. The area was rechecked found acceptable and released by Dr. (b) (7)(C) _____, IIC establishment P-6137A, at 0155 hours. Upon review of the establishment daily implementation and monitoring log for operation, the last check at 2318 hours found acceptable". The Requirements of 9 CFR 416.1, 9 CFR 416.2(d), Plant's written SSOP, were not met 9CFR 416.2(d) Ventilation requirement states "Ventilation adequate to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product, and creation of insanitary conditions must be provided" Establishment's SSOP Part 2- Operational Sanitation Section 6 New Product Room states:</p> <p>(b) (4) _____"</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN191207 2431N-1	07/30/2013	04A06	Poultry Finished Product Standards	C	<p>At approximately 0835 hours, while performing finished product standards verification check on the reprocessing line, I observed the following noncompliance. Four of the ten randomly picked carcasses sample were contaminated with various amounts of ingesta in the lap area, on the lower back bone at the site of the kidneys, and on the fat close to the tail. Another three carcasses were contaminated with various sizes of gall stain on the lap and back skin as well as oil gland partially trimmed, two other carcasses had scabs and feathers on the skin of the lap area, and one carcass marked with split tail with the infected lungs not vacuumed, and dark blue bruises on the thigh. I immediately took regulatory control action by stopping the reprocessing line, and showed my findings to Mr. (b) (6), (b) (6), the (b) (6), and informed them of the forthcoming noncompliance. At approximately 0845 hours, I recorded my findings and released the line after the plant employees removed all the affected carcasses for rework. At approximately 0855 hours, The reprocessing line was rechecked and released after was found acceptable. The plant failed to keep the reprocessing line in control. 9 CFR 381.91(b) states: "Any carcass of poultry accidentally contaminated during slaughter with digestive tract contents shall not be condemned if promptly reprocessed under the supervision of an inspector and thereafter found not to be adulterated. Contaminated surfaces that are cut shall be removed only by trimming. Contaminated inner surfaces that are not cut may be cleaned by trimming alone, or at an approved reprocessing station away from the main processing line, by any method that will remove the contamination, such as vacuuming, washing, and trimming, singly or in combination. All visible specks of contamination must be removed, and if the inner surfaces are reprocessed other than solely by trimming, all surfaces of the carcass shall be treated with chlorinated water containing 20 ppm available chlorine." 9 CFR 381.84 states: "Carcasses of poultry with evidence of extensive involvement of the air sacs with airsacculitis or those showing airsacculitis along with systemic changes shall be condemned. Less affected carcasses may be passed for food after complete removal and condemnation of all affected tissues including the exudate." 9 CFR 381.89 states: " Any part of a carcass which is badly bruised shall be condemned and, if the whole carcass is affected as a result of the bruise, the whole carcass shall be condemned."</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN350307 1330N-1	07/30/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 2400 hrs. I was performing the review and observation component of a Zero Tolerance task on evisceration A line at the pre chill inspection station prior to carcasses entering the chiller. I examined a sample set consisting of ten random carcass when I noted the following non compliance. One carcass of the ten sampled contained brown colored material, approximately 1/4 of an inch in diameter, located on the inside of the carcass below the tail in the pelvic area. This material is consistent with fecal material. (b) (6) was present during this check and shown this finding. I stopped evisceration line A, informed (b) (6). Ms. (b) (6) initiated the establishment's corrective actions as stated in the HACCP plan once the line was restarted. (b) (6) was shown the finding and requested a disposition from PHV Dr. (b) (7)(C). Upon examination of the carcass in question Dr. (b) (7)(C) confirmed that it was fecal material. I informed plant management and Ms. (b) (6) of the documentation of this non compliance report. The Establishment failed to prevent fecal material from reaching the A line FPS inspection station. At this point in the evisceration process carcasses are on their way to enter into the chiller. At this point in the process the establishment has no further intervention steps. 9 CFR 381.65(e) states: Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank. 9 CFR 417.2(c)(4) states: List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits. I reviewed the establishment's documentation associated with this HACCP failure. The establishment was able to show that the CCP was brought back under control and that no further product was affected by this failure.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE440407 4829N-1	07/29/2013	03J04	Poultry Zero Tolerance Verification	C	<p>While performing a Zero Tolerance verification task in the Evisceration department on Evisceration line #1 I, CSI (b) (7)(C), observed the following noncompliance. At approximately 0053 hours I randomly selected ten chicken carcasses. The third carcass of the ten had a greenish brown fecal smear approximately 1 1/2 inch in length and 3/4 of an inch in width located inside the cavity on the breast plate. I took regulatory control of the product by applying U.S. retain tag B38495421 to the product. I then showed (b) (6)</p> <p>(b) (6) my findings and informed them of the noncompliance. (b) (6), performed the recheck as per the establishment's corrective actions passing two consecutive ten carcass checks and the carcass was released to (b) (6) at 0101 hours. This failure represents a noncompliance with regulation 9 CFR 381.65(e), which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." The failure also represents a deviation with the establishment's written HACCP plan, regulatory requirements of 9 CFR 417.2(c)(4), which states: (b) (4)</p>
5308	M6137	BXL0200073 027N-1	07/27/2013	03C02	Raw Intact HACCP	C	<p>On 07/26/2013 at approximately 1947 hours while monitoring Packaging functions at end of the PM shift, I observed the following. The Packaging of product was completed on line (b) (4) and boneless skinless breast fillets were being removed and placed into a brown product tub. Using a company calibrated thermometer I took the temperature of the product still on the line product belt and temperatures registered to 64.3 degrees. (b) (6) was there and observed. (b) (6) was called and product on approximately the last 1' of the center and line (b) (4) side of the belt was over 60 degrees. I informed (b) (6) of the noncompliance and approximately 30 pounds of breast fillets were condemned and placed into a blue inedible product barrel. A check of the Establishments computer revealed that the last temperature check on line (b) (4) was at (b) (4). The temperature of the Packaging area at the line (b) (4) location was approximately 80.4 degrees. A check of the establishments' HACCP Plan - Raw Not Ground -Packaging Step #8 (b) (4)</p> <p>(b) (4) However, CP-12 (b) (4) is used by the establishment to monitor temperature in the processing areas on product being packaged. The procedure states under Corrective Action Procedure that (b) (4) My findings indicated a noncompliance with 9 CFR 381.66(b) and 9 CFR 417.2(c)(4).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1405072 227N-1	07/27/2013	04A06	Poultry Finished Product Standards	C	<p>On 07/20/2013 at approximately 0600 hours while monitoring Presentation in Plant #1, I observed the following. I informed Dr. (b) (7)(C) that both lines were running at 102 bpm (birds per minute) at which time he reviewed the Presentation Logs for the shift. He said that the Paws should have been condemned when the line speed was slowed below (b) (4) bpm and that the paws being collected in the paw room should be condemned. I proceeded to the paw room but (b) (6) (b) (6) was already in the process of placing a QC hold tag a bin of paws. A computer printout was requested for the establishments Paw Verification procedure for lines 1 & 2 for 7/20/2013. The establishment instead provided the Paw Rejection Verification Log that only has some of the paw verification results for the shift. The functions of the automatic paw condemnation system has been addressed at morning meetings in the past with the establishment stating that the automated system does not work properly when the line speed is below (b) (4) bpm so all paws are automatically condemned at that time. Presentation checks had failed for the shift and Line #1 was slowed to 113 bpm after a check at (b) (4) hours failed. Line #2 was slowed to 113 bpm after a (b) (4) hours Presentation check failed. Yet according to the Paw Rejection Verification Log provided a QC check at (b) (4) hours on line #1 passed and by that time line #1 was at 102 bpm. The last entry on the log was at (b) (4) hours and under Comments/Corrective Action says "N/A Paws being condemned on both lines per USDA." There is no log book maintained in the paw room that documents when or from which plant paws are received so it is impossible to determine if adulterated product entered commerce. My findings indicated a noncompliance with 9 CFR 381.65(a) and 9 CFR 381.78(a) .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1905075 027N-1	07/27/2013	01C02	Operational SSOP Review and Observation	C	On 07/27/2013 at approximately 0135 hours while monitoring Packaging Department functions, I observed the following. The high speed line was running taking carcasses exiting Chiller #4 in Plant #2 to a rehang belt in plant #1. Sections of the chain associated with the line was covered with rust. I contacted §(b) (6) and showed him how easily the residue wiped from the chain. While monitoring the product on the exit conveyor belt from Chiller #4 there were brown specks of UFM (Unidentified Foreign Material) on several carcasses with a similar consistency as the rust on the chain. I removed the birds and showed them to §(b) (6). The line was stopped and the carcasses on the belt were tanked and placed on QC hold pending reconditioning. At break the high speed line was started to remove the remainder of the carcasses. The tray in Plant #1 that catches the carcasses and directs then to the rehang belt had a large area measuring several square feet of dried and semi dried brown UFM. As the birds exiting the high speed line come into contact with the brown UFM on the tray the carcasses were also placed into the reconditioning products cart. A placed tag #B31408046 on to the high speed line emergency disconnect switch in Plant #1 until the line could be acid washed. The line was released on 07/29/2013 at approximately 0855 hours by SCSI §(b) (7)(C). My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d) and 9 CFR 416.2(b)(1).
5308	M6137	BXL2205070 027N-1	07/27/2013	01D01	SPS Verification	O	On 07/27/2013 at approximately 0103 hours while conducting a Finish Products Standards check on Line ^{(b) (6)} , I observed the following. There was a small shiny metal flake approximately 1mm in size attached to the connective tissue near the tip of the keel bone. I showed the flake to §(b) (6) who said to give it to §(b) (6), he was not in his office. I returned at approximately 0220 hours and showed §(b) (6) the metal and told him that the metal flake was found attached to the connective tissue near the keel bone at the abdominal opening and that because of the location on the carcass I would check the Line ^{(b) (6)} Body Opener. At the line ^{(b) (6)} Body Opener there was a piece of loose stainless steel curled up on one Guide Bar. The metal measured approximately 3 cm by 1 mm. A second Guide Bar had two small pieces of stainless loose that measured approximately 2-3 mm in length. The flaking metal is caused by contact between the stainless steel Guide Bars and the stainless steel product shackles. The carcasses are being opened at this point in the establishments process. With the guide bars directly above the carcasses, the introduction of metal creates a Physical Hazard. I contacted §(b) (6) and showed him the noncompliance. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1) and 9 CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3403074 225N-1	07/25/2013	01D01	SPS Verification	O	<p>On 07/24/2013 at approximately 2220 hours while conducting Pre-Operational Sanitation in Plant #2, I observed the following. There were pieces of stainless steel peeling off a guide bar associated with the line (b) (6) Body Opener. I called (b) (6) (b) (6). We checked the Body Opener for line (b) (6) and found more loose flaking stainless. I collected the metal as it was removed and gave it to (b) (6) (b) (6). The stainless peels off in small pieces and strips. The metal pieces were approximately 2mm, 5mm, 7mm to larger pieces over 3 cm in length to approximately 1mm in width. The guide bars are on the out flow side of the machines. The carcasses are being opened at this point in the slaughter process. The metal flaking is caused by metal to metal contact between the guide bar and the carcass shackle. All the loose pieces were removed. It is impossible to gage the size of the flakes that occur as part of the natural deterioration process. With the guide bars directly above the carcasses the introduction of metal creates a Physical Hazard condition. On 07/26/2013 at approximately 0100 hours I returned to the Body Openers for line (b) (6) and found more loose flaking stainless. I contacted (b) (6) (b) (6) and showed him the noncompliance. Several pieces of stainless were removed so I could gage the size range that was similar to the sizes on the previous day. A mechanic was called and the sharp edges were rounded to stop the flaking process. My findings indicated a noncompliance with 9 CFR 416.2(b)(1).</p>
5308	M6137	BXL3514073 225N-1	07/25/2013	03J02	Slaughter HACCP	C	<p>While performing a HACCP Slaughter Record Review Task at approximately 1100 hours, I observed the following; On 07/23/2013 at approximately 1235 hours Plant 1, Line #2, PM Shift, had a Zero Tolerance Failure by USDA. Company started performing corrective actions as HACCP Plan for Slaughter-Plant 1 stated. The last passing check of Zero tolerance by Quality Control was at (b) (4) hours and the recheck passed at (b) (4) hours. HACCP Supplement 8, step 5 stated that (b) (4) (b) (4). The HACCP CCP 2B, Corrective action Log, Chiller Exit Log, had a suspect lot from 1404 hours to 1426 hours. The correct suspect lot should have been from 1404 hours to 1436 hours. Quality Control performed the last post-chill check at 1429 hours. This leaves a period of seven minutes of suspect product that was not inspected according to the HACCP Plan. The Pre-Shipment Records Review CCP 2B (b) (4) (b) (4). End of Shift was signed by the Supervisor at (b) (4) hours and the corrective actions for the failure were not completed. The signed documented certifies that the product is ready to be shipped. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 417.5 (a)(3) and 9CFR 417.5 (c). I notified (b) (6) (b) (6) of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN321607 5525N-1	07/25/2013	04C05	Poultry Good Commercial Practices	C	On July 25, 2013 at 1105n hrs I was notified by CSI (b) (7)(C) that Inspector (b) (6) has hang back a suspect DOA at station B2; for veterinary disposition. When I went to the kill floor, I saw Mr. (b) (6); already at B2 Station and looking at the carcass. The carcass had reddish discoloration, smelled putrid, with congested viscera and a friable and enlarged liver and spleen. The intestines were congested and reddened and the neck is limp and purplish in color. I confirmed the carcass as a DOA and notified Mr. (b) (6) of the disposition. I informed him that a NR will be generated as this was the second confirmed DOA for the week. The first confirmed DOA was found on Tuesday, July 23, 2013 at station B2 at approximately 1500 hrs. by Inspector (b) (7)(C). I also confirmed this DOA. Mr. (b) (6) was notified of this first confirmed DOA. Earlier NR NJN4211075618N/1 issued on July 18, 2013. The repetitive occurrence of DOAs entering the evisceration department demonstrates a loss of process control and the creation of insanitary conditions in accordance with 9 CFR 381.71(a) and 416(d).
5333	P7632	HYE002107 1725N-1	07/25/2013	01C02	Operational SSOP Review and Observation	C	When I was observing the process at the Rehang area, I observed a deficiency noncompliant with sections 416.4(a) and 416.4(d) of the Code of Federal Regulations. At approximately 1645 hours I observed a sanitation employee over spraying the reprocessing area while he was washing the giblets chiller exit. No product was on the cart for product to be reprocessed neither in the wash product sink at the moment of the incident. I informed (b) (6). The establishment immediately restored sanitary conditions by cleaning and sanitizing the reprocessing area. (b) (6), was informed of the forthcoming documentation for the failure to comply with the regulatory requirements of 416.4(a) (d). 416.4(a) (d) states, (a) all food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. (d) Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments.
5308	M6137	BXL1917075 023N-1	07/23/2013	03J02	Slaughter HACCP	C	On 07/23/2013 at approximately 1235 hours while performing a Pre-Chill Finished Products Standards Task in Plant # 1 on Line # 2, I observed the following noncompliance. I randomly removed a 10 bird sample and found one out of the ten birds with visible fecal contamination. The fecal was located inside the bird on the right side under the leaf fat. The fecal material was approximately 3/16" in diameter in size and olive green in color and pasty in texture. I informed (b) (6), and the protocol for fecal failure was implemented. At approximately 1301 hours, Quality Control performed a recheck and passed. The cause of the deviation was the Venter. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN511107 4324N-1	07/23/2013	01D01	SPS Verification	O	On Tuesday July the twenty third at approximately 0930 hours, I walked close to the refrigerated trailers yard, South West area of the plant. While I was walking I smelled an offensive odor coming from the trailers yard. when I inspected the area closely, I found that the asphalt underneath the trailers was damaged with different sized pot holes ranged from approximately (10 feet long by three feet wide) to (three feet long by one foot wide). The damaged area was approximately one hundred feet long and fifty feet wide. The pot holes collected bloody water drained from the trailers. the bloody water was retained and putrefied in the pot holes, causing unpleasant odor. At approximately 0940 hours, I showed Mr. (b) (6), my findings, and informed him of the noncompliance. 9 CFR 416.2(a) states; "Ground about an establishment must be maintained to prevent conditions that could lead to insanitary conditions, adulteration of product, or interfere with inspection by FSIS program employees
5333	P7632	HYE120307 2423N-1	07/23/2013	04C05	Poultry Good Commercial Practices	C	On July 22, 2013 at approximately 0130 hours a chicken carcass was retained on Line 1, Station 3's USDA rack for veterinary disposition. Upon examination the musculature and skin were a dark purplish-red, mainly along the dorsal surface of the carcass and had a limp neck. The lungs were congested and the liver was friable on palpation. There was also a slight putrid odor. I notified Mr. (b) (6), N/S of my findings who then summoned Ms. (b) (6), N/S to view the carcass. I presented the carcass and my findings to Ms. (b) (6). At approximately 0150 hours another carcass was retained for veterinary disposition from the same line and station and appeared very similar to the carcass that was previously retained. I notified Ms. (b) (6) of my findings and presented the carcass to her for her observation. The dispositions of both carcasses were confirmed to be dead-on-arrival (DOA). I then informed her of the forthcoming noncompliance documentation. DOA carcasses entering into the evisceration department is in violation of 9 CFR 381.71(a) and creates an insanitary condition in the establishment.
5308	M6137	BXL1312072 922N-1	07/22/2013	01B02	Pre-Op SSOP Review and Observation	C	While monitoring the Establishments' Pre-operational Sanitation Procedures in Plant #2, I found a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4 (a) and 9CFR 416.13 (c). At approximately 0710 hours, I observed in Area #5, Unit #1 the blue conveyor belt that catches the birds from Line 2 had a plastic bristle from the brush that sanitation uses to clean the shackles. It measured approximately 1" long by 1/32" wide. Also in the same area the conveyor belt that leads to the chiller had another plastic bristle measuring approximately 5" long by 1/32" wide. These plastic bristles had UFM (Unidentified Foreign Material) on them and are insanitary. I informed (b) (6) about the noncompliance. Sanitation personnel removed the plastic bristles and rewashed the area, sanitary conditions were restored at approximately 0714 hours.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1712072 422N-1	07/22/2013	03J02	Slaughter HACCP	C	<p>While performing Pre-Chill Finished Products Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 0928 hours, I randomly removed a 10 bird sample from Line (b) (6) in Plant #2, I found one out of the ten birds with visible fecal contamination inside, on the right side, on the top of the leaf fat. The fecal material was a piece measuring approximately 1/8" diameter in size, dark green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 0950 hours an it passed. The cause of the deviation was I/O Bird Washer. This is a violation of the critical limits of CCP-28 (b) (4) (b) (6) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4022070 422N-1	07/22/2013	06D02	Other Inspection Requirements	C	<p>On 07/20/2013 at approximately 0215 hours while monitoring line function in Plant #1, I observed the following. Dr. (b) (6) asked when a Presentation check was last performed as it appeared that the body openers were not working. I told him that I was unsure as it is a low priority item but that after performing a no viscera check there appeared to be a lot of giblets attached to the carcass or being hung on the carcass shackles and a lot of the giblets on the giblet shackles were turned away from the inspector. I performed a Presentation check on Line #2 at a line speed of (b) (6) bpm (birds per minute) at approximately 0221 hours and the second station failed with (1) viscera not uniform, (1) viscera on the shackle, (1) viscera swinging, (5) opening cut and (1) parts inside for a total of 36 points. The fourth station had (3) viscera not uniform, (5) opening cut and (1) parts inside for a total of 30 points. This exceeded the limits of 24 points or 2 occurrences of one error for the process to be in control. I proceeded to Line #1 and at approximately 0228 hours at a line speed of 126 bpm the first station had (3) viscera not uniform and (3) opening cut for a total of 27. The third station had (3) viscera not uniform, (4) opening cut, (2) vents attached and (1) parts inside for 33 points. Station #4 had (2) viscera not uniform, (1) viscera attached to carcass, (3) opening cut and (1) parts inside for 32 points. I informed (b) (6). After break, I contacted (b) (6) who stated that Maintenance had made adjustments and that the lines were ready for a recheck. At approximately 0334 hours on line #2 the first station had (5) viscera not uniform, (1) viscera attached to the carcass and (4) opening cut for a total of 56 points. The second station had (2) viscera not uniform, (4) opening cut and (3) parts inside for a total of 24 points. The third station had (2) viscera not uniform, (7) opening cut, (3) parts inside for 27 points. The end station had (3) viscera not uniform, (4) opening cut and (2) parts inside for a total of 30 points. At approximately 0347 hours at Line #1 the first station had (1) viscera not uniform, (1) viscera attached to carcass and (3) opening cut for a total of 23 points. The second station had (1) front or side, (2) viscera attached to carcass and (4) opening cut for a total of 39 points. The third station had (1) not hung be 2 legs, (2) viscera not uniform and (2) opening cut for 27 points. The fourth station had (1) viscera attached to carcass, (1) viscera swinging, (2) opening cut and (2) parts inside for a total of 26 points. I contacted (b) (6) and the lines were slowed 10% with line #1 going to 113 birds per minute as the line was already at 126 birds per minute for an earlier QC no viscera failure. . At approximately 0434 hours line #2 station one had (4) viscera not uniform, (1) viscera attached to carcass, (3) opening cut and (2) parts inside for a total of 49 points. The second station had (2) viscera not uniform and (3) opening cut for a total of 19 points. The third station had (3) viscera not uniform, (3) viscera attached to carcass and (4) opening cut for 64 points. The fourth station had (3) viscera not uniform, (1) viscera attached to carcass, (2) opening cut and (2) parts inside for 40 points. At approximately 0441 hours on line #1 the second station had (1) viscera not uniform, (2) viscera swinging and (2) opening cut for 30 points, The third station had (3) viscera not uniform, (3)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							opening cut and (2) parts inside for 29 points. The fourth station had (2) viscera not uniform, (1) viscera attached to carcass and (1) opening cut for 29 points. I informed (b) (6) and line #2 was slowed by (b) (4) to 113 bpm (birds per minute) and line #1 to 102 bpm. At approximately 0450 hours Line #2 the third station had (4) viscera not uniform, (1) opening cut and (1) parts inside for 34 points. The fourth station had (4) viscera not uniform, (2) viscera attached to carcass, (2) opening cut and (1) parts inside for 59 points. I contacted (b) (6) and the line was slowed to 102 bpm. Rechecks at 0556 and 0647 hours both failed and the line speed for line #2 was maintained at 102 bpm for the remainder of the shift. At approximately 0547 hours a recheck on line 1 passed and the line speed was increased to 113 bpm. At approximately 0602 hours line #1 the third station had (2) viscera not uniform, (1) viscera attached to the carcass, (1) opening cut, (2) parts inside and (1) contamination for 37 points. The fourth station had (1) viscera not uniform, (1) viscera attached to carcass and (1) contamination inside bird for 26 points. The line speed was again reduced to 102 bpm. A recheck at approximately 0635 hours also failed and the line speed for line #1 was kept at 102 bpm for the rest of the shift. My findings indicated a noncompliance with 9 CFR 381.76(a) & (b).
5309	P6137A	NJN550707 1422N-1	07/22/2013	01D01	SPS Verification	C	I was in the evisceration department at 0428 hrs. when I observed the following non compliance. I noticed that the overhead unit used to clean the reprocessing line was in an insanitary condition. The brushes that are lowered into place to clean the reprocessing line shackles have metal guards that had numerous feathers on the inside and outside of the unit. There was also dried soap residue on the guard surfaces. Evisceration B-line is located just above this brush unit and the shackles where coming into contact with the brush guard as the line was moving along. I informed (b) (6) and (b) (6) of the non compliance of the above regulations.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE350807 5022N-1	07/22/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0616 hours on July 22, 2013 in the chiller rehang area I, CS (b) (7)(C), observed the following noncompliance. The (b) (4) cabinet, above the employee stand for the Segment line rehang belt, was dripping with heavily beaded condensation onto a uncovered tub of overflow product (approximately ten chicken carcasses) from the rehang belt. I immediately took regulatory control of the product and the tub with the application of U.S. Retain tag B38495424. (b) (6) were informed of the noncompliance. Mr. (b) (6) took immediate action by having the condensation removed and the affected product was sent to the product wash station. The affected product was (b) (4) per establishment's procedure. As per Step #6 of the establishments SSOP's plan: (b) (4)</p> <p>Upon reviewing the nightshift's SSOP records for General Evis Area Section #1 the last passing check for Step #6 was performed at (b) (4) and was found acceptable by Quality Control.</p>
5308	M6137	BXL1803075 419N-1	07/19/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 07/19/2013 at approximately 0010 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Packaging Area #1, I observed the following. At the Plant #1 Halver there were numerous black specks that smeared like grease on the top surface and side product contact surfaces of the large white wheel associated with line (b) (6) that holds the carcasses during the cutting process. There was a large piece of rail dust measuring approximately 1/4" on the upper blue belt that collects the carcasses. There was dried product residue on the stainless flashing (Packaging Side) at the end of the upper belt. The stainless flashing captures some of the front halves and directs them to the collection belt. The residue peeled off easily with a finger nail. There was dried product residue on the lower stainless collection assembly (Plant #1 Cooler Side) that weighs the product. There was beaded condensation on the upper drip pans associated with the unit. Sanitary conditions were restored by approximately 0020 hours. The Plant #1 Halving Machine was checked in response to a Directed Task assigned after a previous noncompliance was written on the same piece of equipment. PreOp is scheduled for (b) (4) hours in Packaging, however after asking for more time PreOp did not start until approximately 0005 hours. Better lighting for this unit may make the cleaning process more effective. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5604073 919N-1	07/19/2013	03J02	Slaughter HACCP	C	On 07/19/2013 at approximately 0145 hours while performing a scheduled HACCP Slaughter fecal check in Plant #1 Reprocessing Line (b) (6), I observed the following. After taking a standard 10 bird sample after the final house inspector's station, I observed one bird with visible fecal contamination. Dr. (b) (6) was nearby so I showed him the carcass and verified that the contamination was fecal material. The fecal contamination was on the inside of the carcass approximately 2" down from the tip of the keel bone on the right side of the carcass near the keel bone. The fecal material, a dark brown smear, was pasty in texture and measured approximately 1/2" by 1/4". I stopped the line and contacted (b) (6). I showed him the fecal contamination. He implemented the protocol for fecal failure. A QC recheck passed at 0205 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and CCP-1B of the Plant's HACCP Plan for Slaughter-Plant 1 - (b) (4).
5308	M6137	BXL4904074 318N-1	07/18/2013	04A06	Poultry Finished Product Standards	O	On 07/18/2013 at approximately 0033 hours while monitoring the Establishments' Post-Chill Finished Product Standards in Plant #1 Chiller #1, I observed the following. After taking a standard random 10 bird sample, I accumulated 20 nonconformance points which exceeded the subgroup absolute limit of 10 points. I saved the birds and showed the brown residue on the cut and connective tissue of the carcasses to (b) (6). While a recheck was being performed, I went to Packaging and informed (b) (6) of the residue on the birds. He observed the residue on the parts being packaged on line (b) (6) and placed the cut breasts on hold (9 racks) until the residue went away at approximately 0130 hours. A recheck on chiller #1 failed at 0054 hours with 6 nonconformance points which exceeded Tolerance (5) allowed for a recheck. At this point the process is judged to be out of control. Product was tanked (5) until a recheck passed at 0101 hours. The brown residue on the carcasses has been occurring periodically over the past several months in plant #1. It has been identified as high Manganese in the water by the Establishment in conjunction with City of Livingston officials. The establishments' SSOP Corrective Action logs under 'Preventative Measure' on several occasions has stated "Will continue to monitor the carcasses exiting the chillers." and on the 07/15/2013 SSOP Corrective Action Log that "Maintenance and refrigeration are working on a filtration system." This issue has been discussed since 1/2/2013 at weekly meetings. Although this is not a food safety issue, the Finish Product Standards still must be met. There were no supervisors monitoring the birds exiting the chillers. A QC post chill check passed at 0031 hours. My findings indicated a noncompliance with 9 CFR 381.76(b) and 9 CFR 416.15(a) & (b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN421107 5618N-1	07/18/2013	04C05	Poultry Good Commercial Practices	C	On the morning of Thursday July 18, 2013 at approximately 0930 hours I was notified by CSI (b) (7)(C) that she has hung back a suspected DOA carcass at station B1 while she was giving breaks; for veterinary disposition. I went back to the slaughter floor and confirmed the carcass hung back at station B1 as a DOA. The carcass had reddish discoloration and several hemorrhagic areas with a friable swollen liver and swollen dark red kidneys and a putrid smell. It has a limp neck. I informed Mr. (b) (6) of the DOA and shown him the carcass. I informed him that a NR will be generated as this is the second confirmed DOA for the week. The first DOA was found on Monday July 15, 2013 at approximately 1525 hours at station B2 and was hung back by Inspector (b) (7)(C) and was confirmed as a DOA by Dr. (b) (7)(C). The repetitive occurrence of DOAs entering the evisceration department demonstrates a loss of process control and the creation of insanitary conditions in accordance with 9 CFR 381.71(a) and 416.4(d).
5308	M6137	BXL5504074 417N-1	07/17/2013	01B02	Pre-Op SSOP Review and Observation	C	On 07/15/2013 at approximately 2330 hours while monitoring the Establishments' Pre-Operational Sanitation Procedures in Packaging area #1, I observed the following. There was a heavy layer of pasty fat and tissue on the white nylon support brackets along the entire length of both of the lower conveyor belts from chillers 1 & 2. The belts are used to move carcasses to a second belt for rehanging for cutup on line (b) (6). I showed (b) (6) my findings. The lower belts were rewashed and released by approximately 0018 hours. At approximately 0005 hours there was black UFM (Unidentified Foreign Material) that appeared to be mold on the white plastic and stainless steel support brackets for the tray belt for line (b) (6). An area approximately 12 feet long of the tray belt adjacent to the leg processors was affected. The UFM was in patches of varying size from small specks up to an area measuring approximately 1" by 12" in size. The area was cleaned and released by approximately 0020 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE551107 0916N-1	07/16/2013	01D01	SPS Verification	C	<p>. On Tuesday the 16th, 2013 the following noncompliance was observed in evisceration department. At approximately 0915 the liver harvester on line 2 was not properly washed down during the company break. The arms of the harvester were congested with intestines, livers and gizzards. (b) (6)) was informed of my findings. He had the livers on the line condemned until the harvester was rinsed properly. At approximately 0925 the harvester was released. Mr. (b) (6) was informed of the forth coming Noncompliance. 9CFR 416.1 states: Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated. 9CFR 416.3(a) states: (a) Equipment and utensils used for processing or otherwise handling edible product or ingredients must be of such material and construction to facilitate thorough cleaning and to ensure that their use will not cause the adulteration of product during processing, handling, or storage. Equipment and utensils must be maintained in sanitary condition so as not to adulterate product. 9 CFR 416.4(a) states: (a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4622070 911N-1	07/11/2013	03J02	Slaughter HACCP	C	<p>At approximately 1000 hours while performing a HACCP Slaughter Records Review Task, I observed the following; the HACCP Corrective Monitoring Log -CCP (b) (4), dated on 07/08/13 was not there at the file cabinet, I asked (b) (6) and she provided me the record. As I reviewed the Log I noticed that at approximately 0924 hours, Quality Control had a failure (b) (4), See Corrective Action Log. The HACCP Corrective Action Log stated under location and description of the deviation "Plant 1, (b) (4) Sprayer Line (b) (4) Off". The immediate Corrective action? "Stop L (b) (4) Inf. Pack Maint. Inf. (b) (6)". Was product involved? "Yes, product was involved. Retained 4 racks of product". Quality Control placed the product under hold as documented on the Establishments "Hold & Release Form dated on 07/08/13 made by (b) (6) (initials), Tag #38296 at 0929 hours for Dept: (b) (4) Sprayers L (b) (4) under Product Description "Thighs & Drumsticks" Quantity "4 racks", under Reason "No (b) (4)" Corrective Action "Retained product, washed with (b) (4)". Reviewing the Establishments HACCP Plan - Slaughter Plant 1, Step 28 under (b) (4) (b) (4) (b) (4) The Establishments' Pre-shipment Records Review CCP-7B: (b) (4) dated on 07/08/13 PM shift was signed at (b) (4) hours by (b) (6) Under (b) (4) (b) (4) (b) (4) . Whole carcasses are hung on line (b) (4) and there is no documentation available for corrective action taken on the front halves (breast and wings) the other half of the carcass. With the sprayers off the carcasses received no (b) (4) as required by the Establishments' HACCP Plan for Slaughter allowing carcasses to enter commerce untreated. The Pre-shipment Records Review CCP 7B (b) (4) (Plant 1) was signed before the corrective actions for the failure were completed. My findings indicated a noncompliance with the following regulatory requirements of regulations 9CFR 417.3(b)(1), 9CFR 417.3 (b)(2), 9CFR417.3(b)(4), 9CFR 417. 5(c), and 9CFR 417.6(b) (6) (b) (4) was informed of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5012072 911N-1	07/11/2013	06D02	Other Inspection Requirements	C	<p>At approximately 0833 hours, I performed a presentation check on Line (b) (4) at line speed of (b) (4) BPM (birds per minute). Station #1 had (2) not reflected, total of 4 points. Station #2 had (1) viscera on shackle, (1) membrane, (1) opening cut and (1) not reflected, total of 13 points. Station #3 had (1) viscera not uniform, (3) viscera on shackle and (3) not reflected, total of 38 points. Station #3 failed, this exceed the limit of 25-39 points and (3) occurrences of one error. Quality Control performed a recheck at approximately 0849 hours and Station #2 failed with (4) not reflected. This exceed the limit of (2) occurrences of one error for the process to be in control. (b) (6) was informed and Line speed was reduced to 81 BPM (birds per minute). At approximately 0859 hours all rechecks passed, bringing the process back in control. This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE181307 0911N-1	07/11/2013	03J02	Slaughter HACCP	O	<p>During the FSA in June/July 2013, the EIAO observed at the (b) (4) step in the hazard analysis, the establishment identifies (b) (4) as hazards reasonably likely to occur. The justification provided states (b) (4).</p> <p>9CFR 381.91(b)(1) allows for treatment of contaminated carcasses with chlorinated water containing > or = 20ppm available as an approved antimicrobial. Directive 7120.1 allows for treatment with chlorinated water containing up to 50 ppm available chlorine. The control measures identified include "The risk is reduced/controlled at subsequent steps in the process. The Chlorine Pre-Requisite program monitors chlorine levels to ensure (b) (4)." The establishment did not provide any documentation to demonstrate that (b) (4) would be effective to prevent pathogens such as Salmonella. In addition, whenever a hazard analysis reveals one or more food safety hazards that are reasonably likely to occur, every establishment shall develop and implement a written HACCP plan with critical control points that will eliminate or reduce the food safety hazard to acceptable levels in accordance with Title 9 CFR 417.2(b)(1). The establishment has not identified a point in the process that will eliminate or reduce (b) (4) in salvaged parts to control the hazard identified at the (b) (4) step. This is a noncompliance with 417.2(b)(1). Additionally, on July 3, 2013, EIAO observed establishment personnel conduct monitoring of the concentration from the (b) (4) in the establishment, the (b) (4) and the (b) (4) systems. Establishment personnel followed the monitoring procedures as written in the Chlorine Pre-requisite program for both samples. When the monitor observed the concentration of one of the chlorine lines, the sample indicated that it was at 0 ppm. Establishment personnel called maintenance to have chlorine added to the system and the system was rechecked 15 minutes later. However, no corrective actions were taken in regards to the product. The establishment cannot support the decisions made in the hazard analysis. This is a noncompliance in accordance with Title 9 CFR 417.5(a)(1). 9 CFR 417.2(b)(1) states: (b) The HACCP plan. (1) Every establishment shall develop and implement a written HACCP plan covering each product produced by that establishment whenever a hazard analysis reveals one or more food safety hazards that are reasonably likely to occur, based on the hazard analysis conducted in accordance with paragraph (a) of this section, including products in the following processing categories: (i) Slaughter—all species. (ii) Raw product—ground. (iii) Raw product—not ground. (iv) Thermally processed—commercially sterile. (v) Not heat treated—shelf stable. (vi) Heat treated—shelf stable. (vii) Fully cooked—not shelf stable. (viii) Heat treated but not fully cooked—not shelf stable. (ix) Product with secondary inhibitors—not shelf stable. 9 CFR 417.5(a)(1) states: (a) The establishment shall maintain the following records documenting the establishment's HACCP plan: (1) The written hazard</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							analysis prescribed in § 417.2(a) of this part, including all supporting documentation;
5308	M6137	BXL4908072 710N-1	07/10/2013	01D01	SPS Verification	C	On 07/09/2013 at approximately 2215 hours while conducting Pre-Operational Sanitation in Plant #2, I observed the following. There was a piece of stainless steel flaking off a guide bar associated with the line ^{(b) (6)} Body Opener. I called (b) (6) who took pictures for maintenance and removed the metal. A piece of metal approximately 12mm long and 1mm thick was removed. The affected guide bar at the out flow side of the Body Opener is 1/2" thick and is worn approximately in half. Carcasses are being opened at this point and the introduction of metal creates a Physical Hazard condition. At approximately 2220 hours there were several pieces of stainless steel flaking from the guide bar at the inspectors helpers station for the middle inspection station on line ^{(b) (6)} . The pieces varied in size from approximately 2mm to 14mm in length and 1mm thick. The guide bar at this location is 5/8" thick and is worn approximately in half. I gave all the metal collected to (b) (6). My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).
5308	M6137	BXL2513075 009N-1	07/09/2013	01C02	Operational SSOP Review and Observation	C	On 07/08/2013 at approximately 1020 hours, while passing by the ice machine chute in Plant #2, I observed the stainless steel tank collecting ice from the ice machine. I found a live insect approximately 1/4" diameter in size climbing on the ice inside the tank. (b) (6) was nearby and I showed him my findings. He scooped a handful of ice with the insect and threw it in the drain that runs under Line ^{(b) (6)} as he walked away. I was not able to see the type of insect because (b) (6) disposed of it before I could investigate further. (b) (6) was informed about the noncompliance. She tagged the tank of ice with a Quality Control Red hold tag and had a company employee to condemn it. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.2 (a) and 9CFR 416.4 (d).
5308	M6137	BXL5604071 709N-1	07/09/2013	04A06	Poultry Finished Product Standards	C	On 07/09/2013 at approximately 0130 hours while conducting a Pre-Chill Finished Products Standards test on line ^{(b) (6)} in Plant #2, I observed the following. After removing a standard 10 bird sample I accumulated 40 Processing nonconformance points. This exceeded the limit of 30 points for the process to be in compliance. I informed (b) (6). At 0139 hours a Quality Control recheck failed with 28 nonconformance points. The limit for a recheck is 25 total points. At this point the process is judged to be out of control. Line ^{(b) (6)} was moving to Line ^{(b) (6)} however a series of Quality Control rechecks passed at the Post-Chill bringing the process back into control. My findings indicated a noncompliance with 9 CFR 381.76(b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN462307 5609N-1	07/09/2013	03C02	Raw Intact HACCP	C	<p>At approximately 2040 hours while performing the Review and Observation component of a Raw Intact Verification PHIS Task; I, CSI(b) (7)(C), observed multiple pieces of chicken tenders (fourteen pieces) that were on the top of the North/South 90 degree product conveyor's white plastic guide divider, which is an edible product contact surface, in the Fillet department. As part of the SIP Waiver that was granted to the establishment, I decided to take the temperature on the pieces of Chicken tenders. I requested that (b) (6) , to take the temperature with her calibrated thermometer #441. One piece registered its internal temperature at 63.6 F. (b) (6) as present and was shown the temperatures of this piece and two additional pieces also that Ms (b) (6) thermometer registered at 61.5 F, 62.7 F. The finding of temperatures above 60 degrees F does not comply with the SIP waiver granted to the establishment by USDA/FSIS and does not meet the regulatory requirements of sections 381.3 and 417.5(a) of the 9 Code of Federal Regulations. 9 CFR 381.3 states, "Administration.(b) The Administrator may in specific classes of cases waive for limited periods any provisions of the regulations in order to permit appropriate and necessary action in the event of a public health emergency or to permit experimentation so that new procedures, equipment, and processing techniques may be tested to facilitate definite improvements: Provided, That such waivers of the provisions of the regulations are not in conflict with the purposes or provisions of the Act." 9 CFR 417.5(a) states, "(1) the written hazard analysis prescribed in § 417.2(a) of this part, including all supporting documentation;(2) The written HACCP plan, including decision making documents associated with the selection and development of CCP's and critical limits, and documents supporting both the monitoring and verification procedures selected and the frequency of those procedures. The SIP protocol using the alternative chilling procedures in place of 9 CFR 381.66(b), states, "...the alternative procedures in a HACCP, SSOP or prerequisite program to chill young chicken carcasses immediately after processing so that the internal temperature is reduced to 45 F or less within 6 hours and once product is chilled, the temperature may rise to a maximum of 60 F during further processing and packaging in place of 9 CFR 381.66(b)". The establishment elected to condemn the affected product. Mr. (b) (6) and (b) (6) representative was informed of the forthcoming documentation for the failure to comply with the establishment's SIP program and the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5216070 306N-1	07/06/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1150 hours while monitoring the Establishments Operational Sanitation Procedures in the Re-Wrap Room, I observed the following. A company employee was using a knife to open packages of party wings and drumettes for rewrap. The packages were in the gray plastic baskets that had varying amounts of dried tissue, and black and brown UFM (Unidentified Foreign Material). The gray plastic baskets are not a product contact surface. I watched her for a few minutes and noticed that she was touching the gray plastic baskets, cutting the packages with the knife, handling the product and placing the product in another gray plastic basket lined with blue plastic, not applying sanitizer to her gloves, knife or packages, creating an insanitary condition. I immediately tagged the product with U.S. Retained/Rejected Tag # B31 407096 and informed (b) (6) of the noncompliance. The Establishments SSOP states that (b) (4) (b) (6) had a company employee condemn the product. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4 (d), 9CFR 416.12 (a) and 9CFR 416.14.</p>
5308	M6137	BXL0109075 105N-1	07/05/2013	04A06	Poultry Finished Product Standards	C	<p>On 07/05/2013 at approximately 0605 hours while monitoring Reprocessing Line (b) (4) in Plant #1, I observed the following. I took a ten bird sample and found three birds with varying amount of ingesta. One bird was highly contaminated with ingesta and rice hulls around the cut surfaces of the neck area. A second bird had numerous pieces of ingesta and a brown residue on the cut surfaces of the breast. The third had only a few pieces of ingesta and was of less concern. 9 CFR 381.91 (b)(1) states "Any carcass of poultry accidentally contaminated during slaughter with digestive tract contents shall not be condemned if promptly reprocessed under the supervision of an inspector and thereafter found not to be adulterated. Contaminated surfaces that are cut shall be removed only by trimming. ... and All visible specks of contamination must be removed,..." I stopped the line and contacted (b) (6). Product was tanked until a QC recheck passed at 0616 hours. The tanked product was placed under QC hold pending reconditioned. Virtually every shackle on the line was full. The line was minimally staffed with only one house inspector at the end. My finds indicated a noncompliance with 9 CFR 416.1 and 9 CFR 381.91(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4404075 005N-1	07/05/2013	01D01	SPS Verification	C	<p>On 07/04/2013 at approximately 2225 hours while conducting Pre-Operational Sanitation in Plant #1, I observed the following. There was stainless steel flaking off along approximately a 3" long area of a guide bar associated with the assembly that drops the carcasses into the chiller #1. Carcasses are open at this point and the introduction of metal creates a Physical Hazard condition. Flaking metal will create a hazard on the product and/or fall into the chiller with the product. The metal pieces were removed and varied in size 1/8" to 1 1/2" in length by approximately less than 1mm to 1/8" thick. I collected the metal as it was removed and gave it to (b) (6). At approximately 2240 hours while monitoring Facilities at startup, I observed approximately 20 pieces of stainless steel lacing on the Line #1 rehang belt that were damaged or missing. I showed (b) (6) the belt. He called a mechanic who removed the loose laces. Birds routinely are piled up on this belt for varying periods of time awaiting rehang with the belt running. The poor material condition of the lacing is creating a Physical Hazard condition. The establishment has no metal detection devices as part of the Slaughter or Packaging processes. The establishments' HACCP Plan - Slaughter Plant #1 under (b) (4). The establishments' HACCP Plan - Raw Not Ground Packaging under (b) (4). My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).</p>
5308	M6137	BXL0523070 203N-1	07/03/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 07/03/2013 at approximately 0518 hours while conducting a Zero Tolerance check on line #2 in Plant #1, I observed the following. After taking a standard random ten bird sample, I observed one bird with visible fecal contamination. The fecal material was on the inside of the carcass on the right side where the leaf fat is normally located. The leaf fat had been removed. The fecal material was a smear approximately 1/2" in size, medium brown in color, and pasty in texture. I showed the carcass to (b) (6). The protocol for fecal failure was implemented. A QC recheck passed at approximately 0548 hours. My findings indicated a noncompliance with 9 CFR 381.65(e) and 9 CFR 417.2(c)(4).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3905072 903N-1	07/03/2013	01B02	Pre-Op SSOP Review and Observation	C	On 07/03/2013 at approximately 0002 hours while monitoring the establishments' Pre-Operation Sanitation Procedures in Packaging Area #1, I observed the following. There were numerous pieces of black UFM(Unidentified Foreign Material) that appeared to be a mixture of blackened grease and tissue from the previous days production on the guide bars for line (b) (4). There was a dried yellowish substance on most of the shackles for line (b) (4). The Lead Person mentioned they were having problems with the shackle washer. There were numerous pieces of black UFM on the mechanism at the end of line (b) (4) that drops the drums. Lockout/Tagout was removed so that the line could be run at a slow speed for cleaning. The line components were scrubbed with green pads, sanitized and rinsed with potable water. The line was released by approximately 0030 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), and 9 CFR 416/13(c).
5308	M6137	BXL1418074 502N-1	07/02/2013	03J02	Slaughter HACCP	C	On 07/02/2013 while performing Pre-Chill Finished Products Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65(e) and 9CFR 417.2(c)(4). At approximately 1529 hours, I randomly removed a 10 bird sample from Line (b) (4) in Plant #2. I found one out of the ten birds with visible fecal contamination inside the bird on the leaf fat and in the body cavity directly opposite of the leaf fat on the left side of the bird. The fecal material was a smear measuring approximately 1" in diameter in size and olive green in color and pasty in texture. I informed (b) (6) of the noncompliance, and the protocol for fecal failure was implemented. At approximately 1552 hours, Quality Control performed a recheck and passed. The cause of the deviation was the (b) (4) washer. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL1614070 102N-1	07/02/2013	03J02	Slaughter HACCP	C	On 07/02/2013 while monitoring Post-Chill Finished Product Standards Task, I found a noncompliance with the following regulatory requirements of regulations 9CFR 381.65(e) and 9CFR 417.2(c)(4). At approximately 1011 hours, I randomly selected a 10 bird sample from the exit of Chiller #4 in Plant #2. I found one out of the ten birds with visible fecal contamination inside the bird on the leaf fat on the left side of the bird. The fecal material was approximately 1/4" diameter in size, olive green in color and pasty in texture. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (b) (6) of the noncompliance and they immediately started tanking the birds coming out of Chiller #4. Two and a half tanks were placed under QC red hold tags, pending rework. At approximately 1015 hours Quality Control performed a recheck and passed. The cause of the deviation was the venter and a nozzle out of adjustment. This is a violation of the critical limits of CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN420707 4902N-1	07/02/2013	03C02	Raw Intact HACCP	C	<p>At approximately 0408 hours while performing the Review and Observation component of a Raw Intact Verification PHIS Task; I, CSI (b) (7)(C), observed multiple pieces of dark meat (boneless thighs) that were on the top of the product reprocessing cart which is an edible product contact surface, in the Packaging department. As part of the SIP Waiver that was granted to the establishment, I decided to take the temperature on the pieces of dark meat. I requested that (b) (6), to take the temperature with her calibrated thermometer #425. One piece registered its internal temperature at 66.5F. Mr. (b) (6) was present and took the temperature of two additional pieces with Ms. (b) (6) thermometer that registered at 61.2 F, 60.2 F. The finding of temperatures above (b) (4) degrees F does not comply with the SIP waiver granted to the establishment by USDA/FSIS and does not meet the regulatory requirements of sections 381.3 and 417.5(a) of the 9 Code of Federal Regulations. 9 CFR 381.3 states, "Administration. (b) The Administrator may in specific classes of cases waive for limited periods any provisions of the regulations in order to permit appropriate and necessary action in the event of a public health emergency or to permit experimentation so that new procedures, equipment, and processing techniques may be tested to facilitate definite improvements: Provided, That such waivers of the provisions of the regulations are not in conflict with the purposes or provisions of the Act." 9 CFR 417.5(a) states, "(1) the written hazard analysis prescribed in § 417.2(a) of this part, including all supporting documentation; (2) The written HACCP plan, including decision making documents associated with the selection and development of CCP's and critical limits, and documents supporting both the monitoring and verification procedures selected and the frequency of those procedures. The SIP protocol using the alternative chilling procedures in place of 9 CFR 381.66(b), states, "...the alternative procedures in a HACCP, SSOP or prerequisite program to chill young chicken carcasses immediately after processing so that the internal temperature is reduced to (b) (4) or less within (b) (4) hours and once product is chilled, the temperature may rise to a maximum of (b) (4) during further processing and packaging in place of 9 CFR 381.66(b)". The establishment elected to condemn the affected product. Mr. (b) (6) was informed of the forthcoming documentation for the failure to comply with the establishment's SIP program and the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN530507 5401N-1	07/01/2013	01D01	SPS Verification	C	<p>On June 30, 2013 I, CSI (b) (7)(C), was performing CIP (Red water chiller) inspection at establishment P6137A Foster Farms at approximately 0945 hours. In the hallway that connects the Food Service department to the IQF department I observed multiple large gray product combo bins with approximately 12 insects (house flies) in them. I showed my findings to (b) (6) who offered immediate corrective actions that the establishment employees would move the bins outside and kill the insects. During the IQF department start of production, at approximately 2325 hours, (b) (6) and myself observed one fly on a stack of wooden pallets in the IQF department. Mr. (b) (6) attempted to kill the insect but failed to do so. (b) (6) offered corrective actions that more fly bait stick tape would be hung in the hallway that connects this department to the others. While performing Good Commercial Practices verification task at approximately 0138 hours I observed that the boiler room door and the Maintenance large roll up door were open to the outside of the establishment, I inform (b) (6) of this and he immediately closed both doors. While at the carcass chiller exit I was performing a Finished Products Post Chiller check and observed one fly on the contaminated product loop. The insect flew from the loop to the chiller exit belt onto one carcass. From there the insect flew to somewhere in establishment. I took the only product affected from the belt and informed (b) (6) of my findings. (b) (6) sanitized the hang back loops and condemned the carcass. At approximately 0256 hours I informed (b) (6) of all my findings in this document and of the forthcoming noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE431307 5402N-1	07/01/2013	04A06	Poultry Finished Product Standards	C	<p>I was performing a finished product standards verification task on the reprocessing line in the evisceration department at 0857 hours. I selected ten carcasses marked with a horizontal slash across the back indicating these carcasses had been identified by the on-line inspection team for cellulites salvage. One of the ten carcasses in the sample had cellulites lesions about 1 ½" long and about 1/8" wide on lower left breast area. I showed (b) (6) (b) (6) did the required recheck of ten cellulite carcasses and the check was found acceptable at 900. I informed (b) (6) (b) (6), of the forthcoming non compliance. Failure to meet the regulatory requirement cited above. In addition 9 CFR 381.86 states any organs or other parts of carcasses which is affected by inflammatory process shall be condemned</p>
5333	P7632	HYE280206 3629N-1	06/29/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 6/28/13 at approximately 2314 hours I observed the following while performing the Pre-Operational SSOP Review and observation task in area # III (North Chiller Exit) . There was a thick build-up of fat and grease on the angle iron brackets that are positioned directly above the rehang belt (b) (6) (b) (6) was notified of the noncompliance immediately (b) (6) (b) (6) had one of his workers scrub and rinse the angle iron braces . The braces were reinspected and found in good sanitary condition . At approximately 2317 the drip pan directly above the Segment line cat walk was found to unexcitable . There was a build-up of grease and fat residue along the outer edge of the drip pan . Again (b) (6) (b) (6) was notified (b) (6) (b) (6) had one of his workers get on top of the drip pan scrub the affected area along the side and rinse the entire drip pan . At approximately 2220 the Down Grade belts were inspected . There was pieces of fat found on both Down Grade flex belts (b) (6) (b) (6) was informed of the noncompliance (b) (6) (b) (6) had a member of his crew rinse and resanitized the Down Grade belts . My findings indicate noncompliance with regulations 9 CFR 416.4(a) which states all food contact surfaces must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product and 9CFR 416.4(b) which states non food contact surfaces must also be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0723065 528N-1	06/28/2013	01D01	SPS Verification	C	<p>On 06/28/2013 at approximately 2002 hours while walking from the Rotisserie room to Plant 1 hanging area by Chillers 1 and 2, I observed the following. Sanitation was washing down the area and I saw that the door to the cooler by Plant 1 hanging and sorting area by Chillers 1 and 2 was open. I went inside the cooler, which was congested with tanks being brought in from an employee from Packaging and an employee from Rotisserie, and observed heavy fog and mist through out the entire cooler. I continued walking in the cooler to the other side where I observed that the cooler door that opens to the Packaging room was also open and Sanitation was also washing down the Packaging room. Regulation 416.2(d) states that adequate Ventilation to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product and the creation of insanitary conditions must be provided. I informed (b) (6) of the noncompliance.</p>
5309	P6137A	NJN091606 5428N-1	06/28/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 1111 hours I was performing PHIS Finished Product Standards Inspection Procedure task at the Pre-chill Station on Evisceration Line "A". After all plant interventions were allowed to occur, I randomly selected ten carcasses prior to entering the chilling process. I observed one out of the ten carcasses contaminated with visible feces. The fecal material was located inside the neck attachment in-between the pectoral muscle. It was yellowish in color and pasty in texture measuring approximately ½ inch in diameter and was confirmed by Dr. (b) (7)(C) the (b) (7)(C). This exceeded the limit of Zero Tolerance for the process to be in control. I immediately took regulatory control action by stopping line "A" and showed my finding to (b) (6). The protocol for fecal failure was implemented. A Quality Control recheck passed at 1123 hours. A preshipment review performed at 1258. Mr. (b) (6), were informed of the forthcoming NR. (b) (4) and in accordance with the regulations 9 CFR 417.2© (4) and 9 CFR 381.65(e) which states: "poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank". The establishment's written HACCP Plan dated 4/18/2013 states: (b) (4). Past similar NR's was documented on 06/14/2013 # NJN 4320065814 N/1 Ineffective Plant Response Action(s): "To prevent this situation from reoccurring, a check to verify that (b) (4) angle adjustment is correct was put in place on the I/O (b) (4). Training was performed with the HACCP monitors on the updated version of the monitoring log and on how to check for the proper angle on the (b) (4). Continued failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s) as described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN2005064228N-1	06/28/2013	01B02	Pre-Op SSOP Review and Observation	C	On June 27, 2013 I, CSI (b) (7)(C), was in the Evisceration department performing Pre-Operational Sanitation verification task when I noted the following noncompliance. In Area 01 Evisceration Section D: Offline and Chiller Area I inspected Unit #15, A/B line bird unloader. The stainless steel chute that the chicken carcasses slide down into the carcass chiller on was covered in multiple fat particles and approximately five feathers from the previous days production. I retained the chute with the application of U.S. Retain tag B43303581 at approximately 2304 hours and showed my findings to (b) (6). The chute was wiped clean and sanitized in my presents, no fat particles or feathers entered the chiller. At approximately 2321 hours sanitary conditions were restored and I released Unit #15 by removing the U.S. Retain tag. (b) (6) were informed of the noncompliance.
5333	P7632	HYE3202065925N-1	06/25/2013	01B02	Pre-Op SSOP Review and Observation	C	On 6/25/13 at approximately 0004 hours I observed the following noncompliance while conducting the Pre-Operational SSOP Review and Observation procedure in the packaging area . Unit # 1 the Body halvers had fat and debris on the Bird Indexer Chutes that transport product to the (b) (4) degree cooler , the white PVC pipe running along side the wall and over the halver had fat grease and unidentified foreign material on the exterior of the pipe . (b) (6) was notified of the noncompliance . (b) (6) had one of his workers rinse both Body Halvers and Bird Indexer Chutes . The area was reinspected at approximately 0018 and found to be in sanitary condition . At 0009 unit #13 the # 1 Leg Processor (Manual Feeder) was inspected . The Inside of the right panel was covered with pieces of fat . My findings were again reported to (b) (6) . (b) (6) had the inside of the panel rinsed and resanitized . Sanitary conditions were restored and the packaging area was released for production at approximately 0025 . My findings indicate noncompliance with regulations 9 CFR 416.4(a) , 9 CFR 416.4(b) and 9 CFR 416.13(c) .
5333	P7632	HYE3407061225N-1	06/25/2013	01B02	Pre-Op SSOP Review and Observation	O	. . On June 20, 2013, EIAO (b) (7)(C) observed establishment personnel conduct preoperational sanitation check in the evisceration and rehang areas for the following production day (June 20, 2013 to June 21, 2013). After the establishments preoperational sanitation check was completed, EIAO observed the following: fat particles on the segment 1 return belt and (b) (4) conveyor; a piece of skin on the bag line rehang conveyor; and a piece of bone underneath the divider on the paw grading conveyor. Additionally, EIAO (b) (7)(C) observed a hole containing cracks and jagged stuck up edges in the food contact portion of the (b) (4) Chute. EIAO (b) (7)(C) also observed fat particles on the underside (non-food contact) of the (b) (4) conveyor. These findings are noncompliances in accordance with Title 9 CFR 416.13(c) and 416.3(a). .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE340706 1225N-2	06/25/2013	01B02	Pre-Op SSOP Review and Observation	O	<p>During the FOOD SAFETY ASSESSMENT conducted on June 20, 2013, at approximately 2311 hours EIAO (b) (7)(C) observed the following noncompliance while performing the Pre-Operational Review and Observation task . In the evisceration and rehang areas for the following production day (June 20,2 013 to June 21, 2013) . After the establishments pre-operational SSOP monitoring check was conducted , EIAO (b) (7)(C) observed the following : fat particles on the segment 1 return belt and (b) (4) conveyor ; a piece of skin on the bag line rehang conveyor ; and a piece of bone underneath the divider on the paw grading conveyor. EIAO (b) (7)(C) also observed a hole containing cracks and jagged stuck up edges in the food contact portion of the (b) (4) Chute . EIAO (b) (7)(C) observed fat particles on the underside (non-food contact) of the (b) (4) conveyor. EIAO (b) (7)(C) notified Ms (b) (6) all of the noncompliant areas observed. These findings are noncompliant in accordance with Title 9 CFR 416.13(c) and 416.3(a). EIAO (b) (7)(C) observed establishment personnel rewash, rinse, sanitize, and reinspect the contaminated surfaces of the equipment. Additionally, EIAO (b) (7)(C) observed establishment personnel repair the hole in the food contact portion of the (b) (4) Chute by welding the hole shut. Establishment personnel then rewash, rinsed, sanitized, and reinspected all surrounding equipment surfaces . Once EIAO (b) (7)(C) verified sanitary conditions were restored in the noncompliance areas , the area was released for production at approximately 0012 hours . Title 9 CFR 416.13(c) states: "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's." Title 9 CFR 416.3(a) states: "Equipment and utensils used for processing or otherwise handling edible product or ingredients must be of such material and construction to facilitate thorough cleaning and to ensure that their use will not cause the adulteration of product during processing, handling, or storage. Equipment and utensils must be maintained in sanitary condition so as not to adulterate product."</p>
5309	P6137A	NJN471606 3524N-1	06/24/2013	01D01	SPS Verification	C	<p>At approximately 1349, while I was passing through the evisceration department employee break room, I observed the following non compliance: several flies flying in the break room, trash can over flowing with garbage, , bad odor smell, the floor had stagnant water, used paper towels and debris everywhere. Mr. (b) (6) was informed and he took corrective actions to restore sanitary condition and also notified of the forthcoming non-compliance record. The Requirements of 9 CFR 416.1, 9 CFR 416.2(b) (2), 9 CFR 416.2 (a), and 9 CFR 416.2(h) (3) were not met. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s) as described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN521506 0824N-1	06/24/2013	04A06	Poultry Finished Product Standards	C	<p>At 1230 hrs. I was performing a zero tolerance verification task on the tubs of salvaged parts in the evisceration department. I randomly selected 5 pieces from each tub. I found one piece (thigh) affected with I.P (cellulitis) in a tub identified from B-line. I showed this finding to (b) (6) secured a QC hold tag on the tub after the corrective actions where proffered, which involved reworking the tub of product. I also informed (b) (6) of the non compliance with 9 CFR 381.86. The establishment condemned the affected part and reworked the remaining product in the tub. The finding of I.P. affected tissue on salvage parts constitutes a non compliance according to the regulations cited above. 9 CFR 381.86 states: "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned. There was a similar non compliance report issued for the same occurrence on 06/13/2013, NJN0616065213N/1. The establishment's response included immediate corrective actions of reprocessing the affected tub of product. The establishment responded with "Not applicable" for further planned action. It is unclear if the establishment included or enacted measures to prevent the reoccurrence of the same non compliance.</p>
5308	M6137	BXL0809061 720N-1	06/20/2013	01D01	SPS Verification	C	<p>On 06/19/2013 at approximately 2300 hours while monitoring the Establishments' Operation Sanitation procedures in Plant #1 Line #1, I observed the following. There was a piece of shiny metal approximately 1/2" long and less than 1/16" thick attached to the guide bar at the out flow side of the Venter/Body Opening machine. The loose metal pieces directly above the open carcasses is causing an insanitary condition. There were also several smaller pieces of metal flaking from the guide bar at the same location. I contacted (b) (6) and showed him my findings. A mechanic filed the guide bar to round off the flat sharp edges to stop the metal shedding process. My findings indicated a noncompliance with 9 CFR 416.2(b)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2905062 720N-1	06/20/2013	01D01	SPS Verification	C	On 06/19/2013 at approximately 1940 hours while monitoring Facilities, I observed the following. There was a large puddle of water on the loading dock floor near Rotisserie creating an insanitary condition. The floor drain was clogged and the entire space was flooded to approximately 2" deep near the drain. The water had a black oily film on the surface. Pallets of materials around the outside walls of the space and trash near the empty dock truck door were wet. Rotisserie was still working and establishment personnel were walking through the puddle. Employees did not appear to be aware that they should not be walking through a flooded area. I do not know how long the drain was backed up but there were numerous black pallet jack wheel marks on the floor going into Rotisserie. I went to Rotisserie but no supervisor was available so using the laundry room phone I had (b) (6) called. Movement through the area was stopped. The pallets were moved. The drain was cleared. The floor was drained and a sanitizer was applied to the affected area restoring sanitary conditions by approximately 2015 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(e)(4), and 9 CFR 416.5(a).
5308	M6137	BXL5808065 420N-1	06/20/2013	06D02	Other Inspection Requirements	C	On 06/20/2013 at approximately 0515 hours while monitoring Presentation of line #1 in Plant #1 at a line speed of (b) (4) BPM (Birds Per Minute), I observed the following. The second station had (1) bird front, (2) hung by one leg, (1) carcass swinging, (2) viscera attached to carcass and (1) parts inside for a total of 60 nonconformance points. Once nonconformance points exceed 40 the process is judged to be out of control and a (b) (4) line reduction is required (b) (6) was informed and the line was slowed to 113 BPM. The third station had (2) viscera not uniform and (1) viscera attached to the carcass for a total of 28 nonconformances. Rechecks at 0543 hours returned the line speed to (b) (4) BPM where it stayed for the rest of the shift for high no viscera counts. A review of the Establishments' "No Viscera Log" for the shift revealed that Line #1 failed at 0056 hours with 19 no viscera at (b) (4) BPM. 13 no viscera are allowed at (b) (4) BPM. A recheck failed at 0127 hours with 20 no viscera. The line speed was reduced to 126 BPM. At 0407 hours there were 26 no viscera and 0613 hours 31 no viscera both rechecks failed and the line was kept at 126 BPM for the remainder of the shift. 11 no viscera are allowed at 126 BPM. Three consecutive failures is considered as a loss of process control. On Line #2 at (b) (4) BPM at 0231 hours there were 18 no viscera. At 0400 hours a recheck failed with 23 no viscera. The line was slowed to 126 BPM. At 0618 hours there were 18 no viscera at 126 BPM. The lines was kept at 126 BPM for the rest of the shift. My findings indicated a noncompliance with 9 CFR 381.76(a) & (b).
5308	M6137	BXL3907063 919N-1	06/19/2013	01D01	SPS Verification	C	

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3907063 919N-2	06/19/2013	01D01	SPS Verification	C	<p>On 06/19/2013 at approximately 0300 hours while monitoring the establishments' Operational Sanitation procedures in the Weigh & Price Cooler, I observed the following. The floor on the 'A' side of the Weigh & Price Cooler is covered with a thick layer of liquefied brown UFM (Unidentified Foreign Material). I contacted (b) (6) and asked him when the cooler floor was last cleaned. He said he was not sure but that the cooler was normally cleaned every couple of months. I proceeded to Packaging and observed varying amounts of the same brown UFM at the end of the packaging lines where the racks of packaged products are made up before being Crusted (chilled) and sent by elevator to the Weigh & Price Cooler. The dollies, frames and wheel assemblies, being used in Packaging are covered with a similar brown UFM, the majority appears to be rust, and are the mode of transport of the brown UFM from the Weigh & Price Cooler to the Packaging floor. With hundreds of rust coated dollies being used during a shift the amount of filth being added to Packaging is considerable. I contacted (b) (6) and showed him a stack of dollies near line (b) (6) coated with the brown UFM and the insanitary condition on the floor. I asked him how often the floor is rinsed in packaging. His response was that the floor is (b) (4). With the number of employees and the volume of work that is performed the brown UFM will be tracked all over packaging. I proceeded to Weigh & Price and informed (b) (6) that a noncompliance would be issued for the brown UFM on the cooler floor and because of the insanitary condition being created in Packaging. On 06/20/2013 at approximately 0020 hours, I discussed the insanitary condition of the dollies with (b) (6) and he said he would address the rust and filth on the dollies. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(2) and 9 CFR 416.4(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN192006 3019N-1	06/19/2013	01C02	Operational SSOP Review and Observation	C	<p>At 0950 hrs. I observed the following non compliance in the dark meat packaging area during bulk product packing operations. Employees were beginning to pack boneless skinless thighs into blue plastic lined boxes. I observed the employee assigned to operate the scale remove product with his gloved hands and place the product into the next box on the roller conveyer belt in order to attain the proper weight. The employee then secured the lid on the box and place the box on a wooden pallet. He then preceded to handle product from the next box without sanitizing his gloved hands. I also observed another employee putting the blue liners inside other boxes, preparing them to be filled with product. The employee had these blue lined boxes stacked on top of each other. The blue liners are product contact surfaces, whereas the outside of the cardboard boxes are not. I informed (b) (6) of my observations. Mr. (b) (6) stopped the production to address each issue. Miss (b) (6) applied a QC hold tag on the one box of product and Mr. (b) (6) had that product sent to the establishment's reprocessing procedures. 9 CFR 416.4(d) states: product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments.</p>
5309	P6137A	NJN491906 3619N-1	06/19/2013	04C05	Poultry Good Commercial Practices	C	<p>On June 18, 2013, Tuesday at approximately 1235 hours I was notified by a line inspector that a suspect dead-on-arrival carcass was hung back for veterinary disposition. The carcass was at the USDA rack behind Line B station # 3 with Inspector (b) (7)(C). The carcass was grossly reddish in color with a limp neck, friable liver and spleen and conected kidneys. I confirmed the carcass as a DOA. I informed (b) (6) of the findings. On the same day, at approximately 1450 hours another suspected DOA carcass was hung back at the USDA rack on Line a station # 3 . I confirmed the carcass as another DOA at approximately 1615 hours. I notified the (b) (6), Mr. (b) (6) of the second DOA. The carcass was reddish in color with some areas of purplish discoloration. The liver, spleen and intestines were not present but the kidneys were dark-red to purple color and friable. The carcass had a limp neck and carcass had a putrid odor. I informed the establishment that these two incidences would be documented on a non-compliance. The repetitive occurrence of DOAs entering the evisceratio department demonstrates a loss of process control and the creation of insanitary conditions in accordance with 9 CFR 381.71 (a) and 416.4 (d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN240306 0818N-1	06/18/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 0059 hours while I was performing the Review and Observation component of a Zero Tolerance Task at the offline inspection station I observed the following noncompliance. On the ninth carcass from the ten carcass sample, I noticed a small amount (approximately 1/18 of an inch in diameter) of a greenish/brownish paste like material consistent with fecal material. The fecal material was located on the inside side the fold of the left wing tip. I took regulatory control action by stopping the offline and retaining the affected carcass with U.S. Retain tag# B43303582. I showed my finding to (b) (6).</p> <p>(b) (6). Mr. (b) (6) requested (b) (7)(C) disposition. IIC, Dr. (b) (7)(C) confirmed the fecal material. Ms. (b) (6) initiated corrective actions as stated in the establishment's HACCP plan. The affected carcass was released to (b) (6). (b) (6) passed the required recheck at 0112 hours. The establishment failed to prevent fecal material to reach the offline inspection station with the potential of entering the chiller. Section 381.65(e) from the 9 Code of Federal Regulations requires that the establishments shall prevent contaminated carcasses with visible fecal material from entering the chiller. The finding of fecal material did not meet the requirements of the establishments HACCP plan. The Supervisors and Q.C. representative mentioned in this document were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above. Similar noncompliance was documented on May, 28,2013. Establishment's further planned action to take appropriate management steps with the final inspection employee failed to prevent reoccurrence.</p>
5308	M6137	BXL4317060 217N-1	06/17/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>While monitoring the Establishments' Pre-operational Sanitation Procedures in Main Packaging Area, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4 (b) and 9CFR 416.13 (c). At approximately 0837 hours while inspecting Line (b) (6), I found numerous pieces of semi-dried fat, tissue and blood from the previous day production on the entire length of the gray conveyor belt. I found a piece of fat measuring approximately 2" long by 1/4" wide hanging on a shackle from the chain that brings product to this line. I immediately tagged the Line with U.S. Retained/Rejected Tag # B31 407280 and informed (b) (6) of the noncompliance. (b) (6) had sanitation employee rewashed the entire line. I continued doing pre-operational sanitation procedures on Line (b) (6) and Line (b) (6) and then I came back to reinspected Line (b) (6). At approximately 0859 hours sanitary conditions were restored, I then removed my tag and released the area back to production.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5222064 017N-1	06/17/2013	01C02	Operational SSOP Review and Observation	C	<p>On 06/15/2013 at approximately 0300 hours while monitoring the establishments Operational Sanitation procedures in the Paw Room for the Bulk Line product handling, I observed the following. Bagged bulk product was being packed into cases that weigh approximately 40 pounds. Product is placed in blue plastic bags in packaging. In Packaging the bags are twisted shut and placed with the twisted side down into gray plastic trays that are stacked to make racks which are then placed in the Crust Tunnel for chilling. The gray plastic trays being emptied along the bulk line were covered with varying amounts of dried tissue, and black and brown UFM (Unidentified Foreign Material). The trays are not treated as a product contact surface. To get the weight close as possible to 40 pounds at least one bag in every case was being opened and a piece(s) of product was being removed or added. The opened side of the bag is the end of the bag that is in direct contact with the insanitary gray plastic tray. Opening of the contaminated side of the blue plastic bag and then handling the product without applying a sanitizer was creating an insanitary condition. I watched for several minutes then contacted (b) (6) who was nearby and asked who the bulk line supervisor was? She said that a supervisor comes by about (b) (4), that the employees are required to (b) (4), and was there a problem. I showed her the trays and the cross contamination issue and had her call a supervisor. The line was stopped. (b) (6) was called and the issue was discussed. 29 cases of product that was processed in my presence was placed on QC hold pending reconditioning. The establishments SSOP states that (b) (4) There is a hand sanitizing machine approximately 30 feet away from the location of the bulk line operations but it would be very time consuming for an employee to have to sanitize their gloves after each case. The establishments HACCP Plan - Raw Not Ground Packaging does not address bulk packed product. After consulting with (b) (6) there is no procedure for handling bulk product on file. A temporary solution was implemented whereby the outside of packages to be opened will be sprayed with hand sanitizer before being opened. I talked to (b) (6) about the cleaning schedule for the gray baskets. (b) (6) said that (b) (4) s. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), 9 CFR 416.5(a), 9 CFR 416.12(a) and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN412206 1118N-1	06/17/2013	03J02	Slaughter HACCP	C	When I was performing the Review and Observation/ Record Review component of a Slaughter HACCP Task at the Quality Control Lab I noted recordkeeping deficiencies noncompliant with sections 417.2(c)7, 417.5(a)3 of the 9 Code of Federal Regulations. While reviewing the CCP-2BC (b) (4) HACCP Form I noticed that the last check performed for the CCP-2BC was at 0247 hours, but the verification check for (b) (4) was not performed by the HACCP Monitor assigned for this verification task. The verification check was performed and found acceptable at (b) (4) hours; it was approximately 30 minutes after the due time. This deviation from the frequency (b) (4) established in the establishment's HACCP plan did not meet the regulatory requirements mentioned in this document (b) (6), were informed of the forthcoming noncompliance
5309	P6137A	NJN570506 0517N-1	06/17/2013	01D01	SPS Verification	C	At approximately 2346 hours in the Evisceration department I was called to the "B" line station #3 by Inspector (b) (7)(C). Inspector (b) (7)(C) had observed a leak from the ceiling. I, CSI (b) (7)(C), inspected the ceiling past the third inspection station and observed two leaks overhead. The first leak was from the ceiling dripping between the Evisceration "B" line and the Reprocessing Offline, no product affected. The second leak was from a white cross beam above the Reprocessing offline. I took regulatory control of the Reprocessing line with the application of U.S. retain tag #B43303583 (b) (6). were shown the two leaks and informed of the noncompliance. After the establishment restored sanitary conditions by diverting the water from the leaks with a blue plastic liner that drained into a red trash barell all the offline shackles were washed and sanitized. I reinspected the area and offline then released the offline back to (b) (6) at approximately 0036 hours.
5309	P6137A	NJN230506 5515N-1	06/15/2013	01D01	SPS Verification	C	At approximately 0145 hours I, CSI (b) (7)(C), was performing a Good Commercial Practices verification task when I observed a insanitary condition noncompliant with 9CFR 416.1. In the trash dumping area behind the establishment there was multiple cardboard combo bins of trash (approximately twenty) most where overflowing with trash some were tipped over. The entire area was littered with used paper towels, product containers, broken pallets, used blue plastic liners. In the condemned product area I observed 27 large combo bins of condemned product from multiple departments and shifts of the establishment (carcasses from live hang, thigh bones from Packaging department, carcass backs from MSP department, wing tips from Fillet department) all uncovered. Also in this area 22 gray trash barrels full of various condemned products. There was also a foul odor coming from the bins and the multiple pools of stagnant waste water leaking from the bins and barrels. (b) (6) was informed of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN432006 5814N-1	06/14/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 1555 hours I was performing PHIS Finished Product Standards Inspection procedure task at the pre-chill station on evisceration line 'A'. I randomly selected ten carcasses prior to their entry to the chiller and after all plant interventions were allowed to occur. When I observed the ninth carcass, I noticed that it was contaminated with visible fecal material approximately 1/8th inch in diameter, yellowish in color, paste-like in consistency, and located on the outer surface of the right thigh. Immediately, I took regulatory control action by stopping line 'A' and bringing notice to (b) (6).</p> <p>(b) (6). The fecal finding was confirmed by Dr. (b) (7)(C).</p> <p>. At approximately 1607 hours the establishment initiated corrective actions. Mr. (b) (6), was informed of the forthcoming NR. The findings of fecal material on a carcass passed the final wash cabinet en route to the chilling system represents a (b) (4) as outlined in the establishment's HACCP and in accordance with the regulations 9 CFR 381.65(e) which states: "poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank". The establishment's written HACCP Plan dated (b) (4).</p> <p>(b) (6) Past similar NR was documented on 06/13/2013 # NJN 3120064113 N/1- Previous Ineffective Plant Response Action(s): no plant response at this time. PHIS slaughter HACCP task performed to verify that all corrective and preventive measures were completed. Continued failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s) as described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN061606 5213N-1	06/13/2013	04A06	Poultry Finished Product Standards	C	<p>At 1250 hrs. I was performing a zero tolerance verification task on the tubs of salvaged parts in the evisceration department. I randomly selected 5 pieces from each tub. I found one piece (thigh) affected with I.P (cellulitis) in a tub identified from B-line. I showed this finding to (b) (6).</p> <p>(b) (6). I secured U.S. Retain Tag # B43303543 to the tub. I also informed (b) (6) of the non compliance with 9 CFR 381.86. The establishment condemned the affected part and reworked the remaining product in the tub. At 1331 hrs. I reinspected the reworked product and found no further incidence of I.P. affected product. I removed the U.S. Retain tag and released control of the product back to the establishment. The finding of I.P. affected tissue on salvage parts constitutes a non compliance according to the regulations cited above. 9 CFR 381.86 states: "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned. There was a similar non compliance report issued for the same occurrence on 05/09/2013, NJN1916050109N/1. The establishment's response included immediate corrective actions of reprocessing the affected tub of product. The establishment responded with "Not applicable" for further planned action. It is unclear if the establishment included or enacted measures to prevent the reoccurrence of the same non compliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN312006 4113N-1	06/13/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 1702 hours I was performing PHIS Zero-tolerance task, in the Evisceration Department on the reprocessing off-line, prior to the birds entering the chilling process, and all plant interventions were allowed to occur, when I observed two (2) carcasses in the ten (10) carcasses random sample with the following: the first carcass was contaminated with visible fecal material approximately 6 mm by 2 mm in diameter, greenish in color, paste-like consistency, and located on the tail; The second carcass was contaminated with ingesta, the ingesta located in the pelvic area. I took regulatory control action by stopping the reprocessing line and applied US retain tag NO B43303501 on the affected carcasses. The findings were shown to (b) (6)</p> <p>At approximately 1711 the reprocessing line and the affected carcasses were released to the establishment allowing QC representative to perform corrective actions. Mr. (b) (6) was informed of the forthcoming NR. (b) (4)</p> <p>as outlined in the establishment's HACCP and in accordance with the regulations 9 CFR 381.65(e) which states: "poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank". 9 CFR 417.2(c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits". The establishment's written HACCP Plan dated (b) (4)</p> <p>A similar NR was documented on 06/04/2013 # NJN 5607063704 N/1. Plant Response (Further Planned Action(s) states "upon review of the (b) (4) records, the records indicated that the Critical Limit on the (b) (4) was one or two deviations from being met for a majority of the evening. Training was held with the HACCP monitor and (b) (4) monitor on how to perform a proper (b) (4) check and to notify management of cp check results that are nearing the Critical Limit. PHIS slaughter HACCP task performed to verify that all corrective and preventive measures were completed. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s) as described in 9 CFR 500.4.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1105060 712N-1	06/12/2013	01D01	SPS Verification	C	<p>On 06/12/2013 at approximately 0215 hours while monitoring Operational Sanitation standards in Plant #2, I observed the following. There was a shiny piece of curled metal attached by one end to the guide bar at the Inspectors Helper station at the middle inspection station on line^{(b) (6)}. The line was starting so I removed the piece of stainless steel and gave it to (b) (6). The metal piece was approximately 1/2" long and 1/16" wide. Loose metal pieces directly above open carcasses is creating an insanitary condition. The guide bar at this location is a solid piece of stainless steel approximately 5/8" in size and is worn nearly in half. A check of the guide bars for all the lines in plant #2 revealed numerous places along the lines with similar wear conditions. After line^{(b) (6)} was stopped and washed down, I observed a loose piece of metal measuring approximately 3" by 1/16" on a guide bar just prior to the first inspectors station for line^{(b) (6)}. There was a sliver of metal attached by one end measuring approximately 1/4" long on a guide bar behind the mirror at the first inspection station for line^{(b) (4)}. The guide bar at this location is approximately 3/8" thick and is worn almost in half. There was a piece of loose metal measuring approximately 2" by 1/16" on the guide bar after the inspectors station on line^{(b) (6)}. (b) (6) was shown my findings. A review of the HACCP Plan - Slaughter Plant #2 under (b) (4) states (b) (4). My findings indicated a noncompliance with 9 CFR 416.2(b)(1).</p>
5333	P7632	HYE210306 0312N-1	06/12/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 6/12/ 13 at approximately 0009 hours I observed the following noncompliance while performing the Pre- Operational SSOP Review and Observation task in the packaging area . The drip pan beneath the leg processor and above the blue flex transfer belt that carries product from the bin bumper to the thigh meat belt had a build-up of fat residue inside and around the edges . There was also pieces of fat inside the drip pan . After taking a regulatory control action and applying US Retained/Rejected # B38495456 , I presented my findings to (b) (6). (b) (6) had the drip pan and area below rinsed completely . The drip pan was reinspected and found to be in sanitary condition putting the establishment back in compliance . At 0017 hours unit # 16 was inspected , the^{(b) (4)} Thigh Meat belt . The belt had black specks floating in the water on top . Again I presented my findings to (b) (6). (b) (6) had the entire belt rinsed of all visible black specks . The belt was reinspected and found to be in sanitary condition at approximately 0023 hours putting the establishment back in compliance and ready for production at approximately 0025 hours . My findings indicate noncompliance with regulations 9 CFR 416.4(a) And 9 CFR 416. 4(b) .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0705065 811N-1	06/11/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 06/11/2013 at approximately 0029 hours while performing a Zero Tolerance Verification task on line (b) (6) in Plant #2, I observed the following. After (b) (6) collected a random 10 bird sample, I observed one bird with visible fecal contamination. The fecal material was inside the carcass on the left side adjacent to the keel bone approximately 1" from the neck opening of the carcass. The fecal material consisted of seven small smears. The smears measured up to approximately 1/4" each and were in approximately a 1" area. The fecal material was olive green in color and pasty in texture. This exceeded the zero tolerance for the process to be in control. The protocol for fecal failure was implemented. A QC recheck passed at 0100 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.(c)(4), and the critical limit of CCP-2B (b) (4) of the Plants' HACCP Plan for Slaughter.</p>
5309	P6137A	NJN260506 2411N-1	06/11/2013	01D01	SPS Verification	C	<p>At 0200 hours while I was walking through the evisceration department I observed deficiencies noncompliant with sections 416.1, 416.2(e)(3)(4) and 416.4(d) of the 9 Code of Federal Regulations. At the rehang area I noticed that the entire area was overflowed with water, heads, feathers and debris scatter through the area from the drain that runs under the Head Puller (b) (4) Washer, Head Cutter, (b) (4) line Auto Rehang and the Rehang table and belt, at the same time I observed approximately 15 carcasses on the floor piled up under the A line auto rehang and the Rehang table/belt from which some of the carcasses were over the standing water. The water was also covering the base of a stainless steel combo bin partially filled with carcasses (note that these combo bins have a drain in the base straight down to the floor and is approximately 2 inches above the floor). I also observed approximately 15 carcasses covered with blood and feathers from the kill line piled up on the Bird Catcher that is located prior to the (b) (4) Washer. All the deficiencies were creating insanitary conditions noncompliant with the regulations mentioned in this document. I showed my findings to (b) (6). As immediate corrective action Mr. (b) (6) condemned the carcasses that were on the floor, in the combo bin and on the bird catcher. The establishment restored sanitary conditions immediately by unclogging the drain and cleaning up the debris from the floor (b) (6) was informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4411062 310N-1	06/10/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 0702 hours while performing Pre Op SSOP Review and Observation task in Plant #1, I observed the following noncompliance. While inspecting the Liver Inspection Conveyor on Line #2 I observed numerous specks of black UFM (unidentified foreign material) all over the top and running the full length of the conveyor belt, on further inspection I also found numerous pieces of black UFM under the full length of the belt. I immediately took regulatory control and tagged the Conveyor with USDA Reject/Retain tag #B31 406261 and informed (b) (6) of the noncompliance. (b) (6) immediately instructed sanitation personnel to clean the conveyor and we continued with Pre Op inspection. Upon returning at approximately 0710 hours I reinspected the conveyor finding it clean, restoring sanitary conditions and I removed my tag at that time. My findings indicate a noncompliance with the Regulatory Regulations of 9CFR 416.1, 416.4(a) and 416.13(c).
5308	M6137	BXL5216061 110N-1	06/10/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1003 hours while passing the Gib Chillers in Plant #2, I observed the following. The stack of small brown tubs being used by the company employee to collect the giblets were in an insanitary conditions. The tubs had black, white and brown dried crusty residue from the previous day production, I observed the tubs that were collecting the livers, gizzards and hearts and found the one being used for hearts unclean also. I immediately tagged the tub with U.S.Retained/Rejected Tag # B31 407297 and the stack of tubs with U.S.Retained/Rejected Tag # B31 407536. I informed (b) (6) and showed him my findings. (b) (6) had a company employee condemn the hearts and take the unclean tubs to the wash room. At approximately 1015 hours, I went to Plant #1 and inspected the stack of tubs in Gib Chiller Plant #1 and found them also in an insanitary conditions. The tubs had dried pieces of fat, black and brown dried crusty residue, a pieces of dried gizzards and hearts from the previous day production. Quality Control personnel was close by and tagged two stacks of tubs with a red hold tag and I tagged another stack of tubs with U.S. Retained/Rejected Tag # B31 406857. I informed (b) (6) of the noncompliance. (b) (6) had a company employee take the tubs to the wash room. My findings indicated a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4 (a) and 9CFR 416.4 (d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN350706 0608N-1	06/08/2013	01C02	Operational SSOP Review and Observation	C	At approximately 0514 hours on June 8, 2013 I, CSI (b) (7)(C), was in the I.Q.F. New Products department performing a SSOP Review and Observation verification task when I noted the following noncompliance. The conveyor belt for the (b) (4) dip tank on Line #2 in the I.Q.F. department feeds product, skinless boneless chicken breast, to the Line #2 injection machine conveyor. I observed product over flow between these two conveyor belts. Product was continually falling on the floor into a pile of approximately thirty pieces. A gray trash barrel was in the center of this pile and filled with product, a second gray trash barrel was half full with product next to it. I took a regulatory control action by stopping the flow of product to the (b) (4) dip tank and tagging the conveyor belt for I.Q.F. Line #2 with U.S. retain tag B43303579. Continuing my inspection of the I.Q.F. department I noticed that at the Frigo exit there was approximately twenty frozen pieces of product, chicken strips, on the floor that had fallen from the overhead conveyor. I informed the (b) (6) of the noncompliance for the establishments failure to meet the regulatory requirement of 9CFR 416.4 (d) which states: " Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments." After sanitary condition were restored I released the product conveyor back to (b) (6) at approximately 0527 hours.
5308	M6137	BXL1704060 006N-1	06/06/2013	01B02	Pre-Op SSOP Review and Observation	C	On 06/05/2013 at approximately 2210 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Plant #1, I observed the following. There was tissue sticking through the round hole in the cutting blade assembly on the venting machine for Line #1. Most of the cutting assemblies were in a similar condition with tissue packed into the space above the cutting blade. The tissue was up to approximately 1/1/2" in length. The tissue removed from the machine was coated with blackened UFM (Unidentified Foreign Material) with the consistency of grease. After the tissue was removed, the venting machine was rinsed with potable water and released by approximately 2231 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5507064 506N-1	06/06/2013	06D02	Other Inspection Requirements	C	At approximately 0505 hours, I preformed a presentation check in plant 2 on line (b) (4) at a line speed of (b) (6) BPM (birds per minute). Station #3 had 1- viscera not uniformed, 2- Viscera on shackles, and 2- not reflected for a total of 28 confirmation points. This exceeded the limit of 25-39 conformation points for the process to be in control. I informed (b) (6). Quality Control performed a recheck at approximately 0523 hours and station #3 failed with 1- Viscera not uniformed, 1- Viscera on shackle, and 1- out of sequence for a total of 31 conformation points. This exceeded the limit of 25-39 conformation points for the process to be in control. (b) (6) was again informed of the failure and the line speed was reduced to 81 BPM. At approximately 0605 hours all rechecks passed, bringing the process back in control.
5308	M6137	BXL2705064 205N-1	06/05/2013	01B02	Pre-Op SSOP Review and Observation	C	On 06/05/2013 at approximately 0005 hours while monitoring the establishments Pre-Operational Sanitation procedures in Packaging Area #1, I observed the following. There were numerous pieces of fat and tissue to approximately 1/4" on the inside surfaces of the cover for the tray dispenser for line (b) (4). There were several pieces of fat and tissue to approximately 2" on the tray belt sprocket assemble at the same location. Also on line (b) (4) there was pasty fat and tissue on the white nylon and metal support brackets associated with the product tray belt. Appropriately 30 feet of the plant #1 side of the line (b) (4) belt was affected. The area of the tray belt that passes under the breast processing product belts in addition to the pasty fat also had several areas of black UFM (Unidentified Foreign Material) that appeared to be mold. (b) (6) was informed of the noncompliance. The line was cleaned with green pads, rinsed with potable water and released by approximately 0020 hours. In Packaging Area #2, the (b) (4) Deboning Room, there were two large pieces of tissue measuring approximately 4" by 1/2" inside the white product cones on line #1. There were also several pieces of fat and tissue to approximately 1" also on the inside surfaces of the product cones for line #1. There was also several cones with pasty fat and tissue stuck to the wear marks on the outside surfaces of the product cones. Most of the cones on all (b) (4) lines are in a deteriorated condition with scuff marks and deep cuts contributing to inefficient and ineffective cleaning. There were numerous pieces of fat and tissue on the inside surfaces of approximately an 8' section of the center breast fillet collection conveyor belt also in the line #1 area. (b) (6) was informed. The tissue was removed, areas were rinsed with potable water and the line was released by approximately 0036 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b), 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN560706 3704N-1	06/04/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 0540 hours while performing PHIS zero-tolerance task in the Evisceration Department on B line I noted the following noncompliance. I randomly selected a ten carcass sample set and observed fecal material in the third carcass of that sample. The bird's cloaca was still attached to the inside of the carcass. The fecal material was located inside the cavity near the cloaca. The fecal material was in the shape of a circular glob approximately 1/2 inch in it's greatest diameter, dark green in color with a paste like consistency. I immediately took regulatory control action and stopped "B" line then showed my findings to (b) (6) [REDACTED].</p> <p>[REDACTED] performed corrective actions as per establishment's HACCP plan (b) (6) [REDACTED]. [REDACTED] was notified of the noncompliance. The establishment did not meet the requirements of 9 CFR 381.65(e) which requires that the establishment prevents poultry carcasses contaminated with visible fecal material from entering the chilling system. The failure also represents a deviation from the establishment's written HACCP plan. Regulatory requirements of 417.2(c)(4) states "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." This noncompliance has been linked to the following noncompliances. The establishment has stated in their responses that all noncompliances for these fecal failures were a result of mechanical failures. NJN3007050722N-1, NJN5307054002N-1, NJN3120050529N-1, NJN0605052516N-1, NJN0605052516N-2</p>
5308	M6137	BXL1320060 803N-1	06/03/2013	03J02	Slaughter HACCP	C	<p>While performing Pre- Chill Finished Products Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 1335 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination inside the bird on the left side under the leaf fat area close to the kidneys. The fecal material was three spots each one measuring approximately 1/8" diameter in size, dark green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) [REDACTED] of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 1412 hours and it passed. The cause of the deviation was sprayer plugged up. This is a violation of the critical limits of CCP-2B (b) (4) [REDACTED] of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4816064 003N-1	06/03/2013	04A06	Poultry Finished Product Standards	C	On 06/03/2013 at approximately 1055 hours while monitoring the Establishments' Reprocessing Procedures on Line ^{(b) (4)} in Plant #2, I observed the following noncompliance. I randomly selected a 10 bird sample for my reprocessing check and found 2 birds with airsacculitis exudates remaining in the bird. I immediately took regulatory control action by stopping the line, and I informed ^{(b) (6)} [REDACTED] . The line was started and product was retained while corrective actions were implemented. I performed a recheck at approximately 1110 hours and it passed, bringing the process back into control. I tagged the tank of retained birds with U.S. Retained/Reject Tag #A5324453 pending rework of the product. I informed ^{(b) (6)} [REDACTED] of the noncompliance. I performed a recheck of the held product at approximately 1240 hours and it passed. I removed my tag and released the product back to production at that time. My findings indicate a noncompliance with 9CFR 381.76(b) and 9CFR 381.84.
5308	M6137	BXL3018053 530N-1	05/30/2013	03J02	Slaughter HACCP	C	While performing Pre-Chill Finished Products Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 1514 hours, I randomly removed a 10 bird sample from Line ^{(b) (4)} in Plant #2, I found one out the ten birds with visible fecal contamination inside the bird in the kidney crypt area. The fecal material was a piece measuring approximately 5/16" diameter in size, olive green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed ^{(b) (6)} [REDACTED] of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 1541 hours and it passed. This is a violation of the critical limits of CCP-2B ^{(b) (4)} [REDACTED] of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL4019054 730N-1	05/30/2013	01D01	SPS Verification	C	On 05/30/2013 at approximately 1400 hours while performing the Water Systems Food Defense Task, ^{(b) (6)} [REDACTED] and I observed the following noncompliance. The long ice chute on the roof of Plant #1 that runs from the ice house, had a missing metal plate that covers the section where the pieces of metal meet on the top of the chute. The opening was approximately two inches wide and the auger and ice inside were visible and exposed to the outside elements. There were approximately five other metal plates covering other gaps in the chute, however they were attached by only one bolt apiece and did not seal out the outside elements. Upon further observation we also saw that the next chute that attaches to the ice machine on the roof of Plant #1 was open on the end where the first chute comes up to meet it. The opening was approximately six inches wide and the auger and ice were visible and exposed to the outside elements. Our findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.2(b)(1), and 9CFR 416.2(g)(1). We informed ^{(b) (6)} [REDACTED] of the noncompliance

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN460905 2930N-1	05/30/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 0710 hours in the Fillet Department on 5/30/13 I, CSI (b) (7)(C) was conducting a Pre-Operational Sanitation verification task. On the product conveyors for cone lines #11 and 12, I observed multiple pieces of fat and meat from the previous day's production. The pieces of fat and meat varied in size, the larger pieces were approximately 3/4 of a inch in length and 1/2 an inch in width. Cone lines #11 and 12 were retained with the application of U.S. retain tag B43303568. (b) (6) and (b) (6) were informed of the noncompliance. After the establishment washed and sanitized cone lines #11 and 12 I reinspected and found the affected equipment to be acceptable. I then released cone lines #11 and 12 back to the establishment by removing U.S. retain tag B43303568 at approximately 0720 hours. Similar noncompliance was issued on 4/24/13, in both incidents cone lines were observed in the same condition. The establishment failed to meet the regulatory requirements as per 9CFR 416.4(a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. 9CFR 416.13(c) Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's.
5309	P6137A	NJN312005 0529N-1	05/29/2013	03J04	Poultry Zero Tolerance Verification	C	At approximately 11:29, while performing an FPS verification procedure on "B" line, I observed one carcass of a ten carcass sample with visible fecal material. The fecal matter was located on the front portion of the right leg, below the hock area, and measured approximately one eighth of an inch in diameter. The fecal matter was brown in color and of a semi-solid consistency. After noticing the affected carcass, I stopped the slaughter line and showed the affected carcass to Mr. (b) (6). (b) (6) was also given the opportunity to examine the fecal matter on the carcass. After confirmation of the fecal finding by the IIC, corrective actions were initiated by the establishment including a recheck which was conducted, completed and passed on "B" line. The establishment did not meet the requirements of 9 CFR 381.65(e) which requires that the establishment prevent poultry carcasses contaminated with visible fecal material from entering the chilling system.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5108051 328N-1	05/28/2013	01C02	Operational SSOP Review and Observation	C	On 05/27/2013 at approximately 2300 hours while monitoring Operational Sanitation at startup in Plant #2, I observed the following. There were varying amounts of brown dried and semi-dried tissue residue on the internal surfaces of the smaller size brown product tubs being used at the final trim station for lines (b) (6) and (b) (6) to collect salvaged parts. I placed the tubs, some with edible product, under USDA hold then contacted (b) (6) and showed him my findings. A small amount of product was reconditioned and returned to production. The tubs were replaced with gray tubs that are normally used at that location. I contacted (b) (6) in Packaging about dirty tubs. He said that Packaging had been informed and the affected pallets of tubs had been removed from the coolers and placed into the tub wash room. My finding indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (d).
5308	M6137	BXL4708051 623N-1	05/23/2013	01C02	Operational SSOP Review and Observation	C	On 05/23/2013 at approximately 0605 hours while performing Operational SSOP Review and Observation Task, I found at the end of the Giblets Chiller #4 in Plant #2, the brown small tubs being used to collect the livers and gizzards dirty. The tubs had white and black dried crusty residue along the top inside the tub. I immediately placed a U.S. Retained/Rejected Tag # B31 4070537 to the product. I inspected a stack of small brown tubs that the Giblets Chiller employee have in the area staged to be used and found that they were dirty also with small pieces of dried fat and dried red residue. I tagged the tubs with U.S Retained/Rejected Tag # B31 407552. I informed (b) (6) of the noncompliance and showed them my findings. (b) (6) had a company employee working at the Giblets Chillers, condemned the gizzards and the livers and took the dirty tubs to the tub wash room. My findings indicated a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4 (d).
5308	M6137	BXL4905050 523N-1	05/23/2013	01B02	Pre-Op SSOP Review and Observation	C	On 05/22/2013 at approximately 2224 hours while monitoring the Establishments Pre-Operational Sanitation procedures in Plant #1, I observed the following. There was heavy coating of black UFM (Unidentified Foreign Material) on the guide bars after the (b) (4) machine to a point where the bars intersect the chillers. The guide bars for lines 1, 2 and (b) (6) were in a similar insanitary condition. Contact between the shackles and guide bars during production would create an insanitary condition with the UFM falling onto the carcasses just prior to entering the chilling system. The access to the area for cleaning is a challenge due to the series of drip pans. Areas of the guide bars that obviously come into contact with the shackles were cleaned with a green pad, paper towels and a potable water rinse. The area was released by approximately 2235 hours. A more detailed cleaning will be performed after production. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN300705 0722N-1	05/22/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 0509 hours while I was performing the Review and Observation component of a Zero Tolerance Task at the offline inspection station I observed the following noncompliance. On the tenth carcass from the ten carcass sample, I noticed a small amount (approximately 1/2 of an inch in diameter) of a greenish/brownish paste like material consistent with fecal material. The fecal material was located on the inside side of the right wing between the drumette and wing tip. I took regulatory control action by stopping the offline and retaining the affected carcass with U.S. Retain tag# B43303564. I showed my finding to (b) (6) [REDACTED]. [REDACTED] initiated corrective actions as stated in the establishment's HACCP plan. The affected carcass was released to (b) (6) [REDACTED]. The establishment failed to prevent fecal material to reach the offline inspection station with the potential of entering the chiller. Section 381.65(e) from the 9 Code of Federal Regulations requires that the establishments shall prevent contaminated carcasses with visible fecal material from entering the chiller. The finding of fecal material did not meet the requirements of the establishments HACCP plan. The Supervisors mentioned in this document were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above. Similar non compliance was documented on 5/15/13 for an offline fecal failure. The Preventive measures of "An extra chlorine wash hose was installed, after the birds exit from the second body wash station before the final trimming area", failed to prevent reoccurrence.</p>
5333	P7632	HYE050705 4621N-1	05/21/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 5/20/13 at approximately 0433 hours I observed the following noncompliance while performing the Zero Tolerance verification task on line #2 . After pulling a ten bird random sample observing the fourth sample I noticed a large fecal smear in the pelvic cavity and another smear beneath the leaf fat . The fecal material was light yellow in color , pasty and smooth in texture . In size the fecal material in the pelvic cavity was approximately 1" by 1 " . The fecal material under the leaf fat was approximately ¼" in width and 1 1/2" in length . I called my findings to the attention of (b) (6) [REDACTED] who contacted (b) (6) [REDACTED] . (b) (6) [REDACTED] requested confirmation from (b) (7)(C) [REDACTED] PHV Dr (b) (7)(C) [REDACTED] . Upon confirmation by Dr. (b) (7)(C) [REDACTED] a recheck was performed by (b) (6) [REDACTED] , which passed at approximately 0444 , putting the establishment back in compliance . The establishments fecal failure protocol was implemented by (b) (6) [REDACTED] . My findings indicate a noncompliance with the following regulations 9CFR 381.65(e) which states that carcasses contaminated with visible fecal material shall be prevented from entering the chiller tank and 417.2(c)4 . The criteria for CCP-1B were also compromised .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN140805 2921N-1	05/20/2013	01C02	Operational SSOP Review and Observation	C	When I was walking through the Packaging department I observed the following deficiency noncompliant with the 9 Code of Federal Regulations, Sections 416.2(a) and 416.4(d): At area 2 Section: A, I observed a winged insect (housefly) crawling over the dark meat (thighs) that was inside a combo bin that was staged close to the Delivery System# 2 & Drop Chutes (Unit# 15). At approximately 0425 hours I took regulatory control action by applying U. S. Retain tag# B43303555 to approximately 100 pounds of product. (b) (6) kill the fly when it was standing on the chute from the delivery system #2 (b) (6) tagged the piece of equipment for further cleaning and sanitizing. At approximately 0435 hours the establishment condemned the top layer from the pile of the affected product. (b) (6), was informed of the forthcoming noncompliance.
5308	M6137	BXL2507055 817N-1	05/17/2013	06D02	Other Inspection Requirements	C	On 05/16/2013 at approximately 0230 hours while monitoring the "No Viscera Log" for Line #2 in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76(a) and 9CFR 381.76(b). At 2317 hours with line speed of (b) (4) BPM, Quality Control failed with 24 no viscera, 13 are allowed. At 2347 hours at line speed of (b) (4) BPM, the recheck failed with 23 no viscera, the line speed was slowed to 126 BPM. At 0120 hours with line speed of 126 BPM, Quality Control failed with 17 no viscera and 11 no viscera are allowed. Three failures in a half-shift period is a noncompliance for lack of process control. The line speed stayed at 126 BPM and at 0411 hours Quality Control failed with 22 no viscera and 11 no viscera are allowed. I informed (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN540105 0416N-1	05/16/2013	01C02	Operational SSOP Review and Observation	C	<p>At the start of Nightshift production I, CSI (b) (7)(C), and CSI (b) (7)(C) were conducting a Operational Sanitation verification task in the Evisceration department at approximately 2327 hours. I observed above the carcass chiller a blue plastic liner that was tied to two over head support beams for the purpose of containing a leak from the ceiling. Approximately ten feet in front of this leak another leak had begun above the carcass chiller and was not contained. I immediately informed (b) (6) of the drip and the forthcoming noncompliance. I then tagged the chiller with the application of U.S. retain tag B43303566. (b) (6) stopped the production line and instructed maintenance personnel to contain the leak with another blue plastic liner. The carcass chiller was overflowed with water and chlorine was added to the water after the overflow process was completed. All affected product was condemned. With sanitary conditions restored I released the carcass chiller, at approximately 2335 hours back to production Supervisors. While continuing to verify that the establishment was containing the two drips above the carcass chiller, at approximately 0037 hours, I observed another leak above the offline from the ceiling. I immediately stopped the offline and retained it with the application of U.S. retain tag B43303563. I showed my findings to (b) (6). In the presence of (b) (6) the establishment chose to condemn all affected product from the offline and divert the water from the leak in the ceiling with a blue plastic liner. After sanitary conditions were restored I released the offline back to production Supervisors.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN060505 2516N-1	05/15/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 0243 hours while I was performing the Review and Observation component of a Finish Product Standards Task at the offline inspection station I observed the following noncompliance. On the fourth carcass from the ten carcass sample, I noticed a small amount (approximately 1/8 of an inch in diameter) of a greenish/brownish paste like material consistent with fecal material. The fecal material was located on the outer side of the left hock right below of the hock joint close to the shackle. I took regulatory control action by stopping the offline and retaining the affected carcass with U.S. Retain tag# B43303533. I showed my finding to (b) (6)</p> <p>(b) (6) initiated corrective actions as stated in the establishment's HACCP plan. The affected carcass was reprocessed and found to be acceptable at 0247 hours. The establishment failed to prevent fecal material to reach the offline inspection station with the potential of entering the chiller. Section 381.65(e) from the 9 Code of Federal Regulations requires that the establishments shall prevent contaminated carcasses with visible fecal material from entering the chiller. The finding of fecal material did not meet the requirements of the establishments HACCP plan. The Supervisors mentioned in this document were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN060505 2516N-2	05/15/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 0510 hours while I was performing the Review and Observation component of a Finish Product Standards Task (FPS) at A Line inspection station. While I was performing the FPS verification, I observed the cloaca with a piece of intestine approximately 2 inches long attached to the tenth carcass from the ten carcass sample, after a closer observation, I noticed that the intestine was draining a Brownish paste like material consistent with fecal material inside the carcass on the pelvic area. I took regulatory control action by retaining the affected carcass with U.S. Retain tag# B43303533. I showed my finding to (b) (6)</p> <p>(b) (6)</p> <p>requested a second opinion from Dr. (b) (7)(C) which confirmed that it was fecal material. Ms. (b) (6) initiated corrective actions as stated in the establishment's HACCP plan. The affected carcass was reprocessed and found to be acceptable at 0520 hours. When I informed Online IPP about the zero tolerance failure, they communicated to me that they informed the establishment's management of finding carcasses with cloacas attached and high amounts of contamination. At 0243 hours the establishment had a zero tolerance failure on the Reprocessing Offline. The establishment failed to prevent fecal material to reach the A line FPS inspection station with the potential of entering the chiller. Section 381.65(e) from the 9 Code of Federal Regulations requires that the establishments shall prevent contaminated carcasses with visible fecal material from entering the chiller. The finding of fecal material did not meet the requirements of the establishment's HACCP plan. The Supervisors mentioned in this document were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>
5333	P7632	HYE040005 1215N-1	05/15/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On Friday May 9, 2013 at approximately 0450 hours, I was conducting a Poultry Zero Tolerance Verification Procedure at the finished product standard (FPS) station for Line 1. I had selected a random ten carcass sample from the line and observed a fecal smear approximately ½" x ¼" in size within the carcass cavity. The fecal material was brownish-green in color with a pasty consistency and was located under the left side of the keel bone. I notified (b) (6)</p> <p>(b) (6) of my findings and the forthcoming documentation. Ms. (b) (6) then summoned Quality Control personnel to perform a recheck at the Line 1 FPS station. The prevention of carcasses with fecal contamination to reach the FPS station prior to entering the chiller represents a noncompliance with regulation 9 CFR 381.65(e) which states "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank".</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1904054 214N-1	05/14/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 05/14/2013 at approximately 0014 hours, while performing the Zero Tolerance Task in Plant #1 on Line #2, I found visible fecal contamination on one of the ten birds I randomly removed. The fecal was located inside, above the kidney on the right side on the bird. The fecal material measured approximately 1/8" in size, olive green in color and pasty in texture. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (b) (6) of the noncompliance and the protocol for fecal failure was implemented. Quality Control performed the recheck at approximately 0047 hours and failed with one bird out of ten that had visible fecal contamination. The bird had a vent with approximately 1 1/2" of intestine, attached by connective tissue on the left side of the bird. The fecal material was inside the bird on the kidneys in the middle measuring approximately 1/2" long, dark green in color and slightly runny in texture. (b) (6) were informed of the failure. Quality Control performed the recheck at approximately (b) (4), after the company break, and passed. The cause of the deviation was the guide bar of the inside outside bird washer. Quality Control performed Post Chill checks from 0126 till 0246, all checks passed. My findings indicate a noncompliance with 9CFR 381.65(e), 9CFR 417.2(c)(4), and the critical limit of CCP2B, (b) (4) of the Plant's HACCP Plan for Slaughter.</p>
5308	M6137	BXL4504050 611N-1	05/11/2013	04A06	Poultry Finished Product Standards	C	<p>On 05/10/2013 at approximately 0139 hours, I randomly removed a 10 bird sample from Line (b) (4) in Plant #2 for a Pre-Chill Finished Product Standard Check. I documented 33 points on the Processing Nonconformances from the 10 bird sample. This exceeds the subgroup absolute limit of 30 points for the Processing Nonconformances to be in control. I informed Quality Control of the failure and at approximately 0150 I performed a recheck. I documented 31 points on the Processing Nonconformances, this exceeds the limit of the 25 points allowed for the recheck, at this point the process is considered out of control. I informed (b) (6) of the noncompliance. Line (b) (6) had finished running the Organic birds after I had performed the recheck and had moved to Line (b) (4). Quality Control performed rechecks at Post-Chill and at 0325 hours, all Post-Chill checks had passed. My findings indicate a noncompliance with 9CFR 381.76(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4508050 011N-1	05/11/2013	04A06	Poultry Finished Product Standards	C	On 05/11/2013 at approximately 0515 hours while monitoring evisceration line processes in Plant #1, I observed the following. The automatic rehang feature that transfers carcasses from the kill line to the evisceration line was not working for line #1 causing all the carcasses to be dropped onto the belt at the rehang station. The establishment has an automatic paw condemnation system that drops the paws automatically when a carcass is condemned at any inspection station. The system was not functioning when the association between the carcass and the paws was lost as the carcasses were being manually rehung on a random basis by five employees. I went to the paw collection room and observed that paws were being collected from lines 1 & 2 into a single plastic lined bin which is how the establishment treats edible product. I contacted (b) (6) who condemned by approximately 0550 hours the paws that had collected before break. The automatic rehang machine could not be repaired during the 0530 hour break so the paws from line #1 were condemned for the rest on the shift. This is a loss of process control. My findings indicated a noncompliance with 9 CFR 381.65(a) and 9 CFR 381.78(a).
5308	M6137	BXL1505052 710N-1	05/10/2013	01C02	Operational SSOP Review and Observation	C	At approximately 0210 hours while passing by the Gib Chiller in Plant #2, I noticed the following noncompliance. The brown tub that was being used to collect the gizzards looked dirty. On closer inspection I saw that the tub had dried crusty residue along the top inside of the tub. Upon further inspection I observed that the other brown tubs being used to collect the liver, gizzards and hearts on both Chiller #3 and Chiller #4 also had dried residue and fat on the top inside of the tubs. I observed a stack of brown tubs in the area and I asked the employee working at the Gib Chiller if those tubs were clean and he answered that they were. I inspected the tubs and found that they were also dirty with dried residue and fat. I took regulatory control action and tagged the tubs with USDA Reject/Retain tag B31408043, I then informed (b) (6) of the noncompliance and showed him my findings. He immediately took the tubs to the wash room to be rewashed and he brought clean tubs. He then had the employee working at the Gib Chiller condemn the gizzards, livers and hearts that were in the dirty tubs, restoring sanitary conditions at approximately 0230 hours. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN000105 3010N-1	05/10/2013	01C02	Operational SSOP Review and Observation	C	At approximately 0730 in the Fillet Department on 5/09/13 I, CSI (b) (7)(C) was conducting a Operational Sanitation verification task. On the product conveyor for cone line #7, I observed multiple pieces of fat and skin from the previous days production. The pieces of fat and skin varied in size, the larger pieces were approximately 3/4 of a inch in length and 1/2 an inch in width. The product conveyor did not have product on it because this was observed at start up for the Fillet department. Cone line #7 was retained with the application of U.S. retain tag B43303550. The Fillet Department, (b) (6) were informed of the noncompliance. After the establishment washed and sanitized cone line #7 CSI (b) (7)(C) reinspected and found the affected equipment to be acceptable. CSI (b) (7)(C) then released cone line #7 back to the establishment by removing U.S. retain tag B43303550 at approximately 0811 hours.
5309	P6137A	NJN191605 0109N-1	05/09/2013	04A06	Poultry Finished Product Standards	C	At 0839 hrs. I was performing a zero tolerance verification task on the tubs of salvaged parts in the evisceration department. I randomly selected 5 pieces from each tub. I found one piece (thigh) affected with I.P (cellulitis) in a tub identified from A-line. I showed this finding to (b) (6). I secured U.S. Retain Tag # B43303542 to the tub. I also informed (b) (6) of the non compliance with 9 CFR 381.86. The establishment condemned the affected part and reworked the remaining product in the tub. At 0945 I reinspected the reworked product and found no further incidence of I.P. affected product. I removed the U.S. Retain tag and released control of the product back to the establishment. The finding of I.P. affected tissue on salvage parts constitutes a non compliance according to the regulations cited above. 9 CFR 381.78(a) states in part: "At the time of any inspection under this subpart each carcass, or any part thereof, which is found to be adulterated shall be condemned, except that any such articles which may be made not adulterated by reprocessing." 9 CFR 381.86 states: "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE590205 0909N-1	05/09/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On the 8 May, 2013 at approximately 0008 hours, after Sanitation and QC Performed Pre-Operational Sanitation and released area IV for operations, I performed Pre-operational Sanitation Inspection and observed the following Noncompliance: there was black greasy water with spots of foreign material in the immediate area" approximately an area 6 x 6 square "on the Conveyor Belt below the Chute. I immediately took a regulatory control action by placing U.S Rejected Tag # B39415929 on the affected area and informed Mr. (b) (6) of the noncompliance and forthcoming Non Compliance Record. With the aid of a ladder I climbed to a better vantage point after the belt was cleaned and before the area was released to possibly see where the grease was coming from. The motor housings/cover and drive line/cogs had excessive grease, both mechanical and animal as well as excessive condensation " beaded and dripping " on the ceiling directly above Ln 1 & 2 Body Halvers; Ln 1 & 2 Bird Indexers; the Chute and Conveyor. At that point I informed Mr. (b) (6) that the area was not released and I would be in the USDA office waiting until sanitary conditions had been restored to my satisfaction. Approximately a half hour later Mr. (b) (6) retrieved me from the office to reinspect the area in question. I reinspected the area and found the area to be acceptable with sanitary conditions restored, I removed the U.S. rejected Tag at approximately 0040 hours. Upon review of the SSOP Implementation and Monitoring Log Checklist, QC had found Unit #1 of Area #4 acceptable at 2333 hours.</p>
5309	P6137A	NJN250505 3208N-1	05/08/2013	04A06	Poultry Finished Product Standards	C	<p>At approximately 0239 hours I, CS (b) (7)(C), was in the Evisceration Department performing a Finished Product Standards verification task on the offline. I selected a random ten carcass sample to verify the establishments reconditioning procedure for contaminated product. Three carcasses of the ten had various amounts of ingesta, two of the carcasses had large amounts of ingesta in the neck/crop area of the carcass, one had ingesta located inside the cavity on the rib cage. Production employee stopped the offline, I informed (b) (6) of the failure and showed him my findings. Then I informed (b) (6) that I would conduct the establishment required recheck. After selecting ten carcasses, I observed two of the ten to have ingesta in the neck/crop area. I took regulatory control action with the application of U.S. retain tag B43303544 to the offline e-stop and informed (b) (6) of my findings and the forthcoming noncompliance for the establishment's failure to meet the regulatory requirements. Then I released offline and (b) (6) immediately began the establishment's recheck and corrective actions.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5217053 607N-1	05/07/2013	03J04	Poultry Zero Tolerance Verification	C	While performing Zero Tolerance Verification Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 1457 hours, (b) (6) randomly removed a 10 bird sample from Line # (b) (6) in Plant #2, I found the second bird inspected with visible fecal contamination inside the bird at the right side next to the tail-vent area, what looked to be a venter missed cut. The fecal material was a piece measuring approximately 1/4" long by 3/16" wide, green olive in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) of the noncompliance. The protocol for fecal failure was implemented. At approximately 1521 hours, Quality Control performed a recheck and it passed. The cause of the deviation was the venter. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL3712053 606N-1	05/06/2013	01B02	Pre-Op SSOP Review and Observation	C	While performing Pre Operational inspection in the Packaging area, I found a noncompliance with regulatory requirements of regulations 9 CFR 416.4(a) and 416.14. At approximately 0837 hours, while inspecting The (b) (4) located by the bag fryer lines in the packaging area, I noticed the following insanitary condition: There were several rough surface inside of the hoppers. The yellowish and scabby residue came off easily when I scratched it. The hoppers are a product contact surface utilized to load product into tubs. I showed my finding to The (b) (6). I then, proceeded to place a rejected/retained tag NO B31 407702 on the effected equipment. Sanitation employees scrubbed and washed the affected product contact surfaces. At approximately 0855 hours, I reinspected the equipment finding it clean. I then, remove the US reject tag, releasing the equipment to production. (b) (6) was notified of the noncompliance.
5333	P7632	HYE430605 1606N-1	05/06/2013	03J04	Poultry Zero Tolerance Verification	C	On 5/5/13 at approximately 0215 hours I observed the following noncompliance while performing the Zero Tolerance procedure on line #2 . After pulling a ten bird random sample and observing the third sample , I noticed a large fecal smear just below the leaf fat . The fecal material was light green in color , pasty and smooth in texture approximately 3/8" in width and 3/4" in length . I reported my findings to of (b) (6) who was performing a check on line #1 . (b) (6) contacted (b) (6) (b) (6) requested confirmation from (b) (7)(C) PHV Dr. (b) (7)(C). Upon confirmation by Dr. (b) (7)(C) a recheck was preformed by (b) (6) , which passed at approximately 0222 hours then establishments protocol for fecal failure was implemented by (b) (6) . My findings indicate noncompliance with the following regulations 9CFR 381.65(e) which states that carcasses contaminated with fecal material shall be prevented from entering the chiller tank and 417.2(c)4 and the criteria for CCP-1B were also compromised .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1305050 202N-1	05/02/2013	01C02	Operational SSOP Review and Observation	C	<p>On 05/02/2013 at approximately 0100 hours while monitoring the establishments' Operational Sanitation procedures in Packaging Area #1, I observed the following. There was an off colored film of UFM (Unidentified Foreign Material) on the stainless surfaces that support the brown product belts for line (b) (6). I wiped some of the UFM from Line (b) (6) off onto a white product soaker pad and showed it to (b) (6). The UFM showed up black on the white pad. Line (b) (6) was not yet in use. I proceeded to line (b) (6) the 'A' side was in use and was clean. I found the same UFM on the 'B' side which was not in use. The UFM was also on most of the small tables that are part of the (b) (4) bagging system for lines (b) (6) and (b) (6). (b) (6) was called. A review of the establishment Pre-Operational Sanitation documents for the shift revealed that Line (b) (6) was checked by a General Sanitation employee as part of the establishments Pre-Operational Sanitation check and found to be acceptable at 2300 hours. Line (b) (6) was found to be acceptable at 2304 hours. Quality Control personnel according to the establishments' SSOP Pre-Op Daily Implementation and Monitoring Log for Packaging found Line (b) (6) belt acceptable at 2318 hours and select (b) (4) units for lines (b) (6) & (b) (6) were found to be acceptable by 2317 hours. The establishment uses a cleaner as part of their pre-operational cleaning procedure manufactured by Supply Systems coded A-433 that is a mixture of (b) (4) and (b) (4). According to the label the product only requires a (b) (4) (b) (6). (b) (6) was given a sample of the UFM (b) (6) had production sanitation personnel clean the affected surfaces. The UFM wiped off easily with a paper towel. A (b) (4) followed per establishment policy restoring sanitary conditions by approximately 0200 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.3(a), 9 CFR 416.4(a) and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN530705 4002N-1	05/02/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 0458 hours while performing PHIS zero-tolerance task in the Evisceration Department on B line I noted the following noncompliance. I randomly selected a ten carcass sample set and observed fecal material in the third carcass of that sample. The fecal material was located inside the cavity on the left side flap, approximately 1/2 in length and 1/4 in it's greatest diameter, dark green in color with a paste like consistency. I immediately took regulatory control action and stopped "B" line then showed my findings to (b) (6) [REDACTED].</p> <p>[REDACTED] performed corrective actions as per establishment's HACCP plan. (b) (6) [REDACTED] was notified of the noncompliance. The establishment did not meet the requirements of 9 CFR 381.65(e) which requires that the establishment prevents poultry carcasses contaminated with visible fecal material from entering the chilling system. The failure also represents a deviation from the establishment's written HACCP plan. Regulatory requirements of 417.2(c)(4) states "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits."</p>
5333	P7632	HYE370005 3002N-1	05/02/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 5 /1 /13 at approximately 2158 hours I observed the following noncompliance while performing the Pre-operational SSOP Review and Observation procedure in the picking room . On the way to perform the lock-out and tag-out procedure with (b) (6) [REDACTED] I observed a piece of fiberglass paneling attached to the south wall . The paneling covered an area approximately 7' by 8' . Upon closer observation I noticed what appeared to be several pieces of paneling bonded together covering the area . All four sides of the area were covered with black mold . The three pieces of paneling jointed with caulking contained mold as well . I took a regulatory control action and immediately informed (b) (6) [REDACTED] of the noncompliance . My findings also indicate noncompliance with 9CFR 416.1 and 9 CFR416.2 (b)2 .</p>
5308	M6137	BXL0122054 701N-1	05/01/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 04/30/2013 at approximately 2350 hours while monitoring the establishments' Pre-Operational Sanitation procedures in Packaging, I observed the following. There were several pieces of fat approximately 1/4" to 1" and a blood clot approximately 1/4" under the brown product belt on Line (b) (6) [REDACTED], closest to Line (b) (6) [REDACTED]. I informed (b) (6) [REDACTED] of the noncompliance. The area was rewashed, restoring sanitary conditions. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.4(a), 9CFR 416.14, and 9CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3908054 001N-1	05/01/2013	01D01	SPS Verification	C	On 05/01/2013 at approximately 0535 hours in Plant #1 Evisceration Department, USDA GS7 Inspector (b) (7)(C) saw a live cockroach on the wall where employees hang their aprons, directly behind USDA Inspection Station #6 on Line #2. He killed the cockroach with a paper towel and then showed it to me and I took it to (b) (6) and informed him of the noncompliance. At approximately 2306 hours in Plant #1 Evisceration, Inspector (b) (7)(C) saw another cockroach on a metal pole directly behind USDA Inspection Station #5 on Line #2. Inspector (b) (7)(C) killed the cockroach with a paper towel then gave it to me and I showed it to (b) (6). This was the second incident with a cockroach on the same day.
5308	M6137	BXL4604050 401N-1	05/01/2013	04C05	Poultry Good Commercial Practices	C	On 05/01/2013 at approximately 0216 hours while performing Good Commercial Practices in Plant #1 Live Hanging area, I observed the following. On Line #2, the stainless steel tank marked "USDA CONDEMN" which is used for DOA birds, there was one bird lying on top of approximately 20 dead birds that was breathing and slightly moving it's head. I immediately informed (b) (6) and the bird was removed from the tank and put on Line #2 kill line, to go through stunning and the automatic kill machine. This noncompliance is linked to NR BXL3313020527N/1 on 2/27/2013 for the same root cause. I informed (b) (6) of the noncompliance.
5333	P7632	HYE060705 4601N-1	05/01/2013	01C02	Operational SSOP Review and Observation	C	While performing an Operational Sanitation Review and Observation task in Area #3, Chick Weight/Bag Line at 0345 hours I observed the following noncompliance; Above the Chick Weight /Bag line from the bottom of the (b) (4) Cabinet, heavy beaded condensation was present and dripping onto the product contact surface below. I took immediate regulatory control action by stopping the production line with U.S. Retain tag # B 39757011 and informed Mr. (b) (6) N/S of the Noncompliance and the forthcoming Non Compliance Record. I also informed Miss. (b) (6) of the situation and the noncompliance action. Mr. (b) (6) took immediate action by having the condensation removed and the affected product retained and sent to the product wash station. Control of the Chick Weight/Bag Line was relinquished at 0351 hours after the product contact surface was resanitized and sanitary conditions were restored. The affected product was put back into circulation after it was reprocessed per establishment's procedure. As per Step #6 of the establishments SSOP's plan:" (b) (4)

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE260804 2729N-1	04/29/2013	04A06	Poultry Finished Product Standards	O	On 4/28/13 I observed the following noncompliance while performing a Poultry Finished Product standard verification task on the reprocessing line in the evisceration department at approximately 0216 . Selecting ten birds randomly , marked with split tails for vacuum I observed one out of the ten with air sac exudate . The air sac was yellow in color , watery in texture located on the left side of the opening cut below the leaf fat . (b) (6) was informed her of the noncompliance . (b) (6) performed the recheck immediately . The recheck passed putting the establishment back in compliance . My findings indicate a noncompliance with regulation 9CFR 381.83 which states that evidence of extensive involvement of air sac or showing systemic changes shall be condemned . Less effected carcasses may be passed for food after complete removal and condemnation of all affected tissues including the exudate .
5333	P7632	HYE260804 2729N-2	04/29/2013	04A06	Poultry Finished Product Standards	O	On 4/28/13 I observed the following noncompliance while performing a Poultry Finished Product standard verification task on the reprocessing line in the evisceration department at approximately 0216 . Selecting ten birds randomly marked with split tails for vacuum I observed one out of the ten with air sac exudate . The air sac was yellow in color , watery in texture located on the left side of the opening cut below the leaf fat . (b) (6) was informed of the noncompliance and performed the recheck immediately . The recheck passed putting the establishment back in compliance . My findings indicate a noncompliance with regulation 9CFR 381.83 which states that evidence of extensive involvement of air sac or showing systemic changes shall be condemned . Less effected carcasses may be passed for food after complete removal and condemnation of all affected tissues including the exudate .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN032004 0025N-1	04/25/2013	04A06	Poultry Finished Product Standards	C	<p>I was performing a Poultry Finished Product Standards verification task at 1141 hours on the reprocessing line in the evisceration department when I observed the following noncompliance: The establishment failed to remove airsacculitis tissue and exudates from carcasses identified by USDA for air sac removal. (7) Carcasses of the (10) carcasses sample identified for air sac removal contained air sac exudates. The establishment's written procedure for (b) (4) [REDACTED] states: (b) (4) [REDACTED]. I initiated regulatory control by stopping the reprocessing line and applied U.S. Retained tag NO B38495187 on the affected carcasses. Mr. (b) (6) [REDACTED] were informed of my finding and forthcoming non compliance. At 1148 hours I released the affected carcasses to the establishment for rework and the regulatory control was relinquished to the Quality control so that to start the establishment corrective actions to regain process control and perform rechecks to identify all affected products associated with the failure. Ms (b) (6) [REDACTED] performed a recheck on the reprocessing line. The recheck failed by one carcass out of ten carcasses sample had airsacculitis on the pelvic cavity. She performed another recheck; the recheck passed at 1154 hours. The requirements of 9 CFR 381.84 and the purpose of Plant's written (b) (4) [REDACTED] procedure were not met 9 CFR 381.84 which states: (b) (4) [REDACTED]</p> <p>[REDACTED] Plant's written Airsacculitis procedure document number IX.m dated 8/15/2012. The purpose: (b) (4) [REDACTED]</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN531104 4425N-1	04/25/2013	01C02	Operational SSOP Review and Observation	C	On 04/24/2013 at 1040 hrs I was walking in the fillet department on the north side next to wing singulators line 4 and 6 when I noticed that there was liquid dripping from the drain hole of the catch pan above the line onto the product (wings) being conveyed on the line below. This catch pan houses the product belt sprayers and did not have the drain hose attached. The blue flexible drain hose is used to direct the flow from the drain onto the floor and away from the product. I immediately got the attention of (b) (6) and had him stop the wing singulator belt that was affected by this drip. I informed Mr. (b) (6) of my observations and secured U.S. Reject Tag #B39415848 to the framework of the singulator line. I informed (b) (6) of the non compliance to the regulation cited above. The immediate corrective action by the establishment was to reattach the drain hose to the drain and wash and sanitize the affected product belt. The establishment determined that the drain hose had been in place at 0945 hrs. The establishment retained approximately two combo bins of wings and one rack of bulk bagged wings. After the belt was washed and sanitized I removed the reject tag at 1157 hrs. 9 CFR 416.4(d) states: product must be protected from adulteration during processing, handling, storage, loading and unloading at and during transportation from official establishments.
5308	M6137	BXL1016042 624N-1	04/24/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1053 hours while performing scheduled Operational SSOP Review and Observation task, I observed the following noncompliance. While walking through the (b) (4) Room I stopped at the sink used to recondition product to ensure that the product there was iced. While I was there I observed several pieces of product in a brown tub staged on the right side of the sink under the "clean product" sign that had multiple specks of black UFM (unidentified foreign material) on them. The Establishment's SSOP's state tha (b) (4) and that (b) (4) ". I immediately tagged the tub with USDA Retain Tag #B31406330 and informed (b) (6) of the noncompliance. The lead person immediately started reconditioning the product. I did a recheck of the product and found it to be clean restoring sanitary conditions and removed my tag at approximately 1215 hours. My findings indicate a noncompliance with the regulatory regulations of 9CFR 416.1 and 9CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN122204 3424N-1	04/24/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>At approximately 0720 hours while performing the Review and Observation component of a Pre-Operational Sanitation PHIS task, I observed the following deficiencies at the Fillet Room Section F Wings: At Unit# 21 North Side Sizing Stations (3 stations) on the first sizing station adjacent to the incline conveyor to sizing from the cone lines had fat residue from the previous day's production along the white plastic guide bars and in the interior side of the conveyor. At Unit# 8, North/South KVP Incline conveyor (line diverts product to packaging line (Ossid# 1), on this unit I observed a piece of fat from the previous day's production. The piece of fat had an approximate measurement of 1.5 inches long and ¼ of an inch wide. At unit# 2, Product Transfer Incline belt, I observed a piece of skin lodged in between the wheels located at the lower side of the belt. The piece of skin was from the previous day's production and it had an approximate measurement of 3 inches long and 1 inch wide. The Lock Out/Tag out procedure remained in place until the establishment restored sanitary conditions. I showed the deficiencies to (b) (6) [REDACTED]. The establishment implemented immediate corrective actions by cleaning and sanitizing the affected equipment. Once sanitary conditions were restored and the units were reinspected and found acceptable, I relinquished the units to production at 0730. The finding of pieces of fat and skin from previous day's production on product contact surfaces represents a failure to meet the regulatory requirements of sections 416.4(a) and 416.13(c) of the 9 Code of Federal Regulations. (b) (6) [REDACTED] and (b) (6) [REDACTED], were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>
5309	P6137A	NJN122204 3424N-2	04/24/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>At approximately 0725 hours, while performing the Review and Observation component of a Pre Operational Sanitation PHIS task in the Fillet Room I observed the following non compliance: Cone line # 5: There were considerable amounts of fat and skin pieces along the entire length of the conveyor belt, cones, chutes, dip pans, stands and the lines metal frame. The approximate sizes are 1/2" – 1 ½" and 1/4"– 1/2" in width. I showed the deviations to (b) (6) [REDACTED] and informed him of the noncompliance. The establishment implemented immediate corrective actions. All affected areas were cleaned and sanitized. Once sanitary conditions were restored and the area was found acceptable the area was released at 0730. The establishment failed to meet regulatory requirements as per 9CFR 416.4(a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. 9 CFR 416.13(c) Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN560704 1124N-1	04/24/2013	01D01	SPS Verification	C	<p>At approximately 00:43 in the New Room (IQF), while performing an SPS review and observation PHIS task, I observed the following non compliance. There were three stacks of brown baskets. Several of the baskets had dried fat pieces with an approximate measurement of ½"-2" long and ¼" – ½" wide. I took regulatory control by applying U.S. retain tag #B38495403. I then notified (b) (6) of my findings and of the forthcoming noncompliance. She acknowledged and verified the dirty baskets. At this point plant employees were still getting baskets from the stacks and applying blue plastic liners to the baskets. She then addressed the findings with (b) (6), who then tagged the baskets that were being staged by the plant employees. Ms.(b) (6) then instructed another employee to take the remaining basket out of the production area. Once these corrective actions were implanted and sanitary conditions were restored, I removed my U.S. retain tag. The establishment failed to comply with regulatory requirements 9CFR 416.1Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated.9 CFR 416.4(b) Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.</p>
5333	P7632	HYE480804 0324N-1	04/24/2013	04A06	Poultry Finished Product Standards	O	<p>ON 4/24/13 at approximately 0333 hours I observed the following noncompliance while conducting a Poultry Finished Product Standards verification task . The task was preformed on the bag line due to the amount of contamination found in an earlier verification check at the AQL table . Pulling a sample of approximately ten gizzards from a tan product tub which had been staged to be the next tube of gizzards to be used , I noticed ingesta , grit and black flakes of (UMF) Unidentified Foreign Material in approximately 50% of the sample . Selecting another sample of approximately ten gizzards for further observation I found 50% of that sample to be contaminated as well . Taking a regulatory control action I had the tub removed from circulation . (b) (6) was in the area and was informed of the noncompliance . Mr. (b) (6) placed a QC hold tag on the product which was condemned at approximately 0620 hours . My findings indicate noncompliance with the following regulations 9CFR 318.76(b) and 9CFR 416.4(d) which states that" the product must be protected from adulteration during processing , handling ,storage , loading and unloading at and during transportation from official establishments " .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN500304 1523N-1	04/22/2013	04A06	Poultry Finished Product Standards	C	<p>When I was performing the Review and Observation component of a Finish Products Standard PHIS task at the chiller exit (post chill inspection station) I noted the following deficiency. One carcass from a ten carcass sample was marked for airsacculitis (split tail). This carcass had airsacculitis exudates, pieces of lung in the thoracic area and the cloaca with a piece of intestine still attached to it. I show the carcass to (b) (6). The approximate time of this incident was 0119 hours. A minute later I found another carcass with airsacculitis exudates in the thoracic and pelvic area, this carcass was also marked for airsacculitis (split tail). I showed my finding to (b) (6). At 0123 hours I performed an offline vacuum verification. I collected a sample consisting of 10 carcasses from which 6 carcasses marked with split tail had airsacculitis exudates in the rib cage. I showed my finding to (b) (6). According to the establishment's vacuum procedure 3 carcasses with vacuum defects requires retention and rework of the affected product. (b) (6), initiated immediate corrective actions as prescribe in the establishment's vacuum procedure. The establishment failed to remove airsacculitis exudate from carcasses marked by USDA online inspection personnel. 9 CFR 381.84 requires that establishments completely remove and condemn tissues affected with airsacculitis, including exudates, in carcasses not condemned. Mr (b) (6) were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>
5333	P7632	HYE042004 4422N-1	04/22/2013	04A06	Poultry Finished Product Standards	C	<p>At 1331 hours I performed the Review and Observation of a Finish Product Standards task at the salvaged parts station in the 9th degree cooler. The product had already went through all interventions during the slaughter process and was inspected and released by Quality Control personnel. While performing my verification in a tub of salvage thighs, I noticed that one of the thighs had cellulitis exudate attached to the meat approximately a 1/2 inch by 1/4 inch in size. I took regulatory control action by applying US Retained tag #B38494104 to the affected tub of product. I showed my finding to Ms (b) (6) and informed them of the forthcoming noncompliance. Upon reviewing the establishment records, I noted that Quality Control personnel released and found acceptable the affected product at 1129 hours. The finding of cellulitis exudate in finish product represents a noncompliance as per 9 CFR 381.86 which states, "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned". At approximately 1337 I released the product to Mr. (b) (6) so he could initiate corrective actions.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN400704 1722N-1	04/21/2013	01C02	Operational SSOP Review and Observation	C	<p>I was walking through the Packaging department at the start up of operations and before product reached the product contact surfaces, when I observed the following noncompliance: At Section A: Marination line, I observed in the Incline Conveyor Out of Hopper (Unit #7) pieces of fat, with an approximate measurement of 5mm, from the previous day's production and residue from spice ingredients, reddish in color, that are used to marinate the product that is processed in this units. At 0101 hours I tagged the unit with retain tag #B303531. On the transfer conveyor belt under the delivery system #1 drop chute I noticed a piece of meat from the previous day's production, with an approximate measurement of 1 inch long and ½ inch wide. I tagged the unit with retain tag #B303531. I showed my findings to (b) (6)</p> <p>They also were informed of the forthcoming documentation for the failure to comply with the regulatory requirements of Sections 416.4(a) and 416.13(c) of the 9 Code of Federal Regulations. After the establishment restored sanitary conditions on the affected equipment, I released the units to production at 0146 hours.</p>
5308	M6137	BXL4605045 118N-1	04/18/2013	03J02	Slaughter HACCP	C	<p>On 04/18/2013, while monitoring Post-Chill Finished Product Standards Task, I found noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 0140 hours, I randomly selected a 10 bird sample from the exit of the Chiller #2 in Plant #1, I found one out of the ten birds with visible fecal contamination inside the bird under the leaf fat area, close to the tail. The fecal material was a smear measuring approximately 1/4" diameter in size, green in color and watery in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6)</p> <p>a of the noncompliance. They immediately started tanking the birds coming out of the Chiller #2. Two tanks were placed under QC red hold tags pending for rework. At approximately 0151 hours Quality Control did a recheck and it passed. The cause of the deviation was the Inside/Outside Bird Washer. This is a violation of the critical limits of CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4905043 218N-1	04/18/2013	04A06	Poultry Finished Product Standards	C	On 04/16/2013 at approximately 2300 hours while monitoring the Plant #2 slaughter functions at startup, I observed the following. Due to disease and contamination the establishment had the line speed on line (b) (6) reduced to 56 bpm (birds per minute) and line (b) (6) was at (b) (6) bpm. The establishment has an automated paw condemnation system that drops the paws automatically when a carcass is condemned at any station. The system does not work properly if the line speed is below (b) (6) bpm and the paws are supposed to be automatically condemned. I went to the paw collection room to verify the process and found that paws were on the collection belt and in an edible product bin. The paws were being collected and not automatically condemned as was USDA understanding of the systems function. I contacted (b) (6) to verify that the process had not changed and that the paws were supposed to be condemned per policy. I proceeded to the paw room and monitored paws that were collected as edible being placed into a U.S.D. A. Condemned barrel. The paws being collected were directed to a condemn barrel until the line speed was increased. This is a loss of process control. My findings indicated a noncompliance with 9 CFR 381.65(a) and 9 CFR 381.78(a).
5309	P6137A	NJN080804 1116N-1	04/16/2013	01D01	SPS Verification	C	While walking through the Food Service department I noticed a blue plastic liner affixed to the glue box of the box sealing machine. I investigated the purpose of this blue plastic liner and found that it was to prevent water, from a leak in the ceiling, from falling onto the finished boxed product conveyor belt. Observing the boxed product flow I determined that this corrective action implemented by the establishment failed to prevent the creation of an insanitary condition and did not protect the boxed product. I observed that water was dripping onto one box and the conveyor, I then took an immediate regulatory control action and retained the conveyor with the application of U.S. retain tag B43303552 at approximately 0236 hours. I informed (b) (6) of the noncompliance. After sanitary conditions were restored the boxed product conveyor was released at approximately 2328 hours 4/16/13.
5308	M6137	BXL1009041 911N-1	04/11/2013	06D02	Other Inspection Requirements	C	On 04/11/2013 while monitoring line functions at the start of the shift at approximately 2300 hours there appeared to be an excessive number of viscera missing from line #2. I waited for mechanics to make startup adjustments to the machines on line #2. At approximately 2322 hours, I performed a standard three minute no viscera check at (b) (4) bpm (birds per minute) on line #2 and found 18 no viscera. At (b) (4) bpm 13 no viscera are allowed. I informed (b) (6) of the failure. At 2355 hours QC personnel performed a recheck of line #2 and got 25 no viscera. The line was slowed to 126 bpm. At 0202 hours a QC recheck failed at 126 bpm with 26 no viscera. At 126 bpm 11 no viscera are allowed. Subsequent checks at 126 bpm failed and the line was kept at 126 bpm for the rest of the shift. This is a loss of process control and failure to take proper corrective action. My findings indicated a noncompliance with 9 CFR 381.76(a) & (b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN281004 2511N-1	04/11/2013	01C02	Operational SSOP Review and Observation	C	<p>I was in the evisceration department at 0758 hours when I noticed an employee dumping a fiber (cardboard) bin of ice into the paw chiller. The wood pallet that the bin was on was not shrink wrapped with plastic. I looked in side the paw chiller and noticed a piece of foreign material imbedded in the ice. (b) (6) retrieved the material which was a wood sliver approximately one and a half inches in length. I informed (b) (6), who then applied a hold tag on the paw chiller. I informed Mr. (b) (6) of the issuance of the non compliance report. The establishment chose to implement corrective actions including emptying the paw chiller to wash and sanitize the inside product contact surfaces. The paws that were in the chiller were put on hold by the establishment, waiting further disposition. There was a similar non compliance issued on 02/05/2013, NR #NJN4816025405N/1 for the same occurrence. The establishment's stated further planned actions for this non compliance: "In order to prevent this situation from reoccurring, plastic bins will be used to ice into the paw chiller. In the event that a fiber bin needs to be used, the pallet will be shrink wrapped prior to placing it on the bin dumper. Training was completed with Evisceration management on both night and day shift." These stated corrective actions to prevent a reoccurrence where not implemented.</p>
5308	M6137	BXL0705045 910N-1	04/10/2013	03J02	Slaughter HACCP	C	<p>On 04/10/2013 at approximately 0229 hours while monitoring the establishments' Operational Sanitation procedures in Packaging, I observed the following. I was checking the birds for UFM (Unidentified Foreign Material) on Line #1 at a point just before the giblets are added back into the carcass before bagging. The third bird that I checked had visible fecal contamination. There was a cloaca and approximately 3 inches of intestine inside the carcass. The intestine was attached at a point approximately 3 inches inside the carcass by a piece of connective tissue near the kidney area. The fecal contamination was dark greenish brown in color, measured approximately 1/2" by 1/8" and was located inside the carcass on the left fat flap. A second piece of fecal material was also located inside the carcass on the left lung which was still intact. The second piece of fecal contamination measured approximately 1/4" by 1/4" and was the same dark greenish brown color. There is no procedure for a fecal failure in Packaging so (b) (6) was called and I showed him the carcass. A review of the establishments' records showed that the plant #1 venter checks for lines 1 & 2 were found to be acceptable for the first half of the shift. However, (b) (6) at 0113 hours found (2) cloaca from the 10 birds sampled during the Finished Product Standards check from line #2. At 0029 hours (b) (6) also found (2) cloaca of the 10 birds sampled and at 107 hours (1) cloaca was found of the 10 birds sampled during the Finished Products Standards checks from line #1. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical; limit of CCP-2B (b) (4) of the Plants' HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN151604 4909N-1	04/09/2013	04A06	Poultry Finished Product Standards	O	<p>I noted the following non compliance during a finished product standards verification check of the establishment's off-line reprocessing process. At 1335 hours I randomly selected ten carcasses from the off line after the final wash cabinet. Two of the ten had visible ingesta material inside the body cavity of the carcass. I stopped the off line and showed these findings to (b) (4) (b) (6) and informed (b) (6). The line was restarted, I then performed the required recheck at 1345 hours. Of the ten carcasses examined for the recheck two carcasses had visible ingesta on the outside of the bird at the crop area. The line was immediately stopped. (b) (6) was once again shown these findings, (b) (6) was informed as was (b) (6). The establishment initiated their written corrective procedures for an off line contamination failure. These procedures included a recheck, marking the chiller with a red net and initiating post chill checks on the affected lot. (b) (6) was informed of the documentation of the non compliance of the regulation cited above as was (b) (6).</p>
5308	M6137	BXL4209040 408N-1	04/08/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 04/08/2013 at approximately 0650 hours while monitoring the establishments Pre-Operational Sanitation procedures in Plant 2, I observed the following. In Area 1, Unit 29, Line 9 in the Bleeding room I observed the Picker Brushes had an accumulation of numerous feathers on both sides of the unit, and on the motor. I immediately informed (b) (6) of the noncompliance. Sanitation rewashed the brushes and motor restoring sanitary conditions. I continued with the Pre-Operational Sanitation procedure and I observed the following at Area 2, Unit 11, the 1/2 of Picker 1, Line 8, closest to the scalding of Line 9. There were several feathers inside the picker, underneath the black rubber fingers. I informed (b) (6), and Sanitation rewashed the Picker, restoring sanitary conditions. My findings indicate a noncompliance with 9CFR 416.13(c), 9CFR 416.14, 9CFR 416.1 and 9CFR 416.4(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN281404 2608N-1	04/08/2013	04A06	Poultry Finished Product Standards	C	<p>On 04/05/2013 and at approximately 1410 hours while performing a Poultry Finished Product Standards verification task I observed the following noncompliance: five carcasses out of my ten carcasses sample that randomly selected, and after Inside Outside washing and before the carcasses entering the chiller, were marked with a split tail for air sac vacuum, two of these carcasses had full kidney and three of them had parts of the kidney not vacuumed. I immediately applied U.S. Retained tag NO B38495185 on the affected carcasses. (b) (6) , was informed of my finding and forthcoming non compliance. Mr. (b) (6) immediately stopped the reprocessing line and tanked off the affected carcasses. At 1418 hours I performed recheck on the reprocessing line, the recheck passed and the line was released. The affected carcasses released to the company for rework and found acceptable by QC technician. The requirements of 9 CFR 381.84, 9 CFR 381.76 and the Plant's written (b) (4) procedure were not met 9 CFR 381.84 which states: (b) (4)</p> <p>(b) (4)</p> <p>(b) (4) 9 CFR 381.76 which states ".....Lesion/ condition subject to removal following an approved cleanout process. Examples: airsacculitis, salpingitis, nephritis, spleen or liver conditions requiring removal of the kidneys" Plant's written (b) (4) procedure document number IX.m dated 8/15/2012. The purpose : (b) (4)</p> <p>(b) (4)</p>
5309	P6137A	NJN250804 1808N-1	04/07/2013	01C02	Operational SSOP Review and Observation	C	<p>When I was standing observing the employees performing the midshift clean up at the north side wall of the Packaging Department by the dumper (unit #28) for the dark meat deboning line, I noticed a cart that contained yellow styrofoam trays, which are product contact surface, that are used to pack finished edible product. The trays were covered with a blue liner to protect them from being over sprayed while the midshfit clean up is performed. Upon a closer inspection, I noticed that the liner was not covering the stacks of trays completely allowing pieces of fat and water from the floor to be over sprayed onto the trays. At approximately 0528 hours I tag the affected trays with retain tag # B43303532. The establishment's SSOP program, Section 2, Packaging & Food Service, states, (b) (4)</p> <p>(b) (4) Because product contact surface was contaminated, the establishment failed to meet the regulatory requirements of sections 416.13(c) and 416.4(a) of the 9 Code of Federal Regulations. (b) (6)</p> <p>(b) (6) were informed of the deficiency and the forthcoming documentation of the noncompliance cited in this document. To restore sanitary conditions the establishment condemned the affected trays at 0533 hours.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN120204 1705N-1	04/05/2013	01B02	Pre-Op SSOP Review and Observation	C	While conducting the Review and Observation component of the Pre-Operational task I noted the following noncompliance. At approximately 2305 hours I inspected the offline bird unloader (Unit #12). The offline bird unloader is located above the south/east portion of the carcass chiller. The product contact surface guide bars that push the product off the shackle and into the carcass chiller was covered in fat pieces and feathers from the previous day's production. Also the large coupling that holds the guide bars in place had a black grime like foreign material built up on it. I showed my findings to (b) (6) and informed him of the noncompliance. With sanitary conditions restored I released the area at approximately 2320 hours. I then went to the Q.C. office and informed (b) (6) of the noncompliance and requested to see the Pre-Op records for the Evisceration department. Unit #12, Offline bird unloader, was inspected and found acceptable by a Q.C. technician at 2228 hours.
5309	P6137A	NJN410604 1105N-1	04/05/2013	04A06	Poultry Finished Product Standards	C	At approximately 0410 hours in the Evisceration department I performed the PHIS Finished Product Standards task at the salvage parts inspection station. The tub of parts I inspected was labeled "drums, B-line, 0315 hours." I checked five random pieces, two pieces had small amounts of yellow and green ingesta. The last drum stick had a large yellow piece of cellulitis exudate between the skin and muscle tissue, approximately 3/4 inch in length and 1/2 inch in width. I retained the tub of drums with U.S. retain tag B43303547 and informed (b) (6) of the noncompliance for the establishment failure to meet 9CFR 381.86. At approximately 0600 hours I reinspected the retained tub of drums and found it acceptable and released it back to (b) (6).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN171204 3404N-1	04/04/2013	03J02	Slaughter HACCP	C	<p>During the Food Safety Assessment (FSA), at the "Live Receiving" step in the "Evisceration" hazard analysis, the establishment identifies "pathogens," with Salmonella provided as an example, as a biological hazard reasonably likely to occur. The justification provided states:(b) (4)</p> <p>The establishment has(b) (4)</p> <p>The establishment indicated that they apply a(b) (4). However, the establishment indicated during the food safety assessment (FSA) that(b) (4). Therefore, the establishment has no antimicrobial intervention in place for the salvaged parts to support the statement at the "Live Receiving" step in the "Evisceration" hazard analysis that "pathogens" will be addressed with "subsequent anti-microbial interventions and processing steps." This is a noncompliance with Title 9 CFR 417.5(a)(1). In addition, whenever a hazard analysis reveals one or more food safety hazards that are reasonably likely to occur, every establishment shall develop and implement a written HACCP plan with critical control points that will eliminate or reduce the food safety hazard to acceptable levels in accordance with Title 9 CFR 417.2(b)(1). The establishment has not identified a point in the process that will eliminate or reduce "pathogens" in salvaged parts to control the hazard identified at the "Live Receiving" step. This is a noncompliance with 417.2(b)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN171204 3404N-2	04/04/2013	03J02	Slaughter HACCP	C	<p>During the Food Safety Assessment (FSA), the EIAO found that the establishment is unable to demonstrate that their (b) (4) HACCP program reflects all current practices and identifies procedures for (b) (4). Specifically, on February 28 and March 6, 2013, the EIAO observed the designated HACCP monitoring employee examine and document the (b) (4) concentration and verification reading (b) (4) from the read out display on the (b) (4) computer system. The establishment's HACCP program does not identify that a verification reading of the (b) (4) will be observed and documented during a monitoring procedure. Additionally, the establishment's HACCP program does not contain written procedures for their automatic (b) (4). Ms. (b) (6) clarified during the food safety assessment that the establishment does not have written procedures on file for their (b) (4). Ms. (b) (6) did provide a document from their (b) (4) manufacturer, (b) (4) which describes the methodology of the (b) (4) system and how the (b) (4) operates. This document was not observed to be referenced anywhere in the establishment's Poultry Slaughter HACCP program. The establishment is required to list all monitoring and verification procedures and frequencies which will be used in accordance with Title 9 CFR 417.4 and support compliance with the critical limits. This is a regulatory noncompliance with Title 9 CFR 417.2(c)(4) and 417.2(c)(7).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN171204 3404N-3	04/04/2013	03J02	Slaughter HACCP	C	<p>During the Food safety Assessment (FSA), the EIAO observed that the establishment is referencing the implementation of their Salmonella Initiative Program (SIP) waiver to support the decisions in the Slaughter hazard analysis that Salmonella is not reasonably likely to occur. (b) (4)</p> <p>The establishment is unable to demonstrate how random sampling will be achieved to cover all lines and all shifts as is necessary to meet the requirements of their Salmonella Initiative Program. During the FSA, the EIAO observed that the carcasses exit the chiller and then plant employees sort and rehang carcasses on the Sizing line or one of the two Segment lines which each run through separate (b) (4) cabinets and then a potable water rinse is applied. The EIAO observed that the establishment collects "post chill" carcass samples only from the Sizing line. The EIAO observed that carcasses from the sizing line appeared different than carcasses from the segment lines in that they did not display torn skin or other damage to the carcass. Furthermore, the establishment is utilizing the "post chill" results obtained only from carcasses on the Sizing line to support decisions made in their "Evisceration" and "Offline Reprocessing" hazard analyses that biological hazards are being reduced or controlled in their poultry slaughter process. The establishment is unable to demonstrate that sampling only one of the three carcass rehang lines, which does not include the potentially higher risk damaged carcasses, is adequate to address biological hazards of concern. The establishment is required to maintain documentation to support decisions made in their hazard analysis. This is a regulatory noncompliance under Title 9 CFR 417.5(a)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN171204 3404N-4	04/04/2013	03J02	Slaughter HACCP	C	<p>During the Food Safety Assessment (FSA) the EIAO observed at the (b) (4)</p> <p>The justification provided states: (b) (4)</p> <p>The EIAO observed in reviewing the establishment's SIP Waiver dated February 7, 2012, that there is no waiver to support the justification that on-going Salmonella verification results will validate that regulatory requirements under Title 9 CFR 416.2(g)(3) have been met. To comply with Title 9 CFR 416.2(g)(3), an establishment must consider the effects of reusing the water in the hazard analysis and support all decisions made regarding this reuse. FSIS expects that an establishment would take measures necessary to ensure that their products are not contaminated. Failure to consider the effects of reusing water within the chill system raises concerns about the adequacy of the hazard analysis. The establishment is unable to support decisions made in their hazard analysis at the "Red Water" steps. This is a regulatory noncompliance under Title 9 CFR 417.5(a)(1).</p>
5309	P6137A	NJN351204 0604N-1	04/04/2013	03B02	Raw Non-Intact HACCP	C	<p>In reviewing the establishment's Raw Ground Chicken hazard analysis during the Food Safety Assessment (FSA), Enforcement Investigations and Analysis Officer (EIAO) found that the hazard analysis identifies "Pathogen Growth (Ex. Salmonella)" as a biological hazard not reasonably likely to occur at the "From Raw Not Ground Fillet Process Flow Chart" step, the "Intra Company Transfers" step, and the "Shipping" step. However, the establishment does not identify any potential biological hazards in the hazard analysis at steps where ground product is being produced (after receiving raw intact product to be ground from the Fillet process and prior to shipping the ground product) in the hazard analysis. It is unclear how the hazard "Pathogen Growth" identified at a previous step is not identified as a potential hazard at subsequent process steps such as "Grinding." The establishment is not able to support that there are no potential biological hazards in the Raw Ground Chicken hazard analysis during the production of ground product. This is a noncompliance with Title 9 CFR 417.2(a)(1) and 417.5(a)(1).</p>
5309	P6137A	NJN431204 5304N-1	04/04/2013	03C02	Raw Intact HACCP	C	<p>During the Food Safety Assessment (FSA), in reviewing the establishment's Raw Not Ground hazard analysis for the Individually Frozen (IF) Chicken products, Enforcement Investigations and Analysis Officer (EIAO) found that hazard analysis identifies "overexposure to (b) (4)" as a chemical hazard. However, the hazard analysis does not specify whether it is reasonably likely to occur or not. Every official establishment shall conduct a hazard analysis to determine the food safety hazards reasonably likely to occur in the production process. This is a noncompliance with Title 9 CFR 417.2(a)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN431204 5304N-2	04/04/2013	03C02	Raw Intact HACCP	C	<p>In reviewing the establishment's Raw Not Ground hazard analysis and flow charts during the FSA, EIAO found that the establishment identifies "allergens" as a chemical hazard not reasonably likely to occur at certain process steps. However, the establishment does not identify "allergens" as a potential chemical hazard at all steps in the hazard analysis where allergenic ingredients are handled or stored. The establishment is not able to support that allergens are not a potential chemical hazard at multiple process steps. For example, the (b) (4) hazard analysis does not identify allergens as a potential chemical hazard at the (b) (4) step, the (b) (4) step, and the (b) (4) step where allergens can be handled. Similarly, the (b) (4) analysis only identifies allergens as a chemical hazard at the (b) (4) step and the (b) (4) step; the hazard analysis does not identify allergens as a potential chemical hazard at the (b) (4) step, (b) (4) step, (b) (4) step, the (b) (4) step, the other (b) (4) step, the (b) (4) step, and the (b) (4) machine/(b) (4) step where allergens can be handled. Additionally, the New Products Room – (b) (4) Line hazard analysis only identifies allergens as a chemical hazard at the (b) (4) step; the hazard analysis does not identify allergens as a potential chemical hazard at the (b) (4) step, (b) (4) step, (b) (4) step, (b) (4) step, and the "Reprocessing" step where allergens can be handled or stored. Furthermore, the New Products Room – IF Chicken hazard analysis only identifies allergens as a chemical hazard at the (b) (4) step, the (b) (4) step, and the (b) (4) step; the hazard analysis does not identify allergens as a potential chemical hazard at the (b) (4) step, the (b) (4) step, the (b) (4) step, the (b) (4) step, and the (b) (4) step where allergens can be handled or stored. The establishment is unable to support that allergens are not a potential chemical hazard of concern in the hazard analysis at all steps where allergens are handled and stored and where there is potential for allergen cross-contamination. This is a noncompliance with Title 9 CFR 417.2(a)(1) and 417.5(a)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN431204 5304N-3	04/04/2013	03C02	Raw Intact HACCP	C	<p>During the Food Safety Assessment, in reviewing the establishment's Raw Not Ground – New Products Room – (b) (4) flow chart EIAO found that there is an (b) (4) " step that does not come from any other step and that leads to the (b) (4) " step, which leads to the (b) (4) " step. EIAO discussed this finding with (b) (6) , who clarified that allergens from storage come from the (b) (4) " step. EIAO found that this product flow described by Ms. (b) (6) is not represented in the flow chart. The flow chart also indicates that allergen ingredients or allergen-containing products can go through the injector. However, EIAO observed during the FSA that allergen ingredients are typically applied on product after the injection process. In addition, in reviewing the Raw Not Ground – Individually Frozen (IF) Chicken flow chart, EIAO found that the process flow indicates that allergens are used in the IF process. For example, at the (b) (4) " step indicates that allergen ingredients are handled at the (b) (4) . However, EIAO did not observe any allergens being handled at the (b) (4) , and (b) (6) clarified that there are no allergens handled at the (b) (4) . She also clarified that allergens are not handled anywhere in the IF area except for the tumbler. She indicated that allergens can be used in the tumbler only if the Marination line's tumbler breaks down. However, the IF Chicken flow chart does not reflect this process. The flow chart shows that the product flow goes from the (b) (4) " step through to the end of the line, indicating that allergens are being tracked throughout the IF line. However, EIAO observed during the FSA that there are no allergens utilized and handled on the IF line. (b) (6) clarified that no allergens are handled anywhere on the IF line. The flow charts for the New Products Room – IF Chicken line and for the New Products Room – (b) (4) line do not accurately reflect the establishment's product flow. This is a noncompliance with Title 9 CFR 417.2(a)(2).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN431204 5304N-4	04/04/2013	03C02	Raw Intact HACCP	C	<p>In reviewing the Raw Not Ground hazard analysis during the Food Safety Assessment (FSA), EIAO found that the hazard analysis reference the (b) (4) HACCP Verification & Validation for Foster Farms Cherry Plant (Est. 6137A), Fresno, CA, dated 12/01/2005, to support the decision that "Pathogen Growth (Ex. Salmonella)" is a biological hazard not reasonably likely to occur at multiple process steps, including the (b) (4) steps. (b) (6) clarified that the establishment is currently utilizing the (b) (4) section of the study to support decisions in the Raw Not Ground hazard analysis. This (b) (4) section of the study references a "Reprocessing Station treatment" was applied. However, the study does not specify what the "treatment" was, what the parameters of the treatment were, and how the treatment was used or applied at the reprocessing station/salvage stations during the study. Therefore, it is unclear how the results of this study are utilized to support the establishment's process and decisions in the hazard analysis. In addition, it is unclear which "Reprocessing Stations" in the establishment that the study is referring to; the study utilizes the terms "salvage stations" and "reprocessing stations" interchangeably, making it unclear whether the "reprocessing stations" in the study are for the establishment's Raw Not Ground process or Slaughter process. This specific information is important in order for the establishment to demonstrate that they are able to achieve the same effect (in bacterial reductions) at the establishment's (b) (4) as the study. During the FSA, Ms. (b) (6) indicated that the establishment does not consider (b) (4). The establishment is not able to support the decision in their Raw Not Ground hazard analysis that "Pathogen Growth (Ex. Salmonella)" is not reasonably likely to occur at multiple process steps, including the (b) (4) steps, using the (b) (4) study on file. This is a noncompliance with Title 9 CFR 417.5(a)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN431204 5304N-5	04/04/2013	03C02	Raw Intact HACCP	C	<p>In reviewing the establishment's Raw Not Ground operations during the Food Safety Assessment, the EIAO found that the establishment is maintaining and implementing a Daily Temperature Summary Standard Operating Procedure (SOP) whose purpose is (b) (4) " as stated in the SOP. The establishment stores raw poultry products in these coolers and freezers. In reviewing the establishment's Raw Not Ground hazard analysis, the EIAO found that the establishment does not identify any potential biological hazards at process steps where the raw products are stored. While the establishment is currently monitoring storage temperatures under the Daily Temperature Summary SOP, it is not referenced in the hazard analysis and the establishment is not able to support that there are no potential biological hazards in the hazard analysis at process steps where the establishment stores raw meat. This is a noncompliance with Title 9 CFR 417.2(a)(1) and 417.5(a)(1).</p>
5309	P6137A	NJN431204 5304N-6	04/04/2013	03C02	Raw Intact HACCP	C	<p>In reviewing the establishments Raw Not Ground – New Products Room – Individually Frozen (IF) Chicken hazard analysis during the Food Safety Assessment, the EIAO found that the establishment identifies no potential hazards at the Injector step and the (b) (4) step in the hazard analysis. However, on 03/11/2013, EIAO discussed these process steps with (b) (6) When they reviewed the Raw Not Ground process, the establishment determined that the injected products might be a higher risk product. Therefore, the establishment implemented the (b) (4) and (b) (4) dip application systems on the IF-2 line. EIAO reviewed the establishment's (b) (4) . EIAO also reviewed the establishment's (b) (4) Based on the Salmonella prevalence prior to the (b) (4) treatment, the establishment is not able to support the decision in the hazard analysis that there are no potential biological hazards at the Injector step and at the (b) (4) step. This is a noncompliance with Title 9 CFR 417.2(a)(1) and 417.5(a)(1). In addition, since the parts that enter the IF Chicken line come from other Raw Not Ground departments in the establishment's facility as indicated in their flow chart, the establishment is not able to support the decisions that Salmonella is not reasonably likely to occur throughout the establishment's Raw Not Ground process. This is a noncompliance with Title 9 CFR 417.5(a)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1118043 602N-1	04/02/2013	06D02	Other Inspection Requirements	C	On 04/02/2013 at approximately 1545 hours while monitoring the "No Viscera Log" for Line #1 in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). At 1238 hours with line speed of (b) (4) BPM, Quality Control failed with 19 no viscera, 13 no viscera are allowed. At 1301 at line speed (b) (4) BPM, the recheck failed with 28 no viscera, the line speed was slowed to 126 BPM. At 1457 hours with line speed of 126 BPM, Quality Control failed with 18 no viscera and 11 no viscera are allowed. Three failures in a half-shift period is a noncompliance for lack of process control. I informed (b) (6) of the noncompliance.
5309	P6137A	NJN490304 4502N-1	04/02/2013	01D01	SPS Verification	C	At approximately 2320 hours I, CSI (b) (7)(C), and CSI (b) (7)(C) observed an insanitary condition while we were walking from the Food Service department to the IQF department. In the hallway that connects the two departments the ventilation fan for the Food Service department was covered in gray debris, the debris had a constancy of a lent like material. The cover of this fan was also covered with the same material and an accumulation of feathers. This exhaust fan is located adjacent to the open entrance to the IQF department. The overhead light for this area also had black mold covering the length of the light cover, and was the width of approximately one inch. Under this overhead light was a pile of product from the previous days production, wet paper towels, and pieces of wood from a broken pallet. The drains in the hallway had old discarded labels and paper towels clogging the drains. In front of the entrance to the staging cooler there was a half chicken carcass, the back and rib cage, covered in black residue that forms from the traffic of palletjacks on the floor of the hallway. I informed (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN190504 1901N-1	03/31/2013	01D01	SPS Verification	C	At approximately 2318 hours five minutes after start up, Food Inspector, (b) (7)(C) called me to her inspection station to inform me that the shackles from A and B line had grease. I informed (b) (6) of the grease on the shackles. Upon closer observation, I noticed that 100% of the shackles had beaded black water and solid black residue spots on the frame of the shackles. All the shackles were contaminated in the same area starting at approximately 6 inches away from the hocks of the carcasses and going up close to the rail. The establishment stopped hanging carcasses until sanitary conditions were restored. Although product was not cross-contaminated and no findings of grease or UFM (unidentified foreign material) during the FPS checks performed by quality control and I, the presence of dirty water and foreign material residue on the shackles created an insanitary condition where product potentially could have gotten adulterated. At approximately 0100 hours sanitary conditions were restored. The finding of foreign material (grease) on the shackles represents a noncompliance with sections 416.1 and 416.4 (a) of the Code of Federal Regulations. (b) (6), was informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.
5309	P6137A	NJN572304 3201N-1	03/31/2013	01D01	SPS Verification	C	While in the Evisceration Department at approximately 0024 hours I observed an insect on the side panel of the offline final wash cabinet. The insect was a large mosquitohawk. The (b) (6) for the offline area killed the insect and we showed it to (b) (6). I then began to inspect the rest of the department to determine if there were anymore insects present. On the wall next to the Inspection station for salvage parts I found a small gray moth and also showed my findings to (b) (6). Then while continuing my inspection I observed feathers and dried blood spots from the previous days production on the wall near the salvage cone station behind USDA station #3 for "A" line. At approximately 0032 hours I informed (b) (6) of the noncompliance for the deficiency stated in this document. (b) (6) was also notified.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN520503 1929N-1	03/29/2013	01D01	SPS Verification	C	<p>While in the Packaging Department at approximately 0250 hours I observed the following noncompliance: An establishment employee moved one large gray combo bin of product, salvaged poultry backs, for mechanically separated poultry away from the product conveyor. Then the employee replaced it with another large gray combo bin with a blue plastic liner that was torn from the top of the bin to the bottom of the bin exposing the inside of the combo bin. Product from the conveyor began to flow as normal into the combo bin and I tagged the bin with U.S. retain tag B43303534. CS (b) (7)(C) went an found establishment (b) (6), as I observed the product flow. (b) (6) stopped the product conveyor and elected to condemn all of the product in the bin. I then informed (b) (6) of the noncompliance.</p> <p>The establishment does not consider the inside of these combo bin a sanitary product contact surface. The establishment uses the blue plastic liners as a product contact surface in these combo bins to maintain sanitary conditions. The ripped blue plastic liner represents a noncompliance with the following regulations: 9 CFR 416.1 which states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." CFR 416.3(a) States: "Equipment and utensils used for processing or otherwise handling edible products or ingredients must be of such material and construction to facilitate thorough cleaning and to ensure that their use will not cause the adulteration of product during processing, handling, or storage. Equipment and utensils must be maintained in sanitary condition so as not adulterate product." CFR 416.4(d) states: "Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishment."</p>
5308	M6137	BXL2514030 728N-1	03/28/2013	01D01	SPS Verification	C	<p>At approximately 1100 hours while performing scheduled Sanitation Performance Standards task in Plant #2, I observed the following noncompliance. While I was walking past the sizing lines I observed heavy beaded condensation on one of the drip pans directly above one of the lines. Upon further investigation I observed heavy beaded condensation on all the drip pans in the area, I also observed the condensation actually dripping between the lines and around two tanks of uncovered product that were staged near the (b) (4) machine. There was no Supervisor in the area so I immediately had a company employee start cleaning the drip pans. I went and found (b) (6) and informed them of the noncompliance. (b) (6) came to the area and I showed him where there was still heavy beaded condensation, he had the employee continue cleaning the drip pans restoring sanitary conditions. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.2(d) and 9CFR 416.4(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5308030 028N-1	03/28/2013	06D02	Other Inspection Requirements	C	On 03/28/2013 at approximately 0400 hours while performing an Other Inspection Requirements procedure in Plant #1, I observed the following. A review of the establishments (b) (4) Lines - No viscera Monitoring Log for the shift revealed that both lines had been slowed due to no viscera failures. Line #1 failed at 0153 hours at (b) (4) bpm (birds per minute) with 17 no viscera. At (b) (4) bpm 13 no viscera are allowed. A recheck at 0223 hours failed with 18 no viscera at which time the line was slowed to 126 bpm. The line failed at 126 bpm at 0336 hours with 17 no viscera. At 126 bpm 11 no viscera are allowed. The line stayed at 126 bpm for the rest on the shift due to repeated failures. Line #2 failed at 2325 hours at (b) (4) bpm with 19 no viscera. At 0003 hours the line again failed with 18 no viscera and the line was slowed to 126 bpm. At 0157 hours at 126 bpm the line failed with 15 no viscera. The only time that line #2 passed was at 0611 hours at 126 bpm, however a subsequent check at (b) (4) bpm failed and the line was returned 126 bpm at 0617 hours. This is a noncompliance due to a loss of process control and a failure to take proper corrective action. My findings indicated a noncompliance with 9 CFR 381.76(a) & (b).
5308	M6137	BXL5608032 828N-1	03/28/2013	01B02	Pre-Op SSOP Review and Observation	C	On 03/27/2013 at approximately 2355 hours while monitoring the establishments' Pre-Operational Sanitation procedures in Packaging Area #1, I observed the following. There were several pieces of fat and tissue to approximately 3" on the brown product belt under leg processor #4. Most of the white rollers associated with the product belts for leg processors 1-6 were coated with white pasty fat. There was one white roller under leg processor #6 that does not turn resulting in the roller having approximately a 1/2" flat spot exposing the inside surfaces of the roller. The inside of the roller was completely filled with fat and tissue that gave off a strong putrid odor. As the roller does not turn this putrid material is in constant contact with the product contact surface of the belt during production. There was black UFM (Unidentified Foreign Material) that appeared to be mold on the stainless support brackets under leg processors 4-6. These stainless brackets are not considered a product contact surface and will be cleaned during the enhanced cleaning conducted on Saturday. Sanitary conditions were restored by approximately 0015 hours. The roller was removed and discarded. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b) and 9 CFR 416.14.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN280303 5728N-1	03/27/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>When I was at the Packaging department performing the Review and Observation component of a Pre-operational Sanitation PHIS task I observed the following noncompliances: At Section C: Segment Line & Multivac, I observed specks and pieces of fat, from the previous day's production, scattered on the product contact surfaces of the (b) (4) hoppers (Unit #26). The pieces of fat had an approximate measurement of 1mm to 5 mm in diameter. At approximately 0040 hours I took regulatory control of the unit with retain tag #B303503. At Section A: Marination line, I observed in the interior side of the lower part of the Incline Conveyor Out of Hopper (Unit #7) pieces of fat, with an approximate measurement of 5mm, from the previous day's production and residue from spice ingredients, reddish in color, that are used to marinate the product that is processed in this units. I tagged the unit with retain tag #B303508. At section B: Dark Meat Deboning, I noticed that the Portable Incline Transfer Conveyor (Unit #5) had the same reddish residue of marinated mixture covering an area approximately 4 inches long and 1 inch wide on one of the conveyor's belt hard white plastic guide bars, Upon a closer look I noticed the entire conveyor had specks of spice mixture along the two guide bars and in the inner side of the conveyor. I showed the deficiencies to (b) (6). I tagged the unit with retain tag #B303508. At 0055 hours after the establishment restored sanitary conditions, the affected units were released to production. The finding of pieces of fat and spice mixture on product contact surfaces represents a failure to meet the regulatory requirements of sections 416.4(a) and 416.13(c) of the Code of Federal Regulations. Mr. (b) (6), was informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>
5308	M6137	BXL1604032 326N-1	03/26/2013	03J04	Poultry Zero Tolerance Verification	C	<p>While performing Zero Tolerance Fecal Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). On 03/26/2013 at approximately 0123 hours, (b) (6) randomly removed a 10 bird sample from Line # (b) (4) in Plant #2, I found one out of the ten birds with visible fecal contamination inside the bird located at the left side below the kidneys. The fecal material was a spot measuring approximately 3/16" diameter in size, brownish green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control could not performed a recheck due to completion of organic birds at approximately 0142 hours. The cause of the deviation was the (b) (4) bird washer. Quality Control doubled their procedures at the Post-Chill to ensure the product was in compliance. Post-Chill checks were performed from 0237 hours to 0322 hours. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1916031 626N-1	03/26/2013	03J04	Poultry Zero Tolerance Verification	C	At approximately 1230 hours while performing a Zero Tolerance fecal check on line 2 of plant 1, I found one out of the 10 birds contaminated with feces. The fecal material was located inside of the carcass, on the right side near the tail. It was greenish brown in color and pasty in texture measuring approximately 1/4" in diameter. This exceeded the limit of Zero Tolerance for the process to be in control. I immediately notified (b) (6) of the noncompliance. The protocol for Fecal Failure was implemented. A Quality Control recheck passed at 1256 hours. Post chill checks were performed on the suspect lot from 1308 hours to 1431 hours. All product exiting chiller 2 was found acceptable. My findings indicate a noncompliance with 9 CFR 381.65(e) and 9CFR 417.2(c)(4), and the critical limit of CCP-2B, (b) (4) of the plant's HACCP Plan for Slaughter.
5308	M6137	BXL2303033 026N-1	03/26/2013	01B02	Pre-Op SSOP Review and Observation	C	On 03/25/2013 at approximately 2347 hours while monitoring the establishments' Pre-Operational Sanitation Procedures in Packaging Area #1, I observed the following. There was dried and semi-dried fat and tissue residue on the stainless portions of the overhead wing and breast fillet conveyor belts that transfer product from the (b) (4) Deboning Room to Packaging. The residue was up to approximately 1/16" thick and to approximately 2" high on the stainless portion above the product belt. The length of the two breast belts with the residue measured approximately 50 feet. The two wing belts are approximately 80 feet long. The belts were cleaned with a green pad and potable water then treated with an antimicrobial and a potable water rinse restoring sanitary conditions by approximately 0025 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c) and 9 CFR 416.14.
5308	M6137	BXL4905034 223N-1	03/23/2013	06D02	Other Inspection Requirements	C	On 03/23/2013 while performing "No Viscera" checks in Plant #1, Line 1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). At 0203 hours, I documented 19 no viscera and only 13 are allowed at line speed of (b) (4) BPM. I informed (b) (6) of the failure. After lunch at 0330 hours I performed a recheck and failed with 16 no viscera and only 13 no viscera are allowed. I informed (b) (6) of the failure. The line speed was reduced to 126 BPM. At 0408 hours Quality Control performed a no viscera check and failed with 17 no viscera and only 11 no viscera are allowed at the line speed of 126 BPM. I informed (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1418034 622N-1	03/22/2013	06D02	Other Inspection Requirements	C	At approximately 1539 hours while performing "No Viscera" Checks for Line #1 and Line #2 in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). Line #2 had five failures documented by Quality Control. 1.- At 0816 hours at line speed of (b) (4) BPM, 18 no viscera and only 13 no viscera are allowed. 2.- At 0846 hours at line speed of (b) (4) BPM, recheck failed with 19 no viscera. Line speed slowed down to 126 BPM. 3.- At 1009 hours at line speed of 126 BPM, 16 no viscera and only 11 no viscera are allowed. 4.- At 1246 hours at line speed of 126 BPM, 20 no viscera, only 11 no viscera are allowed. 5.- At 1503 hours at line speed of 126 BPM, 15 no viscera, only 11 no viscera are allowed. Three failures in a half -shift period is a noncompliance for lack of process control. I informed (b) (6) of the noncompliance.
5308	M6137	BXL1709034 622N-1	03/22/2013	04A06	Poultry Finished Product Standards	C	On 03/22/2013 at approximately 0503 hours while conducting the weekly Finished Products Standards check on Reprocessing Line (b) (4) I observed the following. After taking a random 10 bird sample from a point on the line after the final house inspector, I observed two birds wit untrimmed Inflammatory Process (cellulitis) and one bird with a large gall stain on the inside of the carcass. At this point the process is judged to be out of control. All three birds were marked with a slash on the back which according to the establishments' marking system indicates that the bird needs trimming or salvaging. I informed (b) (6) of the failure. The line was running at a slow speed and less then half the shackles were full. The end of the line house inspector was changed which was the only corrective action taken. A QC recheck passed at 0511 hours. My findings indicated a noncompliance with 9 CFR 381.76(b).
5308	M6137	BXL4811035 122N-1	03/22/2013	03J02	Slaughter HACCP	C	At approximately 0800 hours while performing Pre-Chill Finished Products Standards Task in Plant #2, on Line (b) (4) I observed the following noncompliance. I randomly selected a 10 bird sample from Line (b) (4) and found one of the ten birds with visible fecal contamination. The fecal material was located on the back of the tail near the oil gland and measured approximately 1/4" x 1/16" in size, it was brownish green in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. I immediately informed (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at 0826 hours and it passed. All Post Chill rechecks performed between 0919 hours and 1004 hours also passed. The cause of the deviation was the (b) (4) sprayers being out of adjustment. This is a deviation from the critical limits of CCP-2B (b) (4) of the Plant's HACCP Plan for slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1116031 120N-1	03/20/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0918 hours I was walking to Chiller #1 in Plant #1 to performed a Post-Chill Finished Product Standards Task. I observed at the rehang area a stainless steal tank under the (b) (4) cabinet. The tank was staged there for dumping onto the rehang tables. The tank was uncovered and full of whole body birds. I saw one bird with numerous black specks (Unidentified Foreing Material), I inspected several more birds and found UFM material on them. I immediately tagged the tank # N-18 with U.S. Rejected/Retained Tag # B31 407930 and Informed (b) (6) of my findings (b) (6) called (b) (6) (b) (6) took the tank to the Rehang area in Plant #2. Two employees began to reworked the product, I reinspected several birds that had been reworked and they were acceptable. Since Quality Control was monitoring the reworking of the product, I released the retain tank of product to Quality Control at approximately 0947 hours. I removed U.S. Retained/Rejected Tag and Quality Control placed a red hold tag to the tank. Quality Control reinspected and released the product back to production at approximately 1030 hours. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.4 (d).</p>
5308	M6137	BXL2317035 320N-1	03/20/2013	03J02	Slaughter HACCP	C	<p>At approximately 1222 hours while performing Pre-Chill Finished Products Standards Task in Plant #2 on Line (b) (4), I observed the following noncompliance. I randomly selected a 10 bird sample from Line # (b) (4) and found one of the ten birds with visible fecal contamination. The fecal material was located on the back of the tail near the oil gland and measured approximately 1/4" x 1/8" in size, it was brownish green in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. I immediately informed (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at 1248 hours and it passed. The cause of the deviation was the bird turner not turning the birds properly and line (b) (4) was moved to Line # (b) (4) so that the bird turner could be replaced. All Post Chill rechecks performed between 1355 hours and 1425 hours passed. This is a violation of the critical limits of CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2808033 620N-1	03/20/2013	06D02	Other Inspection Requirements	C	On 03/20/13 at approximately 0450 hours while monitoring the "No Viscera Log" for Line #1 and Line #2 in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). On Line #1 at 2324 hours with line speed of (b) (4) BPM, Quality Control failed with 25 no viscera, 13 no viscera are allowed. At 2354 at line speed (b) (4) BPM, the recheck failed with 18 no viscera ,the line speed was slowed to 126 BPM. At 0138 hours with line speed of 126 BPM, 19 no viscera and 11 no viscera are allowed. On Line # 2 at 2320 hours with line speed of (b) (4) BPM, Quality Control failed with 35 no viscera and 13 no viscera are allowed. At 2359 hours at line speed of (b) (4) BPM, the recheck failed with 23 no viscera and the line speed was slowed to 126 BPM. At 0143 hours with line speed of 126 BPM, 21 no viscera and 11 no viscera are allowed. Three failures in a half-shift period is a noncompliance for lack of process control. I informed (b) (6) of the noncompliance.
5308	M6137	BXL0608035 619N-1	03/19/2013	06D02	Other Inspection Requirements	C	At approximately 0550 hours while monitoring the "No Viscera Log" for Line #1 and Line #2 in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). Line # 1 had three failures documented by Quality Control. At 2330 hours at line speed of (b) (4) BPM, 19 no viscera and only 13 no viscera are allowed. At 0008 hours at line speed (b) (4) BPM, recheck failed with 24 no viscera. The line speed was slowed down to 126 BPM and at 0140 hours Quality Control failed with 23 no viscera, 11 no viscera are allowed. On Line #2 at 2335 hours at line speed of (b) (4) BPM, 32 no viscera and only 13 no viscera are allowed. At 0018 hours at line speed (b) (4) BPM, recheck failed with 31 no viscera. The line speed was slowed to 126 BPM and at 0148 hours Quality Control failed with 25 no viscera and only 11 no viscera are allowed. Three failures in a half-shift period is a noncompliance for lack of process control. I informed (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5504031 916N-1	03/16/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 03/15/2013 at approximately 2330 hours while monitoring the establishments' Pre-Operational Sanitation procedures in the Plant #1 hanging area of Packaging, I observed the following. There were numerous black specks of UFM (Unidentified Foreign Material) in a puddle of water in the center of the drip pan approximately 10' from the (b) (4) spray cabinet for line #1 & 2. There were also numerous pieces of dried and semi-dried fat and tissue to approximately 1/16" along the entire length of the same drip pan that measure approximately 4' by 45'. There was also a heavy layer of dried and semi dried fat and tissue to approximately 1/8" along the drip pan associated with the (b) (4) spray cabinet for lines (b) (4). The drip pans are approximately 4' by 30'. (b) (6) said that drip pans are cleaned during the enhanced cleaning that is performed on (b) (4). He was informed that the drip trays were product contact surfaces as they drained back into the (b) (4) cabinets and needed to be cleaned before startup. The area was cleaned, sanitized and released by approximately 0008 hours. At approximately 2340 hours in the Plant #2 hanging area of Packaging there were several pieces of black UFM (Unidentified Foreign Material) with the consistency of rail dust on the drip pans and in the (b) (4) spray cabinet for lines #1 & 2. The drip pans are approximately 20" by 15' long. There was a layer of dried and semi-dried fat and tissue to approximately 1/8" on the drip pans for line 3 & 4. The drip pans are approximately 20" by 6'. There was a brown film on the interior sides and bottom surfaces of the (b) (4) spray cabinet for line (b) (4). There was a 10" adjustable wrench in the bottom of the same spray cabinet that was severely rusted. The drip pans for the cabinet for Line (b) (4) was covered with a layer of brown film and numerous pieces of fat to 1/8". The drip pans are approximately 20" by 8'. The plant#2 (b) (4) unit was already filled and ready for use. The cleaning on the spray cabinets and drip pans drain into the unit so the tank was dumped and the unit was rinsed with (b) (4). (b) (6) asked so I showed him that just the portions of the drip pans that drain back into the (b) (4) spray cabinets needed to be cleaned daily. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c) and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE160903 1815N-1	03/15/2013	03J02	Slaughter HACCP	C	<p>. On 3/15/13 at approximately 0446 hours , I observed the following noncompliance while performing a finished Product Standard Task on the North Chiller (Post Chill) . After selecting a ten bird random sample I observed one out of ten with an attached cloaca with a 2" – 3" portion of intestine . The fecal material was approximately 1 cm by 1 cm in size , watery in texture and geeenish - brown in color flowing from the cloaca . I immediately notified (b) (6) who was standing nearby . (b) (6) contacted (b) (6) who initiated the establishment's fecal failure protocol . The establishment's rechecks passed at approximately 0507 hours putting the establishment back in compliance . My findings indicate a noncompliance with regulations 9CFR 381.65(e) which states that "carcasses contaminated with visible fecal material shall be prevented from entering the chiller tank " and 9CFR 417.2(c)4 , The criteria for CCP-1B were also compromised .</p>
5308	M6137	BXL2009034 714N-1	03/14/2013	03J02	Slaughter HACCP	C	<p>On 03/14/2013 at approximately 0610 hours while performing a Pre-Chill Finished Product Standards check on Line #1 in Plant #1, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. There was a cloacae with approximately 5" of intestine inside the bird. The intestine was attached to the carcass at a point approximately 2" inside the carcass by a piece of connective tissue. The entire intestine was a dark gray color. There was fecal material visible at both the cloacae end and at the cut end of the intestine. The fecal material had leaked from the cut end of the intestine inside the carcass into a crease at the end of the fat flap near the kidneys on the left side. The fecal material was dark brown in color, pasty in texture and measured approximately 1/4" by 1/8" in size. This exceeded the zero tolerance for the process to be in control. I contacted (b) (6) and showed him my findings. The protocol for fecal failure was implemented. A QC recheck passed at 0633 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP 2B (b) (4) of the Plants' HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN271803 3913N-1	03/13/2013	01C02	Operational SSOP Review and Observation	C	At 1548 hrs. I observed the following non compliance in the food service area during bulk drumstick packing. The employee assigned to work the scale was handling the outside of the cardboard fiber boxes. When a box was under weight the employee proceed to handle product (drumsticks) to add to the box. He would then physically move the box down the line and continue to weigh the next box. The employee was not sanitizing his gloves after coming into contact with the outside of the box, a non food contact surface, before returning to handle product. At this time the employees in the area went on a break. I informed (b) (6) of the issuance of the non compliance report. I retained the pallet of cases that had already been packed, 27 cases in total, with U.S. retain tag #B39415846. The establishment's corrective actions included placing a tub of sanitizer solution in close proximity to the scale operator and sending the affected cases of product to their rework procedure. After the product was reworked per the establishment's procedures I removed the retain tag at 1731 hrs. returning the product to control of the establishment.
5308	M6137	BXL0418035 108N-1	03/08/2013	06D02	Other Inspection Requirements	C	At approximately 1500 hours while monitoring the "No Viscera Log" for Line #1 and Line #2 in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). Line #1 had three failures documented by Quality Control. 1.- At 0817 hours at line speed of (b) (4) BPM, 21 no viscera and only 13 no viscera are allowed. 2.- At 0843 hours at line speed of (b) (4) BPM, recheck failed with 28 no viscera. Line speed slowed down to 126 BPM. At 1003 hours Quality Control did a regular check and passed at line speed of 126 BPM with 11 no viscera and 11 no viscera are allowed, line speed increased to (b) (4) BPM. 3.- At 1008 hours at line speed of (b) (4) BPM, 20 no viscera and only 11 no viscera are allowed the line slowed down to 126 BPM. Three failures in a half-shift period is a noncompliance for lack of process control. I informed (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1007031 008N-1	03/08/2013	03J02	Slaughter HACCP	C	<p>On 03/08/2013 at approximately 0046 hours while monitoring the establishments' Operational Sanitation procedures in Packaging, I observed the following. I was checking the birds for UFM (Unidentified Foreign Material) on Line 919 just prior to the point where the giblets are added to the carcass prior to bagging. The fourth bird that I checked had a cloacae attached inside the carcass at the tail with approximately 4" of intestine. There was fecal material on the right side leaf fat. The fecal material was dark brown in color, pasty in texture and measured approximately 1/2" by 1/4" in size. As there are no procedures for a packaging department fecal failure, I had th (b) (6) called. I showed them my findings. A review of the establishments' computer records for the shift shows that Line #1 venting machine failed QC checks for 'improper venting' at 2345 hours, 0036 hours, 0118 hours and 0207 hours with a note 'Informed Production Supervisor'. My findings indicate a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP 2B (b) (4) of the Plants' HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN310503 2508N-1	03/08/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>I was conducting the Review and Observation component of Pre-Operational Sanitation in area #3 the Mechanically Separated Poultry department when I noted the following noncompliance. I inspected unit #11, the (b) (4) Pump (east), including all of the stainless parts associated with the pump. I found inside both of the stainless steel cork screw augers that the black rubber gaskets had a poultry paste like substance from the previous day's production on them. I then retained the augers with U.S. retain tag B43303518 at 0023 hours and informed (b) (6) of the noncompliance. At approximately 0035 hours I reinspected the augers and verified that sanitary conditions were restored and released the area and equipment. In the Food Service Department I continued the Pre-Operational task and inspected area #4 unit #5 Injector and needles. I requested to see the inside of the injector and (b) (6) opened it. I observed inside the injector a white in color watery in texture fat residue covering the motor, hoses and inside surfaces of the injector. I also saw that the gray rubber seal of the injector door was in poor condition. It was covered with black mold and held together with glue at the seams that had come apart (b) (6). (b) (6) was notified of the noncompliance. I retained the injector with U.S. retain tag B43303517 at approximately 0040 hours. At approximately 0115 hours I reinspected the injector, the establishment chose to remove the entire gray rubber seal to eliminate the presence of mold, and the Sanitation department in my presence resanitized the inside and outside of the injector. With sanitary conditions restored I released the injector at 0120 hours. After my inspection was complete I went to the Q.C. office to inform the lead (b) (6) of the noncompliance and too review the Q.C. documents of the nights Pre-Operational Inspection performed by Quality Control. Pre-Op was conducted in the Mechanically Separated Poultry Department unit #11 (b) (4) Pump A east) and was found acceptable by the Q.C. tech at 2346 hours. The establishment's SSOP program states in Part 1 Pre-operational Sanitation/Daily, Section 4 Further Processing (b) (4).</p> <p>(b) (6). This failure represents a noncompliance as per the regulatory requirements of sections 416.1, 416.4(b) and 416.13 (c) of the Federal Code of Regulations. The presence of mold, fat residues and particles on non-food contact surfaces represents a noncompliance with Section 9 CFR 416.1 states, "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." Section 9 CFR 416.4(b) states, "Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." Section 9 CFR 416.13 (c) states, "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's".</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE490703 2108N-1	03/08/2013	04A06	Poultry Finished Product Standards	C	<p>On Thursday 03/07/2013 night shift there was a high percentage of birds presented for post-mortem inspection that were identified by the on line inspectors for airsacculitis removal. The establishment had initiated their alternative (b) (4) procedure. At 0212 hours I elected to verify the effectiveness of the alternative procedure. I went to the FPS Pre-Chill Station on line 1 and collected a ten (split tail) bird sample. One of the ten birds had a horizontal slash across the back with a split tail; the carcass had cellulitis in the left flap of the leaf fat area. According to Document Number: E-14, (b) (4) [REDACTED].</p> <p>[REDACTED]. The finding of this bird at the FPS station is a failure to follow the establishments written procedures (b) (4) [REDACTED]. Also the establishment's failure to prevent cellulitis from entering the chill system. QC performed a ten bird retest, there were no further findings on the retest. I notified (b) (6) [REDACTED] of the forthcoming documentation for the failure to comply with the regulations cited above.</p>
5333	P7632	HYE581603 4408N-1	03/08/2013	04A06	Poultry Finished Product Standards	C	<p>I was performing a finished product standards verification task on the reprocessing line in the evisceration department at 1215 hours. I selected ten carcasses marked with a horizontal slash across the back for cellulitis salvage. Two of the ten carcasses in the sample had cellulitis lesions on the leg quarters. I showed (b) (6) [REDACTED]. Then she performed the required recheck of ten cellulitis carcasses and the recheck was found acceptable at 1222. I informed day shift (b) (6) [REDACTED] of the failure to meet the regulatory requirement cited above. In addition 9 CFR 381.86 states any organs or other parts of carcasses which is affected by inflammatory process shall be condemned.</p>
5308	M6137	BXL1409033 007N-1	03/07/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 03/07/2013 at approximately 0550 hours while performing a Zero Tolerance fecal check on Line (b) (4) [REDACTED] in Plant #2, I observed the following. After the line supervisor took a 10 bird random sample, I observed one bird with visible fecal contamination. The fecal material was a smear measuring approximately 1/2" by 1" in size, olive green in color and pasty in texture. The fecal material was located inside the carcass on the left side under the leaf fat on the thigh. This exceeded the Zero Tolerance for the process to be in control. I showed (b) (6) [REDACTED] my finding. The protocol for fecal failure was implemented. A QC recheck at 0619 hours passed. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP-2B (b) (4) [REDACTED] of the Plants' HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1609035 707N-1	03/07/2013	04A06	Poultry Finished Product Standards	C	On 03/07/2013 at approximately 0401 hours after performing a Pre-Chill Finished Product Standards check on line (b) (6) in Plant #2, I observed the following. While entering my findings from the check onto the establishments' logs there was an entry made by (b) (6) at 0332 hours of 32 points indicating that the line had failed. 9 CFR 376.76(b) states that "If all the past 5 prechill subgroups are at or below the start number, the establishment shall 'immediately' conduct a retest..." Instead of performing a recheck 'immediately' (b) (6) performed a check on Line (b) (6) that passed at 339 hours. I went to the QC Supervisors office but no one was there. I went back to Plant #2 and contacted (b) (6) who had a radio and asked her to contact the QC Supervisor and inform her that line (b) (6) had failed and that no recheck had been performed. I returned later and reviewed the log with (b) (6) to show her that a recheck was not performed until 0412 hours and that a noncompliance would be written for the recheck not being performed 'immediately'. My findings indicated a noncompliance with 9 CFR 381.76(b)(iv)(d)(2)(i).
5308	M6137	BXL4018030 407N-1	03/07/2013	06D02	Other Inspection Requirements	C	At approximately 1535 hours while monitoring the "No Viscera Log" for Line #1 and Line #2 in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). Line #1 had three consecutive failures documented by Quality Control. 1.- At 1237 hours at line speed of (b) (4) BPM, 20 no viscera and only 13 no viscera are allowed. 2.- At 1306 hours at line speed of (b) (4) BPM, 30 no viscera and only 13 no viscera are allowed. Recheck failed and the line speed slowed down to 126 BPM. 3.- At 1456 hours at line speed of 120 BPM, 15 no viscera and only 11 no viscera are allowed. Three consecutive failures in a half-shift period is a noncompliance for lack of process control. The line speed remained at 126 BPM the rest of the shift. (b) (6) was informed about the noncompliance.
5308	M6137	BXL0818031 406N-1	03/06/2013	03J02	Slaughter HACCP	C	At approximately 1330 hours while performing a HACCP Slaughter Record Review Task, I observed the following; Quality Control or designee documented on the HACCP Monitoring Log CCP-2B (b) (4) (Plant #2) dated on 03/06/2013 PM shift, Direct Observation on Line # (b) (6) at 0744 hours. The time enter on verification activities (Direct Observation) did not corresponded with any of the monitor procedure entries. Records Review for that CCP-2B (b) (4) was performed by Quality Control or designee at 1306 hours. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 417.5 (a)(3) and 9CFR 417.5 (b). I notified (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5415032 706N-1	03/06/2013	03J02	Slaughter HACCP	C	<p>While performing Pre-Chill Finished Products Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 0800 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out of the ten birds with visible fecal contamination inside the bird on the right side under the leaf fat area (no fat attached). The fecal material was a piece measuring approximately 1/4" wide and 3/8" long in size, green olive in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 0834 hours and it passed. The cause of the deviation was the water sprayers plugged. This is a violation of the critical limits of CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN130303 0105N-1	03/05/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>I was conducting the Review and Observation component of Pre-Operational Sanitation in area #1 of the Evisceration department when I noted the following noncompliance. I inspected unit #6, the paw incline conveyor, I found a flakey white residue built up on the paw conveyor. I then retained the conveyor with U.S. retain tag B39415840 at 2242 hours and informed (b) (6) of the noncompliance. At approximately 2304 hours I reinspected the conveyor and verified that sanitary conditions were restored. In the Packaging Department I continued the Pre-Operational task and inspected area #2 unit #22 East/West product conveyor to (b) (4). I requested (b) (6) to turn over the product conveyor so I could observe the under side of the conveyor. I observed on that surface fat and meat particles from the previous day's production as well as a bio film residue, yellow and greenish in color the length of the conveyor. I applied U.S. retain tag B39415839 to the conveyor at 0033 hours and informed (b) (6) of the forthcoming noncompliance. At approximately 0054 hours I reinspected the product conveyor and verified sanitary conditions were restored. After my inspection was complete I went to the Q.C. office to inform the (b) (6) of the noncompliance and too review the Q.C. documents of the nights Pre-Operational Inspection performed by Quality Control. Pre-Op was conducted in the Evisceration Department area #1 unit #6 and found acceptable by Q.C. tech at 2219 hours. Pre-Op was also conducted in the Packaging Department in area #2 unit #22 the East/West product conveyor to (b) (4) at 0006 hours and found acceptable by Q.C. tech. The establishment's SSOP program states in Part 1 Pre-operational Sanitation/Daily, Section 3 Packaging (b) (4) ". This failure represents a noncompliance as per the regulatory requirements of sections 416.4 (a), 416.4(b) and 416.13 (c) of the Federal Code of Regulations. The presence of fat and meat particles on a food contact surface represents a noncompliance with Section 9 CFR 416.4(a) which states, "All food-contact surfaces, including food contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". Section 9 CFR 416.4(b) states, "Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." Section 9 CFR 416.13 (c) states, "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's".</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE360003 0705N-1	03/05/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 3/4/13 at approximately 2208 hours I observed the following noncompliance while performing the SSOP Pre-Op Review and Observation Task . While inspecting Unit # 40 of area II (the Neck and Giblet chiller) I observed the following . There was a white build-up of grease on the upper rim of the bottom hopper and there was also a support bracket approximately 3" – 4" in width and approximately 1' -15" in length covered with fragments of liver product . I immediately informed (b) (6) of the non-compliance . Retained/Rejected tag B38-495466 was applied . (b) (6) instructed a member of the clean-up crew to scrub and rinse the affected areas . A recheck was performed at approximately 2214 hours . The Neck and Giblet chiller was found to be in sanitary condition and the area was released and resanitized , putting the establishment back in compliance and ready for production . At 2216 hours unit #10 of area II was inspected (Line # 1 Salvage Station) . While inspecting the knife holder in the area I observed fat and meat particles in the plastic insert , as well as black unidentified foreign fiber material in the corners of the metal bracket that holds the plastic insert . U.S. REJECTED/RETAINED tag B38-495465 was applied to the area and (b) (6) was once again notified (b) (6) instructed a member of his crew to remove the plastic insert and rinse it with a high pressure nozzle and the bracket was hand scrubbed and rinsed on the inside . A recheck was performed at approximately 2222 hours . The area was found to be in sanitary condition putting the establishment back in compliance and ready for production . The contamination of product contact surfaces are violations of the following regulations 9CFR 416.1 , 9CFR 416.4(a) , 9CFR 416.4 (d) ,9CFR 416.13(a) , 9CFR 416.14 and 9CFR 416.13 .</p>
5308	M6137	BXL1518030 604N-1	03/04/2013	06D02	Other Inspection Requirements	C	<p>At approximately 1330 hours while monitoring the "No Viscera Log" for Line #1 and Line #2 in Plant#1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). Line #1 had 4 consecutive failures by Quality Control. At 0818 al line speed of 111 BPM, Quality Control documented 16 no viscera, only 10 are allowed. At 0846 hours at line speed of (b) (4) BPM the check failed with 20 no viscera only 11 are allowed. At 1010 hours at line speed of (b) (4) BPM the check failed with 17 no viscera, only 11 are allowed. At 1304 hours the check failed with 18 no viscera at the same line speed of (b) (4) BPM. Three consecutive failures in a half-shift period is a noncompliance for lack of process control. I informed (b) (6) of the noncompliance. The line speed remained at (b) (4) BPM the rest of the shift.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4405030 602N-1	03/02/2013	01C02	Operational SSOP Review and Observation	C	<p>On 03/02/2013 at approximately 0019 hours while monitoring the Establishments' Post-Chill Finished Product Standards for Chiller #2, I observed the following. After taking a random 10 bird sample, I observed on bird with a shiny metal flake on the left side of the carcass on the connective tissue associated with the cut skin near the neck area. (b) (6) was there taking temperatures so I showed her the carcass. I then took the carcass to the Pre-Chill Finished Product Standards table and called (b) (6). At approximately 0158 hours while performing a Pre-Chill Finished Product Standards check on Line #1, I observed the following. After taking a standard 10 bird random sample, I found one bird with a shiny metal flake on the exterior left side of the carcass on the breast near where the wing is attached. The carcass was mutilated. A second shiny metal flake was found inside the skin on the right side of the breast near the wing. The wing had been removed. I again showed the bird to (b) (6). The metal flakes were of similar size approximately 1mm by 1/2mm. Although the metal flakes were not large enough to be a Health Hazard, metal is still a contaminant. The Establishments SSOP for Operational Sanitation: Daily Procedures under Corrective Action states under (b) (4)</p> <p>" My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), and 9 CFR 416.14.</p>
5308	M6137	BXL5617031 501N-1	03/01/2013	06D02	Other Inspection Requirements	C	<p>On 03/01/2013, The (b) (4) No Viscera log in plant one, lines 1, reflected 5 consecutive failures during the production day. Two checks failed at (b) (4) birds per minute, which allows 13 nonconformances and four checks failed at line speed of 126 BPM, which allows 11 nonconformances. The viscera checks that were performed at 126 BPM did not meet the required standards; however, the line speed remained at 126 BPM. This scenario reflects a lack of control in the process. Line 1 At 0818 hours, failed with 32 nonconformances at line speed of (b) (4) BPM (13 nonconformances are allowed) At 0847 hours, the recheck failed with 32 nonconformances at line speed of (b) (4) BPM. Line speed was slowed down to 126 BPM. At 1019 hours, failed with 21 nonconformances at line speed of 126 BPM (11 nonconformances are allowed). At 1300 hours, failed with 25 nonconformances at line speed of 126 BPM. At 1500 hours, failed with 15 nonconformances at line speed of 126 at line speed of 126 BPM This is a noncompliance with regulatory requirement of regulation 9 CFR 381.76. (b) (6) was notified of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2817024 828N-1	02/28/2013	06D02	Other Inspection Requirements	C	On 02/28/2013, The (b) (4) No Viscera log in plant one, lines 1, reflected 5 consecutive failures during the production day. Two checks failed at (b) (4) birds per minute, which allows 13 nonconformances and three checks failed at line speed of 126 BPM, which allows 11 nonconformances. The viscera checks that were performed at 126 BPM did not meet the required standards; however, the line speed remained at 126 BPM. This scenario reflects a lack of control in the process. Line 1 At 0815 hours, failed with 17 nonconformances at line speed of (b) (4) BPM (13 nonconformances are allowed) At 0847 hours, the recheck failed with 32 nonconformances at line speed of (b) (4) BPM. Line speed was slowed down to 126 BPM. At 1018 hours, failed with 24 nonconformances at line speed of 126 BPM (11 nonconformances are allowed). At 1238 hours, failed with 24 nonconformances at line speed of 126 BPM. At 1458 hours, failed with 17 nonconformances at line speed of 126 BPM. This is a noncompliance with regulatory requirement of regulation 9 CFR 381.76. (b) (6) was notified of the noncompliance.
5308	M6137	BXL2913023 827N-1	02/27/2013	06D02	Other Inspection Requirements	C	At approximately 0834 hours, I performed a presentation check on Line "(b) (4)" at line speed of (b) (4) BPM (birds per minute). Station #1 had (4) viscera on shackle, (2) not reflected and (2) parts inside, total of 38 points. Station #2 had (2) viscera on shackle, (1) no viscera and (1) not reflected, total of 38 points. Station #3 had (1) viscera on shackle, (2) not reflected and (1) parts inside, total of 13 points. Station #1 failed with 38 points, this exceed the limit of 25-39 points and (3) occurrences of one error, Station #2 also failed with 38 points. Quality Control performed a recheck at approximately 0848 hours and Station #2 failed with (3) viscera on shackle. This exceed the limit of (2) occurrences of one error for the process to be in control. (b) (6) was informed and line speed was reduced to 81 BPM. At approximately 0909 hours all rechecks passed, bringing the process back in control. At approximately 0840 hours, I performed a presentation check on Line "(b) (4)" at line speed of (b) (4) BPM (birds per minute). Station #1 had (1) viscera on shackle, (1) not reflected and (1) contamination inside the bird, total of 16 points. Station #2 had (1) not reflected and (3) parts inside, total of 5 points. Station #3 had (1) viscera on shackle, (1) not reflected and (2) parts inside, total of 12 points. Station #2 failed with (3) occurrences of one error, this exceed the limit of (3) occurrences of one error. Quality Control performed a recheck at approximately 0854 hours and Station #1 failed with (3) not reflected. This exceed the limit of (3) occurrences of one error for the process to be in control. (b) (6) was informed and line speed was reduced to 81 BPM. At approximately 0924 hours all rechecks passed, bringing the process back in control. This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3313020 527N-1	02/27/2013	04C05	Poultry Good Commercial Practices	C	While performing Good Commercial Practices Task, at approximately 1050 hours in Plant #2 Live Hanging Area, I found a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (b). On Line (b) (4) the stainless steel tank marked "USDA CONDEMN" which is used for DOA birds was approximately half full of dead birds. While making my observations I shined my flashlight in the tank and found one bird with his eyes open. The bird was on the top and started moving his wings, I then placed my hand on his breast and it was breathing. A company employee, (b) (6) was near me. He took the bird from the condemn tank and placed in the live hanging line (b) (4) for me. I informed (b) (6) of the noncompliance.
5308	M6137	BXL4408020 427N-1	02/27/2013	04A06	Poultry Finished Product Standards	C	On 02/27/2013 at approximately 0354 hours, I randomly removed a 10 bird sample from Line (b) (4) in Plant #2 for a Pre-Chill Finished Product Standard Check. I documented 32 points on the Processing Nonconformances from the 10 bird sample. This exceeds the subgroup absolute limit of 30 points for the Processing Nonconformances to be in control. I informed (b) (6) of the failure and approximately 0410 hours Quality Control performed a recheck. Quality Control documented 26 points on the Processing Nonconformances, this exceeds the limit of the 25 points allowed for the recheck, at this point the process is considered out of control. I informed (b) (6) of the noncompliance. Quality Control performed rechecks at Pre-Chill and Post-Chill. At approximately 0515 hours the process was back in control. This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76(b).
5308	M6137	BXL0005023 226N-1	02/26/2013	01B02	Pre-Op SSOP Review and Observation	C	On 02/26/2013 at approximately 0013 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Packaging Area #2, the (b) (4) Room, after establishment SSOP monitors completed their inspections, I observed the following. There was a thick continuous layer of fat and tissue on approximately a 20 foot section of the white support brackets, at a point where the brackets contact the product belt, for the overhead wing line. There were numerous specks of black UFM (Unidentified Foreign Material) that appeared to be mold on the white sprocket at the end of the line. The affected portion of the line is nearest the door to Packaging Area #1. The affected area was cleaned with a green scouring pad and given a rinse with potable water restoring sanitary conditions per establishment procedure by approximately 0026 hours. My finding indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c) and 9 CFR 416.14.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2014023 426N-1	02/26/2013	03J02	Slaughter HACCP	C	While performing a HACCP Slaughter Record Review Task at approximately 1050 hours, I found a noncompliance with the following regulatory requirements of regulation 417.5 (c). The CCP-2B (b) (4) Pre-Shipment Records Review End of Shift, dated on 02/23/2013 AM shift, Plant #1 was signed at 0900 hours (first page) and 0903 hours (second page). The CCP-2B (b) (4) Monitoring Log Line #1 had last Zero Tolerance check at 0904 hours and Line #2 had last Zero Tolerance check at 0908 hours. The signed document certifies that the product is ready to be shipped. The Pre-Shipment Records Review, End of Shift was signed before the last Zero Tolerance checks on Line #1 and Line#2 were performed. I informed (b) (6) of the noncompliance.
5308	M6137	BXL2108020 926N-1	02/26/2013	06D02	Other Inspection Requirements	C	On 02/26/2013 at approximately 0344 hours while monitoring slaughter line processes in plant #1, I observed the following. There appeared to be a lot of viscera missing from line #2. There were a number of off color birds (dehydrated) passing down the line and the birds are often condemned as without the viscera it is difficult to determine a cause. A check of the (b) (4) Lines No-Viscera Monitoring Log for the shift showed that line #1 was in a failed status but that line #2 was in compliance. I performed a standard 3 minute no viscera check on Line #2 and found that there were 34 no viscera at (b) (4) bpm (birds per minute). At (b) (4) bpm 13 no viscera are allowed. I informed (b) (6) A QC recheck failed at 0410 hours and the line was slowed to 126 bpm. Another QC check at 0613 hours also failed at 126 bpm. A QC no viscera check of Line #1 failed at 0140 hours. A QC recheck at 0204 hours failed with 23 no viscera and the line was slowed to 126 bpm. QC rechecks at 0358 and 0609 hours failed with 39 no viscera at 126 bpm. At 126 bpm 11 no viscera are allowed. The three consecutive failures on line #1 is also a noncompliance for failure by the establishment to take proper corrective action. My findings indicated a noncompliance with 9 CFR 391.76(a) & (b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3319024 826N-1	02/26/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1030 hours, at the packaging re hang area for plant 1, I observed a noncompliance with regulations 416.1 and 416.4(a). There was three stainless steel tanks align right next to chiller 2 re hang line. These tanks were coming from the Rotisserie Room. The employee collecting ice grabbed a hose and rinsed them with hot water. As he was ready to push them to the ice collection area, I stopped him with the purpose of inspecting the sanitary conditions of these tanks. I found them with chunks of fat and what seemed to be a brownish residue built up on the inside bottom of the tanks. Rinsing with hot water was not sufficient to clean the brownish residue on the bottom of the tanks. I immediately place retained tags on the affected edible containers (US Tag NO. B31 407786, B31 407787 and B31 407788). (b) (6) was notified of the noncompliance. I also observed a couple of stainless steel tanks brought out of plant 1 cooler. These tanks were covered with blue liners. When I uncovered them, I noticed the same type of brownish residue building up inside of the tanks. I also placed rejected US tags on both tanks (B31 407949 and B31 407950). I then, contacted (b) (6) and notified him of the insanitary condition. He took immediate corrective action by assigning employees to the edible condemn room to wash these tanks by applying soap, scrubbing and rinsing each one of them with hot water. I released the stainless steel containers back to production after sanitary conditions were restored. (b) (6) was also notified of the noncompliance (b) (6) mentioned his intention to keep these employees at the edible dump room so that all stainless steel tanks are properly cleaned. My finding represent a noncompliance with Pre Operational and Operational sanitary practices.</p>
5308	M6137	BXL5720023 326N-1	02/26/2013	06D02	Other Inspection Requirements	C	<p>On 02/26/2013, The (b) (4) No Viscera log in plant one, lines 1, reflected 3 consecutive failures during the first four hours of production. Two checks failed at (b) (4) birds per minute, which allows 13 nonconformances and one check failed at line speed of 126 BPM, which allows 11 nonconformances. The no viscera checks that were performed at 126 BPM did not meet the required standards; however, the line speed remained at 126 BPM. Latter on during the day, line one was slowed down to 100 birds per minute due to pathology. This scenario reflects a lack of control in the process. Line 1 At 0815 hours, failed with 17 nonconformances at line speed of (b) (4) BPM (13 nonconformances are allowed) At 0848 hours, the recheck failed with 14 nonconformances at line speed of 140 BPM. At 0902 hours, Line speed was slowed down to 126 BPM untill further notice. At 1031 hours, failed with 13 nonconformances at line speed of 126 BPM (11 nonconformances are allowed). At 1312 hours, failed with 20 nonconformances at line speed of 126 BPM. At 1500 hours, passed with 7 nonconformances at line speed of 100 BPM (9 nonconformances are allowed) This is a noncompliance with regulatory requirement of regulation 9 CFR 381.76. (b) (6) was notified of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3600020 823N-1	02/23/2013	01D01	SPS Verification	C	<p>On 02/22/2013 at approximately 0315 hours while performing a Raw Intact HACCP procedure in Packaging, I observed the following. There was a piece of stainless steel lacing on a thigh being collected in brown product tubs near line ^{P16} for further processing. I showed my finding to (b) (6). The lacing is used to hold the cloth belts together. A lace is approximately 1" long. The metal piece was too large to be considered a safety hazard and would probably have been found during the deboning and final trim process. To determine a source, we checked the belts for leg processors 7-12 that were in use and found 4 laces missing on the belt that collects the legs associated with Leg Processors 7-9. There were also several laces that have wear marks that are normally associated with a rubbing action. There were 2 laces missing on the thigh collection belt associated with Leg Processors 7-12. A check of the other cloth belts in Packaging revealed that 3 laces were missing on the leg collection belt associated with Leg Processors 1-3. There is also wear marks on the rest of the laces on this belt. The main product belt associated with Line ^{P16} that collects half breasts and takes them to the point where they are packaged was missing at least 15 laces in four separate places. One belt that collects the wings from under the Breast Processors was missing 4 laces and a second belt that also collects wings from the Breast Processors was missing 6 laces. There are also wear marks on the rest of the lacing on these belts. The lacing is deteriorating either through wear or by separation from the belt with the metal contaminating the finished product just prior to packaging. The response to NR#BXL708013131N/1 dated 1/31/2013 under 'Immediate Action' states "Maintenance replaced the lacing for the belts." The response to NR #BXL4004023609N/1 dated 2/9/2013 for a similar observation under 'Immediate Action' stated that "Maintenance replaced the lacing for the belts, tightened the rollers, and verified the clearance." No mention was made of a preventative measure to prevent reoccurrence. The Establishment is either unable or unwilling to address this issue. My findings indicate a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d) and 9 CFR 416.2(b)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3604025 023N-1	02/23/2013	04A06	Poultry Finished Product Standards	C	On 02/22/2012 while monitoring the Establishments' Reprocessing Procedures on Line ^{PM} in Plant #1, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.84 (Airsacculitis). At approximately 2337 hours, I randomly removed a 10 bird sample for my reprocessing test, I found one out of six birds with splits tails in the sample that contained Airsacculitis exudates by the kidney area. I performed a recheck at approximately 2344 hours, in which three out of the ten birds sample contained Airsacculitis exudates. I immediately informed (b) (6) of the noncompliance and he immediately took action by stopping the line and retained the product into a tank. Quality Control placed a red hold tag to the tank. At approximately 2355 hours Quality Control performed a recheck and it passed. I released the product to Quality Control. The retained product was reworked and released by Quality Control at approximately 0030 hours.
5333	P7632	HYE110202 3422N-1	02/22/2013	01D01	SPS Verification	C	At approximately 03:36 am while performing the Review and Observation component of the Operational Sanitation PHIS task, the following noncompliance was noted: At the the end of the rotisserie packing line ten stacks of baskets were staged, five with product and five without. All ten stacks of baskets were contaminated with foreign residue of black consistency and ½ - 2½ inches of fat. Inspector CSI (b) (7)(C) took regulatory control of the affected product and baskets by applying USDA retain tags. CSI (b) (7)(C) then informed (b) (6) of the forthcoming noncompliance. Mr. (b) (6) took immediate action by removing all products and washing all affected baskets. (b) (6) was informed of the noncompliance and he placed Q.C. retain tags to affected baskets for recheck. Regulatory control of the area was released at 03:47 am once sanitary conditions were restored. This failure represents a noncompliance with regulations: 9 CFR 416.1 which states "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary condition and to ensure that product is not adulterated." 9 CFR 416.4 (b) which states "Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1700023 721N-1	02/21/2013	01C02	Operational SSOP Review and Observation	C	On 02/20/2013 at approximately 0040 hours while monitoring the establishment's Operational Sanitation procedures in Packaging, I observed the following. I checked five birds from a group of the first birds hung and found three birds on Line (b) (4) that had black and brown UFM (Unidentified Foreign Material) on the three carcasses as follows: on the tissue left hanging from the neck, on the skin flap and on the fat and tissue in the area of the neck, and on the skin flap that included approximately a 3/4" piece of neck bone. From the location of the UFM the birds must have been dragged across a contaminated surface. I contacted (b) (6) and showed him my findings. We observed the line operation along the drip pans in packaging but found no issues. We proceeded to the Plant #2 and found birds dragging on the drip pans before the (b) (4) machine on Line (b) (4). These drip pans are not treated as product contact surfaces. Birds were also dragging on the the Chick/Weight line at the bottom of the incline between stations WX and AABB, and along the overhead drip pans for line #2. The drip pans are not treated as a product contact surface and the overhead drip pans were coated with a heavy layer of black UFM contaminating the birds that came into contact with the UFM on the drip pan surface. The Chick/Weight line was stopped. An attempt was made to scrub and wash the line but with no soap available and only cold water, the green scrub pad used just smeared the UFM around. A plastic sheet was applied to the drip pans as a temporary solution and the line was restarted after approximately 30 minutes. A work order was submitted. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 4(d), 9 CFR 416.2(b)(1), and 9 CFR 416.14.
5308	M6137	BXL2404024 521N-1	02/21/2013	03J02	Slaughter HACCP	C	On 02/21/2013 at approximately 0015 hours while performing the weekly monitoring of Reprocessing Line (b) (4), I observed the following. After taking a standard 10 bird sample, I observed one bird with visible fecal contamination on the right side where the leaf fat would be located. The leaf fat is removed as part of the reprocessing line function. The fecal material was a smear measuring approximately 1/2", medium brown in color, pasty in texture, and gave off a distinctive odor. I contacted (b) (6) who called (b) (6). Approximately 50 birds were tanked. A recheck passed at approximately 0022 hours. A review of the Off Line (b) (4) & (b) (4) Inspection Form for the shift showed that Line (b) (4) was running at (b) (4) birds per minute at 2303 hours. There was one house inspector at the end of the line. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP-1B - (b) (4) (Reprocess) of the Plants' HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN110502 2521N-1	02/21/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>I, CSI (b) (7)(C) [REDACTED], was performing the review and observation component of Pre Operational Sanitation PHIS task at 00:46 in Area 4 Food Service, I noted the following noncompliance: While checking the return bird slide and north/south rehang belt area I observed excessive amount of fat pieces along the length of the belt, the inner and outer metal ends of belt, the dip pans directly above the belt and the WOG drop slide. I took regulatory control by applying US retain tag B43303504. (b) (6) [REDACTED] were notified of the forthcoming noncompliance. Once corrective actions were implemented and sanitary conditions were restored the area was released at 00:52 The establishment failed to meet the requirements of CFR 9 416.4 (a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.(b) Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. CFR9 416.13 (c)Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's.</p>
5308	M6137	BXL2222024 420N-1	02/20/2013	06D02	Other Inspection Requirements	C	<p>On 02/20/2013 while performing 'No Viscera' checks in Plant #1, line #1 and line #2, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). -Line #2 At 0114 hours, I documented 19 no viscera and only 13 are allowed at line speed of (b) (4) BPM, I informed (b) (6) [REDACTED] of the failure. At 0144 hours, Quality Control performed a recheck and failed with 22 no viscera and only 13 no viscera are allowed at line speed of (b) (4) BPM. (b) (6) [REDACTED] was informed and line speed was reduced to 126 BPM. Line speed remained at 126 BPM the rest of the shift. -Line #1 At 0431 hours, I documented 16 no viscera and only 13 are allowed at line speed of (b) (4) BPM, I informed (b) (6) [REDACTED] of the failure. At 0459 hours, Quality Control performed a recheck and failed with 16 no viscera and only 13 no viscera are allowed at line speed of (b) (4) BPM. (b) (6) [REDACTED] was informed and line speed was reduced to 126 BPM. Line speed remained at 126 BPM the rest of the shift. (b) (6) [REDACTED] was informed about the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0507023 719N-1	02/19/2013	01C02	Operational SSOP Review and Observation	C	<p>On 02/19/2013 at approximately 0330 hours while monitoring the establishments' Operational Sanitation procedures in Packaging, I observed the following. The birds on the high speed line from Plant #2 to Plant #1 were dragging on the catwalk located to the right as the line exits the tunnel into Plant #1. The birds also drag on the drip trays as they turn the corner on their approach to the (b) (4) spray cabinet for line (b) (4). The catwalk and drip pans are not treated as a product contact surface and are adding contaminants to the product upon contact. The chain associated with the high speed line is heavily rusted and needs reconditioning or replacement. I showed (b) (6) my findings. Hanging of birds on the line was stopped. The birds on the line were tanked and placed under QC hold for reconditioning. A review of the establishments' (b) (4) shows that no Chemical, Physical or Biological Hazards were identified. Under 'Justification for Decision' it states (b) (4) "My finding indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), 9 CFR 416.2(b)(1) and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4708024 516N-1	02/16/2013	01C02	Operational SSOP Review and Observation	C	<p>On 02/16/2013 at approximately 0215 hours while monitoring the establishments Operation Sanitation procedures in Packaging, I observed the following. There were several oily black specks of UFM (Unidentified Foreign Material) approximately 6-10 per tray to approximately 1/16" on the product tray and absorbent pads on packaging line (b) (6) just prior to the product being added. The side of the line adjacent to the packaging supervisors office was involved. I watched for approximately a minute and every third or fourth tray was being contaminated. I contacted (b) (6). A mechanic was called. The auto padder unit used to cut and dispense absorbent pads was tipped over by the mechanic and repairs were made. A large piece of black UFM (Unidentified Foreign Material) approximately 1/2" and several small pieces that appeared to be clumps of blackened padding residue appeared on the belt that holds the packaging trays. The line was cleaned. Several attempts were made to repair the auto padder. I continued to remove contaminated trays during this process. After break at approximately 0300 hours a final attempt was made resulting in the same black specks on the packaging trays. (b) (6) had the absorbent pads placed on the trays manually until repairs could be made at a later time. At the 0300 hour, I removed several trays from Line (b) (6) at the point where product was being added. Four of the trays had the blackened dust like material on the trays measuring approximately 1/4" by 1/16". I showed the trays, one with product already being packed, to (b) (6). I contacted the Lead Mechanic who informed me that the establishment used only (b) (4). A review of the establishments' (b) (4) shows that no Chemical, Physical or Biological Hazards were identified. Under Justification for decision it states "(b) (4)". My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(d) and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN261902 2216N-1	02/16/2013	03C02	Raw Intact HACCP	O	At approximately 0855 hours, while performing the PHIS task for Operational Sanitation in the second processing area, I observed two bins filled with chicken back bones staged in the re-hang area of the food service floor. The first, bin # 22420, weighed 1,879 lbs; from kill date 2/14/2013. The second, bin # 32277, was filled with 2,420 lb; kill date 2/15/2013 Thursday. I asked (b) (6) to use his thermometer to check the temperature of the products. The maximum temperature for bin #22420 was 44.7 degrees Fahrenheit, and for bin # 32277 was 42 degrees Fahrenheit. I immediately retained the products by placing retained tags NO. B34776900 and NO. 40266747 on each bin respectively. I informed Ms. (b) (6), of my findings and forthcoming noncompliance. At approximately 0910 hours, the product was released to Ms. (b) (6) who condemned the product in my presence. Upon review the thermometer calibration log entry for thermometer# 467 was documented as acceptable at 2328 hours. Failure of the establishment to maintain a maximum internal temperature of the product at 40 degrees Fahrenheit or less is a noncompliance in accordance with 9 CFR 381.66(a) and 9CFR 381.66(c) (3). 9 CFR 381.66(a) states in part " Temperature and procedures that are necessary for chilling and freezing ready-to-cook poultry, including all edible portions thereof, must be in accordance with operating procedures that ensure the prompt removal of the animal heat, preserve the condition..." 9CFR 381.66(c) (3) states "Previously chilled poultry carcasses and major portions must be maintained constantly at 40 degrees F or below until removed from the vats or tanks for immediate packaging "
5308	M6137	BXL2207021 115N-1	02/15/2013	03J02	Slaughter HACCP	C	On 02/15/2013 at approximately 0215 hours while monitoring the establishments' Operational Sanitation procedures in Packaging on line (b) (6), I observed the following. I was monitoring birds for UFM (Unidentified Foreign Material) just prior to the point where the giblets are added to the carcasses prior to begging. The fourth bird that I checked had a cloacae attached inside at the tail with approximately 3" of intestine. There was fecal material leaking from the cut end of the intestine into the left side kidney area. As there is no procedure for a packaging department fecal failure, I had Quality Control and (b) (6) called. The fecal material was olive green in color, pasty in texture and measured approximately 1/2" by 1/8". Two racks of packaged birds were held for further inspection by Quality Control. Fecal material normally contains a large number of microbes. A review of the Establishments' (b) (4) states (b) (4) (b) (4). " My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP 2B (b) (4) of the Plants' HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3013021 915N-1	02/15/2013	04A06	Poultry Finished Product Standards	C	While monitoring the Establishments' Reprocessing Procedures on Line 9 in Plant #2, I observed the following noncompliance. At approximately 1050 hours, I randomly selected a 10 bird sample for my reprocessing check. I found 2 birds with airsacculitis exudates remaining in the bird. I immediately took regulatory action by stopping the line and I informed (b) (6) of the noncompliance. The line was started and product was retained while corrective actions were implemented. I performed a recheck at approximately 1104 hours and it passed, bringing the process back into control. I tagged the tank of retained birds with U.S. Retained/Rejected Tag #B31407602 pending rework of the product. I performed a recheck of the held product at approximately 1259 hours and it passed. I removed my tag and released the product back to production at that time. My findings indicate a noncompliance with 9CFR 381.76(b) and 9CFR 381.84.
5308	M6137	BXL3504022 315N-1	02/15/2013	01B02	Pre-Op SSOP Review and Observation	C	On 02/14/2013 at approximately 2350 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Packaging Area #1, I observed the following. There was a thin layer of pasty fat and issue on the stainless steel sides of both overhead breast fillet transfer belts that carry finished product from the (b) (4) Deboning room to packaging lines. The affected belts run parallel to the Crust Tunnel and are approximately 60 feet long. The pasty tissue was up to approximately 2" high in places and cover areas that were several feet long. There were numerous pieces of semi-dried fat and tissue on the internal surfaces and metal support brackets associated with the short transfer belt that carries breast fillets rejected by the X-Ray machine to a belt that takes them to a deboning station. The tissue had been there for some time as the product residue gave off a strong sour offensive odor. Sanitary conditions were restored by approximately 0025 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.13(c), and 9 CFR 416.14.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE450002 0115N-1	02/15/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 2/14 at approximately 2204 hours I observed the following while performing the SSOP Review and Observation Task in Area II .The paddles and upper frame work on the outer portion of the North Chiller (east section from center) had a build-up of grease left from the previous shifts production . I immediately informed (b) (6) of my findings .(b) (6) had one of his workers wipe the paddles down and the affected areas of the frame work . The area was reinspected and found to be in sanitary condition putting the establishment back in-compliance . At approximately 2210 hours Unit # 14 of Area # II was inspected . The cabinet on the South West Wall that houses the company computer used to retrieve establishment data had a build-up of black mold and (UMF) Unidentified Foreign Material on the in side of the flip-up cover to the cabinet and outer portions around one fastener .(b) (6) was immediately informed of the non-compliance and US Rejected/Retained tag # B38495468 was applied .(b) (6) had one of his workers clean the the in side of the cabinet door and the area inside surrounding the computer .The cabinet was reinspected at approximately 2217 and sanitary conditions had been restored . The tag was removed and Area # II was ready for production . My findings indicate non-compliances with the following regulations 9CFR 416.13(a) , 9CFR 416.4(b) , 9CFR 416.14 , 9CFR 416.13(c) , 9CFR 416.4(a) and 9CFR 416.1 .</p>
5308	M6137	BXL2813020 114N-1	02/14/2013	01C02	Operational SSOP Review and Observation	C	<p>On 02/14/2013 at approximately 1039 hours while monitoring the establishments' Operational Sanitation procedures in the Packaging Department, I observed the following. Between the Bag Fryer Line^{(b)(6)} and the Bag Fryer Line^{(b)(6)} at the final tie station where rework is done and before the tied bag fryers go on to the revolving table to be put on racks. There were two birds that were not in bags, that had fallen on the floor close to Line^{(b)(6)} and I witnessed an employee walk over to the two birds on the floor and using her feet she kicked the two birds approximately two feet towards Line^{(b)(6)}. The employee then picked up the two birds and holding them in one hand she took a hose and sprayed the two birds. She then put the two birds in a stainless steel rework cart that was at the end of Line^{(b)(6)} by the final tie station. I immediately went over to the cart with the two birds inside it and I observed UFM approximately 1/32" in size embedded in the skin. I took regulatory control action and tagged the two birds with USDA Reject/Retain tag #B31407603. I then informed (b) (6) and (b) (6) of the noncompliance. I removed my retain tag at 1050 hours and (b) (6) condemned the two birds.(b) (6) washed the stainless steel cart restoring sanitary conditions at 1052 hours.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3003022 914N-1	02/14/2013	01B02	Pre-Op SSOP Review and Observation	C	On 02/13/2012 at approximately 2310 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in the Rotisserie Room, I observed the following. There was a coating of pasty fat and tissue to approximately 1/4" with pieces of tissue to approximately 1/2" on the sprockets, and along the entire length of the white nylon and stainless support brackets for the product belt associated with the injection machine. Sanitary conditions were restored by approximately 2335 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c) and 9 CFR 416.14.
5308	M6137	BXL3203023 614N-1	02/14/2013	03J04	Poultry Zero Tolerance Verification	C	On 02/14/2012 at approximately 0036 hours while performing a Zero Tolerance fecal check on Line #1 in Plant #1, I observed the following. After taking a random ten bird sample, I observed one bird with visible fecal contamination. The fecal material was a smear measuring approximately 1/2" by 3/4" in size, medium brown in color and pasty in texture. The fecal material was located in the area of the keel bone inside of the carcass approximately 1-1/2 inches from the abdominal cut. This exceeded the zero tolerance for the process to be in control. I showed (b) (6) my findings. The protocol for fecal failure was implemented. It took over 30 minutes for maintenance personnel to clean the spray heads on the bird washer. A QC recheck passed at 0115 hours. My findings indicated a noncompliance with 9 CFR 381.65(e) and 9 CFR 417.2(c)(4), and the critical limit of CCP-28 (b) (4) of the Plants' HACCP Plan for Slaughter.
5308	M6137	BXL4208020 914N-1	02/14/2013	06D02	Other Inspection Requirements	C	On 02/14/2013, at approximately 0504 hours, I performed a presentation check on Line (b) (6). Station #1 failed with (2) viscera on shackle, (2) not reflected and (1) contamination inside the bird, total of 26 points. Station #2 failed with (2) viscera on shackle and (3) not reflected, total of 22 points. Station #3 had (1) viscera on shackle and (1) not reflected, total of 10 points at line speed of (b) (6) BPM (Birds Per Minute). This exceed the limit of (3) occurrence of one error and (25-39) points. At approximately 0523 hours Quality Control performed a recheck and Station #1 failed with (1) viscera not uniform, (2) viscera on shackle and (2) not reflected, total of 28 points. Station #2 had (2) not reflected, total of 4 points. Station #3 failed with (1) viscera not uniform, (1) viscera on shackle and (4) not reflected total of 24 points. This exceed the retest conformance levels of 3 occurrences of one error and 25 points for the process to be in control. (b) (6) was informed and the line speed was reduced to (b) (6) BPM. At approximately 0552 hours Quality Control performed a recheck at line speed of (b) (6) BPM and it passed. At approximately 0557 hours at line speed of (b) (6) BPM, Quality Control performed a recheck and passed it, bringing the process back in control. This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4216024 014N-1	02/14/2013	06D02	Other Inspection Requirements	C	<p>On 02/14/2013, The (b) (4) No Viscera log in plant one, lines 1 and 2, each reflected 6 consecutive failures during the production day. Two checks failed at (b) (4) birds per minute, which allows 13 nonconformances and four checks failed at line speed of 126 BPM, which allows 11 nonconformances. The viscera checks that were performed at 126 BPM did not meet the required standards; however, the line speed remained at 126 BPM. This scenario reflects a lack of control in the process. Line 1 At 0759 hours, failed with 22 nonconformances at line speed of (b) (4) BPM (13 nonconformances are allowed) At 0828 hours, the recheck failed with 27 nonconformances at line speed of (b) (4) BPM. Line speed was slowed down to 126 BPM. At 1100 hours, failed with 22 nonconformances at line speed of 126 BPM (11 nonconformances are allowed). At 1321 hours, failed with 20 nonconformances at line speed of 126 BPM. At 1503 hours, failed with 25 nonconformances at line speed of 126 BPM. At 1632 hours, failed with 22 nonconformances at line speed of 126 BPM This is a noncompliance with regulatory requirement of regulation 9 CFR 381.76. Line 2 At 0813 hours, failed with 25 nonconformances at line speed of (b) (4) BPM (13 nonconformances are allowed) At 0842 hours, the recheck failed with 18 nonconformances at line speed of (b) (4) BPM. Line speed was slowed down to 126 BPM. At 1107 hours, failed with 19 nonconformances at line speed of 126 BPM (11 nonconformances are allowed). At 1325 hours, failed with 19 nonconformances at line speed of 126 BPM. At 1509 hours, failed with 20 nonconformances at line speed of 126 BPM. At 1720 hours, failed with 18 nonconformances at line speed of 126 BPM. This is a noncompliance with regulatory requirement of regulation 9 CFR 381.76. (b) (6) was notified of the noncompliance.</p>
5308	M6137	BXL5008022 814N-1	02/14/2013	03J02	Slaughter HACCP	C	<p>On 02/14/2013 at approximately 0200 hours while performing a HACCP Slaughter Record Review Task, I found the following. Quality Control or designee documented on the HACCP Monitoring Log -CCP 1B-(b) (4), Line (b) (4) (Plant #2) dated on 02/12/2013 PM shift, Direct Observation at 0951 hours. The time enter on verification activities (Direct Observation) did not corresponded with any of the monitor procedure entries of 0751 hours, 0859 hours and 0958 hours. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 417.5 (a)(3) and 9CFR 417.5 (b). I informed (b) (6) of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0505021 513N-1	02/13/2013	04C05	Poultry Good Commercial Practices	C	On 02/13/2013 at approximately 0130 hours while monitoring the Establishments' Good Commercial Practices in Plant #1 Live Hang area, I observed the following. There was a bird hanging by it neck at the end of the dumping belt for Line #1. It's head was caught behind a piece of stainless that was loose. The stainless sheet is used to direct the birds off the dumping belt. The birds neck was bent at almost a 180' angle. It was not moving. I went to the office but no supervisor was available so I had (b) (6) and the employee doing the dumping release the bird. The bird was dead so I attached U.S. Retained Tag #B31407772 to the carcass. Except for the injuries to the neck the bird appeared normal. There were no signs that it struggled. There was very little blood. I found (b) (6) in the Plant #1 Supervisors Office in a meeting with the other Plant #1 Supervisors. I told him about the bird. We proceeded to the hanging area and I showed him the loose piece of stainless near the end of the right side of the dumper belt (b) (6) called a mechanic who used a tie wrap to hold the metal in place until a more permanent repair could be made. I informed (b) (6) that a noncompliance would be issued for 'Death Other Than By Slaughter. My findings indicated a noncompliance with 9 CFR 381.65(b).
5308	M6137	BXL1105021 113N-1	02/13/2013	01B02	Pre-Op SSOP Review and Observation	C	On 02/13/2013 at approximately 0005 hours while monitoring the establishments Pre-Operational Sanitation procedures in Packaging Area #1, I observed the following. There were numerous pieces of fat and tissue, and black UFM (Unidentified Foreign Material) that appeared to be mold on the internal stainless and white nylon support brackets associated with Trim Conveyor Belt #2 for line #1. There are small access ports on both sides of the belt, however, the access does not allow for a thorough cleaning or visual inspection to the ends of the belt. (b) (6) will be submitting a work order to modify the belt design. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.3(b), 9 CFR 416.4(a) and 9 CFR 416.13(c).
5308	M6137	BXL2217022 213N-1	02/13/2013	06D02	Other Inspection Requirements	C	While monitoring The (b) (4) no viscera in line 1 of plant 1, I found a noncompliance with regulatory requirement of regulation 9 CFR 381.76 At approximately 0910 hours, I performed a no viscera check on line 1 at line speed of (b) (4) birds per minute(BPM). My check failed with 18 nonconformances out of 13 nonconformances allowed at (b) (4) BPM. I notified (b) (6). At 1029 hours, line speed (b) (4) BPM, QC performed a recheck failing with 20 nonconformances out of 13 nonconformances. At this point a non compliance is issued. Line speed was slowed down to 126 BPM which allows 11 nonconformances. At approximately 1325 hours, at 126 BPM line speed, QC performed a passing recheck with 8 out of 11 nonconformances. Line speed remained at 126 the rest of the day. At approximately 1505 hours, (b) (6) was notified of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2217022 213N-2	02/13/2013	06D02	Other Inspection Requirements	C	On 02/13/2013, a second noncompliance was issued in plant 1 due to no viscera failures during the day. The Line 2 (b) (4) No Viscera log reflected 5 consecutive failures during the production day. Two checks failed at (b) (4) birds per minute, which allows 13 nonconformances and three checks failed at line speed of 126 BPM, which allows 11 nonconformances. The viscera checks that were performed at 126 BPM did not meet the required standards; however, the line speed remained at 126 BPM. This scenario reflects a lack of control in the process. At 0802 hours, failed with 17 nonconformances at line speed of (b) (4) BPM (13 nonconformances are allowed) At 0816 hours, the recheck failed with 15 nonconformances at line speed of (b) (4) BPM. Line speed was slowed down to 126 BPM. At 1011 hours, failed with 26 nonconformances at line speed of 126 BPM (11 nonconformances are allowed). At 1244 hours, failed with 25 nonconformances at line speed of 126 BPM. At 1500 hours, failed with 25 nonconformances at line speed of 126 BPM. This is a noncompliance with regulatory requirement of regulation 9 CFR 381.76 At approximately 1505 hours, (b) (6) was notified of the noncompliance.
5308	M6137	BXL5015024 713N-1	02/13/2013	04A06	Poultry Finished Product Standards	C	While monitoring the Establishments' Reprocessing Procedures on Line (b) (4) in Plant #2, I observed the following noncompliance. At approximately 1020 hours, I randomly selected a 10 bird sample for my reprocessing check. I found 1 bird with airsacculitis exudates remaining in the bird. I immediately informed (b) (6) and told her I would have to perform a recheck. I again randomly removed a 10 bird sample at approximately 1030 hours and found 2 birds with airsacculitis exudates remaining. I immediately took regulatory action by stopping the line and informed (b) (6) of the noncompliance. The line was started and product was retained while corrective actions were implemented. I performed a recheck at approximately 1046 hours and it passed. bringing the process back into control. I tagged the tank of retained birds with U.S. Retained/Rejected Tag #B39 554619 pending rework of the product. I performed a recheck of the held product at approximately 1247 hours, finding 2 birds with airsacculitis exudates remaining. I informed (b) (6) of my findings and told her that the product would have to be reworked a second time. I rechecked the tank again at approximately 1325 hours and it passed, I removed my tag and released the product back to production at that time. My findings indicate a noncompliance with 9CFR 381.76(b) and 9CFR 381.84.
5308	M6137	BXL5104020 013N-1	02/13/2013	01D01	SPS Verification	C	At approximately 0232 hours, I observed a live juvenile cockroach on the wall between the hand wash sink and the drinking fountain in the body opening area of Plant #2. The cockroach was caught and immediately shown to (b) (6). He said that he would inform (b) (6). This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE270102 0513N-1	02/13/2013	01C02	Operational SSOP Review and Observation	C	On February 11, 2013 at approximately 2235, I was performing a Zero Tolerance task at the Pre-chill station on line one. The first two birds I pulled off had grease smears on the keel bone area approximately ½ inch square. I then noticed all the birds going down the line had grease smears from ¼ inch to ½ inch. I immediately stopped the line and informed (b) (6) of the problem. I released control of the line at 2239 after extra employees were placed at the final trim station to trim the grease from the affected carcasses. At 2245 the line was back in compliance. 9CFR 416.1 states "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." 9CFR 416.4(a) states "All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." 9CFR 416.4(d) states "Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments."
5308	M6137	BXL2713022 712N-1	02/12/2013	04C05	Poultry Good Commercial Practices	C	On 02/12/2013 at approximately 0840 hours while performing Good Commercial Practices in Plant 2 Live Hanging area I observed the following. On Line 9 the stainless steel tank marked "USDA CONDEMN" which is used for DOA birds in the live hanging area there were approximately 18 dead birds in the tank and one bird that was alive and lying on it's back at the bottom of the tank. The bird was breathing and had it's eyes open and was lifting it's head and moving it's legs. I immediately informed (b) (6) who in turn, using his radio, notified (b) (6). The bird was removed from the tank and placed on the live hanging line. I informed both (b) (6) and (b) (6) that this was a noncompliance with CFR 381.65(b) Good Commercial Practices.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4814022 312N-1	02/12/2013	06D02	Other Inspection Requirements	C	While monitoring The (b) (4) no viscera in line 2 of plant 1, I found a noncompliance with regulatory requirement of regulation 9 CFR 381.76 At approximately 0913 hours, I performed a no viscera check on line 2, at line speed of (b) (4) birds per minute(BPM). My check failed with 43 nonconformances out of 13 nonconformances allowed at (b) (4) BPM. I notified (b) (6) . At 0950 hours, at line speed (b) (4) BPM, QC performed a recheck failing with 22 nonconformances out of 13 nonconformances. At this point a non compliance is issued. Line speed was slowed down to 126 BPM which allows 11 nonconformances. At approximately 1245 hours, at 126 BPM line speed, QC performed a passing recheck with 10 out of 11 nonconformances. Line speed was increased to (b) (4) BPM. At approximately 1301 hours, at (b) (4) BPM line speed, QC performed a passing recheck with 10 out of 13 nonconformances bringing the process back in control. (b) (6) was notified of the noncompliance.
5308	M6137	BXL4814022 312N-2	02/12/2013	06D02	Other Inspection Requirements	C	On 02/12/2013, a second noncompliance was issued to line 2 in plant 1. During the afternoon there were 3 consecutive failures recorded on the (b) (4) no viscera log. One checks failed at (b) (4) birds per minute, which allows 13 nonconformances and two checks failed at line speed of 126 BPM, which allows 11 nonconformances. The viscera checks that were performed at 126 BPM did not meet the required standards during the afternoon; however, the line speed remained at 126 BPM. This scenario reflects a lack of control in the process. At 1326 hours I performed a no viscera check on line 2, at (b) (4) BPM line speed. I failed with 34 nonconformances out of 13 allowed. I notified (b) (6) who, decided to slow the line down to 126 BPM. At 1454 hours, QC performed a no viscera check at 126 birds per minute. She failed with 18 nonconformances out of 11 nonconformances allowed. At 1646 hours QC performed another failing no viscera check at line speed of 126 BPM. She recorded 23 nonconformances out of 11 nonconformances allowed. This scenario represents a noncompliance with regulatory requirement of regulation 9 CFR 381.76

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN340302 4912N-1	02/12/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>I was conducting the Review and Observation component of Pre-Operational Sanitation in area #2 of the Packaging department when I noted the following noncompliance. I inspected unit #30, the overhead incline transfer conveyor to dark meat deboning, I found 4 paint chips white in color approximately 1/8 of an inch in diameter continuing my inspection I also observed on the conveyor fat and meat particles from the previous days production. In between the white hard plastic side barriers of the conveyor fat was also present. The drip pan underneath the conveyor was covered with large pieces of fat, one measuring approximately 3 inches in length and 1 1/2 inches width. I then retained the conveyor with the application of U.S. Retain tag B39415838 at 0040 hours and informed (b) (6) of the forthcoming noncompliance. At approximately 0051 hours I reinspected the conveyor and verified that sanitary conditions were restored and released the conveyor. The establishment's SSOP program states in Part 1 Pre-operational Sanitation/Daily, Section 3 Packaging "(b) (4)".</p> <p>. This failure represents a noncompliance with as per the regulatory requirements of sections 416.4 (a) and 416.13 (c) of the Federal Code of Regulations. The presence of fat and meat particles on a food contact surface represents a noncompliance with Section 9 CFR 416.4(a) which states, "All food-contact surfaces, including food contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". Section 9 CFR 416.13 (c) states, "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's".</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2708021 011N-1	02/11/2013	01B02	Pre-Op SSOP Review and Observation	C	On 02/11/201 at approximately 0507 hours while monitoring the establishments Pre-Operational Sanitation Special Units procedures in Plant 2, I observed the following. There was a deteriorating chicken foot from Saturday mornings production inside of Line ^{(b) (4)} scalders at the west end next to the Line ^{(b) (4)} picker. I also observed a clump of feathers approximately 4 inches long, in a crease on the bottom of Line ^{(b) (4)} scalders on the east end where the scalders rounds to head back west. Approximately one foot away from the clump of feathers, on the south side of Line ^{(b) (4)} scalders I observed numerous spots of dried crusty UFM approximately 1/8" in size and several feathers approximately 1/2" long at the scalders water level. I informed (b) (6) of the noncompliance. I released the area at approximately 0515, after recleaning and sanitary conditions were restored.
5308	M6137	BXL5712022 011N-1	02/11/2013	03J04	Poultry Zero Tolerance Verification	C	While performing a scheduled Zero Tolerance check on line 2 of plant 1, I found a noncompliance with regulatory requirement of regulation 9 CFR 381.65(e) and 417.2 (c)(4). At approximately 1000 hours, I randomly removed 10 birds from line 2 finding one out of ten birds contaminated with feces. The fecal contamination was located inside of the bird on the right side near the tail area. It was pasty in texture and light yellow in color, measuring approximately 1/4" in diameter. This is a violation of the critical limit of CCP-2B (b) (4) of the plant's HACCP plan for slaughter. (b) (6) were notified of the noncompliance. The establishment's fecal protocol was implemented. According to QC records the cause of deviation was "one of the water sprayers was plug up". At approximately 1025 hours, QC performed a passing recheck bringing CCP 2B back in control. Post chill checks were performed from 1054 hours to 1200 hours. All product coming out of the chiller was found acceptable.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN190202 4112N-1	02/11/2013	01C02	Operational SSOP Review and Observation	C	<p>I, CSI, (b) (7)(C) and CSI, (b) (7)(C) were performing the Review and Observation component of a Sanitation Performance Standards PHIS Task. At approximately 2320 hours, seven minutes after the start of the official hours of operation, we observed at the North/East Carcass Chiller, Unit#10 (Area 1 Section D: Offline & Chiller Area) that two of the chiller's paddles had fat residue from the previous day's production on the support bars and on the paddles' bars. The paddles at the moment of our observation were above the chiller's water level. The first paddle had fat residue along the support bar surface and on the first bar of the paddle had a smear of fat approximately 5 inches long, 1 inch wide and ½ inch thick. The second paddle had a piece of fat with an approximate measurement of 3 inches long, 1 inch wide and ½ inch thick. We showed our findings to (b) (6).</p> <p>(b) (6) We took control of the affected area until the establishment restored sanitary conditions by cleaning and sanitizing the affected pieces of equipment. At 0045 hours approximately 2000 carcasses (5 combo bins) were retained and reprocessed. The establishment failed to clean the affected product contact surfaces during the general sanitation. This failure represents a noncompliance as per the regulatory requirements of sections 416.4(a), 416.4(d) and 416.13(c) of the Federal Code of Regulations. Section 9 CFR 416.4(a) states, "All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". Section 9 CFR 416.4(d) states, Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments. Section 9 CFR 416.13(c) states, "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's". (b) (6)</p> <p>(b) (6) were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3804022 509N-1	02/09/2013	01C02	Operational SSOP Review and Observation	C	On 02/07/2013 at approximately 2255 hours while monitoring the establishments' Operational Sanitation procedures in Plant #2, I observed the following. The plant was running Organic birds when Line ^{(b) (6)} broke down. Line ^{(b) (6)} was being stopped repeatedly due to pathology (airsacculittis, inflammatory process, and contaminants). I walked to the kill line/evisceration auto transfer area and observed a large pile of birds on the floor, approximately 200. The three tanks , conveyor belt and catch trays were all also full. The birds that were on the floor were under the transfer machines and along the catch trays. The tank under the transfer unit for line ^{(b) (6)} was full so another tank was brought up. Birds that had collected on the floor, approximately 35, while the tanks were being transferred were run over by the replacement tank adding more contaminants to the product. About 2300 hours (b) (6) arrived. The kill was stopped, however it still took until approximately 2315 hours to get the birds off the floor. The conveyor belt for line ^{(b) (6)} is not setup to be used as a means of filling tanks with excess product as is line ^{(b) (6)} . This requires the birds to be removed by hand. The available tank storage at the point of transfer is inadequate to collect the 15 minutes of birds from the kill line during a breakdown. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).
5308	M6137	BXL4004023 609N-1	02/09/2013	01D01	SPS Verification	C	On 02/09/2013 at approximately 0115 hours while monitoring Facilities in Packaging Area #1, I observed the following. The stainless steel lacing that holds the cloth belt together on the belt that collects the thighs under Leg Processors 7-12 has deteriorated. Approximately 5 laces are worn with 2 that are completely worn off to the belts surface. One lace is approximately 1" long. The lacing was replaced soon after NR # BXL1708013131N/1 dated 1/31/2013 was written, however, the wear issue that is causing the lacing to deteriorate rapidly was not addressed. The lacing for the cloth belt that collects the legs for Leg Processors 7-9 has four missing laces. The main collection belt for Line ^{(b) (6)} that carries legs to the point where they are packaged has approximately 15 laces that have separated with 4 of the half laces on one side missing. The lacing on line ^{(b) (6)} that carries wings to the point of packaging has two laces separated with 3 of the 4 half laces missing. The belt that carries the wing sections and runs under the breast processors has wear marks on most of the laces on the entire length of the lacing. There are also four laces missing from that belt. As the lacing deteriorates either through wear or separation there is potential for stainless steel to attach to the product as it passes down the belts just prior to packaging. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0419023 408N-1	02/08/2013	06D02	Other Inspection Requirements	C	At approximately 1630 hours, while monitoring the (b) (4) "No Viscera Log" for plant 1, lines 1 and 2, I observed a noncompliance with regulatory requirements of CFR 381.76 (a) and (b). Lines 1 and 2, each had three consecutive failures during the four hour period before lunch. Two checks failed at the line speed of (b) (4) birds per minute, which allows 13 nonconformances and the third check failed at the line speed of (b) (4) BPM, which allows 11 nonconformances. This reflects a lack of process control. Line 1 At 0813 hours, the check failed with 16 nonconformances at the line speed of (b) (4) BPM (13 nonconformances are allowed) At 0839 hours, the recheck failed with 14 nonconformances at the line speed of (b) (4) BPM. The line speed was slowed down to 126 BPM. At 1028 hours, the check failed with 13 nonconformances at the line speed of 126 BPM (11 nonconformances are allowed) Line 2 At 0817 hours, the check failed with 28 nonconformances at the line speed of (b) (4) BPM (13 nonconformances are allowed) At 846, the recheck failed with 20 nonconformances at the line speed of (b) (4) BPM. The line speed was slowed down to 126 BPM. At 1036 hours, the check failed with 16 nonconformances at the line speed of 126 BPM (11 nonconformances are allowed). I informed (b) (6) about the noncompliance.
5308	M6137	BXL4105020 106N-1	02/06/2013	03J02	Slaughter HACCP	C	On 02/06/2013 at approximately 0202 hours while monitoring the establishments' Finished Product Standards in Plant #2 Line (b) (4), I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. There was a partial stomach attached to the carcass with an intact gizzard and approximately 8" of intestine attached to the stomach. The fecal material was leaking from the cut end of the intestine into the area of the kidneys. The fecal material was medium yellow in color, with a creamy texture and measured approximately 3/8" by 1/4" in size. This exceeded the Zero Tolerance for the process to be in control. (b) (6) was contacted and the protocol for fecal failure was implemented. A QC recheck at 0224 hours passed. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP 2B (b) (4) of the Plants' HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4405020 306N-1	02/06/2013	01C01	Operational SSOP Record Review	C	<p>On 02/06/2013 at approximately 0320 hours while conducting a SSOP records and associated documents review, I observed the following. The establishments' HOLD and Release Form for 02/04/13 indicated that at 1055 hours 2814 pounds of product at Packaging Line (b) (6) was condemned for being contaminated with 'foreign material'. At 1935 hours in Packaging Line (b) (6) two racks were held for being contaminated with 'foreign material'. At 1956 hours several tanks in PLT #1 were held for being contaminated with 'foreign material'. A review of the Establishments' SSOP for Operational Sanitation under Monitoring states (b) (4) (b) (6) " A review of the establishments' SSOP Daily Implementation and Monitoring Log for Operations in the affected areas for the shift under Operational SSOP indicated that conditions were found to be acceptable. The SSOP Daily Implementation and Monitoring Log for Operations was not used per the SSOP to record product contaminated during production. Under Corrective Actions the requirements for documentation concerning 'Restoration of Sanitary Conditions or Prevention of Recurrence which are to be documented by the 'Appropriate Plant Management Team Member were also not documented. My findings indicated a noncompliance with 9 CFR 416.4(d), 9 CFR 416.13 (b) & (c) and 9 CFR 416.16(a).</p>
5309	P6137A	NJN481602 5405N-1	02/05/2013	01C02	Operational SSOP Review and Observation	C	<p>I had just completed performing a zero tolerance check on the paws when I noticed at the paw chiller the ice dumper was in the upright position. While in the upright position there was a cardboard bin on a wooden pallet in the dumper restrainer. I looked inside the paw chiller and noticed a piece of what appeared to be foreign material floating on the ice. I informed (b) (6) of what I found. (b) (6) retrieved the material in question, which at this point was adhered to the inside wall of the chiller. The material was a wood sliver approximately 1 ½ inches in length. At 0948 hours I tagged the paw chiller with U.S. Retain tag # B39415845. The establishment chose to implement corrective actions including emptying the paw chiller to wash and sanitize the inside product contact surfaces. The paws that were in the chiller were bagged and boxed and put on hold by the establishment, waiting further disposition, eleven cases in total. I informed (b) (6) of the documentation of the non compliance with the regulations cited above. After the chiller and belts were washed and sanitized I removed the U.S. Retain tag at 1048 hours.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1219020 901N-1	02/01/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1640 hours SCS (b) (7)(C) was called to the Plant 2 evisceration line by the USDA Inspectors. The inspectors informed him that there was a high amount of birds with pathology (airsacculitis) being run on Line (b) (7)(C). SCS (b) (7)(C) observed that evisceration Line (b) (7)(C) was continually stopping due to pathology. The reprocessing line, off/line reprocessing stations and reprocessing hang back racks were all full of birds being held for reprocessing. SCS (b) (7)(C) and I walked to the kill line/evisceration auto transfer area. We observed the Line (b) (7)(C) transfer table, where birds collect when the evisceration lines stop. The table was overflowing and we could see approximately 10 birds on the floor around the Line (b) (7)(C) transfer table. At approximately 1645 hours while we were observing the process in this area, evisceration Line (b) (7)(C) stopped. This caused the chute that moves birds from the Line (b) (7)(C) transfer machine to the transfer table to become congested. We observed approximately 25 birds overflow from the side of the congested chute and fall on the floor. On his way to inform (b) (6) of the insanitary condition in the re-hang area, SCS (b) (7)(C) passed by evisceration Line (b) (7)(C). He observed that Line (b) (7)(C) was stopped and all inspection stations had hang back racks full. He also noticed that on Station 3 birds marked for reprocessing were hanging on the rack designated for "hang high" birds that have not been inspected. The reprocessing birds and hang high birds were comingled on the rack. This caused Line (b) (7)(C) to be stopped for several minutes, while the reprocessing was being performed. At approximately 1650 hours while SCS (b) (7)(C) was observing the process of evisceration Line (b) (7)(C), I remained in the auto transfer area. I observed evisceration Line (b) (7)(C) stop and because the Line (b) (7)(C) transfer table was already full of birds this caused approximately 15 birds to fall on the floor at the transfer chute on Line (b) (7)(C) automatic transfer machine. An employee brought a smaller metal tank over to the transfer chute to catch the birds that were falling on the floor, however in doing so he ran over the birds that had fallen on the floor. The wheels and the underside of the tank came in contact with the birds on the floor causing the birds to become more contaminated and created an insanitary condition. My observations reflect a noncompliance with regulations 9CFR 416.4(d) and 416.1. We notified (b) (6) of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1708013 131N-1	01/31/2013	01D01	SPS Verification	C	On 01/31/2013 at approximately 0145 hours while monitoring Operational Sanitation procedures in Packaging Area #1, I observed that the stainless steel lacing that hold the brown cloth product belts together under Leg Processors 7-12 have deteriorated. One wire piece of the lacing on the belt under the Processors that collect the legs is worn off level with the top of the belt material. One lace is approximately 1 inch long. There are wear marks that are normally caused by a rubbing motion on the product contact side along most of the length on the lacing. The lacing on the belt under the Processors that collect the thighs is missing three wire laces that are worn off level with the top of the cloth belt. The lacing on the thigh belt has wear marks on the product contact side that are much deeper than the wear marks on the leg belt. I showed (b) (6) my findings. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).
5308	M6137	BXL3422011 331N-1	01/31/2013	01C02	Operational SSOP Review and Observation	C	On 01/31/2013 at approximately 0030 hours while monitoring the Establishments' Post-Chill Finished Product Standards in Plant #1 Chiller #2, I observed the following. One carcass had a shiny metal flake approximately 1 1/2mm by 1mm between the tissue and skin surface near the neck area. (b) (6) was nearby so I showed her my finding. I took the metal flake to the Production office and showed (b) (6). While checking for possible sources for the metal contaminant, I observed the chiller operation from the platform at the product inflow side. Each chiller paddle has a solid side and a forked side. The solid sides alternate with each chiller paddle. The backside of the chiller paddle has a ridge approximately 2" high. Near the rounded end of the solid side of the paddle that is submerged when the paddle is in use, there are worn areas on top of the ridge that vary in size with each paddle. The wear spots are several inches in length and up to approximately 1/4" in depth. All the paddles in both Chillers #1 & #2 that I observed have a similar wear spot in approximately the same location on both the right and left sides of the alternating solid portion of the paddles. On the edge of most of the wear spots that I observed there are metal shards of varying size. (b) (6) agreed that the metal flake on the carcass looks the same as the shards on the chiller paddles. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1) and 9 CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN080901 1331N-1	01/31/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 0622 hours while performing PHIS zero-tolerance task in the Evisceration Department on B line I noted the following noncompliance. I randomly selected a ten carcass sample set and observed fecal material in the forth carcass of that sample. The fecal material was located inside the cavity on the right side thigh and also the right side leaf fat, approximately 1/4 in diameter on the inside and 1/4 of an inch on the leaf fat, dark green in color with a paste like consistency. I immediately took a regulatory control action and stopped "B" line then showed my findings to (b) (6).</p> <p>Ms (b) (6) performed corrective actions as per establishment's HACCP plan and (b) (6) was notified of the noncompliance. The establishment did not meet the requirements of 9 CFR 381.65(e) which requires that the establishment prevents poultry carcasses contaminated with visible fecal material from entering the chilling system. The failure also represents a deviation from the establishment's written HACCP plan. Regulatory requirements of 417.2(c)(4) states "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits."</p>
5308	M6137	BXL1617014 230N-1	01/30/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1120 hours whilen performing scheduled Operational SSOP Review and Observation task I observed the following noncompliance. While walking through the Packaging area I walked into the Plant #2 Aged Breast Cooler where I found two pallets of brown tubs and lids, marked as clean, contaminated with numerous pieces of splintered wood up to approximately 1 1/4" by 1/8" in size, up to about three feet from the floor. I immediately took regulatory control action and tagged both pallets with USDA Reject/Retain tags #B31406328 and #B31406329, I then informed (b) (6) of the noncompliance and showed him my findings. He immediately took corrective action and had a company employee come with a pallet jack to take the pallets of tubs to the wash room to be rewashed. The two pallets of tubs were rewashed and sanitary conditions were restored by approximately 1240 hours. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1313012 429N-1	01/29/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1010 hours while performing scheduled Operational SSOP Review and Observation task I observed the following noncompliance in the Packaging area. I walked between Line (b) (4) and the Leg Processor machines to look at the Leg Halver machine area and found condensation dripping into a brown tub staged for use at the Leg Halver machines. The condensation was dripping from the drip pan that is under a large exhaust fan on the ceiling just above the end of the halvers. I immediately notified (b) (6) of the noncompliance. He immediately removed the brown tub to be washed and called (b) (6) who immediately removed all product from the line and cleaned the condensation from the drip pan, restoring sanitary conditions by 1022 hours. My findings indicate a noncompliance with the regulatory requirements of 9 CFR 416.1, 9 CFR 416.2(d) and 9 CFR 416.4(a).
5308	M6137	BXL3618015 728N-1	01/28/2013	06D02	Other Inspection Requirements	C	On 01/28/2013, The (b) (4) "No Viscera Log" for plant 1, lines 1 and 2 reflected a noncompliance with regulatory requirement of 9 CFR 381.76 (a) and (b). Line 1 and 2, each had three consecutive failures during the morning time. Two checks failed at line speed of (b) (4) birds per minute, which allows 13 nonconformances and the third check failed at line speed of 126 BPM, which allows 11 nonconformances. At this point production decided to continue running the lines at 126 BPM until further notice; however, the no viscera checks that were performed at 126 BPM did not meet the required standards during the afternoon. The line speed did not slowed down. This scenario reflects a lack of control in the process. Line 2 At 0805 hours, failed with 24 nonconformances at line speed of (b) (4) BPM (13 nonconformances are allowed) At 0823 hours, the recheck failed with 28 nonconformances at line speed of (b) (4) BPM. At 0835 Line was slowed down to 126 BPM until further notice. At 1030 hours, failed with 15 nonconformances at line speed of 126 BPM (11 nonconformances are allowed). At 1339 hours, failed with 30 nonconformances at line speed of 126 BPM. At 1500 hours, failed with 19 nonconformances at line speed of 126 BPM. Line 1 At 0800 hours, failed with 22 nonconformances at line speed of (b) (4) BPM (13 nonconformances are allowed) At 0819 hours, the recheck failed with 20 nonconformances at line speed of (b) (4) BPM. At 0825 Line was slowed down to 126 BPM until further notice. At 1025 hours, failed with 26 nonconformances at line speed of 126 BPM (11 nonconformances are allowed). At 1310 hours, failed with 31 nonconformances at line speed of 126 BPM. At 1449 hours, the check passed with 8 nonconformances. Line speed was increased from 126 BPM to (b) (4) BPM. At 1454 hours, the check passed with 13 nonconformances at line speed of (b) (4) BPM.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE030101 0028N-1	01/28/2013	01D01	SPS Verification	C	<p>On 1/27/13 at approximately 2245 I observed the following while performing the SPS task . The Blast Tunnel in the (b) (4) degree cooler . Lines 1 2 & 3 had debris on the floor including old frozen exposed paws a large package of Skin on Jumbo Breast and soaker pads . Lines (b) (4) had frozen exposed drums , thighs and paws on the floor as well . Regulation 416. 2(b)2 states walls,floors,and ceilings within the establishment must be built of durable materials impervious to moisture and be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions . My observation also indicates a non-compliance with regulation . (b) (6) was working close to the area so he was informed of the non-compliance . (b) (6) assured me the situation would be taken care of immediately . My findings indicate non-compliance with the following regulations 9CFR 416.2(b)2 , 9CFR 416.1 and 9CFR 416.4d .</p>
5309	P6137A	NJN360101 3629N-1	01/27/2013	04A06	Poultry Finished Product Standards	C	<p>While I was giving breaks to online inspection personnel, I noticed an increment of birds with airsacculitis being hanged on the offline. After the breaks were done, I decided to perform a directed task to verify if the establishment was implementing its (b) (4) written procedures. At approximately 0700 hours I performed the Review and Observation component of a Finish Products Standards Directed PHIS Task. At the offline inspection station I collected a sample consisting of 10 carcasses from which 2 carcasses marked with split tail had airsacculitis exudates in the rib cage. At 0709 hours I performed a recheck on a 10 carcass sample from which 1 carcass had airsacculitis exudates in the rib cage also. I showed my findings to (b) (6) . According to the establishment's vacuum procedure part A- Plant Standard Criteria for Critical Control Points, states, "(b) (4)". Part B states, "(b) (4)". (b) (6) initiated immediate corrective actions as prescribe in the establishment's vacuum procedure. The establishment failed to remove airsacculitis exudates from carcasses marked by USDA online inspection personnel. Section 381.84 of the 9 Code of Federal Regulations requires that establishments completely remove and condemn tissues affected with airsacculitis, including exudates, in carcasses not condemned. Mr. (b) (6) , was informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4222010 825N-1	01/25/2013	01C02	Operational SSOP Review and Observation	C	<p>On 01/24/2013 at approximately 0215 hours while monitoring the establishments' Operational Sanitation procedures in the Packaging Department, I observed the following. On the rehang belt adjacent to the plant #2 (b) (4) unit there were several uncut gizzards mixed in with the Organic birds being hung on a line going to the halving machine in Packaging. As the Organic birds at this point in the process have received their final microbial intervention, I collected several of the gizzards and found that some of the gizzards were still full of ingesta and intestinal digestive juices, some had partial stomachs attached, and one had a piece of intestine approximately 6" long with fecal material still present inside. The conveyor belt and birds were potentially cross contaminated by the contents of the uncut gizzards, stomachs and intestine which are normally contaminated with various bacteria i.e. Salmonella, and are normally removed by step #31 according to the establishments' Hazard Analysis Flow Chart of the slaughter process. The conveyor belt was emptying off so I continued to collect the gizzards when (b) (6) arrived I explained to him the cross contamination issue and had him call (b) (6) who was informed of the noncompliance. The belt was rinsed with (b) (4) restoring sanitary conditions. There were approximately 90 uncut gizzards collected from the belt that had been there for an undetermined period of time. Birds normally exit the chillers at approximately 0025 hours and start to collect on the rehang belts. The birds remain on the belt for varying periods of time until selected for hanging. I proceed to line (b) (4) in Packaging which was being used to manually cutup Organic carcasses into parts for packaging. These birds come from the same chiller. There was a uncut gizzard on a pile of half breast collected at that location. (b) (6) was nearby. The gizzard with a partial stomach attached was removed. The gizzard was full of ingesta and digestive juices. The breast halves near the location of the gizzard were reconditioned and returned to production. The area was rinsed with (b) (4). I proceeded to the Superintendents office and discussed the issue with the (b) (6). I informed him of the possible cross contamination issue and that I would place product that may have come into contact with the bacterial source, the gizzards and intestine, on hold. I proceeded to the Staging Cooler and placed USDA hold tags on 27 pallets of Organic Front halves by approximately 0315 hours. I proceeded to the USDA Office and informed SCSI (b) (7)(C) and SVMC (b) (7)(C) of the issue and that product was involved. (b) (6) and Dr. (b) (7)(C) discussed the issue and I was told by Dr. (b) (7)(C) to release the product. All product was released by approximately 0340 hours. A review of the establishments' SSOP - (b) (4) under Daily Procedures states (b) (4) " and (b) (4) " A review of the (b) (4) states (b) (4)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							(b) (4) [REDACTED] My finds indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), and 9 CFR 416.14.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5608014 725N-1	01/25/2013	01D01	SPS Verification	C	On 01/24/2012 at approximately 2240 hours while monitoring Operational Sanitation procedures at startup in Plant #2, I observed the following. There was a shiny metal flake approximately 2mm by 1mm in size on the Transfer Belt for line (b) (4). At this point in the process the birds are being moved from the kill line to the evisceration line. As the birds were arriving at the automatic re-hang machine for the line and with the potential of a physical hazard being added to the product, I removed the metal flake and showed it to (b) (6) who was monitoring the rehang equipment in the same location. A row of metal pins is used to hold the fabric of the belt together. I showed (b) (6) the condition of the metal pins associated with the transfer belt. The stainless pins on both transfer belts for lines (b) (4) were in similar condition. There appeared to be one to four pins missing on the both ends of both transfer belts. Several more pins on both belts were separated from one end of the belt material. The tops of many of the pins have wear marks that are normally caused by a rubbing action and is a possible source of the metal flake. A review of the HACCP plan - Slaughter plant 2 under (P) Physical Hazards has "None Identified". Under 'Justification for Decision' there are no reasons listed or supplemental documents listed as support for the decision. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).
5308	M6137	BXL1105010 424N-1	01/24/2013	06D02	Other Inspection Requirements	C	On 01/24/2013 at approximately 0032 hours while monitoring Presentation on line (b) (4) in Plant #2, I observed the following. At a line speed of (b) (4) bpm (birds per minute) station #1 had (2) viscera not uniform, (1) viscera on the shackle, (5) membranes, (3) not reflective for a total of 40 weighted nonconformance points from a standard 10 bird check. An accumulation of 40 or more nonconformance points requires an immediate line speed reduction to 81 bpm. I contacted (b) (6) and the line was slowed. The 2nd station had (3) membranes, (3) not reflective, and (2) parts inside. Station #3 had (3) viscera on the shackle, (1) membrane, (2) not reflective and (1) contamination inside for a total of 36 nonconformance points. Three occurrences for the same error or more than 25 total points are also failures requiring a recheck. (b) (6) was informed that all three stations on line (b) (4) had failed. A Quality Control recheck at 0057 hours failed at 2nd of the 3rd stations with (4) not reflective at station #2, and (3) no viscera and (3) not reflective for 30 total points at station #3. The line was slowed to 71 bpm. QC rechecks at 0107 hours, 0121 hours and 0127 hours all passed bringing the line back into compliance. My findings indicated a noncompliance with 9 CFR 381.76(b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN500201 0824N-1	01/24/2013	01D01	SPS Verification	C	At approximately 2354 hours I, CSI (b) (7)(C), and CSI (b) (7)(C) were in the Wet cooler performing the review and observation element of the Sanitary Performance Standards task. In the Wet cooler I observed six racks of product, code #920 in dirty baskets. On the baskets I observed pieces of fat and muscle tissue, dried blood, and black spots of foreign material. Upon further inspection the product's immediate packaging, individually sealed plastic containers, was also covered in black foreign material. The racks had a written temporary labels that read, "#920, back to cherry, date 1/23/13". I then retained the six racks with the U.S. retain tags sited in section 9B of this document, and informed Fillet Swing Shift (b) (6) of the noncompliance. (b) (6) was also informed of the noncompliance. After I verified that sanitary conditions were restored by the baskets and product's immediate packaging being cleaned of the visible foreign material, product was released to be repacked in new containers. The dirty packages and baskets represent a noncompliance with 417.4(d) which states: Product must be protected from adulteration during processing, handling, storage, loading, unloading at and during transportation from official establishments.
5308	M6137	BXL0808011 024N-1	01/23/2013	01C02	Operational SSOP Review and Observation	C	On 01/24/2013 At approximately 0135 hours while performing a scheduled Operational SSOP Review and Observation task, SCS (b) (7)(C) and I were walking in Plant One around the back side (south end) of rehang weight chute area next to Line (D). We observed condensation dripping from an unsanitary structure, a catwalk, into a large metal tank of product. I immediately tagged the tank with retain tag #B31407307, and notified (b) (6). Product was reworked and placed into a sanitized tank and covered with plastic to prevent any further contamination. Product was released at 0205 hours. My findings indicate a noncompliance with the regulatory requirements of 9CFR 416.2(d) and 9 CFR 416.4(d).
5308	M6137	BXL1112015 923N-1	01/23/2013	03J02	Slaughter HACCP	C	While performing a Finished Products Standards Task, I found a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 0823 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination outside of the bird located on the back of the tail in the right side. The fecal material was spot measuring approximately 1/8" diameter in size, green olive in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0855 hours and it passed. The cause of the deviation was the water pressure. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1718013 222N-1	01/22/2013	01D01	SPS Verification	C	At approximately 1440 hours, CSI's (b) (7)(C) and I observed a live juvenile cockroach on the wall between the hands wash sink and the paper towels dispenser in the body opener area in Plant #2. The cockroach was caught and immediately shown to the (b) (6). He immediately called (b) (6) and informed him about our findings. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2 (a).
5333	P7632	HYE310201 1122N-1	01/22/2013	01B02	Pre-Op SSOP Review and Observation	C	On 1/21 /13 at approximately 2315 hours I observed the following while performing the SSOP Review and Observation task . Unit # 3 of area 3 the incline conveyor flex belt had a build-up of yellowish/brown UMF (unidentified foreign material) underneath the frame between the flex belt and the inner portion of the frame . The area was approximately 2" in width and approximately 8" to 10" in length I immediately applied U.S . Retained/Rejected tag # B38493695 on the conveyor and brought my finding to the attention of (b) (6) who was standing near . (b) (6) Had 2 of his workers scrub and rinse the bottom and the inside of the frame work .The area was reinspected at approximately 2325 hours . Sanitary conditions were restored and the tag was removed . The conveyor was resanitized and the area was ready for production. My findings indicate non-compliances with the following regulations 9CFR 416.4(b) , 9CFR 416.14 , 9CFR 416.4(a) , 9CFR 416.13 and 9CFR 416.13(c) .
5308	M6137	BXL2320010 721N-1	01/21/2013	06D02	Other Inspection Requirements	C	At approximately 1544 hours while monitoring the "No Viscera Log" for Line #1 and Line #2 in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). Line #2 had five consecutive failures by Quality Control. At 0802 hours at line speed of (b) (4) BPM, Quality Control documented 25 no viscera only 13 are allowed. At 0825 hours the recheck failed with 24 no viscera. Line Supervisor was informed and at 0841 hours, the line speed was reduced to 126 BPM. At 1031 hours at line speed of 126 BPM Quality Control documented 16 no viscera and only 11 are allowed. Three consecutive failures in a half- shift period is a noncompliance for lack of process control. I informed (b) (6) of the noncompliance. Two more consecutives checks failed, one at 1334 hours with 24 no viscera and another one at 1533 hours with 18 no viscera at the same line speed of 126 BPM.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN130301 3022N-2	01/20/2013	03C02	Raw Intact HACCP	C	<p>At approximately 0245 hours while performing the Review and Observation component of a Raw Intact Verification PHIS Task; CSI, (b) (7)(C) and I, CSI (b) (7)(C), observed approximately 7 pieces of dark meat (boneless thighs) that were on the top of the cover of the (b) (4) #1, which is not edible product contact surface, in the Packaging department. As part of the SIP Waiver that was granted to the establishment, we decided to take the temperature on the pieces of dark meat. We requested to (b) (6), to take the temperature with her calibrated thermometer #471. One piece registered its internal temperature at 61.3 F. Mr. (b) (6), requested to take the temperature one more time. On the second recheck, the internal temperature registered was 63.1 F. The finding of temperatures above (b) (6) degrees F does not comply with the SIP waiver granted to the establishment by USDA/FSIS and does not meet the regulatory requirements of sections 381.3 and 417.5(a) of the 9 Code of Federal Regulations. 9 CFR 381.3 states, "Administration.(b) The Administrator may in specific classes of cases waive for limited periods any provisions of the regulations in order to permit appropriate and necessary action in the event of a public health emergency or to permit experimentation so that new procedures, equipment, and processing techniques may be tested to facilitate definite improvements: Provided, That such waivers of the provisions of the regulations are not in conflict with the purposes or provisions of the Act." 9 CFR 417.5(a) states, "(1) the written hazard analysis prescribed in § 417.2(a) of this part, including all supporting documentation;(2) The written HACCP plan, including decisionmaking documents associated with the selection and development of CCP's and critical limits, and documents supporting both the monitoring and verification procedures selected and the frequency of those procedures. The SIP protocol using the alternative chilling procedures in place of 9 CFR 381.66(b), states, (b) (4)</p> <p>(b) (4)</p> <p>(b) (4). The establishment elected to condemn the affected product. Mr. (b) (6), was informed of the forthcoming documentation for the failure to comply with the establishment's SIP program and the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN420501 5718N-1	01/18/2013	03C02	Raw Intact HACCP	C	<p>On 1/17/13 I was in the Fillet Department and observed numerous tray pack racks lined up to be sent into the crust tunnel. I then used my sanitized digital thermometer to measure the temperature of one package of boneless skinless breast, the temperature was 61.0 F. I then retained the rack from which the tray pack was retrieved with U.S. retain tag B38495476. I showed (b) (6) my findings and requested a Q.C. Technician to take a temperature measurement with a calibrated thermometer (b) (6) used calibrated thermometer # 427 and measured the temperature of the product to be 60.4 F. I then requested more readings from the same rack and we found two packages at the following temperatures: 58.7 F and 59.5 F. I informed (b) (6) of the forthcoming noncompliance for product exceeding 60 F. The last passing temperature check for boneless skinless breast was taken at 2037 hours, temperature measurement was 38.8 F. Establishment P-6137 A was granted a Salmonella Initiative Program Letter issued on September 9, 2011. The SIP program allows establishment P-6137A to use alternative chilling procedures in place of 9 CFR 381.66(b), provided the establishment: Assesses, modifies and validates as appropriate, the Hazard Analysis and Critical Control Points (HACCP) plan according to 9 CFR 381.22 and 417.4. The establishment failed to implement their SIP program by allowing the internal temperature of their product to rise above 60 degrees F. SIP protocol states: "(b) (4) ."</p> <p>In addition establishment P 6137 A prerequisite CP-4B SOP states: "(b) (4) ."</p>
5308	M6137	BXL4718010 317N-1	01/17/2013	03J02	Slaughter HACCP	C	<p>At approximately 1550 hours while performing a HACCP Slaughter Record Review Task, CSI (b) (7)(C) and I found the following; the HACCP Monitoring Log - CCP 2B, Line # (b) (4) dated on 01/16/2013 AM shift had a failure at approximately 0633 hours. Corrective actions were performed and finished at approximately 0850 hours. The Pre-Shipment Records Review CCP 2B (b) (4) End of Shift, was signed at 0800 hours. The signed documented certifies that the product is ready to be shipped. The Pre-Shipment Records Review, End of Shift was signed before the corrective actions for the failure were completed. This is a noncompliance with the following regulatory requirements of regulations 9CFR 417.5 (c). I informed (b) (6) of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE030501 4817N-1	01/17/2013	04A06	Poultry Finished Product Standards	C	On Wednesday 01/16/2013 night shift there was a high percentage of birds presented for post-mortem inspection that were identified by the on line inspectors for airsacculitis removal. The establishment had initiated their alternative On-line Vacuuming/Air sac Removal procedure. At 0230 hours I elected to verify the effectiveness of the alternative procedure. I went to the FPS Pre-Chill Station on line 1 and collected a ten (split tail) bird sample. Three of the ten birds exhibited air sac exudate on the left side along the ribcage area; one of the ten birds had intact kidneys indicating that the vacuum procedure was ineffective. QC performed the required ten bird retest, there were no failure findings on the retest. I notified (b) (6) of the forthcoming documentation for the failure to comply with the regulations cited above.
5309	P6137A	NJN062201 1116N-1	01/16/2013	04A06	Poultry Finished Product Standards	C	At approximately 0455 hours I was performing the Review and Observation component of a Finish Products Standards PHIS Task. At the offline inspection station I collected a sample consisting of 10 carcasses from which 1 carcass marked with split tail had airsacculitis exudate in the rib cage. I showed my finding to (b) (6). I initiated a recheck of 10 carcasses marked with a split tail and again 1 carcass had airsacculitis exudate in the rib cage. (b) (6) began immediate corrective actions as prescribed in the establishment's vacuum procedure. I informed (b) (6) of the forthcoming noncompliance. The establishment failed to remove airsacculitis exudate from carcasses marked by USDA online inspection personnel. 9 CFR 381.84 requires that establishments completely remove and condemn tissues affected with airsacculitis, including exudates, in carcasses not condemned. Two noncompliances were documented for the same cause on 11/23/2012 NR# NJN0409114623N/1 and on 1/15/2013 NR# NJN3407011415N/1.
5308	M6137	BXL0309014 715N-1	01/15/2013	04A06	Poultry Finished Product Standards	C	On 01/15/2013 at approximately 0025 hours while monitoring the Establishments' Post-Chill Finished Product Standards in Plant 1 from Chiller #1, I observed the following. After collecting a random 10 bird sample, I accumulated 21 nonconformance points which exceeded the subgroup absolute limit of 10 points. I informed (b) (6). A QC recheck failed with 14 points at 0032 hours. The limit at the Post-Chill for a recheck is Tolerance which is 5 points. At this point the process is judged to be out of control. Production was aware and had tanked the failing product since the initial birds exited the chiller. A QC recheck failed again at 0109 hours with 8 nonconformances. A recheck at 0259 and 0512 hours brought the process back into control. A total of 8 tanks of carcasses were placed on QC hold pending rework. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv)(e)(3).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2914012 015N-1	01/15/2013	04A06	Poultry Finished Product Standards	C	While monitoring the Establishments' Reprocessing Procedures on Line 9 in Plant #2, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.84. At approximately 0900 hours, I randomly removed a 10 bird sample for my reprocessing check, I found three out the eight birds with split tails in the sample that contained Airsacculitis exudates. I immediately took regulatory control action by stopping the line and informed the (b) (6) and also (b) (6). The line was started and the product retained while corrective actions were being implemented. I performed a recheck at approximately 0910 hours and it passed bringing the process back in control. I tagged the tank containing the product with U.S. Retained/Rejected Tag # B31 406714. After the product was reworked, I performed a recheck and released it , at approximately 0940 hours.
5309	P6137A	NJN340701 1415N-1	01/15/2013	04A06	Poultry Finished Product Standards	C	At approximately 0505 hours I was performing the Review and Observation component of a Finish Products Standards PHIS Task. At the offline inspection station I collected a sample consisting of 10 carcasses from which 4 carcasses marked with split tail had airsacculitis exudate in the rib cage. I showed my finding to (b) (6). According to the establishment's vacuum procedure 3 carcasses with vacuum defects it requires retention and rework of the affected product. (b) (6), initiated immediate corrective actions as pescribe in the establishment's vacuum procedure. The establishment failed to remove airsacculitis exudate from carcasses marked by USDA online inspection personnel. 9 CFR 381.84 requires that establishments completely remove and condemn tissues affected with airsacculitis, including exudates, in carcasses not condemned. Mr. (b) (6), was informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0918013 011N-1	01/11/2013	06D02	Other Inspection Requirements	C	<p>At approximately 1445 hours, while monitoring the "No Viscera Log" for Line #1 and Line #2, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). --Line #1 had three consecutive failures by Quality Control in a four hours period, before lunch time break. At approximately 0816 hours at line speed of (b) (4) BPM, Quality Control documented 36 no viscera and only 13 no viscera or less are allowed. At approximately 0842 hours, Quality Control recheck failed with 26 no viscera at line speed of (b) (4) BPM. Line Supervisor was informed and at approximately 0851 hours the line speed was reduced to 126 BPM. At approximately 1018 hours at line speed of 126 BPM, Quality Control did her regular check and failed with 19 no viscera. At this line speed only 11 no viscera or less are allowed. --Line #2 had also three consecutive failures by Quality Control in a four hours period, before lunch time break. At approximately 0811 hours at line speed of (b) (4) BPM, Quality Control documented 21 no viscera and only 13 no viscera or less are allowed. At approximately 0838 hours, Quality Control recheck failed with 21 no viscera at line speed of (b) (4) BPM. Line Supervisor was informed and at approximately 0846 the line speed was reduced at 126 BPM. At approximately 1031 hours at line speed of 126 BPM, Quality Control did her regular check and failed with 19 no viscera. At this line speed only 11 no viscera or less are allowed. At this point both lines were out of control. Three consecutive failures is a noncompliance for a failure to take proper corrective actions. (b) (6) was informed about the noncompliance. Line #1 was back in control at approximately 1455 hours and Line #2 remained at 126 BPM till the end of the shift.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1409010711N-1	01/11/2013	01C02	Operational SSOP Review and Observation	C	<p>On 01/11/2013 at approximately 0630 hours while reviewing the establishment SSOP records and associated documents, I observed the following. On 12/31/2012 a noncompliance BXL4107122331N/1 was written for product from plant #1 being contaminated with UFM (Unidentified Foreign Material). On 01/02/13 at 0028 hours the establishment retained product contaminated with UFM that was exiting the plant #1 chillers. The cause of the contamination was determined to be dirty city water. At the weekly meeting on 01/02/2013 the issue of contaminated product with dirty city water was discussed with plant management and documented on MOI BXL3019012102G. Maintenance was to contact the city to solve the problem. On 01/09/2013 at 1320 hours the establishment shutdown plant #1 as a result of dirty city water contaminating product. At 1353 hours on 01/09/2013 product exiting the giblet chillers was found to be contaminated with foreign material. The cause again was determined to be dirty city water. On 01/10/2013 at 0025 hours product exiting the Plant #1 chillers was retained for being contaminated with foreign material. On 01/11/2013 at 0025 hours product exiting the Plant #1 chillers was retained for being contaminated with foreign material. A review of the establishments Operational Sanitation SSOP 'Corrective Action' states in part under '(b) (4)' [REDACTED]. " No effective preventative measure has been established as the contamination of product in Plant #1 from dirty city water continues. My findings indicated a noncompliance with 9 CFR 416.15(b) which states in part 'Corrective Actions include... appropriate reevaluation and modification of the Sanitation SOP's and the procedures specified therein or appropriate improvements in the execution of the Sanitation SOP's or the procedures specified therein.' 9 CFR 416.4(d), 9 CFR 416.14 and 9 CFR 416.1.</p>
5308	M6137	BXL5409013011N-1	01/11/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1400 hours, while walking through the (b) (4) Room, I observed a brown tub on the reprocessing station. This tub was located on the right side of the reprocessing station next to a conspicuous "clean product" red sign. I removed the lid and found the tub full with product. I proceeded to verify compliance with the establishment's Product reconditioning Procedure. I inspected the already reconditioned product, finding one fillet and two half breast contaminated with several small specks of freing material. I immediately place a US. Rejected/Retained tag NO. B31 407744 on the affected product. I notified (b) (6) and (b) (6) [REDACTED] of the noncompliance. All products was reconditioned again. At approximately 1500 hours, I re-inspected the reconditioned product finding it acceptable. I then, remove the USDA hold tag. My findings represent a noncompliance with regulation 9 CFR 416.4(d); 416.14 and 416.1</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5804013 911N-1	01/11/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 01/10/2013 at approximately 2210 hours while monitoring the establishments' Pre-Operational Sanitation procedures in Plant #2, I observed the following. There were numerous specks to approximately 1/8" of black UFM(Unidentified Foreign Material) on the transfer table for line (b) (4). The guide bars for lines (b) (4) adjacent to the transfer table were coated with a thick layer of fat, blood, tissue and feathers. There is a section of guide bar approximately 5' long on line (b) (4) located along the wall just before the line (b) (4) transfer table that is worn half away. The internal surfaces of the guide bar were partially filled with sour fat & tissue from previous days production. This deteriorating maternal condition is creating an insanitary condition. There are several short sections of the rail at the same location for lines (b) (4) that are deteriorating into layers of flaky rust. The rail is directly above the birds during production potentially contaminating product. There was numerous pieces of welding slag to approximately 1/4" on the top of the sprocket associated with the oil sack cutter for line (b) (4). The support brackets above the line (b) (4) oil sack cutter were coated with a greasy film of brown UFM. There is no catch tray associated with the unit that would protect the product during production. There was a thin coating of brown UFM with the consistency of dry rust on the shaft and kickout assembly for the second station on line (b) (4). The kickout is directly above the carcasses which are open at this point in the process. There was peeling paint & rust on the support brackets associated with sprocket directly above the gizzard puller assembly on line (b) (4). Carcasses run directly under the unit and are open at this point in the process. There was a black powdery UFM with small shiny specks that could be metal directly under the chain drive portion of the gizzard puller on line (b) (4). There is no catch pan associated with the gizzard puller units creating a potential for the UFM to contaminate carcasses during production. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.2(b)(1), 9 CFR 416.13(c) and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3617010 910N-1	01/10/2013	06D02	Other Inspection Requirements	C	While performing No Viscera Check on Line #1 and Line #2 at approximately 1351 hours, I found a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). Line #2 had three consecutive failures by Quality Control in a four hours period before lunch break. At approximately 0811 hours at line speed of (b) (4) BPM, Quality Control documented 21 no viscera and only 13 no viscera or less are allowed. At approximately 0840 hours at line speed of (b) (4) BPM, Quality Control recheck failed with 18 no viscera. Line Supervisor was informed and at approximately 0847 hours, line speed was reduced to 126 BPM. At approximately 1027 hours at line speed of 126 BPM, Quality Control documented 12 no viscera and only 11 no viscera or less are allowed. At this point the process is out of control. Three consecutive failures is a noncompliance for a failure to take proper corrective action. At approximately 1320 hours at line speed of 126 BPM, Quality Control documented 13 no viscera, only 11 no viscera or less are allowed. At approximately 1501 hours at line speed of 126 BPM the check passed with 11 no viscera. At approximately 1509 hours at line speed of (b) (4) BPM the check passed with 9 no viscera, bringing the process back in control. I informed (b) (6) of the noncompliance.
5308	M6137	BXL5717011 910N-1	01/10/2013	01D01	SPS Verification	C	At Approximately 1037 hours while performing scheduled Operational SSOP Review and Observation task I was walking into the packaging area from Plant #2, I observed the following noncompliance. I was looking down the Cut Up Line (b) (4) when I looked up and noticed heavy beaded condensation covering the bottom of the drip pan that is below the large exhaust fan on the ceiling. The drip pan is directly above the line of carcasses that go to Line (b) (4) in packaging. I immediately notified (b) (6) of my findings and showed him the condensation. He immediately had a sanitation employee get a ladder to reach the affected area and had another Supervisor stop employees from hanging on that line to create a gap in the carcasses, when the gap reached the affected area the line was stopped and sanitation cleaned the drip pan without affecting product. Sanitary conditions were restored by approximately 1049 hours. My findings indicate a noncompliance with the Regulatory requirements of 9 CFR 416.2(d) and 9 CFR 416.1.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN291801 1110N-1	01/10/2013	03C02	Raw Intact HACCP	C	<p>On January 9, 2013 at approximately 1736 hours, while performing PHIS procedure Raw Intact in Packaging Department, while the establishment was processing and packaging Buffalo Chicken Breasts with a marinade that declares in the label to contain allergens (dry milk), I observed the following non compliance: Allergen residue inside a tote that was half full of product of boneless thigh meat next to the dark meat conveyor. The ice inside the tote covering the product, had visual traces of allergen residue. I immediately placed U.S. Retained Tag #B39415825 to the product and informed Mr. (b) (6) of the non compliance. Mr. (b) (6) elected to condemn the product instead of rework. At approximately 1835 hours, I decided to inspect the process again and observed at the end of the dark meat conveyor line, just prior to the (b) (4), a strip of plastic (14 to 15 inches long) that was smeared with the allergen marinade and was resting on top of boneless thighs, (10 to 15 lb). Closer inspection revealed that the boneless thigh meat table that runs parallel to Buffalo Chicken Breasts had specs of marinade all along that specific side. I immediately showed my findings to (b) (6) and (b) (6) and informed them that this instance would be added to the forewarned non compliance. Mr. (b) (6) elected to condemn the product immediately so no tag was applied and to seize production for the day. Boneless dark meat product on the table is retained by the establishment. Establishments hazard analysis address allergens as not reasonably likely to occur because of their Pre-requisite program which states: (b) (4)</p> <p>The establishment's Pre-requisite program failed to determine the unforeseen hazard of allergenic cross-contamination.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE310401 5911N-1	01/10/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 2345, I began a preoperational inspection of the establishment's 2nd processing area. This inspection began after I was notified by the designated establishment employee that the area was ready for inspection. While inspecting a blue product transfer belt, I found fat residue build-up from previous usage on the product contact surface side of the belt. Mr. (b) (6) was in the vicinity at the time of my finding and was both informed of and given the opportunity to observe the condition of the product transfer belt. Immediate corrective actions were then taken by establishment personnel to restore the sanitary condition of the belt. After the establishment's corrective actions were completed, I re-inspected the product belt and determined that it was acceptable for use. The establishment did not adequately monitor the implementation of the Sanitation SOP resulting in noncompliance with 9 CFR 416.13(c). In addition, the establishment did not meet the requirements of 9 CFR 416.1 which requires that each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions. Finally, 9 CFR 416.4(a) requires that all food contact surfaces must be cleaned and sanitized as frequently as necessary to prevent the creation of an insanitary condition.
5308	M6137	BXL0613013 209N-1	01/09/2013	03J04	Poultry Zero Tolerance Verification	C	At approximately 1022 hours, I found a noncompliance with regulatory requirement of regulation 9 CFR 381.65(e) and 9 CFR 417.2(c)(4). I randomly removed 10 birds from line P4 in Plant 2 to perform a Zero Tolerance Fecal check, finding one out of ten birds contaminated with feces. The fecal material was located inside of the carcass by the vent area. It was dark brown in color and pasty in texture measuring approximately 1/16" in diameter. I immediately notified (b) (6) of the noncompliance. The Fecal Protocol was implemented. The cause of deviation was the sprayers. At approximately 1043 hours, after the sprayers were adjusted, QC performed a passing recheck which brought CCP 2B back in control. From 1122 hours to 1222 hours, Post Chill checks were performed on the suspect lot. All product coming out of chiller 3 was found acceptable.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1215012 209N-1	01/09/2013	06D02	Other Inspection Requirements	C	On 01/7/2013 The (b) (4) Line 1 and 2 NO VISCERA MONITORING LOG records reflected a noncompliance with regulatory requirement of 9 CFR 381.76(a)(b). At 1318 hours QC performed a no viscera check in line 1, failing with 19 no viscera nonconformances. The line was running at (b) (4) BPM (birds per minute) which allows 13 or less no viscera to be in compliance. Maintenance was notified. At 1341 hours, QC performed a recheck at (b) (4) BPM, failing with 17 no viscera nonconformances. The line speed was reduced to 126 BPM. At 126 BPM 11 or less no viscera nonconformances are allowed. At 1538 hours QC performed a recheck at line speed 126 BPM failing the line with 13 no viscera nonconformances. Production continued running line 1 at 126 BPM the remainder of the day with out any further corrective action. At 1345 hours QC performed a no viscera check in line 2, failing with 33 no viscera nonconformances. The line was running at (b) (4) BPM (birds per minute) which allows 13 or less no viscera to be in compliance. Maintenance was notified. At 1402 hours, QC performed a recheck at (b) (4) BPM, failing with 24 no viscera nonconformances. The line speed was reduced to 126 BPM. At 126 BPM 11 or less no viscera nonconformances are allowed. At 1530 hours, QC performed a recheck at line speed 126 BPM failing the line with 23 no viscera nonconformances. Production continued running line 2 at 126 BPM the remainder of the day without any further corrective action. My findings reflect the establishment's failure to correct the deficiency and therefore, lack of control in the process. On 01/09/2013, (b) (6) was notified of the noncompliance.
5308	M6137	BXL2014013 609N-1	01/09/2013	06D02	Other Inspection Requirements	C	On 01/05/2013 The (b) (4) LINE #2 - NO VISCERA MONITORING LOG records reflected a non compliance with regulatory requirement of 9 CFR 381.76(a)(b). At 0817 hours QC performed a no viscera check in line 2, failing with 27 no viscera nonconformances. The line was running at 126 BPM (birds per minute) which allows 11 or less no viscera to be in compliance. Maintenance was notified. At 0852 hours QC performed a recheck at 126 BPM, failing with 18 no viscera nonconformances. Lead person was notified as well as maintenance once again. Despite the establishment's failure to meet the standards at 126 BPM, line speed remained at 126 BPM. At 1028 QC performed another recheck at 126 BPM, failing with 19 no viscera nonconformances. All these failures represent the establishment's lack of control in their process. After 5 1/2 hours, the process was brought back in control with two passing rechecks. First passing recheck at 1319 hours at 126 BPM line speed and the second passing recheck at 1336 hours at (b) (4) BPM line speed. On 01/09/2013, (b) (6) was notified of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3408010 209N-1	01/09/2013	03J02	Slaughter HACCP	C	On 01/09/2013 at approximately 0130 hours while monitoring the Establishments' Finished Product Standards in Plant #2 line (b) (4) I observed the following. After removing a 10 bird random sample, I observed two birds with visible fecal contamination. There was a cloacae with approximately 6" of intestine attached inside the carcass at the base of the tail. The fecal material was leaking from the cut end of the intestine into the left kidney area. The fecal material was olive green in color, pasty in texture and approximately 1/8" in size. I washed my gloves thoroughly before examining the remaining four carcasses for FPS standards. The last carcass of the ten bird sample also had visible fecal contamination on the front of both legs approximately 2" from the hock. The fecal material was olive green in color, pasty in texture and measured approximately 1/4" by 1/8" on the left leg and approximately 1/8" by 1/8" on the right leg. (b) (6) was informed. The protocol for fecal failure was implemented. A QC recheck passed at 0156 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP 2B Zero Tolerance Fecal Contamination of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL4008010 009N-1	01/09/2013	01C02	Operational SSOP Review and Observation	C	On 01/09/2013 at approximately 0030 hours while monitoring Operation Sanitation Standards in the Plant #2 Multi-Vac cooler, I observed the following. There was a partial pallet of brown product tubs with product giving off a strong odor. The partial pallet was made up tubs labeled 090294 Keel Cartilage 020-0342-1361, 12/7 salvage keel bone, and 12/5 AM shift. It was impossible to tell how many of the 9 total tubs were stored under which dated label. The cooler was at approximately (b) (4) degrees. The product was very slimy and gave off a very strong pungent odor that was evident immediately upon entering the cooler. I noticed previously on 01/02 in the same cooler a similar odor with decaying product being condemned by an establishment supervisor on that date. I believed the problem to be solved however the odor kept getting stronger as the days passed. A review of the Establishments' Operational Sanitation procedures SSOP Daily Implementation Monitoring Logs for the past week indicate that the coolers are monitored (b) (4) by QC personnel and are always found to be 'Acceptable'. A total of approximately 250 pounds in 9 partial tubs was condemned in the edible dump room. I monitored the washing and sanitizing of the stainless tank involved with (b) (4) being applied (b) (4) before releasing it. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(d), and 9 CFR 416.4(d)

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4916013 009N-1	01/09/2013	06D02	Other Inspection Requirements	C	<p>On 01/08/2013 The (b) (4) LINE 2 - NO VISCERA MONITORING LOG records reflected a non compliance with regulatory requirement of 9 CFR 381.76(a) and (b). At 0818 hours QC performed a no viscera check in line 2, failing with 18 no viscera nonconformances. The line was running at (b) (4) BPM (birds per minute) which allows 13 or less no viscera to be in compliance. Maintenance was notified. At 0843 hours, QC performed a recheck at (b) (4) BPM, failing with 32 no viscera nonconformances. The line speed was reduced to 126 BPM. At 126 BPM 11 or less no viscera nonconformances are allowed. At 1021 hours QC performed a recheck at line speed 126 BPM failing the line with 17 no viscera nonconformances. Production continued running line 2 at 126 BPM the remainder of the day. There were two more failures during the afternoon at 126 BPM. At 1302 hours, 16 no viscera nonconformances out of 11 no viscera allowed and at 1509 hours, 19 no viscera nonconformances out of 11 no viscera allowed. There was a total of 5 consecutive failures during the day. My finding reflect the establishment's failure to correct the deficiency and therefore, lack of control in the process. On 01/09/2013, (b) (6) was notified of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0822014 505N-1	01/05/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 01/05/2013 at approximately 1815 hours while monitoring Operational Sanitation procedures in Plant #1 at the end of the shift, I observed the following. A sanitation employee in the Line ^{(b) (6)} room area was washing tanks as they were being emptied by production. The cleaning process was taking 1-2 minutes per tank as the employee was keeping up with production. As production emptied a tank the one being washed was covered with blue plastic and pushed into the Plant #1 cooler. The blue plastic is the establishments way of identifying that a tank is clean and ready for use. Tanks 14-L, 4-L, #123, #112, N-4, #20, 81-L, 39L, N-3, 1-L, #102, 64-L, #72, 58-L, #125, 63-L and #124 were all cleaned in a 30 minute period while I observed. The Establishments' Pre-Operational Sanitation procedure under 'Wet Clean-Up (food contact surfaces)' states in part "(b) (4) ^{(b) (6)} ^{(b) (6)}." The employee was adding the foam cleaner to the tanks with varying amounts of necks, giblets, fat and bloody fluids still inside. I was told previously by (b) (6) ^{(b) (6)} that to be effective the Foam Cleaner that the establishment uses must be in contact with the product contact surface for a minimum of 5 minutes. The employee washing the tanks was rinsing off the foam cleaner immediately after it was applied not even waiting for the foam cleaner to run down the inside surfaces to the bottom of the tank before rinsing it off. (b) (4) ^{(b) (6)} ^{(b) (6)}." There appeared to be no 'Check' step being performed as the tanks being covered still had pasty fat on the inside surfaces of the tanks to approximately 1/4". "(b) (4) ^{(b) (6)} ^{(b) (6)}." I went to the office but could not find a Sanitation Supervisor, however (b) (6) ^{(b) (6)} was nearby so I had him observe the process being used. He agreed that established procedures were not being followed. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c), and 9 CFR 416.14.</p>
5308	M6137	BXL2717011 105N-1	01/05/2013	03J02	Slaughter HACCP	C	<p>At approximately 1240 hours, I found a noncompliance with regulatory requirement of regulation 9 CFR 381.65(e) and 9 CFR 417.2(c)(4). I randomly removed 10 birds from line 1 in Plant 1 to perform a Finish Product Standard check, finding one out of ten birds contaminated with feces. The fecal material was located on the right flap of the bird. It was dark brown in color and pasty in texture measuring approximately 1/8" in diameter. I immediately notified (b) (6) ^{(b) (6)} of the noncompliance. The Fecal Protocol was implemented. The cause of deviation was a loose guide rail inside the cropper. At approximately 1310 hours QC performed a passing recheck which brought CCP 2B back in control. Post Chill checks were performed from 1400 hours to 1445 hours. All product coming out of chiller 1 was found acceptable.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3609010 805N-1	01/05/2013	06D02	Other Inspection Requirements	C	On 01/04/2013 at approximately 2248 hours while monitoring Plant #1 at startup, I observed the following. There was approximately half the viscera missing on line #2. The line was stopped and (b) (6) called a mechanic. Adjustments were made to the PMT machine. I waited several minutes for the line to settle out after being restarted then performed a standard three minute no viscera check. The line failed with 49 no viscera at approximately 2302 hours at (b) (6) bpm (birds per minute). At (b) (6) bpm 13 no viscera are allowed. (b) (6) was informed. A recheck by Quality Control failed at 0107 hours with 45 no viscera at (b) (6) bpm. The line was slowed to 126 bpm. A Quality Control recheck at 0159 hours at 126 bpm again failed with 39 no viscera. At 126 bpm 11 no viscera are allowed. The line was kept at 126 bpm for the rest of the shift. This is a failure by the establishment to take proper corrective action. My findings indicated a noncompliance with 9 CFR 381.76(a) & (b).
5309	P6137A	NJN321601 5805N-1	01/05/2013	01C02	Operational SSOP Review and Observation	C	While performing an Operational Sanitation SSOP, at approximately 0756 hours, in Area #2-Packaging Section C, by the tub conveyor of Body Halver #2, and next to product conveyor for (b) (4) #4, I observed the following non compliance: A stream of liquid overflowing drip pan that runs underneath the line that supplies product to that unit, onto a bin that was staged by the Drum and Thigh conveyor. After closer inspection I noticed the bin was ¾ full of thighs and the liquid was splashing directly on the exposed product. I immediately took regulatory control of the product with USDA Retained Tag #B39415871, and showed and informed Mr. (b) (6) and (b) (6) of the non compliance. Mr. (b) (6) climbed the latter for body halver #2 and removed a whole front plugging the drain line restoring sanitary conditions. Product was reworked, inspected and released by USDA at approximately 0944 hours, and preventive measures were proffered.
5333	P7632	HYE440901 4105N-1	01/05/2013	04A06	Poultry Finished Product Standards	C	On 1/03/13 at 1040 hours, I was performing a finished product standards verification task, to verify the establishment's alternative online vacuum procedure on line one in the evisceration department. I selected ten carcasses marked for vacuum by a split tail. One out of the ten carcass sample had two full kidneys inside the carcass. I informed (b) (6) and (b) (6) of my findings. I then performed the required recheck and found lung tissue and airsacculitis adhered to the rib cage of one of the carcasses. I informed (b) (6) and (b) (6) of the noncompliance for the failure to meet the regulatory requirement cited above. No further rechecks were performed because the establishment chose to stop the alternative online vacuum procedure. In addition 9 CFR 381.76 table 1 #7 states: Lesions/conditions subject to removal following an approved cleanout process: Airsacculitis condition requiring removal of the kidneys.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3004013 604N-1	01/04/2013	01B02	Pre-Op SSOP Review and Observation	C	On 01/03/2013 at approximately 2350 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Packaging Area #1, I observed the following. There were several pieces of fat, blood and tissue to approximately 1/4" from the previous days production on a portable FPS table located between chillers 3 & 4. At the same location there was a portable tray that is used to direct product exiting the chillers to a rehang belt. The tray was stored on the floor. This is used as a product contact item and needs to be stored in a sanitary manner. Sanitary conditions were restored by approximately 2355 hours. At approximately 0105 hours there were numerous pieces of fat and tissue to approximately 1" on the overhead belt that transports wings to the packaging area. The section of the belt affected runs adjacent to the elevator. Approximately 20' of the belt was rewashed by approximately 0018 hours. In Packaging Area #2 the (b) (4) Deboning room there was fat and tissue to approximately 3" on two cutting wheels associated with the third machine along line #1 that makes the initial wing cuts. The machine was recleaned by approximately 0115 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0204011 403N-1	01/03/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 01/02/2013 at approximately 2303 hours while monitoring Pre-Operational Sanitation Procedures in the Rotisserie Room, I observed the following. There were three pallet jacks with pasty fat and tissue, and dried and semi-dried tissue to approximately 1/2" on the stainless product contact portion of the units. The affected arms of the pallets jacks which extend into the product during use were recleaned with green scouring pads, brown paper towels and a potable water rinse then released by approximately 2311 hours. In Packaging area #1 at approximately 2355 hours a section of approximately 15 stainless pins are missing on the half breast collection belt for line (b) (4). The affected area appears to rub on a white nylon divider at that location. This deteriorating belt condition has the potential of adding metal flakes to the product. There were several gray flakes from approximately 1/8" to 1/2" in size that appeared to be paint on the stainless and white nylon portions of Leg Processor #8. The paint on the overhead pipes above Leg Processors #7, 8 and 9 has severely deteriorated with numerous large areas of flaking paint. At approximately 0005 hours there were numerous pieces of dried and semi dried pieces of fat and tissue on the covers to the tray dispenser units for lines (b) (4). The items were rinsed and returned to service by approximately 0010 hours. At approximately 0016 hours in Processing area #2 the (b) (4) Room there was a red flake approximately 1/2" in size on the wing section collection belt near line #1 that appeared to be paint. There was also two small red flakes on the collection belt for the carcass shredder. that appeared to be paint. The red paint on the fire fighting system piping attached to the ceiling in the area from line #1 to the carcass shredder is deteriorated with numerous large areas of visible loose flakes. At approximately 0015 hours there was a large piece of tissue to approximately 4" on the blade of the carcass shredder. The unit gave off a strong offensive odor. A (b) (4) and potable water rinse was applied to the shredder and associated belt restoring sanitary conditions by approximately 0035 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(2), 9 CFR 416.4(a) and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1709012 203N-1	01/03/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0035 hours in Plant #1 at the end of the chiller out flow belt from chiller #2 an establishment employee was sorting contaminated carcasses from a stainless tank. The empty tank N-15 had up to approximately a 2" layer of contaminated ice and tissue in the bottom and numerous pieces of fat and tissue on the inside surfaces of the tank. The empty tank was pushed into the tank wash area by another establishment employee who rinsed it with potable water at approximately (b) (4) degrees and applied a spray of (b) (4) . The tank was then moved to the Check/Weight line area and used to collect WOG's (With Out Giblets) for Rotisserie. The tank still had numerous pieces of fat and tissue to approximately 1/2" and a puddle of brown fluid in a large depression in the bottom of the tank to approximately 1/2" deep. As the WOG's are finished product and were being cross contaminated by the residue in the tank, I applied US Retained tag B31406750 to the partially filled tank. I contacted (b) (6) and showed him the residue on the tank from the previous days production. The affected birds were rinsed with a (b) (4) rinse and returned to production. The tank was recleaned and released by approximately 0356 hours. A review of the Establishments Operational Sanitation SSOP Corrective Action Log for 01/02/2012 documented that 24 tanks of contaminated product was collected at 0047 hours. Tank N-15 was one of the affected tanks of contaminated product that was still being reworked. The Establishments SSOP under 'Operational Sanitation' Implementation states "(b) (4) ."</p> <p>The Operational Sanitation SSOP does not say how this is to be accomplished. Also under 'Corrective Action' the Operational Sanitation SSOP states "(b) (4) ."</p> <p>This action is to be accomplished by the "Plant Management Team Member". As I could not find any documentation in the daily SSOP file, I contacted (b) (6) . (b) (6) agreed that the 24 tanks should have been treated as a contaminated product contact surface, had seen no 'documented actions' entries on any logs, and was not aware of whom the night shift "Plant Management Team Member" was. My findings indicated a noncompliance with 9 CFR 416.1 , 9 CFR 416.4(a) & (d), 9 CFR 416.12(a), 9 CFR 416.13(c), 9 CFR 416.14 and 9 CFR 416.16(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5722014 302N-1	01/02/2013	01C02	Operational SSOP Review and Observation	C	On 01/02/2013 at approximately 1930 hours while monitoring Operational Sanitation Procedures in the Plant #2 Aged Breast Cooler, I observed the following. There was a partial pallet of brown product tubs with product giving off a strong odor. The partial pallet was made up of mixed product (legs, breast halves, front halves) with the majority of the pallet consisting of front halves. The front halves were a pale green color and gave off a strong pungent odor. There was no label on the product of any kind. I contacted (b) (6) who condemned the product which weighed (b) (4) pounds and disposed of it in the edible dump room by approximately 1940 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), and 9 CFR 381.145(b) which states that products need to be identified in some manner (not full label) such that inspection program personnel can re-inspect at any time or as often as they deem necessary to assure the products are not adulterated or misbranded.
5308	M6137	BXL4107122 331N-1	12/31/2012	01C02	Operational SSOP Review and Observation	C	On 12/31/2012 at approximately 0044 hours while monitoring the establishments Operational Sanitation procedures in Plant #1, I observed the following. There was brown UFM (Unidentified Foreign Material) specks and smears on the birds exiting Chillers #1 & #2. The UFM was on the cut surfaces of the breast, on the fat, skin and tissue around the neck area, and on the tissue at the abdominal opening at the tip of the keel bone. The amount of UFM varied from approximately 1" to several square inches in size. I took several samples from both chillers and from the bag fryer line going into packaging and contacted (b) (6). As product had been going into Packaging for approximately 15 minutes I requested that she call (b) (6) for guidance. (b) (6) arrived and was shown the UFM on the product. I returned at approximately 0115 hours and as no corrective action was in progress I contacted (b) (6) and showed him the product that I had retained earlier. I went to Packaging and found the birds being packaged on line (b) (4) to be acceptable. I proceeded to the Plant #1 Cooler and checked the first tanks of WOG's (With Out Giblets) that had been collected for Rotisserie and the first pallets of front halves that were collected for the (b) (4) Deboning room placing the product on hold. Having found the same brown UFM, I contacted (b) (6) and showed him the contaminated carcasses and product. He said that production was told that there might be a water quality problem in Plant #1. (b) (6) had the first birds exiting both chillers tanked. However, Establishment QC personnel found the birds acceptable and released them. Three pallets of front halves labeled PLANT #1 12:31 hours, 12:54 hours and 12:57 hours were later placed under QC hold pending reconditioning. Four tanks of WOG's labeled 18073 at 12:47 hours weighing (b) (4) pounds, 18072 at 1242 hours weighing (b) (4) pounds, 18071 at 1239 hours weighing (b) (4) hours, and 18079 at 1250 hours weighing (b) (4) pounds were also placed on QC hold pending reconditioning. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416 4(d) and 9 CFR 416.14. .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3204122 429N-1	12/29/2012	01B02	Pre-Op SSOP Review and Observation	C	On 12/28/2012 while performing Pre-operational Sanitation SSOP Procedures in Main Packaging, I found a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.2(d) and 9CFR 416.13(c). At approximately 2348 hours, while inspecting the halvers machine for plant #1, I observed numerous beads of condensation formed on the ceiling above the halvers machine. I immediately informed (b) (6) of the noncompliance. He then sent sanitation personnel to wipe off the condensation. I then went to inspected Line (b) (6) and Line (b) (6) and found heavy beads of condensation on the ceiling above where these two lines start at the west wall till the middle of the lines and also on the drip pans that are above these two lines. On the ceiling above Line (b) (6), (b) (4) along the west wall, it was also covered of condensation. I informed (b) (6) of the noncompliance. He sent sanitation personnel to wipe off the condensation, sanitation personnel used the air hose and the squeegee to restore sanitary conditions. At approximately 0021 hours, I reinspected and released the area.
5308	M6137	BXL1800121 828N-1	12/28/2012	01D01	SPS Verification	C	On 12/27/2012 at approximately 0700 hours a live cockroach was observed on the right leg of a carcass on line (b) (6) in Plant #2 at the end inspection station #12 by Inspector (b) (7)(C). The line was stopped and the live cockroach was caught and removed from the product. Three affected birds was removed from the line to be reprocessed. The roach was shown to (b) (6) and (b) (6). Cockroaches spread disease and filth. This is a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(a).
5309	P6137A	NJN371612 3328N-1	12/28/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 1411 hours while performing PHIS task for Zero tolerance on the Reprocessing Line, I observed one of the ten carcass sample with visible fecal material on the inside of the cavity adjacent to the right thigh of the bird. The fecal material was approximately one inch radius dark green in color and had a paste-like consistency. I immediately took regulatory control action by stoping the reprocessing line and notified Mr. (b) (6) and Mr. (b) (6) and the (b) (6) assigned to the area, showed them my findings and informed them of the forthcoming non compliance. That the establishment failed to prevent fecal material from entering the chilling system represents noncompliance with 9 CFR 381.65(e). The failure also represents a deviation from the establishment's written HACCP plan, regulatory requirement of 9 CFR 417.2(c)(4) that states: List the procedures and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN2016120027N-1	12/27/2012	01C02	Operational SSOP Review and Observation	C	<p>While performing PHIS task Sanitary Operational Procedure (SSOP) at approximately 1034 hours in the Fillet Department, I observed the following non compliance: Unidentified foreign material on styrofoam plates on line #2, Sliced Breast Packing Conveyor. The plates had the soaking pad in them and were traveling on the line ready to be packed with sliced fillet. I pulled six empty plates from the line with foreign material in them, (plates in the line are Product Contact Surface) and placed Retained tag #B39415855 on them. The foreign material ranged in size from black specks and smears to approximately 1/8 inch in diameter. I showed my findings to Mr. (b) (6) and (b) (6). Mr. (b) (6) pulled out another 15-20 plates with the same kind of unidentified foreign material from the pile of styrofoam plates that were staged to be used to be packed and added an employee to double check plates as preventive measures and to restore sanitary conditions. I continued my inspection procedure same department, Area 6: Unit 23; Product Chute to Bin from delivery system at approximately 1049 hours and observed a pile of whole breast fillets on the floor (approximately 40-45 pieces) next to a plastic bin that was being filled with the same kind of product. I waited to see if anybody was taking action on this situation and no one was around. I took regulatory control of the product with USDA Retained tag #B39415854 and informed Ms. (b) (6) and (b) (6) that this situation would be documented in the fore-mentioned SSOP non compliance. Ms. (b) (6) mentioned she did not know how long the product had been on the floor, so she elected to condemn the product in my presence. Plants SSOP's #XV Post chill Reprocessing of parts and carcasses step 10 states: (b) (4)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE301312 3727N-1	12/27/2012	03J04	Poultry Zero Tolerance Verification	C	<p>I was in the Evisceration department performing a Zero Tolerance verification task at the line one pre-chill evaluation station at 1049 hours when I observed fecal material on one of the ten randomly selected carcasses. The fecal material was located in the cavity of carcass under the kell bone. It was oval shaped approximately .5mm in length 0.2mm in width, dark green in color, with a paste like consistency. I took regulatory control of the product with the application of U.S. retain tag B39757046. I informed (b) (6) and (b) (6) of my finding. Mr. (b) (6) contested that the material was fecal, and requested veterinary disposition. FSIS IIC Dr. (b) (7)(C) confirmed the material was fecal. (b) (6) was informed of the forthcoming noncompliance. (b) (6) performed the recheck as per establishment's corrective actions, the recheck passed. This failure represents a noncompliance with regulation 9 CFR 381.65(e), which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank. The HACCP plan is not ensuring compliance with the critical limits for fecal contamination. Regulation 9 CFR 417.2(c)(4), states: "The HACCP plan shall, at minimum: " (4)List the procedures, and frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." There has been four fecal failures on line one in the past two and half months. The first, NR # HYE213104603 was on 10/19/12, the second, NR# HYE3415125103N occurred on 12/03/12 and the third NR# HYE4815124218 N/1 on 12/18/12, the last NR# HYE3013123727N/1 occurring on 12/27/12. On 12/19/12 FSIS IPP shared their concerns about the fecal failures on line #1 with the establishment's management at the weekly meeting.</p>
5333	P7632	HYE220712 5424N-1	12/24/2012	04A06	Poultry Finished Product Standards	C	<p>There was a high percentage of birds presented for post-mortem inspection that where identified by the on line inspectors for airsacculitis removal. The establishment had initiated their alternative On-line Vacuuming/Air sac Removal procedure. At 0454 hours I elected to verify the effectiveness of the alternative procedure. I went to the FPS Pre-Chill Station on line 1 and collected a ten (split tail) bird sample. Two of the ten birds had intact kidneys indicating that the vacuum procedure was ineffective in the proper removal of the tissue and one bird exhibited air sac exudate on the right side along the ribcage area. The required ten bird retest passed as there where no failure findings. I notified (b) (6) and (b) (6) of the forthcoming documentation for the failure to comply with the regulations cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2612120 520N-1	12/20/2012	03J04	Poultry Zero Tolerance Verification	C	On 12/20/2012, while performing a zero Tolerance fecal check, I found a Noncompliance with regulatory requirement of regulation 9 CFR 381.65(e) and 417.4(c)(4) At approximately 0900 hours, I randomly removed 10 birds from line 2 in plant 1, finding one carcass contaminated with feces. The fecal material was pasty in texture and dark yellow in color. It was located under the right leaf fat area measuring approximately 1/4" in diameter. I immediately notified (b) (6) of the noncompliance. The fecal Protocol was implemented. The cause of deviation was due to shower heads plugged on the first cabinet. QC performed a passing re check at approximately 0925 hours putting the process back in control. Post-Chill checks were performed from 1004 hours to 1104 hours. This is a violation of the critical limit of CCP-2B, (b) (4) of the plant's HACCP Plan for Slaughter.
5308	M6137	BXL3722122 719N-1	12/19/2012	01C02	Operational SSOP Review and Observation	C	On 12/19/2012 at approximately 0650 hours, while monitoring the Establishments' Operational Sanitation Procedures in Main Packaging, I observed a company employee grasping halves of birds from the drip pan that is next to the chute of the halvers machine in Plant #2. Company employee direct those halves of birds to the chute. This drip pan it's not a food product contact surface. As per company procedure written in the SSOP Plan the employee failed to follow the product reconditioning procedure and contaminated the product that it was going through the chute. I attached a U.S. Retained/Rejected Tag # B31 406711 to the product that it was coming out from the chute, 8 brown tubs in total. I informed (b) (6) and (b) (6) of the noncompliance. (b) (6) informed me that the product will be reconditioning as per company procedure, I removed the U.S. Retained /Rejected Tag and released the product to Quality Control. Quality Control attached red hold tag on the product pending for reconditioning. At approximately 0840 hours after the product was reconditioned, Quality Control inspected the product and released. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4 (d), 9CFR 416.13 (b) and 416.13 (c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0309120 818N-1	12/18/2012	03J04	Poultry Zero Tolerance Verification	C	While performing Zero Tolerance Fecal Task, I observed noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). On 12/18/2012 at approximately 0616 hours, (b) (6) randomly removed a 10 bird sample from Line (b) (4) in Plant #2, I found the last bird inspected with visible fecal contamination inside the bird located at the middle of the kidney area. The fecal material was a smear measuring approximately 1/2" long and 1/4" wide, dark green in color in pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0644 hours and it passed. The cause of the deviation was the (b) (4) bird washer. This is a violation of the critical limits os CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.
5333	P7632	HYE481512 4218N-1	12/18/2012	03J04	Poultry Zero Tolerance Verification	C	I was in the Evisceration department performing a Zero Tolerance verification task at the line one pre-chill evaluation station at 1334 hours when I obsevrred fecal material on one of the ten randomly selected carcasses. The fecal material was located on the left side leaf fat of the carcass. It was oval shaped approximately 1cm in length 0.3cm in width, dark green in color, with a paste like consistency. I took regulatory control of the product with the application of U.S. retain tag B38495479. I informed (b) (6) and (b) (6) of my finding. Mr. (b) (6) contested that the material was fecal, and requested veterinary disposition. FSIS IIC Dr. (b) (7)(C) confirmed the material was fecal. First (b) (6) was informed of the forthcoming noncompliance (b) (6) performed the recheck as per establishment's corrective actions, the recheck passed. This failure represents a noncompliance with regulation 9 CFR 381.65(e), which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." The failure also represents a deviation with the establishment's written HACCP plan, regulatory requirements of 9 CFR 417.2(c)(4), which states: "List the procedures, and frequency with which those procedures will be performed, that will be monitor each of the critical control points to ensure compliance with the critical limits." There has been three fecal failures on line one in the past two months. The first was on 10/19/12, the second occurred on 12/03/12 and this being the last on 12/18/12.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE530212 4318N-1	12/18/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>After QC had performed the pre-operational inspection and released area 3 as acceptable, I performed the hands on observation component of the Preoperational Sanitation Inspection procedure. The following non compliance was noted: At area 3, unit #5, the stainless steel cover of the dumper's hydraulic assembly had pieces of fat and particles of product residue built up on all four inside surfaces. These pieces of fat and particles varied in size and where too numerous to count. I also observed at unit #3 a portable metal grate stand that had numerous pieces of fat with the largest approximately three inches long on the bottom surfaces. I showed these findings to (b) (6) and (b) (6), and informed them of the documentation of the non compliance. This finding represents a non compliance with 9 CFR 416.4(b) which states: "Non-food contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." In addition the establishment's Pre-Op SSOP, Part 1 (b) (4), step #2 Equipment(including conveyors, shackles and floors) will be completely (b) (4). The establishment's failure to implement the SSOP procedures represents a non compliance with 9 CFR 416.13(a) which states: "Each official establishment shall conduct the pre-operational procedures in the Sanitation SOP's before the start of operations.</p>
5308	M6137	BXL4905120 314N-1	12/14/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 12/13/2012 at approximately 2340 hours while monitoring the Establishments' Pre-operational Sanitation Procedures in the Packaging area, I found a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4(a), 9CFR 416.4 (b) and 9CFR 416.13 (c). There were numerous pieces of semi-dried fat, tissue and blood approximately 1/4" to 1" sections, from the previous day production, on a white support bracket that is in contact with the blue conveyor belt that transfers product from the dumper at the end of the chiller #1 to the rehang belt for line (b) (6). There was also a build up of fat and tissue approximately 3" x 3" square on the white support sprocket at the end of the same blue conveyor belt. I tagged the area with the U.S. Rejected/Retained Tag # B31 406712 and informed (b) (6) of the noncompliance. Sanitation personnel re-washed the area. At approximately 2355 hours I reinspected the area and released it. I also informed (b) (6) of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5405123 814N-1	12/14/2012	06D02	Other Inspection Requirements	C	<p>On 12/14/2012, at approximately 0230 hours, while monitoring the "No Viscera Log" for Line #1, I observed the following: Line #1 had three consecutive failures by Quality Control in the 4 hour period before lunch break. At 2320 hours at line speed of (b) (4) BPM, Quality Control documented 23 no viscera and only 13 or less are allowed. At 2352 hours at line speed of (b) (4) BPM, Quality Control recheck failed with 24 no viscera. Line Supervisor was informed and line speed was reduced to (b) (4) BPM. At 0116 hours at line speed of (b) (4) BPM, Quality Control documented 34 no viscera, at this line speed only 11 no viscera are allowed, at this point the process is out of control. (b) (6) was informed. Three consecutive failures is a noncompliance for a failure to take proper corrective action. Line speed remained at (b) (4) BPM for the rest of the shift. At 0400 hours at line speed of (b) (4) BPM Quality Control documented 36 no viscera only 11 no viscera are allowed. At 0619 hours at line speed of (b) (4) BPM Quality Control documented 38 no viscera only 11 no viscera are allowed. This is a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE520712 1713N-1	12/13/2012	01C02	Operational SSOP Review and Observation	O	<p>On Wednesday December 12, 2012, during start up of the first processing at approximately 2230 hours, inspector (b) (7)(C) hung back two carcasses contaminated with grease like, black colored, foreign material at station # 4 line B. At approximately 2300 hours, I was called to Evisceration, station # 3 line B by inspector (b) (7)(C), to observe two birds with the same foreign material located in the inner surface of the thigh. While I was still on the floor, and at approximately 2310 hours, inspector (b) (7)(C), at station # 2 line B hung back four more carcasses. Two carcasses contaminated with the same grease like, black colored, foreign material and the other two carcasses contaminated with rail dust/grease like, also black colored, foreign material, located in the inner surface of the left thigh and the breast. Again at approximately 2335, inspector (b) (7)(C) hung back two more carcasses contaminated with the same grease like, black, foreign material, also located in the inner surface of the left thigh. After lunch, and at approximately 0353, inspector (b) (7)(C), at station # 2 line B, hung back three more carcasses contaminated with the same black, grease like, foreign material, located again in the inner surface of the left thigh. In all these instances (b) (6) and (b) (6) were informed and the affected carcasses were trimmed and reconditioned. (b) (6) stated that (b) (4). At approximately 0420 hours when I went to release inspector (b) (7)(C), from station # 2, line B, for USDA break, I observed that she had hung back one other carcass contaminated with that same black, grease like, foreign material, again located in the inner surface of the left thigh. While I was performing post mortem inspection I called Ms. (b) (6) to inform her of (b) (7)(C) findings. While (b) (6) was still next to me listening to my notes, another two carcasses passed by us that were also contaminated with grease like, thick oily in consistency, black, foreign material, one which was approximately ¼ inch in diameter the second approximately one inch by one inch in diameter, both located also in the inner surface of the left thigh. At approximately 0450 hours, and 0455 hours inspector (b) (7)(C) hung back one carcass each time contaminated with the same black, grease like, foreign material, again located in the inner surface of the left thigh. Again the affected carcasses were trimmed and reconditioned. Ms. (b) (6), was informed of the forthcoming noncompliance This issue was brought to the attention of plant personal at the weekly meeting on 12/12/2012. The requirements of 9 CFR 416.3(a), 9CFR 416.4(d), 416.13(c), 416.1 and Establishment SSOP's were not met. 9 CFR 416.3(a) in part which states: "... Equipment and utensils must be maintained in a sanitary condition so as not to adulterate product". 9CFR 416.4(d) states "Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments." 9CFR 416.13(c) states "Each official establishment shall monitor daily the implementation of the procedures in the</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							<p>Sanitation SOP's". 9CFR 416.1 states "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." Establishment SSOP's procedures dated 03/13/2012 Section 1 Evisceration states "(b) (4) [REDACTED]"</p> <p>[REDACTED] Inspection personal documented a similar finding on NR # HYE4000124107N dated 12/6/2012. A response has not been received from the establishment regarding the previous NR.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0121122 512N-1	12/12/2012	06D02	Other Inspection Requirements	C	On 12/12/12 at approximately 1041 hours while performing the no-viscera check in plant # 1 on line # 2 I observed the following . The Monitoring Log for the shift revealed QC personnel had failed line # 2 at 1003 hours at a line speed of (b) (4) BPM with a total of 16 no viscera . The line speed was then reduced to (b) (4) BPM and a recheck was preformed . At 1031 hours a recheck was preformed at a line speed of (b) (4) BPM which also failed with a total of 21 no-viscera . My no/viscera check was preformed at approximately 1041 hours . At a line speed of (b) (4) BPM there is a total of 11 no-visceras allowed my check revealed a total of 19 no-viscera . The next company recheck was at 1249 at a line speed of (b) (4) BPM which failed with a total of 12 no-visceras . The line was never brought back-into compliance and stayed at (b) (4) the rest of the afternoon . Three consecutive failures of not meeting the standards for the no-viscera check is a non-compliance . (b) (6) was contacted and notified of the non-compliance and that there would a NR written . My findings indicate non-compliances with thw following regulations 9CFR 381.76(a) and 381.76(b) .
5308	M6137	BXL1515121 612N-1	12/12/2012	06D02	Other Inspection Requirements	C	At approximately 1045 hours while performing a Presentation check on line (b) (4), in Plant #2, I found the following noncompliance. At a line speed of (b) (4) birds per minute, Line (b) (4), Station #2 had 36 weighted nonconformance points which requires a recheck by QC within 10 minutes. I informed (b) (6) and she had a QC come to perform the recheck. QC failed the recheck at approximately 1053 hours with 4 viscera on the shackle at Station #1. This exceeds the limit of 3 occurrences of one error. I then informed (b) (6) that a noncompliance record would be issued. The line speed was immediately slowed to (b) (4) birds per minute. At approximately 1101 hours QC did a recheck at the lower line speed of (b) (4) birds per minute and it passed. The line speed was then increased to (b) (4) birds per minute and QC did a recheck which passed at approximately 1107 hours bringing the process back in control. My findings indicate a noncompliance with the regulatory requirements of regulation 9 CFR 381.76(b).
5308	M6137	BXL0116124 311N-1	12/11/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 1303 hours while performing a Zero Tolerance Verification Task on Line (b) (4) in Plant #2 I observed the following noncompliance. After removing a 10 bird random sample, I observed one bird with visible fecal material on the left leaf fat. The fecal material was a dark greenish brown color, pasty in texture and was approximately 1/16" by 1/8" in size. (b) (6) was informed of the noncompliance and the protocol for fecal failure was implemented. A QC recheck passed at 1327 hours. The leaf fat lifter was determined to be the cause of the failure. My findings indicate a noncompliance with 9 CFR 381.65(e) and 9 CFR 417.2(c)(4) and the critical limit of CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE381312 0711N-1	12/11/2012	03J02	Slaughter HACCP	C	<p>On 12/07/12 CSI (b) (7)(C) and I, CSI (b) (7)(C), performed a record review to follow up on Zero-Tolerance failure for 12/03/12. As per the establishment's Corrective Deviation Report the preventive measure states: "Replaced blade arm and will do blade arm check once/shift for a week to verify effective." At 1312 hours, in the Maintenance Department, I reviewed the establishment's verification document and noted the following: The entry for Friday the 7th at 1110 p.m. had no quantifiable values recorded. At the bottom of the establishment's verification document states, (b) (4). "Neither acceptable or unacceptable were circled. Upon further review I noted the times for all the completed checks, Wednesday the 5th at (b) (4) and (b) (4) Thursday the 6th at (b) (4) and (b) (4). At the top of this document it states (b) (4). "First shift starts at (b) (4) and ends at (b) (4) hours. Second shift starts at (b) (4) and ends at (b) (4) hours. According to this document, all the checks on Wednesday the 5th and Thursday the 6th were performed on one shift only. I informed Ms. (b) (6) of my findings and of the forthcoming noncompliance for the failure to meet the regulatory requirements cited above. 9 CFR 417.5(a)(3) which states: (a) The establishment shall maintain the following records documenting the establishment's HACCP plan: (3) Records documenting the monitoring of CCP's and their critical limits, including the recording of actual times, temperatures, or other quantifiable values, as prescribed in the establishment HACCP plan; the calibration of process monitoring instruments; corrective actions, including all actions taken in response to a deviation; verification procedures and results. In addition 9 CFR 417.4(a)(2)(i)(ii)(iii) states: Ongoing verification activities include but are not limited to the calibration process monitoring instruments; direct observations of monitoring activities and corrective actions; and the review of records generated and maintained in accordance with 9 CFR 417.5 (a) (3) of this part. This is the second noncompliance for the same ongoing verification activity. The first occurred on 12/5/12 NR # HYE0017120905 N/1.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5813120 210N-1	12/10/2012	01B02	Pre-Op SSOP Review and Observation	C	On 12/11/12 at approximately 0907 hours I observed the following while performing the Pre-Op SSOP Review and Observation task after the establishments completion establishments inspection in the (b) (4) Room . There were two large pieces of fat laying on of the blue flex belt inside the Wing Midjoint Carnietech Loader . One piece was approximately 4" by 6" and the other approximately 3" by 4 in size" . I immediately applied US Retained/Rejected tag # B31406755 and notified (b) (6) . (b) (6) had both pieces of fat removed from the inside of the Wing Carnietech Midjoint Loader and had the entire machine rinsed throughly . At approximately 0916 hours the Wing Midjoint Loader was re-inspected and found to be in good sanitary condition, putting the establishment back in-compliance .My findings are indications of several regulations being violated 9CFR 416.14 , 9CFR 416.4(a) , 9CFR 416.13(c) and 9CFR 416.13(a) .
5309	P6137A	NJN100612 0511N-1	12/10/2012	04C05	Poultry Good Commercial Practices	C	On night shift Sunday 9 December, 2012 at approximately 0230 hours Dr (b) (7)(C) identified a poultry carcass on line A as being a dead-on-arrival (DOA). Later in the shift around 0730 hours an inspector on line B hung back a bird for a supervisor to examine. I identified it as a dead-on-arrival (DOA). Both carcasses were reddish in color with limp necks, friable livers and had a putrid odor. (b) (6) was notified of the two separate occasions by Dr. (b) (7)(C) and me at the time of these findings and that a non-compliance record would be forthcoming. The repetitive occurrence of DOAs entering into the evisceration department demonstrates a loss of process control and the creation of insanitary conditions in accordance with 9 CFR 381.71(a) and 416.4(d).
5308	M6137	BXL1804120 908N-1	12/08/2012	01B02	Pre-Op SSOP Review and Observation	C	On 12/07/2012 at approximately 2225 hours while monitoring the establishments' Pre-operational sanitation Standards in Plant #1 after establishment QC personnel finished their inspections, I observed the following. There were numerous black specks and flakes of UFM(Unidentified Foreign Material) to approximately 3/8"on three of the four paddles checked on Chiller #1. The section of the chiller checked was on the inflow side nearest line #1. There was also black UFM of similar size on the support beams that cross the width of the chiller, and on the brackets and tray associated with the chain. The chiller was released by approximately 2235 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE390212 1408N-1	12/08/2012	03C02	Raw Intact HACCP	C	<p>On Friday, December 7th, 2012 at approximately 2305 hours, I was performing an SPS task in the 19°-degrees cooler and observed a pallet containing several tubs filled with salvaged drums, thighs, and leg quarters. The production card on the tubs indicated that the product was produced on 12/07/2012, during the day shift. I noticed two of the tubs did not contain ice so, I borrowed (b) (6) calibrated thermometer # 54, to check the product temperature. The thermometer read 42.3 degrees Fahrenheit in one tub and 42.4 in the other. I immediately took regulatory control action and applied U.S. retain tags # B38495487 and # B38495488. I informed (b) (6), and (b) (6), of my findings and the forthcoming noncompliance. U.S. retains tags NO. B38495487 and NO. B38495488 were removed at 0008 hours and 0009 hours, after I found the temperature to be acceptable at 35.2 and 34.2 degrees Fahrenheit, respectively. Upon review of the thermometer calibration log, thermometer # 54 was found acceptable at 2155 hours. I reviewed the salvage cp 4 monitoring log and the last two checks at 1318 hours and 1320 hours registered 37.8, 39.7, 38.5, 37.0, 35.4 and 36.1 degrees Fahrenheit This is a failure to meet the regulatory requirement of 9 CFR 381.66(a) and 9CFR 381.66(c) (3). 9 CFR 381.66(a) states " Temperature and procedures that are necessary for chilling and freezing ready-to-cook poultry, including all edible portions thereof, must be in accordance with operating procedures that ensure the prompt removal of the animal heat, preserve the condition and wholesomeness of the poultry, and assure that the products are not adulterated." 9CFR 381.66(c) (3) states "Previously chilled poultry carcasses and major portions must be maintained constantly at 40 F or below until removed from the vats or tanks for immediate packaging" This is a repetitive non-compliance; a similar non-compliance was documented on NR HYE0801111427N/1 dated 11/27/2012. A response has not been received from the establishment regarding the previous NR.</p>
5308	M6137	BXL0509120 107N-1	12/07/2012	03J02	Slaughter HACCP	C	<p>On 12/06/2012 at approximately 0645 hours while performing a HACCP Slaughter Record Review Task, I found the following. The Pre-shipment Records Review for the End of Shift for CCP-1B (b) (4) Zero Tolerance for the Reprocessing Line #9 in Plant #2 dated on 12/05/2012 AM Shift was signed at 0710 hours. The Pre-shipment Records Review for the End the Shift for CCP-2B (b) (4), Zero Tolerance for Line (b) (4) in Plant #2 dated on 12/05/2012 AM Shift was signed at 0713 hours. The Pre-shipment Records Review for the End of the Shift CCP-2B (b) (4) Zero Tolerance for Line 9 in Plant #2 dated on 12/05/2012 AM Shift was signed at 0715 hours. The signed document certifies that the product is ready to be shipped. The end of the shift for the day of 12/05/2012 AM Shift was at 0730 hours. My findings indicate a noncompliance with the following regulatory requirements of regulation 9CFR 417.5 (c). I notified (b) (6) of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE400012 4107N-1	12/07/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On Dec. 6, 2012 at approximately 2218 hours, after sanitation and QC performed preoperational sanitation and released area II for operations, I performed preoperational sanitation inspection and observed the following noncompliance: the Guide Bar and the Blue Chain of USDA Inspection Station 4-Line 2, had unidentified black material. The Blue Chain interior is a food-contact surface. I immediately rejected the Station by applying US Rejected Tag NO. B39757049. At approximately 2222 hours I observed a beaded condensation on the ceiling above the Lung machine for Line 2. I immediately rejected the area by applying US Rejected Tag NO. B38495162 (b) (6), was notified. I showed my findings and informed him of the forthcoming NR. At 2225 hours the Guide Bar and the Blue Chain of USDA Inspection Station 4-Line 2 were re-inspected, found acceptable and released. At 2227 hours the Lung machine-Line 2 area was released once sanitary conditions were restored. Upon review of the SSOP-Implementation and Monitoring checklist log part 1: Pre-Operation Section 1 Evisceration was found acceptable at 2146 hours. The requirements of 9 CFR 416.13(c), 9 CFR 416.2(b) (2), 9 CFR 416.2(d), 9 CFR 416.4 (a), 9 CFR 416.4(b), and Plant's written SSOP plan were not met. 416.13(c) states "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's". 9 CFR 416.2 (b)(2) states: "Walls, floors, and ceilings within establishments must be built of durable materials impervious to moisture and be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions." 9 CFR 416.4(a) States: "All food-contact surfaces, including food-contact surface of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". 9 CFR 416.4(b) states, "Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". 9 CFR 416.2(d) Ventilation requirement states " Ventilation adequate to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product, and the extent necessary to prevent adulteration of product and creation of insanitary conditions must be provided" Plant's written SSOP procedures dated 03/13/12; page 1 step # 4, which states: (b) (4) . Step # 7 which states: (b) (4) .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE100312 2906N-1	12/06/2012	01C02	Operational SSOP Review and Observation	C	<p>.At approximately 0045 hours while performing the Review and Observation component of Operational Sanitation PHIS task, the following noncompliance was noted: The Liver Harvester machines on line 1 and line 2 had not been rinsed down at company break. Both machines had intestines, livers and gizzards on the arms of the Harvesters. I immediately stopped both lines and showed my findings to (b) (6). No retain tag was applied because the plant implemented immediate corrective action by condemning the viscera packs until the machines were properly rinsed down. I reinspected and released both machine at 0058 hours. According to the establishments SSOP, Part II (b) (4) Section 1, Step #1," (b) (4)</p> <p>" 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." 9 CFR 416.13(c) states: (c) " Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's." 9 CFR 416.4(a) states: "All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." 9 CFR 416.4(b) states: (b) " Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." .</p>
5333	P7632	HYE161112 2306N-1	12/06/2012	04A06	Poultry Finished Product Standards	C	<p>I was performing a finished product standards verification task on the reprocessing line in the evisceration department at 0730 hours. I selected ten carcasses marked for vacuum by a split tail. One out of the ten carcass sample had lung tissue adhered to the rib cage of the carcass as well as one full kidney still in the cavity. I informed (b) (6) and (b) (6). Then I performed the required recheck of ten split tail carcasses and found two carcasses containing airsac exudate. I informed (b) (6) and (b) (6) of the failure to meet the regulatory requirement cited above. In addition 9 CFR 381.76 table 1 #7 states: Lesions/conditions subject to removal following an approved cleanout process: Aircacculitis condition requiring removal of the kidneys.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE001712 0905N-1	12/05/2012	03J04	Poultry Zero Tolerance Verification	C	On December 5, 2012 CSI (b) (7)(C) and I, CSI (b) (7)(C), performed a record review to follow up on a Zero-Tolerance failure for 12/03/12 at 1345 hours in the Q.C. office. I requested the verification document for the preventive measures for the failure from (b) (6). Ms. (b) (6) told me that the (b) (6) had the document. I then went to Mr. (b) (6) office and requested the document from him, to which he replied "I don't have it, it's not where it should be." I then informed Mr. (b) (6) that by not being able to produce the on going verification document represents a noncompliance with 9 CFR 417.5(a)(3) which states: (a) The establishment shall maintain the following records documenting the establishment's HACCP plan: (3) Records documenting the monitoring of CCP's and their critical limits, including the recording of actual times, temperatures, or other quantifiable values, as prescribed in the establishment HACCP plan; the calibration of process monitoring instruments; corrective actions, including all actions taken in response to a deviation; verification procedures and results. (b) (6) was also informed of the noncompliance.
5333	P7632	HYE341512 5103N-1	12/03/2012	03J04	Poultry Zero Tolerance Verification	C	I was in the Evisceration department performing a Zero Tolerance verification task at the line one pre-Chill Evaluation Station at 1210 hours when I observed fecal material on one of the ten carcass sample. The fecal material was located inside the cavity of the carcass. It was oval shaped approximately 4mm in width and 1cm in length, greenish-brown in color, and had a paste like consistency. I took regulatory control of the product with the application of U.S. Retain tag B38495480, and then informed (b) (6) and (b) (6) of my findings and the forthcoming noncompliance. (b) (6) was also informed and performed the recheck as per establishment's corrective actions, the recheck passed. This failure represents a noncompliance with regulation 9 CFR 381.65(e), which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank". The failure also represents a deviation from the establishment's written HACCP plan, regulatory requirements of 9 CFR 417.2(c)(4), which states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits".

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0609121 201N-1	12/01/2012	01C02	Operational SSOP Review and Observation	C	On 12/1/12 at approximately 0340 hours I observed the following while performing the operational SSOP Review and Observation Task in Plant # 1 . Stations # 1 and # 2 on line # 1 had large beads of water on the ceiling directly above the evisceration line . Which appeared to be seeping from a crack in the ceiling and possibly from the rain fall from outdoors . (b) (6) was informed immediately . (b) (6) had the areas mopped of all . My findings indicate that regulation 9CFR 416.2(b)(2) was violated , which states that walls , floors , and ceilings must be in good repair and prevent insanitary conditions .
5308	M6137	BXL2607124 201N-1	12/01/2012	01B02	Pre-Op SSOP Review and Observation	C	On 12/1/12 at approximately 0005 I observed the following while performing the Pre-Op Review and Observation task in the packaging area . The gray PVC pipe that runs the length of the Plant # 1 Halver , which is approximately 8'-10' in length had a build-up of fat and old product tissue on the bottom side of the pipe . I immediately contacted (b) (6) . (b) (6) had the PVC pipe scrubbed and rinsed throughly . The PVC pipe was re-inspected at approximately 0012 hours . The area was found to be in good sanitary condition and ready for production . My findings indicate non-compliances with the following regulations 9CFR 416.13(c) , 9CFR 416.4(b) , 9CFR 416.14 , and 9CFR 416.13(a) .
5308	M6137	BXL4803120 401N-1	12/01/2012	03J02	Slaughter HACCP	C	On 12/01/2012 at approximately 0044 hours while monitoring the establishments' Finished Products Standards in Plant #2 line (b) (4) I observed the following. After removing a 10 bird random sample, I observed one bird with visible fecal contamination. There was a cloacae attached inside the carcass at the base of the tail with approximately 2" of intestine. The fecal material was leaking from the intestine into the area of the right empty lung socket. The fecal material was a dark green color, pasty in texture and approximately 1/4" by 1/8" in size. (b) (6) was informed and the protocol for fecal failure was implemented. A QC recheck passed at 0105 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP 2B (b) (4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN321012 5701N-1	12/01/2012	01D01	SPS Verification	C	<p>On November 29, 2012, while performing the Observation component of SPS (Sanitary Performance Standard) following the bird flow gap, I observed the following non compliances: Approximately 0754 hours in the Evisceration Department, underneath the (b) (4) cabinet, water dripping from one of the corners of the exhaust vent onto the outside wall of the (b) (4) cabinet. Upon closer inspection I noticed the outside walls of the chute were saturated with condensation, the ceiling mount of the chute had heavy beaded condensation. I showed my findings to Mr. (b) (6) and Mr. (b) (6) of the non compliance. Mr. (b) (6) stopped the line before the birds got to that station, so no product was affected. Condensation was wiped dry to restore sanitary conditions and the line started running at approximately 0800 hours. In the South entrance to the Fillet Department in the Bulk Room at approximately 0813 hours, I observed three pallets of Styrofoam plates staged to be used. A whole package of plares that was partially used, was directly on the floor, (approximately 40 to 50 plates). Regulatory control of that package was applied with US Reject tag #B39415868 and informed Mr. (b) (6) and (b) (6) of the non compliance.</p>
5308	M6137	BXL3313110 129N-1	11/29/2012	03J04	Poultry Zero Tolerance Verification	C	<p>While performing Zero Tolerance Verification Task, I observed noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 0904 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination inside the bird on the right side under the leaf fat area. The fecal material was a smear measuring approximately 1/4" diameter in size, dark green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0935 hours and it passed. The cause of this HACCP deviation was a shower head and a nozzle partial plugged up (city water). This is a violation of the critical limits of CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4404113 929N-1	11/29/2012	03J02	Slaughter HACCP	C	<p>On 11/27/2012 at approximately 0637 hours while monitoring the Establishments' Finished Products Standards in Plant #2 on Line ^{(b) (6)}, I observed the following. After removing a 10 bird random sample, I observed one bird with visible fecal contamination. The fecal material was inside the skin near the neck in a crease adjacent to an intact crop. The fecal material was medium brown in color, pasty in texture, approximately 1/2" by 1/4" in size and gave off a pungent odor. This exceeded the zero tolerance for the process to be in control. ^{(b) (6)} was informed and the protocol for fecal failure was implemented. A QC recheck at 0708 hours passed. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417. 2(c)(4), and the critical limit of CCP 2B ^{(b) (4)} of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE541511 0129N-1	11/29/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0859 hours while performing the Review and Observation component of an Operational Sanitation PHIS task, the following noncompliance was noted: At the North Chiller Exit, I noticed two combo bins with a new liners which appeared to be ready to be loaded with edible product. Upon closer investigation, I noticed that beaded condensation formed underneath a white pipe that was located right above the combo bins. When I was inspecting the combo bins, I noticed the condensation was dripping onto the liners, which is an edible product contact surface. I showed the deficiency to (b) (6) [REDACTED], and inquired about the intended use for the combo bins, and he replied to me that in case of a breakdown, they would be able to load it with carcasses to prevent pile ups of product on the floor. For immediate corrective action, the establishment removed the combo bins away from the area and replaced the dirty liner with a clean liner. By allowing condensation dripping on direct product contact surface, the establishment failed to meet the regulatory requirements of 9 CFR 416.1 which states, "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated". 9 CFR 416.3(a) states, "... Equipment and utensils must be maintained in sanitary condition so as not to adulterate product". 9 CFR 416.4(a) states, "All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". 9 CFR 416.4(b) states, "Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". 9 CFR 416.13(c) states, "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's". Upon reviewing the SSOP Daily Implementation Monitor Log from night shift, I noted that the last acceptable check for condensation (Step#6 (b) (4) [REDACTED].) was at (b) (4) [REDACTED] hours and for day shift no checks were performed previous to the noncompliance. (b) (6) [REDACTED] and (b) (6) [REDACTED] were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0312112 728N-1	11/28/2012	03J02	Slaughter HACCP	C	At approximately 0825 hours, while performing a Finish Product Standard check on line (b) (6), Plant 2, I found one bird contaminated with feces. The bird had a cloaca with a 2" intestine attached to it. There was a chunk of light yellow feces inside of the bird's cavity near the kidney area. The feces were soft in texture, measuring approximately 1/4" in diameter. I notified (b) (6) of the failure. This is a violation of the critical limit of CCP2B (b) (4) of the Plant's HACCP Plan for slaughter. The fecal protocol was implemented. Venter machine was the cause of deviation. At approximately 0848 hours, Quality control performed a Passing recheck. Post chill checks were performed on the suspect lot from 0924 hours to 1023 hours. All product exiting the chiller was found acceptable. My finding represent a failure with regulatory requirement of 9 CFR 381.65(e) and 417.2(c)(4).
5308	M6137	BXL0920110 828N-1	11/28/2012	04A06	Poultry Finished Product Standards	C	While monitoring the Establishments' Reprocessing Procedure on Line (b) (6) in Plant #1, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.84. At approximately 1342 hours, I randomly removed a 10 bird sample for my reprocessing test, I found one out of five birds with split tails in the sample that contained Airsacculitis exudates. I performed a recheck at approximately 1345 hours, in which one of the ten birds sample contained Airsacculitis exudates. I immediately took regulatory control action by stopping the line and informed the (b) (6) and (b) (6) of my findings. The line was started and the product retained while corrective actions were being implemented. I performed a recheck at approximately 1403 hours and it passed bringing the process back in control. I tagged the tank were the product was retained with U.S. Rejected/Retained Tag # B31 406736. After the product was reworked, I performed a recheck and released it, at approximately 1525 hours.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4007112 227N-1	11/27/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 11/26/12 at approximately 2208 hours I observed the following while performing the Pre-Op SSOP Review and Observation task in Plant # 1 . In the Paw room the blue incline flex belt that is used to transport paws to larger bin had a white build-up of hardened soap film . I immediately contacted (b) (6) and applied Rejected/Retained tag # 406709 . (b) (6) had one of his workers scrub and rinse the entire flex conveyor . The Flex incline conveyor was re- inspected at approximately 2224 hours and found to be in good sanitary condition putting the establishment back in-compliance . At 2218 the Venter Opener on line # 2 (area #3 unit # 14) was inspected . The module area of the Vent Opener had areas of chicken grease ranged in size from 1" by 1" to 3" by 4" which appeared to be from the previous shift . (b) (6) was contacted once again . (b) (6) had the affected areas scrubbed and rinsed . At approximately 2227 hours the Vent Opener was re-inspected and found to be in sanitary condition . At 2230 hours the Final Trim Station/ Bird wash for lines # 1 and # 2 was inspected . In the bird wash area the recovery tank that catches the excess from the shower heads had a build-up of thick white grease and fat approximately 1/8" around portions of the under side of the rim . (b) (6) had the underneath portion of the tank scrubbed and rinsed . At approximately 2236 hours the rim of the tank was re-inspected and found to be in good sanitary condition putting the establish back in-compliance . My findings indicate the violation of several regulations 9CFR 416.14 , 9CFR 416.13(c) ,9CFR 416.4(a) and 9CFR 416.4(b) .</p>
5308	M6137	BXL5722115 227N-1	11/27/2012	01C02	Operational SSOP Review and Observation	C	<p>On 11/27/12 at approximately 0525 hours while preforming the Operational SSOP Review & Observation task I observed the following . The drip pan over lines # 1 and # 2 in the Paw Room were covered with large beads of condensation . Plant personal attending the lines and the individual preforming operational sanitation were the only personal in the area . The condensation was pointed out of the sanitation attendant , who mopped the drip pan of all condensation . Sanitary conditions were restored at approximately 0532 hours . My findings indicate noncompliances with the following regulations 9CFR 416.2(d) 9CFR 416.13(c) and 9CFR 416.14 .</p>
5309	P6137A	NJN451711 0027N-1	11/27/2012	01D01	SPS Verification	O	<p>On November 27, 2012 I was in the fillet department at 1035 hrs and observed the following non-compliance; while I was standing by the ice machine where there was one combo bin under the chute being filled with ice. I saw a piece of unidentified foreign material approximately half inch by half an inch in size in the combo bin with the ice. I notified the (b) (6) and (b) (6) about the forthcoming non-compliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE080111 1427N-1	11/27/2012	03C02	Raw Intact HACCP	C	<p>On November 26th 2012, at approximately 0540 hours while performing an Operational Sanitation task in the second processing, I observed a bin filled with (b) (4) lb of young chickens thighs kill date Friday November 23d 2012. I borrowed (b) (6) calibrated thermometer # 54 to check the product temperature and it measured 48 degrees Fahrenheit. I immediately retained the product by placing retain Tag # B38494916, and informed Mr. (b) (6), of my finding and forthcoming noncompliance. Immediately, Mr. (b) (6) started the establishment's corrective actions by adding ice on the product and moving it to the cooler. At approximately 0611 hours, the product was released after I found the temperature to be acceptable (39.7 degrees Fahrenheit). Upon review of the thermometer calibration log, thermometer # 54 was found acceptable at 2308 hours. Failure of the establishment to maintain a maximum internal temperature of the product at 40 degrees Fahrenheit or less is noncompliance in accordance with 9 CFR 381.66(a) and 9CFR 381.66(c) (3). 9 CFR 381.66(a) states " Temperature and procedures that are necessary for chilling and freezing ready-to-cook poultry, including all edible portions thereof, must be in accordance with operating procedures that ensure the prompt removal of the animal heat, preserve the condition and wholesomeness of the poultry, and assure that the products are not adulterated." 9CFR 381.66(c) (3) states "Previously chilled poultry carcasses and major portions must be maintained constantly at 40 F or below until removed from the vats or tanks for immediate packaging "</p>
5308	M6137	BXL0809113 523N-1	11/23/2012	01C02	Operational SSOP Review and Observation	C	<p>On 11/23/2012 at approximately 0043 hours while monitoring Operational Sanitation procedures in Plant #1, I observed the following. There were black UFM (Unidentified Foreign Material) smears on the birds exiting Chiller #1. The UFM was on the cut surfaces of the breast, on the fat, skin and tissue around the neck area, and on the tissue at the abdominal opening at the tip of the keel bone. The amount of UFM varied from approximately 1 inch to several square inches in size. I took several samples and contacted (b) (6). I proceeded to the exit side of Chiller #2 and found the carcasses exiting Chiller #2 to have a similar black UFM. I again took samples for (b) (6). Birds coming from the chillers were tanked off until approximately 0108 hours. The WOGS (With Out Giblets) being collected at the Sorting & Sizing line also had the same black UFM. The tanked product was placed under QC hold pending reconditioning. (b) (6) was informed. At approximately 0350 hours in the Rotisserie Room there were two tanks of WOG's with similar black UFM smears. The tanks were labeled 31328 on Nov. 23, item 180260 at a time of 0048 hours weighing (b) (4) pounds, and 31329 on Nov. 23, also item 180260 at a time of 0052 hours weighing (b) (4) pounds. I contacted (b) (6) and showed her the UFM. The tanks of WOG's were placed under QC hold tags pending reconditioning. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5108113 023N-1	11/23/2012	03J02	Slaughter HACCP	C	On 11/22/12 at approximately 0140 hours I observed the following while performing the Finished Product Standard Task on line 04 in Plant # 2 . After randomly removing 10 birds, I observed one bird with the cloaca still in-intact (attached to the leaf fat) with visible fecal material escaping from the opening of the cloaca . The fecal material was green in color and watery in texture . I immediately notified (b) (6) who notified (b) (6) . (b) (6) implemented the establishments fecal failure protocol at approximately 0144 hours . The recheck passed at approximately 0207 hours . The venter was determined to be the cause of the failure . This incident was a violation of the critical limits of CCP-2B (b) (4) of the HACCP Plan for slaughter including the violation of regulations 9CFR 381.65(e) and 417.2(c)4 .
5309	P6137A	NJN040911 4623N-1	11/23/2012	04A06	Poultry Finished Product Standards	C	At 0439 hrs. I was performing a FPS (Finished Product Standards) check on the reprocessing line in the evisceration department when I noted the following noncompliance: The establishment failed to remove airsacculitis exudate from carcass identified by USDA for air sac removal. (1) Of the (10) carcass sample identified for air sac removal with a split tail, contained air sac exudate. I informed and showed my findings to (b) (6), she was given the opportunity to examine the airsacculitis in the carcass. I performed a recheck at 0445 hrs, at this time (1) of the (10) carcass sample identified for air sac removal with a split tail, contained air sac exudate. The retest defect requires retention and rework. The line was stopped, (b) (6) and Ms (b) (6) were informed of the failure. The establishment did not meet the requirements of 9 CFR 381.84 which states in part: "less affected carcasses may be passed for food after complete removal and condemnation of all affected tissues including the exudate. Per the procedure of the establishment, (b) (6), initiated immediate corrective action as prescribed in the establishment Vacuum Procedure.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN080511 5723N-1	11/23/2012	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 2341 hours while performing PHIS task for zero tolerance on the reprocessing line I observed one carcass of a ten carcass sample with visible fecal material on the inside cavity of the bird by the vent area. The fecal material was approximately 1/8 inch in diameter, dark green and tan in color and had a paste-like consistency. After noticing the affected carcass, I stopped the reprocessing line and both informed and showed the fecal matter on the affected bird to Mr. (b) (6) and Ms. (b) (6). The establishment did not meet the requirements of 9 CFR 381.65(e) which requires that the establishment prevent poultry carcasses contaminated with visible fecal material from entering the chilling system. The failure also represents a deviation from the establishment's written HACCP plan, regulatory requirements of 9 CFR 417.2(c)(4). Regulation 9 CFR 417.2(c)(4) states "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits". Per the procedure of the establishment, (b) (6), initiated immediate corrective action as prescribed in the establishment HACCP plan. Upon reviewing the records pertaining to the failure, the establishment found all the mandatory pre-chill and post chill checks acceptable.</p>
5308	M6137	BXL1813113 321N-1	11/21/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1043 hours while walking through the Plant #2 Packaging area I observed the following noncompliance. A company employee working on Line #2 picked up an empty pallet from the floor to move it out of the way and then came back to the line without washing or sanitizing his gloves and put his hands in the product, contaminating it. I immediately took regulatory control and had them stop the line and informed (b) (6) of the noncompliance. He immediately had company employees condemn the product on the line and had the line washed and sanitized, restoring sanitary conditions. My findings indicate a noncompliance with regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2017111 721N-1	11/21/2012	04A06	Poultry Finished Product Standards	C	At approximately 1025 hours, I randomly removed a 10 bird sample from line 1 in plant 1 for Pre-Chill finish Product Standard check. I documented 51 points of the processing nonconformances from the 10 bird sample. This exceeded the subgroup absolute limit of 30 points for the Processing nonconformances to be in control. I informed Quality Control and (b) (6) of the failure. At approximately 1035 hours QC performed a recheck, documenting 27 points on the Processing Nonconformances. This exceeded the limit of the 25 points allowed for the recheck. At this point the process is considered out of control. Birds size was inconsistent and maintenance was having problems adjusting equipment. QC. was failing the venter machine CP, There was mutilation on the birds and a very noticeable amount of birds with attached intestines. Line was slowed down to (b) (4) BPM, one back up employee was assigned to cut long shanks, two back up employees were assigned after the body opener and venter machine, two trimmers were assigned to the final trim station. (b) (6) was notified of the noncompliance. Corrective actions were implemented. Quality Control performed rechecks at Pre-Chill and Post-Chill. At approximately 1242 hours the process was back in control. My findings indicate a regulatory noncompliance with Reg. 9CFR 381.76(b).
5308	M6137	BXL0709111 921N-1	11/20/2012	06D02	Other Inspection Requirements	C	On 11/21/2012 at approximately 0600 hours while performing a Presentation check in Plant #1, I observed the following. A review of the establishments' (b) (4) Lines - No Viscera Monitoring Log for the shift revealed that QC personnel had failed line #1 at 0052 hours with 21 no viscera. A recheck failed at 0149 hours with 25 no viscera. At (b) (4) BPM 13 no viscera are allowed. The line was slowed to (b) (4) BPM. A check at 0351 hours failed at (b) (4) BPM with 14 no viscera. At (b) (4) BPM 11 no viscera are allowed. Rechecks brought the line back into compliance at 0455 hours. On line #2 at 0058 hours QC personnel had failed the line with 28 no viscera. A recheck at 0153 hours failed with 19 no viscera. The line was slowed to (b) (4) BPM. A check at 0355 hours at (b) (4) BPM failed with 16 no viscera. Rechecks brought the line back into compliance by 0504 hours. Three consecutive failures is a noncompliance for a failure to take proper corrective action. My findings indicated a noncompliance with 9 CFR 381.76(a) & (b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1409114 420N-1	11/20/2012	01C02	Operational SSOP Review and Observation	C	<p>On 11/20/2012 at approximately 0545 hours while monitoring the establishments Operational Sanitary Procedures in Plant #1, I observed the following. The brown tubs being used to collect finished product from the giblet chiller had varying amounts of dried and semi-dried blood, and a few tubs had liver/gizzard tissue to 1/2" on the internal and exterior surfaces. The dirtiest tubs had a semi-dried light brown scum in large areas approximately 1' by 6" in size on the internal surfaces. Most of the blood and scum residue was located on the sides of the tubs while the internal bottom surfaces were generally clean. The tubs gave off a strong musty odor. I contacted (b) (6) and showed him my findings. The two stacks of tubs staged for use were taken to the tub wash room for cleaning. There were at least 30 tubs in each stack. I proceeded to the Plant #2 aged breast cooler where an additional stack of tubs was found to be in the same insanitary condition. I next went to the out flow area of the Plant #2 giblet chiller where two more stacks of brown product tubs were also found to be insanitary. I contacted (b) (6) and showed him my findings. By approximately 0600 hours I returned to Plant #1 where a recleaned stack of brown tubs was just being brought back from the tub wash room. The tubs still had the same dried and semi-dried blood, tissue and scum. The tubs were again returned to the tub wash room. I showed (b) (6) the insanitary condition of the rewashed tubs. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).</p>
5308	M6137	BXL3615110 619N-1	11/19/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>At approximately 0845 hours while performing a Pre Operational sanitation inspection in the (b) (4) room, I observed the following: The wing line conveyors were affected with dark gray grease. There were two chunks of pasty grease measuring approximately 1/4" each. There were also two areas of approximately 3 square inches, each affected with numerous spots of grease unbidden in the conveyor. I also observed a wing portion inside of one of the hoppers. These are all product contact surfaces. I proceeded to place a U.S Rejected/Retained tag NO. B31 407696 on the affected equipment. I showed my finding to (b) (6). All affected areas were scrubbed and washed. Wing line conveyors were re inspected and found under sanitary conditions. At approximately 0905 hours, USDA released the equipment. My findings reflect a noncompliance with regulations 9 CFR 416.1; 416.4(a); 416.13(c) and 416.14</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4617115 519N-1	11/19/2012	03J02	Slaughter HACCP	C	At approximately 1320 hours while performing a HACCP Slaughter Record Review Task, I found the following; Quality Control or designee documented on the HACCP Monitoring Log CCP-2B (b) (4) (Plant #2) dated on 11/19/2012 PM shift, Direct Observation on Line (b) (4) at 1029 hours. The time enter on verification activities (Direct Observation) did not corresponded with any of the monitor procedure entries. Records Review for that CCP-2B (b) (4) were already performed by Quality Control or designee at approximately 1258 hours. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 417.5 (a)(3) and 9CFR 417.5 (b). I notified (b) (6) of the noncompliance.
5308	M6137	BXL5413110 219N-1	11/19/2012	06D02	Other Inspection Requirements	C	At approximately 0830 hours, I performed a presentation check on Line (b) (4) at Line Speed of (b) (4) BPM. Station #1 had (2) not uniform and (2) viscera on shackle, total of 32 points. Station #2 had (1) not uniform and (1) viscera on shackle, total of 21 points. Station #3 had (1) viscera not uniform and (1) not reflected, total of 10 points. Station #1 failed with 32 points, this exceed the limit of the 25- 39 points. At approximately 0842 hours, Quality Control performed a recheck and Station #2 failed with (3) not uniform, (1) viscera on shackle, (1) membrane and (1) not reflected, total of 36 points. This exceed the retest conformances levels of 25 points for the process to be in control. (b) (6) was informed and the Line speed was reduced to (b) (4) BPM. At approximately 0918 hours all rechecks at Line Speed of (b) (4) BPM and (b) (4) BPM passed, bringing the process back to control. This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76(b).
5333	P7632	HYE040311 4419N-1	11/19/2012	04A06	Poultry Finished Product Standards	C	I was performing a Poultry Finished Product Standards Verification task in the evisceration department on the reprocessing line at 0036 hours when I observed the following non compliance: I selected a ten bird sample after the final wash cabinet, marked with a horizontal slash across the back indicating that these carcasses were identified for cellulitis (inflammatory condition) removal. One out of ten carcasses had visible cellulitis exudate tissue under the leaf fat flap. I stopped the reprocessing line and showed the carcass to (b) (6). I then performed a ten carcass recheck at 0041 hours after the line had restarted. I noted one carcass out of the ten with cellulitis exudate along the inside of the thigh. I informed (b) (6) of the of the documentation of the non compliance. (b) (6) initiated corrective actions by performing a recheck. That recheck passed. He then marked the chiller per the establishment's corrective actions. The failure to remove cellulitis affected tissue is a non compliance with 9 CFR 381.86 which states: "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general disturbance, the whole carcass shall be condemned."

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE180811 1319N-1	11/19/2012	01C02	Operational SSOP Review and Observation	C	<p>At 0415 hours I was giving the on-line inspector a break on line number two (north line), station one when I noted the following non compliance: a carcass coming down the evisceration line was presented for inspection with a cockroach crawling down the inside of the leg towards the leaf fat flap. I immediately stopped the line and secured the insect into a paper towel. I rang my call button for a supervisor. (b) (6) along with (b) (6) approached the station. I showed the cockroach to (b) (6) and informed her of the non compliance. The establishment had the affected carcass condemned. 9 CFR 416.1 states: "Each establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure product is not adulterated." 9 CFR 416.2(a) states: "The grounds about an establishment must be maintained to prevent conditions that could lead to insanitary conditions, adulteration of product, or interfere with inspection by FSIS program employees." 9 CFR 416.4(d) states: " Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments."</p>
5308	M6137	BXL0805114 417N-1	11/17/2012	01C02	Operational SSOP Review and Observation	C	<p>On 11/17/12 at approximately 0150 hours after completing a HACCP Slaughter Fecal check on line (b) (6), I observed the following. An employee brought a brown product tub of birds from the Kill Line/ Evisceration Line rehang area. The carcasses are missed by the mechanism that removes the carcasses from the line and directs them into the chiller. The carcasses are contaminated when they drag on drip pans and over support brackets that are considered non-contact surfaces and are seldom cleaned. Varying numbers of carcasses are missed by the mechanism throughout the shift. The employee started to hang the birds on line (b) (6) after the final inside/outside wash cabinet. I removed the first bird that was hung on line (b) (6) and observed UFM consisting of black smears to approximately 2" by 1" and specks to approximately 1/8" on the tissue and skin around the neck area. The employee stopped hanging, got a scissors and started reconditioning the carcasses using the water at the line (b) (6) final inspection station. Of approximately 10-12 birds that were reconditioned three carcasses were still contaminated with the black UFM. I contacted (b) (6) and showed him my findings. (b) (6) retained the carcasses for retraining purposes. A review of the establishments' SSOP document (b) (4) dated 09/10/12 under (b) (4) (b) (4) . " Under (b) (4) " There is a sink near the entrance side of the chillers but the water valves are tagged "Danger do not operate". No QC or Production Supervisor was ensuring that reconditioning procedures were being followed. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), and 9 CFR 416.12(b),(c) & (d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2705112 817N-1	11/17/2012	01B02	Pre-Op SSOP Review and Observation	C	On 11/16/12 at approximately 2215 hours I observed the following in Plant # 1. While performing the SSOP Review and Observation Task which was pre formed after the establishments SSOP Monitoring Procedure . The Gall Bladder and Intestine remover unit # 18 of area # 3 had a yellowish / brown build-up on the plastic blades and the rotating augers , the iron stub auger had a build-up of product imbedded in the grooves the pan beneath the upper augers had several large white grease spots ranging in size from 1" by 1" to 3" by 4" . US Rejected/Retained tag B31406745 was immediately applied . (b) (6) has one of his workers clean the affected areas .The Intestine Gall Bladder Remover was re-inspected at approximately 2227 hours . The area was found to be in sanitary condition and released for production . At approximately 0019 the (b) (4) Room .The Wing Transfer Line had fat particles ranging in size 1/8 " to 1" . (b) (6) was informed immediately . (b) (6) had the Wing Transfer Line rinsed thought . At approximately 0025 the Wing Transfer Line was re-inspected and to be in sanitary condition and released for production . My find in both incidents are indications of several regulations being violated 9CFR 416.4(b) ,9CFR 416.14 , 9CRF 416.13(a) .416.(c) and 416.4(a) .
5308	M6137	BXL2713113 816N-1	11/16/2012	03J02	Slaughter HACCP	C	While performing Pre-Chill Finished Products Standards Task, I observed noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 0844 hours, I randomly removed a 10 bird sample from Line #1 in Plant #1, I found one out of the ten birds with visible fecal contamination inside the bird on the left side of the kidney area. The fecal material was a sphere approximately 1/4" diameter in size, dark green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 0902 hours and it passed. The cause of the deviation was the venter. This is a violation of the critical limits of CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4615114 616N-1	11/16/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1112 hours while walking through the (b) (4) Room I observed the following noncompliance. I turned to walk into the wing room and noticed heavy beaded condensation covering the entire bottom of the long white air conditioning unit, this unit is located right above the Hopper taking front halves to Lines #1, #2, (b) (4) the (b) (4) Room and the two wing lines. I immediately found (b) (6) and told him of the noncompliance. (b) (6) walked with me to look at the condensation and while doing so I observed condensation dripping from the bottom of the air conditioning unit onto product in the Hopper that was being taken up the incline belt and on to Lines #1, #2 and (b) (6) in the (b) (4) Room. (b) (6) stopped the lines and had the remaining front halves from the lines and hopper put into brown tubs to be reworked. There were 29 tubs of product retained by (b) (6). The air conditioning unit was cleaned and a company employee was put in the area to keep the unit wiped clean, the belts to the lines are all continuously washed with (b) (4) and the rest of the line was washed during the company break restoring sanitary conditions. All affected product was reconditioned by production then rechecked and released by QC under my supervision. My findings indicate a noncompliance with 9CFR 416.2(d), 416.4(b), 416.1 and 416.4(d).</p>
5308	M6137	BXL5815110 216N-1	11/16/2012	03J04	Poultry Zero Tolerance Verification	C	<p>While performing Zero Tolerance Fecal Task, I observed noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2(c)(4). At approximately 1244 hours, I randomly removed a 10 bird sample from Line #1 in Plant #1, I found one out of the ten birds with visible fecal contamination inside the bird on the right side under the leaf fat area. The fecal material was a smear measuring approximately 1/8" long and 3/16" wide, dark green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 1312 hours and it passed. The cause of the deviation was the leaf fat lifter. This is a violation of the critical limits of CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN310311 1516N-1	11/16/2012	01D01	SPS Verification	C	At approximately 0735 hours while monitoring the establishment's GMP's for hand washing and sanitizing at the start of shift in the Fillet Department the following Noncompliance was observed: A plant employee was moving a portable foot stand to (b) (4) South, after which he dipped his gloved hands in a tub of potable water, without sanitizing his gloves the employee began putting blue liners into bins used for edible product. These blue liners are considered direct product contact areas. I informed Mr. (b) (6) of the Noncompliance of the plants GMP's. Mr. (b) (6) had the employee wash and sanitize his gloved hands . He had the blue liners removed from the bins. The establishment did not meet the requirements of 9 CFR 416.1 and 9 CFR 416.5(a) All persons must adhere to hygienic practices.
5308	M6137	BXL1709114 415N-1	11/15/2012	04A06	Poultry Finished Product Standards	C	On 11/14/12 at approximately 0638 hours, I randomly removed a 10 bird sample from line (b) (4) in plant #2 for Pre-Chill Finish Product Standard Check, I documented 35 points of the Processing Nonconformances from the 10 bird sample. This exceed the subgroup absolute limit of 30 points on the Processing Nonconformance to be in control. I informed Quality Control of the failure and at approximately 0648 hours she performed a recheck. Quality Control documented 36 points on the Processing Nonconformance, this exceed the limit of the 25 points allowed for the recheck, at this point the process is considered out of control. I informed (b) (6) of the noncompliance. Corrective actions were implemented. Quality Control performed rechecks at Pre-Chill and at Post-Chill. At approximately 0725 hours the process was back in control. This is a noncompliance with the following regulatory requirements of regulation 9 CFR 381.76(b).
5308	M6137	BXL5108115 615N-1	11/15/2012	01B02	Pre-Op SSOP Review and Observation	C	On 11/13/12 at approximately 2307 hours I observed the following while performing the Pre-Op SSOP Review and Observation task in the Rotisserie Room after the establishments SSOP daily monitoring procedure . The section of the box line directly above the whole bird packing line which is approximately 10' in length by 3' in width . The area had thick particles of cardboard and other debris in the pan directly beneath the flex belt spanning the entire length of the packing line . Rejected/Retained tag # B31407698 was immediately applied and (b) (6) was notified . (b) (6) rinsed the whole area spanning approximately 10' .The area was reinspected and found to be in sanitary condition . At 2313 hours the Rotisserie Room was released production . My findings are indication of several regulations being violated 9CFR 416.13(a) , 9CFR 416.13(c) , 9CFR 416.14 and 9CFR 416.4(b) .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN300311 5115N-1	11/15/2012	01B02	Pre-Op SSOP Review and Observation	C	On 11-15-2012 at approximately 1217 hours I performed Pre-Operational Sanitation Inspection on Area # 4 Food Service. After the Establishments monitoring and preventative measures I observed the following noncompliance: I inspected unit # 20 Case Sealer and Roller belt I observed approximately 5 pieces of meat on the roller belt approximately ¾ inches in diameter , dried fat and meat , slightly smaller in diameter, on the inner sides of the frame that guides the rollers for this belt. I also observed meat scraps of the same diameter on the floor around this piece of equipment. I applied U.S. Reject Tag #B39146489 rejecting this piece of equipment for use. Upon reinspection of the tagged equipment I observed identifiable pieces of wings in the drain directly under this piece of equipment. This in a noncompliance of 9 CFR 416.4(b), and 416.14.
5308	M6137	BXL5408110 214N-1	11/14/2012	03J02	Slaughter HACCP	C	On 11/14/2012 at approximately 0236 hours while monitoring the Establishments' Post-Chill Finished Product Standards from Chiller #3, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. There was a piece of intestine approximately 6" long attached to the carcass at the base of the kidneys where the sex organs would be located. The fecal material was inside the carcass on the right side in a crease at the end of the fat flap. The fecal material was a smear approximately 1/4" in size, medium brown in color and pasty in texture. This exceeded the Zero Tolerance for the process to be in control. The 10 bird sample collected were the first birds exiting the chiller after a scheduled company break so no carcasses were being hung going into packaging. (b) (6) was nearby so I showed her the carcass and asked her to do a recheck which passed at 0240 hours. Approximately 1 1/2 tanks of birds were placed on hold. The birds were released at approximately 0450 hours after reconditioning. (b) (6) was informed. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4), and the critical limit of CCP 2B (b) (4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN042211 0214N-1	11/14/2012	01C02	Operational SSOP Review and Observation	C	On 11-14-2012 at approximately 0120 I performed an Operational Sanitation task in the Packaging Department, Area 2, Section C, Segment Line & (b) (4) area. I observed grease specs in a brown tub, the grease came off to the touch, it was on a pallet with approximately 200 other tubs that had been cleaned and sanitized, the pallet of tubs was wrapped with plastic indicating they were cleaned, and sanitized ready for use in production. This pallet of tubs was being used to place product in that was being produced by the Body Halver #2 machine located on the north wall of the packaging room, behind the leg processors. I applied U.S. Reject Tag # B39146491 rejecting this tub for use. I immediately informed (b) (6). I relinquished my U.S Reject tag after a Quality Control tag was applied to the pallet of bins. This is a noncompliance of 9 CFR 416.4(a), and 416.14.
5309	P6137A	NJN581311 0014N-1	11/14/2012	01C02	Operational SSOP Review and Observation	C	While doing Review and Observation procedure of SSOP in the Fillet Department, I observed four maintenance personnel working on Wing Cutter at line 10. After they were done and QC removed her tag, a lead person splashed some sanitizer solution on the equipment and production started running product, I decided to inspect the product landing on the empty basket next to the cone lines. The product of whole skinless breast (four pieces) that landed in the empty basket had unidentified foreign material around the neck shoulder area. The foreign material ranged in size from approximately 1/16 of an inch to 1/8 of an inch in length plus some grease smears up to approximately ¼ inch in length. Regulatory control of the line was taken at approximately 0815 hours by stopping the line and the application of U.S. Retained tag #B39415870 and informing Mr. (b) (6) of the non compliance. Regulatory Control was released at approximately 0839 hours after equipment was properly washed and sanitized, disposition to condemn the product and preventive measures were proffered by Mr. (b) (6) to conduct a training with leads to inspect product after maintenance has worked on equipment.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN561511 1912N-1	11/12/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1030 hrs while performing Operational Sanitation procedure in the fillet department I observed the following non-compliance. At the re-processing station # 2 one employee was re-conditioning the wings. She put more than 15 pieces of wings on to the rack and wash them at the same time. I showed my findings to the (b) (6) and inform him about the forthcoming N R. In the Establishment SOP for the Reprocessing of poultry parts and carcasses step # 5 states that (b) (4). All adulterated parts will be condemned. Wholesome parts will be thoroughly washed and made available for re-inspection.
5333	P7632	HYE291711 0512N-1	11/12/2012	01C02	Operational SSOP Review and Observation	C	While I was observing the process at the packaging department as part of the review and observation of an Operational Sanitation PHIS routine task, I noticed the following noncompliance: At the (b) (4) #1 (area IV) I noticed a fly landing and walking on the guide bars and the clear film that is used to pack thighs. The fly landed right after the clear film roll is unrolling and prior to the feeder of the (b) (4) machine. (b) (6) killed the fly and the line was stopped immediately at 1405 hours. No retain tag was applied because the establishment implemented immediate corrective actions by cleaning the guide bars and removing approximately 20 feet of clear film in my presence. No edible product was affected. The establishment resumed production after sanitary conditions were restored. The finding of a fly in the production area and affecting product contact surfaces represents a noncompliance, in consequence, the establishment did not meet the regulatory requirements of 9 CFR 416.1, 9 CFR 416.2(a) and 9 CFR 416.13(c). 9 CFR 416.1 states, "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated". 9 CFR 416.2(a) states, "The grounds about an establishment must be maintained to prevent conditions that could lead to insanitary conditions, adulteration of product, or interfere with inspection by FSIS program employees. Establishments must have in place a pest management program to prevent the harborage and breeding of pests on the grounds and within establishment facilities..." 9 CFR 416.13(c) states, "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's". (b) (6), and (b) (6) were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1701111 209N-1	11/09/2012	01B02	Pre-Op SSOP Review and Observation	C	On 11/8/12 at approximately 2217 hours I observed the following while performing the SSOP Pre-Op Review and Observation Task in Plant #2 .The Vent Opener in area # 3 unit 21 had a thick layer of old dried fat and UMF (unidentified foreign material) I on top of the sprayer which is approximately 6"- 8" in length . The birds rotate beneath the sprayers which makes this a contact area . I immediately applied US Rejected/Retained tag # B31407699 and contacted (b) (6) who had one of his workers scrub and rinse the top portion of the sprayer . The sprayer was re inspected at approximately 2222 hours and found to be in good sanitary condition putting the establishment back in compliance . My findings indicate the violation of several regulations 9CFR 416.4 , 9CFR 416.14 and 9CFR416.13(c) .
5308	M6137	BXL2004114 208N-1	11/08/2012	01B02	Pre-Op SSOP Review and Observation	C	On 11/07/2012 at approximately 2355 hours while monitoring the Establishments' Pre-Operational Sanitation Procedures in Packaging Area #1 after SSOP monitors completed there inspections, I observed the following. There were numerous pieces of fat and tissue to approximately 2", and dried and semi dried fluids and tissue along large sections of both breast fillet product belts that take finished product from the (b) (4) Deboning room to Packaging. The overhead belts are approximately 100 feet long and run parallel to the Crust Tunnel. There was a strong sour odor at the end of the belt near the elevator. The dried and semi dried tissue was on the stainless support brackets at the junction with the flexible belt. The patches of dried and semi-dried product were several feet long, in several places approximately 2" wide and 1/8" thick. Sanitary conditions were restored by approximately 0023 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), and 9 CFR 416.13(c).
5309	P6137A	NJN271611 1608N-1	11/08/2012	01D01	SPS Verification	C	At approximately 1054 hour, while performing Sanitary Performance Standard procedure (SPS) in the Fillet Department , Area 6; Fillet-Section E: Cutting & Packing, I observed four stacks of empty baskets staged to be used. I observed many fat particles adjacent to two of the stacks. The particles ranged in size from approximately 1/8 inch to over 1 ½ inches in length. After closer inspection I observed numerous fat particles spread throughout the top side of baskets and some hanging from the bottoms of baskets and throughout inside and outside walls of equipment. Regulatory control of the baskets was taken with the application of USDA Reject Tags #B39415821 and #40266794 and informing Mr. (b) (6) of the forth coming non compliance. Regulatory Control was released at approximately 1146 hours after the baskets were washed, sanitized and inspected by USDA.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE360211 3307N-1	11/07/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 2300 hrs. I was performing a Zero Tolerance verification task of the reprocessing line in the evisceration department, when I noted the following non compliance: I observed one carcass out of a ten carcass sample with visible fecal material. These carcasses where visually checked after the final wash cabinet. This carcass contained a dark green-brown colored elongated paste-like smear approximately a 1/2 inch wide by 2 1/2 inches long on the inside along the right side of the rib cage. I took regulatory control by stopping the reprocessing line. I showed this finding to (b) (6) and (b) (6) and informed them of the documentation of the non compliance. I then relinquished regulatory control of the reprocessing line to production and QC to implement corrective actions. This failure represents a non compliance with regulation 9 CFR 381.65(e), which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank". The failure also represents a deviation from the establishment's written HACCP plan, regulatory requirements of 9 CFR 417.2(c)(4), which states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits". Per the procedure of the establishment, (b) (6) initiated immediate corrective action as prescribed in the establishment's HACCP plan. Upon reviewing the records pertaining to the failure, the establishment found all mandatory pre-chill and post-chill checks acceptable.
5308	M6137	BXL3816113 406N-1	11/06/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1010 hours, while performing a vefication check on reprocessing line #6 in plant 1, I observed the following. Out of a ten bird sample I found 3 birds contaminated with black grease. I showed the contaminated carcasses to (b) (6). Maintenance was notified. I continued checking the birds after the final trimmer, finding several more birds affected with foreign material. I proceeded to stop the line and had production to tank off all product. I place a U.S. REJECTED/RETAINED tag N0 B31 407703 on a stainless steel tank 1/3 full with contaminated product. At approximately 1035 hours, maintenance had found the problem. The fingers on the Inside/Out bird washer were dirty. I performed a recheck, after the problem had been fixed, finding the product on line to be acceptable. All contaminated product was reconditioned by production. At approximately 1050 hours, I performed a recheck on the retained product finding it acceptable. U.S retained tag was removed by me. My finding represent a noncompliance with regulatory requirement of regulation 9 CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN080311 5407N-1	11/06/2012	04B04	General Labeling	C	On 1/30/12, while reviewing products in the establishments cooler for compliance with product labeling requirements, I observed a noncompliance with 9CFR 317.1(a). I observed 6 baskets of breast tenders , 5 basket of several different poultry parts products and 1 tub of poultry trim product, all which were not labeled with information to identify the lot of product or the slaughter/processing date. Regulation 317.1(a) states: When in an official establishment, any inspected and passed product is placed in any receptacle or covering constituting an immediate container, there shall be affixed to such container a label as described in 317.2. I took regulatory control of the products by applying US Retain Tags # B25206983, B25206989, B25206984 B39415811 and B6179507 and informed (b) (6) of the noncompliance.
5308	M6137	BXL0418114 805N-1	11/05/2012	04B04	General Labeling	C	On 11/03/2012 at approximately 1250 hours while monitoring the weigh and price labeling processes, I noticed a new product being weighed and priced on line 1. According to the case label it was a PANKO Crusted Chicken Breast Distributed by (b) (4). The product was individual portioned plastic trays with the Net Weight/Price label indicating the product was from Est. (b) (4). I contacted a W/P Supervisor who mentioned that the product was brought from NCDC where it was relabeled with the (b) (4) Label and sent to the weigh and price department. The original labels with the date of pack were removed and destroyed, and the reason for relabeling such product was unknown. USDA at (b) (4) was not notified of this product at any time. As per regulation 381.138(b) which states in part: "Labeling and containers bearing any official inspection marks , with or without the official establishment number, may be transported from one official establishment to any other official establishment, only if such shipments are made with prior authorization of the inspector incharged at point of origin, who will notify the inspector in charged at the destination concerning the date of shipment, quantity, and type of labeling material involved." At approximately 1340 hours, I issued a Memorandum of Interview (BXL2016111503G) addressed to (b) (6). The MOI stated that all Product code 096401 (b) (4) PANKO CRUSTED/chicken breast) relabeled with establishment No (b) (4) was on hold and was not to be shipped out of the NCDC pending further investigation. 3,784 cases were put on hold. The relabeling on this product was false and misleading. This product was not processed, packaged and labeled at (b) (4) This is a noncompliance with regulatory requirement of 9 CFR 381.1; 381.129; 381.138(b); 381.139 and 381.140.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5316115 805N-1	11/05/2012	01D01	SPS Verification	C	At approximately 1255 hours, while performing post-mortem inspection on Line # ^{(b) (6)} , station #11, I observed a live adult cockroach on a carcass, I immediately stopped the line, turned the light on and grabbed some paper towels to catch the cockroach. I showed to SCSI (b) (7)(C) what I found. The bird was condemned, I then went to washed and sanitized my gloves and returned back to work. SCSI (b) (7)(C) went to talked to (b) (6) and informed her about my findings. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2(a).
5308	M6137	BXL2305111 902N-1	11/02/2012	01C02	Operational SSOP Review and Observation	C	On 11/01/2012 at approximately 2300 hours whole monitoring the establishments Operational Sanitation procedures, I observed the following. There were numerous black specks to approximately 1/8", black streaks to 1/2", and a piece of black tubing to approximately 6" on the giblets and necks coming out of Plant #2 Giblet chillers 3 & 4. I was told that the black tubing was gasket material . I contacted (b) (6) and showed him my findings. The product exiting the Giblet chillers was condemned by production until approximately 2315 hours. At approximately 0040 hours there were several carcasses on the exit chiller belt for Chiller #3 with numerous black specks of UFM (unidentified Foreign Material) to approximately 1/4". I took three samples to the FPS table and had a supervisor call (b) (6) . Hanging of product going into Packaging for the Organic lines was stopped. My findings indicated a noncompliance with 9 CFR 416.1, 416.4(d), and 9 CFR 416.14.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE380711 5102N-1	11/02/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On Nov. 1st and at approximately 2211 hours, after the sanitation and QC performed pre-operational sanitation and released the evisceration department for operations, I performed pre-operational sanitation task in Area II. While doing so, I observed the following: beaded condensation on several locations including the pipes above line # 1, the outer surface of the drip pan above the paws belt, and on the ceiling above the South Chiller at the east end. I immediately rejected area II by applying US rejected tag NO.B 38495148. I also notified and showed Mr. (b) (6) [REDACTED], of my findings and the forthcoming NR. After the sanitary issue was fixed, I re-inspected all affected locations, at approximately 2229, and were found acceptable and released. Upon review the SSOP-implementations and Monitoring checklist sanitation Log, the Subsection C Evisceration area and Subsection D Reprocessing equip, chillers & ADJ.Equip., were found acceptable at 2200 hours. The Requirements of 9 CFR 416.1, 9 CFR 416.2(d) and Plant's written SSOP were not met. 9CFR 416.1 states "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." 9CFR 416.2(d) Ventilation requirement states "Ventilation adequate to control odors vapors and condensation to the extent necessary to prevent adulteration of product, and creation of insanitary conditions must be provided." Establishment's SSOP, Pre-operational, Subsection C Evisceration page 1 (b) (4) [REDACTED]</p> <p>"</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0312103 730N-1	10/30/2012	01C02	Operational SSOP Review and Observation	C	At approximately 0910 hours while performing a Finish Product Standard at the Post Chill area in plant 2, I observed the following: It was shift change. Night shift employees left the line at 0910 hours and a few day shift employees took over the line. It was obvious that the line was not fully staffed. There was no product being tanked off at the end of the chillers #3 and #4 conveyors. The carcasses coming out of the chillers started to fall on the floor because the conveyors were too full to handle the load of product. There was also carcasses falling from the conveyors. I observed approximately 100 birds on the floor throughout the post chill/rehang area. I approach (b) (6) and notified them of the problem and pointed out to them all the carcasses falling on the floor. They mentioned that it was night shift product and proceeded to look for the night shift supervisor. At approximately 0915 hours, day shift started to tank some of the product out of the line to alleviate the problem. There was an employee picking up the carcasses from the floor. He was grabbing several carcasses at once and taking them to the chlorinated hose located at the chiller 4 exit, where he placed them on the catwalk and sprayed one by one. This area does not have a 200 foot candle light intensity. Without any further inspection, he placed the "reconditioned carcasses" in a stainless steel cart label "washed Product". I proceeded to inspect the reconditioned product, finding two carcasses contaminated with foreign material. I notified (b) (6) of my findings and showed him the affected carcasses. Both contaminated carcasses were rewashed and made acceptable. My finds reflect a lack of process control and the establishment's failure to followed the product reconditioning Procedure as written in the SSOP Plan. This is a failure to comply with regulatory requirements of regulations 9 CFR 416.4(d); 416.14; 416.13(b); 416.13(c) and 416.1
5308	M6137	BXL2105104 230N-1	10/30/2012	01C02	Operational SSOP Review and Observation	C	On 10/30/2012 at approximately 0035 hours while monitoring Facilities, I observed the following. There was heavy condensation dripping from major portions of the ceiling in the plant #2 cooler. There were two partial tanks of ice that were not covered and one tub of product labeled 'good legs' with an open lid. I contacted (b) (6) and showed him my findings. The dripping condensation was removed however the ceiling was still wet. The plastic protective covering on several tanks were replaced as in addition to the pooling condensation there were also several specks and flakes of black UFM (Unidentified Foreign Material) to approximately 1/8" on the plastics. I returned at approximately 0230 hours and again observed beaded condensation on the ceiling. I contacted (b) (6) who again had the condensation wiped off. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(d), and 9 CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN500410 1831N-1	10/30/2012	04C05	Poultry Good Commercial Practices	C	<p>On October 29, 2012 at approximately 2335 hours while performing the Poultry Good Commercial Practices task, I observed the following noncompliance. I observed chickens stacked up to 3 birds high on the conveyer that leads to the shacklers. Inside at the shacklers, it appeared that approximately 100 birds had very recently been suffocated or crushed and died and were being placed into dead piles. Minutes earlier, (b) (7)(C) , CSI, had observed a mechanic adjust the conveyer to speed this belt up. He then left without visualizing what effect the adjustment had. We took regulatory control action and stopped dumping more cages; the remaining birds were allowed to be hung to reduce suffering. The establishment took immediate corrective action and sorted through the dead bird piles to ensure that no live birds were placed in the dead bins. (b) (6) , spoke with all of his personnel to notify them that they should not change the speed of the conveyer belt. The establishment then turned the conveyer belt speed down to resume dumping. They stationed a person at the conveyer control while the establishment came up with a temporary lock for the control. Mr. (b) (6) notified the USDA that the company would work on a permanent lock box later on that shift. He then spoke with the mechanic about the matter and informed the USDA that the incident was apparently a miscommunication due to a language barrier and disciplinary action will be taken against the employee. A second incident was observed 4 hours later by (b) (7)(C) , SCSi. On October 30, 2012, at approximately 0337 hours while performing a good commercial practice task near the bird dumper, (b) (7)(C) observed the following: The bird dumper was coming down, which was controlled by a plant employee moving a lever, directly on top of a live chicken roosting underneath the dumper, smashing the chicken between an iron bar and flat sheet of stainless steel. He immediately instructed the plant employee who was controlling the lever to raise the dumper. He then observed another live chicken trapped between a cage door and the dumper. When he removed the chicken from the conveyor belt and set it on the cement floor, the chicken appeared paralyzed and could not move but was conscious. He then instructed the plant employee who was controlling the dumper to remove the chicken that was stuck between the cage door and dumper. By this time, the chicken that was stuck between the cage door and the dumper was not conscious. He immediately informed (b) (6) of what happened. He also immediately went to the USDA office and informed me. The company was prevented from dumping any more cages until preventative measures were taken. The plant responded to the incident by having a person stationed to watch for any chickens that may be harmed by the unit until further modification can happen after slaughter ends Tuesday afternoon. Slaughter was resumed. (b) (6) was informed of the forthcoming noncompliance record. Both situations show a failure to comply with the regulation 9CFR 381.65(b) that states "Poultry must be slaughtered in accordance with good commercial practices in a manner that will result in thorough bleeding of the carcasses and ensure that</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							breathing has stopped prior to scalding. Blood from the killing operation must be confined to a relatively small area."

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1504101 427N-1	10/27/2012	04A06	Poultry Finished Product Standards	C	On 10/26/2012 at approximately 2344 hours, I randomly removed a 10 bird sample from Line (b) (4) in Plant #2 for Pre-Chill Finished Product Standard Check, I documented 37 points on the Processing Nonconformances from the 10 bird sample. This exceed the subgroup absolute limit of 30 points for the Processing Nonconformances to be in control. I informed Quality Control of the failure and at approximately 2357 hours she performed a recheck. Quality Control documented 30 points on the Processing Nonconformances, this exceed the limit of the 25 points allowed for the recheck, at this point the process is considered out of control. I informed (b) (6) of the noncompliance. Corrective actions were implemented. Quality Control performed rechecks at Pre-Chill and Post-Chill. At approximately 0248 hours the process was back in control. This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b).
5308	M6137	BXL2604101 026N-1	10/26/2012	01B02	Pre-Op SSOP Review and Observation	C	On 10/26/2012 at approximately 0002 hours while monitoring the Establishments' Pre-Operational Sanitation Procedures after SSOP and HACCP monitors completed their inspections, I observed the following in Packaging Area #2, the (b) (4) Room. There were numerous pieces of tissue to approximately 3" on the carcass shredder blades. There was a thick layer of pasty white fat on the white edible product shovel hanging from the shredder housing. There were numerous pieces of fat and tissue to approximately 1/2" along the entire length of the carcass collection belt. There were numerous smears and specks of black UFM (Unidentified Foreign Material) on the large blue conveyor belt that collects skin from line (b) (4). A 4' belt associated with line (b) (4) had numerous pieces of fat and tissue to approximately 1/2". There was a red flake approximately 1/8" on the main hanging belt for line #1 that appeared to be paint. There was a gray flake approximately 1/8" by 1/4" that appeared to be paint on the breast tender collection belt near line #1. Sanitary conditions were restored by approximately 0035 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(a), 9 CFR 416.13(c) and 9 CFR 416.14.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3104102 526N-1	10/26/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 10/25/2012 at approximately 2140 hours while verifying the Establishments' SSOP Pre-Operational Sanitation monitoring procedures in plant #1, I observed the following. (b) (6) was performing her checks from a list of randomly selected items. In the Reprocessing Area/Line (b) (6) she observed the inside of a bin used during production to store ice for chilling finished product. The bin had several pieces of dried and semi-dried tissue to approximately 1/4" plus a puddle of water in the bottom of the tank that contained numerous specks of black UFM (Unidentified Foreign Material). She directed a sanitation employee to reclean the ice bin. He rinsed the bin with warm potable water and QC Tern released at 2154 hours. The establishments' Pre-Operational Sanitation - SSOP under 'Corrective Action' states '(b) (4)</p> <p>(b) (4)</p> <p>" The establishments' Pre-Operational SSOP wet procedure for food contact surfaces states '(b) (4)</p> <p>(b) (6) The issue was discussed with (b) (6) and (b) (6). My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c), and 9 CFR 416.15(a) & (b).</p>
5308	M6137	BXL3113103 526N-1	10/26/2012	03J04	Poultry Zero Tolerance Verification	C	<p>On 10/25/2012, I observed a noncompliance with regulatory requirement of Regulation 9 CFR 417.2(c)(4) and 381.65(e) in Plant 1. At approximately 1007 hours, while performing a Finish Product Standard check on line 2, I observed one out of ten birds with visible light yellow fecal contamination. The fecal material was on the left wing of the carcass. There was one spot of feces approximately 1/16" on the wing's mid joint and another spot of feces approximately 1/8" on the drummette's joint close to the breast. I also observed a loose intestine approximately 5" long inside of the bird. This exceeded the limit of Zero Tolerance for the process to be in control. I contacted (b) (6) and showed her my findings. The protocol for fecal failure was implemented. A QC recheck passed at 1025 hours putting CCP 2B back in control. Pos Chill checks were performed from 1129 hours to 1204 hours finding the product acceptable for shipping.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1009101 425N-1	10/25/2012	03J04	Poultry Zero Tolerance Verification	C	On 10/25/2012 at approximately 0629 hours while performing a Finished Product Standards procedure in Plant #1 Line #1, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. There was a piece of intestine approximately 2" long attached to the carcass inside at the tail. The fecal material was leaking from a cut in the intestine approximately 1" from the cut end into the left side area of the kidneys. The fecal material was medium brown in color, pasty in texture and measured approximately 1/2" by 1/8". This exceeded the limit of Zero Tolerance for the process to be in control. I contacted (b) (6) and showed him my findings. The protocol for fecal failure was implemented. A QC recheck passed at 0656 hours. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), 9 CFR 381.65(e), and the Critical limit of CCP-2B (b) (4) of the Plants HACCP Plan for Slaughter.
5308	M6137	BXL5504100 424N-1	10/24/2012	01B02	Pre-Op SSOP Review and Observation	C	On 10/24/2012 at approximately 0017 hours while monitoring Pre-Operational Sanitation procedures in Packaging Area #2, (b) (4) Room, after SSOP and HACCP monitors completed their inspections, I observed the following. There were numerous pieces of fat, tissue, and bone pieces to approximately one foot in length and 2" in width on the auger blade associated with the carcass shredder. The product exiting the shredder is collected and used for MDP. Sanitary conditions were restored by approximately 0035 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), and 9 CFR 416.13(c).
5309	P6137A	NJN300310 4224N-1	10/24/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 23:51 while performing a zero tolerance verification procedure on the reprocessing line, I observed one carcass of a ten carcass sample with visible fecal material. The fecal matter was located on the interior arch of the wing and measured approximately one eighth of an inch in diameter, was brown in color and of a paste like consistency. After noticing the affected carcass, I stopped the reprocessing line and both informed and showed the fecal matter on the affected bird to Ms. (b) (6) and Mr. (b) (6). Mr. (b) (6) was also given the opportunity to examine the fecal matter on the carcass. At approximately 00:01, a recheck was conducted, completed and passed on the reprocessing line by Ms. (b) (6). The establishment did not meet the requirements of 9 CFR 381.65(e) which requires that the establishment prevent poultry carcasses contaminated with visible fecal material from entering the chilling system. Similar occurrences have been documented previously on NR NJN3513094913N/1 dated 09/13/12 and NR NJN1414063025N/1 dated 06/25/12.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0205105 424N-1	10/23/2012	03J02	Slaughter HACCP	C	On 10/24/2012 at approximately 0040 hours while monitoring Facilities in Plant #1, I observed the following. The Cetylpyridinium Chloride system that is used by the establishment to provide the final microbial treatment was not functioning. The spray nozzles at the end of Chillers 1 & 2 were on dispensing (b) (4) at (b) (4) PPM as part of the establishments CCP-7B Corrective Action procedure. An establishment employee was operating the dumper adding tanks of carcasses to the product exiting the chillers going to the cutup line. I check the labels on the product being dumped and discovered that the carcasses were excess birds tanked by the PM shift labeled #31444 at 1718 hours on 10/23 Day Shift and #31445 at 1688 hours on 10/23 Day Shift. The birds were being added to the product entering Packaging past the final microbial agent application and were not being treated. I contacted (b) (6) and (b) (6), and discussed the issue. My findings indicated a noncompliance with 9 CFR 416.4(d), 9 CFR 417.3(b), and the critical limit of HACCP Plan - Slaughter Plant #1 CCP-7B (b) (4).
5309	P6137A	NJN101910 1022N-1	10/22/2012	01C02	Operational SSOP Review and Observation	C	While performing Operational SSOP Review and Observation in the MSP Room at approximately 1618 hours I observed the following non compliance: Dripping condensation into a bin of chicken backs that was inside the east product dumper ready to be processed. After closer inspection, I observed the drip pans above both dumpers were saturated with heavy beaded condensation. I took regulatory control of the area and the product with the application of US Reject/Retained Tag #B39415822 and showing and informing Mr. (b) (6) and (b) (6) of the forthcoming non compliance. Mr. (b) (6) elected to condemn the bin of product and had the condensation wiped dry to restore sanitary conditions.
5333	P7632	HYE070110 1920N-1	10/20/2012	01C02	Operational SSOP Review and Observation	C	On October 19, 2012 at approximately 540 hours Inspector (b) (7)(C) informed me that she observed two flies, one of them flying around her and the second was standing on the hock of one bird. Immediately, Inspector (b) (7)(C) condemned the affected bird and showed the other fly to the plant management. Mrs. (b) (6), was notified of the forthcoming documentation of the failure to comply with the regulatory requirements of 9 CFR 416.1, 9 CFR 416.4(d) and 416.2(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4316104 619N-1	10/19/2012	06D02	Other Inspection Requirements	C	At approximately 1040 hours while performing a Presentation check on line (b) (4) I found a noncompliance with regulatory requirement of regulation 9 CFR 381.76(b). At line speed of (b) (4) birds per minute, Line (b) (4), Station #2, failed with 19 nonconformance points (3 birds with parts inside, 2 birds with viscera not uniform). This exceeded the limit of 3 occurrences of one error. At approximately 1049 hours Quality Control performed a recheck, failing station #1 with 6 birds with parts inside. (b) (6) was notified of the noncompliance. Line was slowed down to (b) (4) bird per minute. At approximately 1053 hours QC performed a recheck at line speed of (b) (4) BPM and passed it. Line speed was reduced to (b) (4) BPM due to increase in poultry pathology. At approximately 1336, due to less pathology, line speed was increased to (b) (4) BPM. QC performed a passing recheck bringing the process back in control.
5308	M6137	BXL4918100 419N-1	10/19/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1545 hours, while monitoring the establishment's Operational Sanitation, I observed the following: There was a couple of employees removing birds from a drip pan in packaging near the (b) (4) Room entrance. The employee on the ladder grabbed (1) front half, (1) whole bird and (1) half chicken from the drip pan, handling one at the time to the employee holding the ladder, who was tossing them on the floor. The two employees proceeded to take the ladder to a nearby drip pan leaving the carcasses on the wet and dirty floor. I then, observed a sanitation employee washing the floor and splashing dirty water on these carcasses. I noticed the two employees coming back to grab the birds from the floor. One of them pick up the carcasses and took them to the reprocessing station located in the (b) (4) Room, where he rinsed the product and was about to take it back to production without any further inspection. These employees were further adulterating the product and not following the establishments procedure for product reconditioning as written in the SSOP plan. I requested the employee to leave the affected product on the reprocessing station and then contacted (b) (6), who went to look for (b) (6). As I was waiting by the reprocessing station, I noticed approximately 20 pound of scattered tender on the floor. This product had fallen from the tender line near a green combo bin. I observed a production employee pushing some of the tender into a pile by using his dirty boot. A sanitation employee working in the area grabbed a brown lid (product contact surface) and use it as a shovel to scrape all scattered tender into a pile. He then, place the lid on the floor and proceeded to grab hand fulls of tender from the floor into the lid. The employee was taking the lid full of tender to the reprocessing station, when (b) (6) came to the area. I share my observation with the Supervisor. The product was handled under insanitary practices and did not follow the product reconditioning procedure. All affected product (tenders/carcasses) was condemned by production. My findings represent a noncompliance with regulation 9 CFR 416.4(d); 416.1; 416.14; and 416.13(b)

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN530310 4719N-1	10/19/2012	01D01	SPS Verification	C	I was walking into packaging at 0145 hours when the following SPS noncompliance was observed. Paint was peeling in an area approximately 12 inches by 12 inches on the ceiling above the overhead incline conveyor to the dark meat deboning area of the Segment line. Mr. (b) (6) and Mr. (b) (6) were notified of my findings. The temporary corrective action was plastic sheeting placed below the peeling paint. I was informed that the ceiling would be scraped and repainted over the weekend. No USDA reject tag was applied at this time because there was no product involved. The peeling paint indicates that the area is not maintained in a sanitary condition as stipulated in 9 CFR 416.1. "And compartments must be of sound construction, be kept in good repair " as stipulated in 9 CFR 416.2(b) (1). Also 9 CFR 416.2(b)(2) states "Walls, floors, ceilings, doors within establishment must be built of durable materials impervious to moisture and to be cleaned as necessary to prevent adulteration of product or the creation of insanitary conditions."
5333	P7632	HYE140710 1319N-1	10/19/2012	04C05	Poultry Good Commercial Practices	C	On October 19, 2012 at approximately 0330 hours a food inspector had hung back a poultry carcass suspected to be a dead-on-arrival (DOA) on the USDA rack behind Line 1, Station 3 for veterinary disposition. I was notified of the finding and confirmed the disposition to be a DOA. The carcass had a limp neck with a reddish coloration and a putrid odor. The liver was friable on palpation. I notified Mr. (b) (6) who also informed Mrs. (b) (6) and Mr. (b) (6). After discussing the disposition with Mr. (b) (6), I later informed Mrs. (b) (6) that the occurrence will be documented on a non-compliance record. On October 10, 2012 another DOA poultry carcass was discovered at approximately 2300 hours on Line 2 at Station 4. The allowance of DOAs to enter the evisceration department creates an insanitary condition and is in violation of 9 CFR 381.71(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5617104 118N-1	10/18/2012	06D02	Other Inspection Requirements	C	At approximately 1415 hours, while monitoring the "No Viscera Log" for Line #1, I observed the following: Line #1 had three consecutive failures by Quality Control in the four hours period before lunch break. At 0803 hours at line speed of (b) (4) BPM, Quality Control documented 34 no viscera and only 13 or less are allowed. At 0828 hours at line speed of (b) (4) BPM, Quality Control recheck failed with 19 no viscera. Line Supervisor was informed and Line Speed was reduced to (b) (4) BPM. At 1026 hours at Line Speed of (b) (4) BPM, Quality Control documented 15 no viscera, at this Line Speed only 11 no viscera are allowed. at this point the process is out of control. At 1227 hours at line speed of (b) (4) BPM, Quality Control documented 10 no viscera, Line supervisor increased the line speed to (b) (4) BPM. At this time there were no other check documented as performed by Quality Control. At approximately 1430 hours, I informed (b) (6) of the noncompliance and discussed with her about a missing "No Viscera" check, I explained that a check passed at (b) (4) BPM the line speed was increased to (b) (4) BPM and after two hours there was no recheck at (b) (4) BPM. (b) (6) informed me later that QC had performed the recheck but had failed to documented the recheck on the No Viscera Log. This is a noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b).
5309	P6137A	NJN320210 3318N-1	10/18/2012	01C02	Operational SSOP Review and Observation	C	At approximately 2355 hours, the following noncompliance was observed in the fillet department. Four employees returning from break put on aprons, gloves and protective sleeves. Without sanitizing, the employees went to line and started packing product. I immediately informed Mr. (b) (6) of what took place. He stopped the line and had all the employees on the line sanitize their gloves before resuming work. The affected product was put in a bin, at which time production put a hold tag on the bin to be washed and reworked. According to the plants GMPs "(b) (4) s." The establishment's monitoring system was not effective in detecting the deficiency resulting in noncompliance with 9 CFR 416.13(c). In addition, the establishment did not meet the requirements of 9 CFR 416.5(a) which requires all persons to adhere to hygienic practices.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0105104 117N-1	10/17/2012	04B04	General Labeling	C	On 10/16/2012 at approximately 2300 hours while monitoring Facilities, I observed the following. In the Plant #2 Aged Breast Cooler there were two bins of product, each approximately half full, that were not labeled. There was other product in the cooler dated from 10/12/2012. At approximately 0015 hours after Packaging production personnel arrived, I contacted (b) (6) concerning the product. The partial bin of wing sections and a partial bin of breast fillets was also found not on the establishments inventory. The wings in the bin were well iced and at approximately 33 degrees, intended for use as a 180094 product, the bin was labeled 10/15/2012 and shipped to Porterville. The bin of breast fillets which still had CO2 present was labeled 10/16/2012 PM shift. My findings indicated a noncompliance with 9 CFR 381.145(b) which states that products need to be identified in some manner(not full label) such that inspection program personnel can reinspect at any time or as often as they deem necessary to assure the products are not adulterated or misbranded., and 9 CFR 381.180(a) which states that the establishment shall furnish inspectors with accurate information including product composition and any changes to procedures in respect to the manufacturing of products such that they are not adulterated.
5308	M6137	BXL0619104 016N-1	10/16/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1550 hours, while monitoring the establishment's operational sanitation on the Packaging area, I observed the following: There was a sanitation employee washing a tub full with front halves. He was using the hose located next to the tub wash room exit. This area does not have sufficient light intensity to reprocess product. According to the establishments SSOP plan under the product reconditioning procedure (b) (4) It took the employee approximately 5 minutes to finish spraying the product. He mentioned that the product was cleaned. I then, took the product to the reprocessing station; where, I inspected each front half under a 200 foot candle light intensity. I found approximately 75 percent of the product to be contaminated with foreign material that seemed to be a mix of dirt and rail dust. The employee failed to follow the establishment's procedure for product reconditioning as written in the SSOP plan. I immediately attached a US. Rejected/Retained tag No.B31 407689 on the affected product. I then, notified (b) (6) of the noncompliance. All affected product was reconditioned following the establishment's procedure. At 1630 hours, I re inspected the product finding it acceptable. US tag was removed after sanitary conditions were restored. My finding indicate a noncompliance with regulations 9 CFR 416.1; 9 CFR 416.4(d); 9 CFR 416.12(a) and 9 CFR 416.14

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5318101 516N-1	10/16/2012	03J02	Slaughter HACCP	C	<p>While performing Post-Chill Finished Products Standards Check, I found noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 1515 hours, I randomly selected a 10 bird sample from the exit of the Chiller #1 in Plant #1, I found the last bird inspected with visible fecal contamination outside of the bird at the right side of the back, in the tail area. The bird had a cloaca attached and approximately 2" of intestine, from there the fecal material was oozing. The fecal material was two spots measuring approximately 1/4" and 1/8" diameter in size, yellow-green in color and watery in texture. This exceed the limit of Zero Tolerance for the process to be in control. Since there was no Packaging Supervisor available, I informed (b) (6) of the noncompliance. She immediately contacted the Lead Person of that area and he started tanking the birds coming out of the Chiller #1. Three tanks were placed under QC red hold tags pending for rework. At approximately 1521 hours, Quality Control did a recheck and passed it. This is a violation of the critical limits of CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.</p>
5308	M6137	BXL5811100 315N-1	10/15/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>At approximately 0700 hours, while monitoring the establishment's Pre Operational Sanitation procedure, I observed the following: Plant 2 gib chillers were found under insanitary conditions. There was a brownish residue building up on the gib chiller's exit where the gibs come out. The residue coved an area of approximately 6 square inches on each chiller. The neck conveyor was also found under insanitary conditions. There was dried ingesta and several rocks that measured approximately 1/16". The areas affected are considered product contact surfaces. I proceeded to attach a Rejected/Retained U.S hold tag NO. B31 406753 to the affected equipment. (b) (6) were notified of the noncompliance. All insanitary areas were scrubbed and washed, restoring sanitary conditions. Gib chillers were released at approximately 0718 hours. My findings indicate a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c), and 9 CFR 416.14.</p>

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5309	P6137A	NJN351610 4215N-1	10/15/2012	01C02	Operational SSOP Review and Observation	C	While performing PHIS task SSOP (Standard Sanitary Operational Procedure) in Fillet Department, I observed the following non compliance: Approximately a ten foot radius pool of liquid debrie of fat, skin, bone fragments, four pieces of breast front halves and an unidentified grayish black material on the floor underneath the basket catch and the first station of the wing cutter on line one. After closer inspection, I observed an employee trying to scoop the liquid material with squeegee and shovel with no avail. The liquid of debrie kept pouring out from the basket catch faster that the employee could collect; drainage for that wing cutter was plugged. More front halves kept falling on the pool of debrie, and employees kept trafficking through the area, thus creating an insanitary condition. Regulatory control of the line was taken at approximately 1249 hours with the application of US Retained tag #B21948350 and informing Mr. (b) (6) and (b) (6) of the forth coming non compliance. Regulatory control was released at approximately 1303 after product on floor was condemned, product contact surfaces were sanitized and floor washed down.
5308	M6137	BXL2712103 511N-1	10/11/2012	04A06	Poultry Finished Product Standards	C	On 10/09/2012 a review of the Post Chill Finish Product Standards Records for plant 1, reflected a noncompliance with regulatory requirement of regulation 9 CFR 381.76 (e)(1)(i) Postchill testing, establishment actions. "The establishment shall conduct a 10-bird subgroup test for each chiller system at a randomly selected time of production. In no case shall the time between tests exceed 2 hours of production time". Quality Control monitoring checks at the postchill were performed as follow: Chiller 1- first check at 0808 hours and second check at 1233 hours (4 hours, 15 minutes). Chiller 2- first check at 0811 hours and second check at 1231 hours (4 hours, 15 minutes). The time between tests exceeded the 2 hours of production time limit. (b) (6) was notified of the noncompliance at approximately 1235 hours on the same day.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5022102 011N-1	10/11/2012	01C02	Operational SSOP Review and Observation	C	<p>On 10/10/2012 at approximately 1928 hours while monitoring Operational Sanitation Procedures in Plant #1, I observed the following. Although the establishment had finished hanging product going into packaging there were still carcasses exiting chillers 1 & 2 that were being collected in stainless steel tanks. The tanks being filled had numerous pieces of fat and tissue, and pink to light brown fluids on the sides and bottom from the previous days production. Tanks #VT260 and # 12 were labeled with the date and time of collection, iced and placed in the plant #1 cooler. I checked with the QC temperature monitors for the shift who were monitoring 19 tanks of carcasses leftover from the PM shift. In addition, there were approximately 10 tanks of ice and 20 tanks of WOG's (without giblets) staged from the PM shift for use by the AM shift. At approximately 0030 hours when Packaging production functions were starting, I informed a supervisor of the issue. (b) (6) and (b) (6) were called and informed of the SSOP failure. A review of the Establishments SSOP Section #1, Pre-Operational Sanitation states that "(b) (4) [REDACTED]".</p> <p>[REDACTED] The internal surfaces of a tank is a product contact surface yet they are not cleaned "(b) (4) [REDACTED]" as part of pre-operational sanitation processes as the tanks were full of product leftover from the previous days production. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), and 9 CFR 416.13(a),(b) & (c).</p>
5308	M6137	BXL3218102 210N-1	10/10/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1555 hours while performing a Operational Sanitation verification check, I observed the following. At the rotisserie and ground chicken area, while the line employees were on break, there was a sanitation employee washing the floor. He was using high pressure causing water to splash. As I got closer to the ground chicken line, I noticed a 2 foot tall stack of uncovered wax cardboard that was severely wet. This cardboard is considered a food contact surface utilized to make boxes to pack ground chicken. This noncompliance was brought to the attention of (b) (6) [REDACTED]. She took immediate corrective action by disposing the affected cardboard. There was no product involved. A pallet with new and clean wax cardboard was assigned to the ground chicken area. My findings indicate a noncompliance with regulatory requirement of regulation 9 CFR 416.1, 416.4(a), 416.14 and 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3220102 810N-1	10/10/2012	03J02	Slaughter HACCP	C	At approximately 1700 hours while performing a HACCP Slaughter procedure record keeping review, I found the following; Quality Control or designee documented on the HACCP monitoring Log CCP-2B (b) (4) (Plant #1) dated on 10/09/2012 AM shift, Direct Observation on Line #2 at 2319 hours. The first Zero Tolerance Check on Line #2 by Quality Control for that day was performed at 2339 hours. The time enter on verification activities (direct observation) did not corresponded with any of the monitor procedure entries. My findings indicate a noncompliance with regulations 9CFR 417.5 (a)(3) and 9CFR 417.5 (b). I notified (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5822104 510N-1	10/10/2012	01C02	Operational SSOP Review and Observation	C	<p>On 10/04/2012 at approximately 0125 hours while monitoring Operational Sanitation procedures in Plant #2, I observed the following. An employee was moving a brown product tub filled with carcasses removed from Line (b) (6) at the rehang station. The carcasses are missed by the mechanism that removes the carcasses from the line and directs them into the chiller. The carcasses are contaminated when they drag on drip pans and over support brackets that are considered non-contact surfaces and are seldom cleaned. The employee was about to put the carcasses back onto line # (b) (6) at a location after the final IOBW's (inside/outside bird washers) and the final trim station. I took one carcass from the edible product tub and found it to be contaminated with large patches, measuring several inches, of black and brown UFM (unidentified foreign material). The UFM was on the back and breast skin, and around the neck area on the skin and tissue. I checked several other carcasses from the same product tub that contained approximately 20 carcasses and found them also to have varying amounts of black and brown UFM. (b) (6) was nearby so I showed him my findings. He directed the employee to wash and/or trim the carcasses to return them to a sanitary condition. The employee was reconditioning the carcasses at the line (b) (6) auto rehang station where carcasses are transferred from the kill line to the eviscerating line. After a time the same employee was again about to put the reconditioned carcasses back onto line (b) (6). I again checked a carcass and found it to be still contaminated. There were 5 carcasses in the product tub that still had varying amounts of UFM still measuring to several inches. I watched the employee finish trimming and rinsing the product restoring sanitary conditions by approximately 0150 hours. The employee used the second final trim station and nearby chlorinated water hose at the end of line (b) (6) to recondition the last 5 birds. A review of the establishments' SSOP document 'Reconditioning Procedures' dated 09/10/12 under 'Procedures for Whole carcasses - post- evisceration, pre-chill' states "(b) (4) " Under 'Equipment' it lists (b) (4) " under 'Responsibilities' it states that a "(b) (4) " There is no hands free sink at the rehang station where the birds were being reconditioned, lighting is poor, and no QC or Production Supervisor was ensuring that reconditioning procedures were being followed. I discussed the issue with (b) (6) and he was unsure where the designated reconditioning station used to recondition contaminated product in plant #2 is located. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), 9 CFR 416.12(d), and 9 CFR 416.12 (b) & (c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0508104 809N-1	10/09/2012	01C02	Operational SSOP Review and Observation	C	<p>On 10/09/2012 at approximately 0350 hours while performing a Raw Intact HACCP procedure in Packaging Area #1, I observed the following. A sanitation employee was dumping a green container marked "Inedible" into a blue product barrel. I contacted (b) (6) who called (b) (6) and the issue was discussed. An issue with the blue barrels occurred during pre-operational sanitation and at that time I asked (b) (6) if the blue barrels were edible or inedible. He said the blue barrels were replacing the white edible barrels. I reviewed the Establishments' SSOP and found no color coding reference or any indication as to whether the blue barrel was intended for edible or inedible product. The blue barrel was not marked. The contents of the blue barrel was taken to the edible dump room for disposal. The edible dump room is not maintained as a product contact surface. After dumping the blue barrel was rinsed with potable water before being returned to production. Using a company calibrated thermometer the temperature of the water being used registered approximately 160 degrees. I checked the establishments SSOP about the water temperature used to restore sanitary conditions of the product contact surfaces. The establishments SSOP Section II : Operational Sanitation states (b) (4) ."</p> <p>However the SSOP does not explain how that is to be accomplished. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.12(a), 9 CFR 416.13(b), and 9 CFR 416.4(d).</p>
5308	M6137	BXL4204104 709N-1	10/09/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 10/09/2012 at approximately 0015 hours while monitoring Pre-Operational Sanitation standards in Packaging Area #1 after Quality Control and HACCP monitors completed their inspections, I observed the following. A blue barrel located at the end of packaging line^{(b) (6)} had a mechanics grease and oil covered WYPALL in the bottom. (b) (6) was nearby so I asked if the blue barrels were for edible or inedible product. He said that the barrels were intended to be used as edible product containers. The WYPALL was removed and the barrel was rinsed with (b) (4) per establishment procedure. At approximately 0016 hours, the entire ceiling area above the Plant #1 Halving Machine was covered with heavy condensation. Sanitary conditions were restored by approximately 0030 hours. There are also four support brackets attached to the ceiling at the same location that are severely rusted and partially covered with peeling flaking paint. The brackets are directly above the product processing lines. A work order will be submitted. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(d), 9 CFR 416.4(a), 9 CFR 416.2(b)(1), and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5408102 208N-1	10/08/2012	01C02	Operational SSOP Review and Observation	C	On 10/08/2012 at approximately 0315 hours while monitoring Operational Sanitation processes in Plant #1 Cooler, I observed the following. There was a partial pallet of brown product tubs with the product giving off a strong sour odor. There was a tub of breast trim, three tubs of front halves, and five tubs of 'B' grade carcasses on a pallet. There were no tags on any of the product tubs so it was impossible to establish a kill date for the product. I contacted (b) (6) and he condemned approximately 450 pounds of product. The product was disposed in the edible dump room by approximately 0615 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), and 9 CFR 381.145(b) which states that products need to be identified in some manner (not full label) such that inspection program personnel can re-inspect at any time or as often as they deem necessary to assure the products are not adulterated or misbranded, and 9 CFR 381.180(a) which states that the establishment shall furnish inspectors with accurate information including product composition and any changes to procedures in respect to the manufacturing of products such that they are not adulterated.
5308	M6137	BXL3815100 906N-1	10/06/2012	01C02	Operational SSOP Review and Observation	C	While monitoring the Operational Sanitation in plant 2, I observed a noncompliance with regulatory requirement of regulation 9CFR 416.1, 416.13(c), 416.14. and 416.2(d). At approximately 1315 hours, I walked into the paw room located in plant 2, finding it under insanitary conditions. There was feathers and paw peeling on the the walls, motors and floor. There was approximately 40 pounds of paws on the floor throughout the room. All this debri was preventing the water on the floor from draining freely. There was also a drip pan affected with heavy condensation. I notified (b) (6) of the noncompliance. She contacted the lead person, who got a sanitation employee to help him clean the area. Condensation was wiped up and fans on the area were turned on. All debri was picked up from the floor with a red shovel and place into a gray inedible barrel. Floor was washed restoring sanitary conditions (b) (6) who is in charged of the area was notified of the noncompliance latter on.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0204100 905N-1	10/05/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 10/04/12 at approximately hours while performing the Pre-operational SSOP Review and Observation task after the establishments SSOP and HACCP monitoring inspection , I observed the following In the Packaging area . The stands the employees use to stand on at the chiller rehang were turned over to observe underneath . There was 1/8 -3/8 thick build-up (black soiled gunk) under the stands on chiller rehang line (b) (4) (b) (6) was contacted immediately (b) (6) had all the soiled stands overturned and washed completely .At approximately 0020 the stands were reinspected and found to be in sanitary condition .At 0009 Line # 1 the deboning line was inspected .There was fat particle ranging from 1/8 " to 2" in length .(b) (6) had one of his workers rinse the line thoughly . The line was reinspected and found to be in sanitary condition at approximately 0016 hours . At 0018 the leg processors were inspected .There was a 3 " by 5 " area covered with fat and grease from the previous shifts production .(b) (6) once again had one of his employees remove the grease from the effected area and rinse the machine .My findings indicate non-compliances with several regulation 9 CFR 416.4(a) , 9 CFR 416.4(b) ,9CFR416.13 (a) and 9CFR 416.13(c) and 9 CFR 416.14 .</p>
5308	M6137	BXL4405103 505N-1	10/05/2012	06D02	Other Inspection Requirements	C	<p>On 10/04/2012 at approximately 0122 hours while monitoring Finished Product Standards at the reprocessing line in Plant #2, Line 9, I observed the following. I took a random 10 bird sample and found the inside of one carcass with a large green stain and several pierces of ingesta (corn and rice hulls). I contacted (b) (6) who was nearby and showed her my findings. I informed her that I would be performing a recheck. At approximately 0115 hours, I took a second 10 bird sample and found three birds with pieces of ingesta attached to the connective tissue on the inside of the carcasses. I again showed (b) (6) my findings. At that point the process is judged to be out of control. Product was tanked until maintenance made some adjustments to the second bird washer. At approximately 0153 hours another 10 bird recheck passed. The tanked product was reworked and released by approximately 0213 hours. My findings indicated a noncompliance with 9 CFR 381.76(b) and 9 CFR 381.91(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0401100 404N-1	10/04/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 10/03/12 at approximately 2223 hours while performing the Pre-operational SSOP Review and Observation task after the establishments SSOP and HACCP monitoring inspection . I observed the following In the Plant #1 area # 3 unit 16 of the evisceration area . The Eviscerator on line # 1 had what appeared to be fat left from the pervious shifts production on the module area . US RETAINED/REJECTED tag # 407630 was applied and my findings were brought to the attention of (b) (6) . (b) (6) had an employee standing close scrub and rinse the affected areas . At approximately 2227 hours a recheck was performed . The Eviscerator was found to be in sanitary condition and the tag was removed . At approximately 2231 hours the Inside /Outside Bird Washer was inspected on line # 1 area # 4 unit 22 . The interior guide bars along with the lower module that holds the bird had white grease film covering 1/3 of the Bird Washer . US RETAINED/REJECTED tag # 407452 was applied and (b) (6) was once again contacted (b) (6) had one of his worker standing close scrub the guides bars and the affected parts of the module area . The Bird Washer was reinspected at approximately 2237 hours . Sanitary conditions were restored and the Inside/Outside Bird Washer was ready for production . At 2238 hours area # 5 was inspected . The Salvage Station opposite side the vacuum station had one knife holder with a brownish red build-up on the inside . (b) (6) was notified again . (b) (6) had the inside of the knife holder scrubbed and rinsed . the knife holder was reinspected and found to be free of build-up . The area was released and ready for production . My findings indicate non-compliances with the following regulations 9CFR 416.4(a) , 9CFR 416.4(b) , 9CFR 416.13(a) 9 CFR 416.13(c) and 9 CFR 416.14 .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1709103 703N-1	10/03/2012	01C02	Operational SSOP Review and Observation	C	<p>On 09/26/2012 at approximately 2030 hours while monitoring the establishments' computer records, I observed the following. Packaging chlorine levels for the PM shift were documented at 1333 hours at (b) (4) ppm (part per million), at 1412 hours at (b) (4) ppm and at 1514 hours at (b) (4) ppm. The establishments' 'Reprocessed Products Log' for the shift which monitors the reconditioning of contaminated product in the (b) (4) Room showed that Quality Control personnel had monitored the reconditioning of product at 1300 hours, 1410 hours and 1515 hours and found that the procedure used and the washed product to be acceptable. The (b) (4) Room reconditioning sink uses the same chlorinated water the is monitored under 'Packaging Chlorine'. A review of SSOP Reconditioning Procedure under #6. states "(b) (4) [REDACTED]".</p> <p>(b) (4) a." A review of procedures to be followed under CP-5 under (c.) states that "(b) (4) [REDACTED]". and under (f.) Corrective Action for reconditioning sink/hose concentration (b) (4) ppm. (b) (4) [REDACTED]".</p> <p>(b) (4) I discussed the issues with (b) (6) [REDACTED].</p> <p>The reconditioning of product was not stopped when chlorine registered at (b) (4) ppm as directed by establishment procedures. There were no entries on the Reprocessed Products Log that documents the number of pounds that were affected by the (b) (4) ppm chlorine application. There is no entries in the computer other then 'Informed Refrigeration'. There are no entries on the Reprocessed Products Log that suggest that the QC monitoring the procedures is aware of current chlorine levels. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d) , 9 CFR 416.14, 9 CFR 416.13(c), and 9 CFR 416.15(b).</p>
5308	M6137	BXL2009100 503N-1	10/03/2012	03J04	Poultry Zero Tolerance Verification	C	<p>On 10/03/2012 at approximately 0522 hours while monitoring the establishments' Finished Products Standards on line (b) (4) in Plant #2, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. Inside the carcass there was a partial stomach attached to a gizzard with approximately 4" of intestine attached to the gizzard. The visible fecal material was leaking from a hole in the intestine at a point approximately 2" from the cut end of the intestine onto the carcass in the area of the kidneys. The fecal material measured approximately 1/2" by 1/8", was medium yellow in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. (b) (6) [REDACTED] was contacted and the protocol for fecal failure was implemented. A QC recheck passed at 0546 hours. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), 9 CFR 381.65(e), and the Critical limit of CCP-2B (b) (4) [REDACTED] of the Plants HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4918101 803N-1	10/03/2012	03J04	Poultry Zero Tolerance Verification	C	While performing Pre-Chill Finished Products Standards Check, I observed noncompliance with the following regulatory requirements of regulations 9CFR 381.65(e) and 9CFR 417.2 (c)(4). At approximately 1344 hours, I randomly removed a 10 bird sample from Line #1 in Plant #1, I found one out of the ten birds with visible fecal contamination inside the bird on the right side under the leaf fat area. The fecal material was two spots measuring approximately 1/4" and 1/8" diameter in size, dark green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 1412 hours and it passed. The cause of the deviation was the "venter". This is a violation of the critical limits of CCP-2 (b) (4) of the Plant's HACCP Plan for Slaughter.
5333	P7632	HYE421310 4603N-1	10/03/2012	03J04	Poultry Zero Tolerance Verification	C	Due to the high incidence rate of pathology, at approximately 1045 hours, I performed Finish Product Standard (FPS) verification on the alternate airsacculitis procedure on Line A, at the quality control inspection station for FPS. I collected a 10 carcass sample. On the seventh carcass inspected, I noticed a smear of gastrointestinal contents on the hock area of the left drumstick. The smear was approximately 5 mm in diameter. The smear had a tan/green color with a paste like consistency, consistent with fecal material. I showed my finding to Mr. (b) (6). The establishment failed to prevent fecal contamination to reach the FPS station, prior to enter the chilling system. This failure represents a noncompliance with regulation 9 CFR 381.65(e). Regulation 9 CFR 381.65(e) states "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank". The failure also represents a deviation from the establishment's written HACCP plan, regulatory requirements of 9 CFR 417.2(c) 4. Regulation 9 CFR 417.2(c) 4 states "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits". Per the procedure of the establishment, (b) (6), initiated immediate corrective action as prescribed in the establishment HACCP plan. Upon reviewing the records pertaining to the failure, the establishment found all the mandatory pre-chill and post chill checks acceptable. Mr. (b) (6) was informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3403102 102N-1	10/02/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 10/1/12 at approximately 0013 hours I observed the following while performing the Pre-operational SSOP Review and Observation Task in the packaging area . The Plant # 2 Halver had a build-up of yellow film on the frame work surrounding the halver , there was pieces of dried meat on and inside the large white sprocket there was also pieces of fat and other debris in the halver area. I immediately applied US Retained/Rejected tag # B 31 407687; (b) (6) was immediately contacted . He had one of his workers scrub and rinse the effected areas . At approximately 0018 a recheck was performed .Sanitary conditions were restored at approximately 0020 and the Plant # 2 Halver was ready for production .My findings indicate non-compliances with the regulations 9CFR 416.13(c) , 9CFR 41613(a) , 9CFR 416.14 , 9CFR 416.4(b) ,and 416.4(a) .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE201110 1702N-1	10/02/2012	01D01	SPS Verification	C	<p>At approximately 0850 hours, inspector (b) (7)(C) notified me that he noticed approximately 6 roaches crawling up from underneath the rack that is attached to the wall located at the South East corner of the evisceration department (Area #3). The rack is used to hang aprons and frocks that are utilized in the slaughter process. The rack at the time of inspection was empty, did not have hanging aprons. Inspector (b) (7)(C) immediately informed (b) (6) and (b) (6). At approximately 0905 hours, CSI (b) (7)(C) and I, CSI (b) (7)(C), inspected the area mentioned above, and we also noticed approximately 5 roaches crawling on the wall and on the upper frame of the door leading to the maintenance shop. I took regulatory control action by applying retain tag #B38495153 to the apron rack. We showed our finding to (b) (6). Upon closer observation of the affected area, we noticed crevices in the frame of the door leading to the maintenance room; adjacent to where the roaches were found. The roaches were also observed underneath the emergency light unit located right above the door. By allowing a pest to enter into the evisceration department where edible product is being processed, the establishment has failed to meet the regulatory requirements of 9 CFR 416.1, 9 CFR 416.2 (a), and 9 CFR 416.2(b). 9 CFR 416.1 states, "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated". 9 CFR 416.2 (a) states, "The grounds about an establishment must be maintained to prevent conditions that could lead to insanitary conditions, adulteration of product, or interfere with inspection by FSIS program employees. Establishments must have in place a pest management program to prevent the harborage and breeding of pests on the grounds and within establishment facilities..." 9 CFR 416.2(b) which states "Establishment buildings, including their structures, rooms, and compartments must be of sound construction be kept in good repair...". The establishment washed and sanitized the affected areas and caulked the edges of the apron rack. At 1005 hours the establishment restored sanitary conditions and (Regulatory Control Action) RCA was relinquished by removing retain tag #B38495153. (b) (6), was informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above. The (b) (6), verbally stated to me, CSI (b) (7)(C) and Dr. (b) (7)(C), the IIC, the establishment corrective action and stated that the corrective action will be provided in writing as well.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0819091 328N-1	09/28/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1555 hours, I observed an Operational Sanitation noncompliance in plant 2. I observed an employee claiming on a ladder near the the end of the gib chillers and post chill rehang dumping area. He was using a metal hook to reach the carcasses on the drip pan. He grabbed a couple of carcasses and threw them on the floor. He then, came down from the ladder, grabbed both carcasses from the floor and placed them on the catwalk. He reached for the hose and picked up one bird from the catwalk, sprinkled a little bit of water on it and was ready to toss the bird back on the line with out any further inspection. I then, approach him and prevented him from placing the carcass back on the line. This employee was not following the establishments procedure for product reconditioning as stated on section #3 subtitle "Whole carcasses/Poultry Parts-Post-Chill". Instead, he was further adulterating the product. (b) (6) who was walking through the area, grabbed the birds and toss them into a gray inedible barrel (b) (6) were notified of the noncompliance. The establishments SSOP plan estates under Operational Sanitation Daily Procedures: (b) (4) ". This procedure goes into detail describing where, when and how product is to be reconditioned. There is only 3 reprocessing station that meet this criteria through out the plant. These stations are designated reprocessing area with a (b) (4) . Product is to be reconditioned and re inspected by the production employee responsible for reconditioning. Product will be held at the designated area for a minimum of 5 minutes to give QC/USDA an opportunity to inspect the product before it is returned back into production. The establishment's reconditioning Procedure states under RESPONSIBILITIES (b) (4) ."</p> <p>My findings represent a noncompliance with regulatory requirements of regulations 9 CFR 416.1, 416.4(d) and 416.13(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4305091 228N-1	09/28/2012	01B02	Pre-Op SSOP Review and Observation	C	On 09/27/2012 at approximately 2355 hours while monitoring the establishments' Pre-Operational sanitation procedures after establishment SSOP and HACCP monitors completed their inspections, I observed the following. In Packaging Area #1, there were numerous black & brown specks and flakes to approximately 1/8" with the consistence of rust on both overhead wing flex belts coming out of the (b) (4) Deboning room at a location in the corner near the elevator. The belts were partially disassembled by repair personnel. After repairs were completed a sanitizer was applied followed by a (b) (4) rinse. Sanitary conditions were restored by approximately 0038 hours. At approximately 0005 hours there were numerous pieces of fat and tissue to approximately 1/2" on the gray product belt and most of the associated Marel chutes utilized on Line #2 breast fillet sorting line. The area was rinsed with (b) (4) and released by approximately 0015 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), and 9 CFR 416.13(c).
5308	M6137	BXL4805094 328N-1	09/28/2012	03J02	Slaughter HACCP	C	On 09/28/2012 at approximately 0049 hours while performing a Post-Chill Finished Products Standards check on line #1 in Plant #1, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. There was a partial stomach attached to the carcass, a gizzard was attached to the stomach with approximately 4" on intestine attached to the gizzard. The visible fecal material under the cut end of the intestine, inside on the left side of the carcass on the kidneys. The fecal material was approximately 1/2" by 1/4" in size, light brown in color, and creamy in texture. This exceeded the limit of Zero Tolerance for the process to be in control. There were no supervisors or QC personnel immediately available so I directed Line #1 personnel to stop hanging birds going into packaging. I had a lead person tank the carcasses coming from Chiller #1. (b) (6) was shown my findings. I conducted a recheck that passed at approximately 0058 hours. Two and one-half tanks of carcasses coming out of chiller #1 were placed under USDA hold pending rework. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), 9 CFR 381.65(e), and the Critical limit of CCP-2B (b) (4) of the Plants HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE540209 3528N-1	09/28/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>After QC had performed the pre-operational inspection and released Area 4 as acceptable, I performed the hands on observation component of the Preoperational Sanitation Inspection procedure. I observed the following noncompliance: At 0009 hours at unit 22, the bag line as identified by the schematics, the table that is used to stage the tubs of giblets had a thick, brownish- yellow residue build up around the bottom edge and several pieces of fat on the attached stand. I showed this finding to (b) (6) and informed him of the issuance of the noncompliance record. This finding represents a non compliance with 9 CFR 416.4(b) which states: Non-food contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. In addition the establishment's Pre-Op SSOP, section 2-5, step 2 states: (b) (4)</p> <p>The establishment's failure to implement the SSOP procedures represents a non compliance with 9 CFR 416.13(a) which states: Each official establishment shall conduct the pre-operational procedures in the Sanitation SOP's before the start of operations.</p>
5308	M6137	BXL1305090 127N-1	09/27/2012	06D02	Other Inspection Requirements	C	<p>On 09/26/2012 at approximately 0215 hours Line 1 in Plant #1 appeared to be having a Presentation issue with too many viscera attached to the carcasses at the inspection stations. I discussed the issue with Inspector (b) (7)(C) who told me that he had already informed production at approximately 0100 hours of the problem. I conducted an unscheduled Presentation check on the line at approximately 0226 hours and observed the following. The second station failed with (2) 'viscera not uniform', (2) 'viscera attached to the carcass', and (1) 'parts inside' for a total of 41 nonconformance points. The third station failed with (1) 'not hung by 2 legs', (2) 'viscera not uniform' and (3) 'attached vents' for a total of 23 nonconformances points. The fourth station failed with (1) 'not hung by 2 legs', (2) 'viscera not uniform' and (1) 'vent attached' for a total of 27 nonconformance points. I also performed a standard three minute 'no viscera' check as part of the procedure and counted (27) no viscera nonconformances. A no viscera recheck at 0338 hours again failed at (b) (4) bpm with 16 no viscera nonconformances. The line was running at (b) (4) bpm (birds per minute) which allows less than (3) occurrences of one error and (24) or less total nonconformance points for the process to be in control. Any station with over 40 nonconformance points requires an immediate line speed reduction of 10%. No viscera at (b) (4) bpm is limited to 13 or less nonconformances for the process to be in control. At (b) (4) bpm 11 or less no viscera nonconformances are allowed. I contacted (b) (6) who slowed the line to (b) (4) bpm. My findings indicated a noncompliance with 9 CFR 381.76(a) & (b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1421093 727N-1	09/27/2012	06D02	Other Inspection Requirements	C	At approximately 1540 hours, while monitoring the "No Viscera Log" for Line #1, I observed noncompliance with the following regulatory requirements of regulations 9CFR 381.76 (a) and 9CFR 381.76 (b). Line #1 had three consecutive failures by Quality Control in a four hours period. At approximately 1228 hours at Line speed of (b) (4) BPM, Quality Control documented 18 no viscera and only 13 or less are allowed. At approximately 1258 hours, Quality Control rechecked failed with 24 no viscera at Line speed of (b) (4) BPM. Line Supervisor was informed and the Line speed was reduced to (b) (4) BPM. At 1456 hours, at Line speed of (b) (4) BPM Quality Control did her regular check and failed with 15 no viscera. At this Line speed only 11 no viscera are allowed. Company Management elected to keep the Line speed at (b) (4) BPM the rest of the shift. I am issue a noncompliance because at this point the process was out of control. I informed (b) (6) of the noncompliance.
5308	M6137	BXL4820091 027N-1	09/27/2012	04A06	Poultry Finished Product Standards	C	While performing Pre-Chill Finished Product Standards Check, I observed noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b). At approximately 1324 hours, I randomly removed a 10 bird sample from Line #1 for Pre-Chill Finished Product Standard Check. I documented 32 points on the Processing Nonconformance's from the 10 birds sample. This exceeds the subgroup absolute limit of 30 points for the Processing Nonconformance's to be in control. I informed Quality Control of the failure and at approximately 1333 hours she performed a Recheck and it passed. Quality Control started performing Pre-Chill Finished Product Standards Checks at the exit of the Chiller because the CUSUM number reached (12) at the started of the shift which is above the start number (11) on one of the five previous company checks. The regulations states in part "If any of the past 5 pre-chill subgroups result in a cusum above the start number, the establishment shall proceed as if CUSUM reaches the action number and shall begin process actions as set forth in paragraph (b)(3)(iv)(d)(4)." Corrective actions were implemented, all rechecks at the Pre-chill and the at the exit of the Chiller passed bringing the process back in control. I informed (b) (6) and (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5108091 627N-1	09/27/2012	06D02	Other Inspection Requirements	C	On 09/27/2012 at approximately 0225 hours while monitoring the Establishments' slaughter functions in Plant #1 Line #2, I observed the following. There appeared to be an excessive number of viscera missing at the front of the slaughter line. I checked the establishments (b) (4) Lines - No Viscera Monitoring Log for the shift and found that a Quality Control check at 0150 hours passed. I performed a standard three minute 'no viscera' check on line #2 and counted 21 no viscera nonconformances at approximately 0232 hours at a line speed of (b) (4) bpm (birds per minute). At (b) (4) bpm 13 or less no viscera are allowed. A QC recheck at 0345 hours failed with 25 no viscera nonconformances. The line was slowed to (b) (4) bpm. A recheck by Quality Control at 0611 hours failed with 25 no viscera nonconformances. At (b) (4) bpm 11 or less no viscera nonconformances are allowed. Attempts to fix the issue failed and the line speed remained at (b) (4) bpm for the rest on the shift. My findings indicated a noncompliance with 9 CFR 381.76 (a) & (b).
5308	M6137	BXL5408095 227N-1	09/27/2012	03J04	Poultry Zero Tolerance Verification	C	On 09/27/2012 at approximately 0513 hours while performing a Zero Tolerance fecal check in Plant #1 Line #2, I observed the following. After taking a 10 bird random sample, I observed one bird with visible fecal contamination. The fecal material was inside the carcass on the left side approximately 1" below the tail just before the start of the kidney crypt. The fecal material was approximately 1/4" in size, medium brown in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. (b) (6) was contacted and the protocol for fecal failure was implemented. A QC check passed at 0556 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4), and the critical limit of CCP-2B (b) (4) of the plants HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE241609 1227N-1	09/27/2012	03J02	Slaughter HACCP	C	<p>On September 27, 2012 I was walking through the chiller rehang area of the Packaging department, at approximately 1319 hours, when I observed one carcass and two saddles (unsplit leg quarters) on the over-head drip pans. (b) (6) measured the temperature of this product with calibrated thermometer #37. The temperature of the carcass was 62.4 degrees F, the first leg quarter was 61.7 degrees F, and the last piece was 61.0 degrees F. (b) (6) was notified of the forthcoming noncompliance. The establishment chose to condemn all affected product. Establishment P-7632 was granted a Salmonella Initiative Program Letter issued on September 2, 2011. The SIP program allows establishment P-7632 to use alternative chilling procedures in place of 9 CFR 381.66(b), provided the establishment: Assesses, modifies and validates as appropriate, the Hazard Analysis and Critical Control Points (HACCP) plan according to 9 CFR 381.22 and 417.4. The establishment failed to implement their SIP program by allowing the internal temperature of their product to rise above (b) (6) degrees F. SIP protocol states: "(b) (4) [REDACTED] This noncompliance is linked to NRs # HYE4415085406N dated 8/6/12, # HYE5617085809N dated 8/9/12 and # HYE5909080828N dated 8/28/12. The previous preventive measures proffered by establishment failed to prevent reoccurrence.</p>
5308	M6137	BXL4418090 726N-1	09/26/2012	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 1345 hours while monitoring the establishment's Finish Product Standard in Plant 1, I observed the following: After randomly removing a 10 birds sample from line 1, I found one bird with visible fecal contamination. The fecal material was inside of the bird on the left side of the tail. It was light yellow in color and soft in texture measuring approximately 1/8" in diameter. This exceeded the limit of Zero Tolerance for the process to be in control. (b) (6) were notified of the noncompliance. The protocol for fecal failure was implemented. Venter machine was the cause of deviation. QC performed a passing recheck at 1413 hours. Post chill rechecks were performed on the suspect lot from 1511 hours to 1551 hours. My findings indicate a noncompliance with 9 CFR 381.65(e) and 417.2(c)(4).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5618092 126N-1	09/26/2012	06D02	Other Inspection Requirements	C	<p>On 09/26/2012 The (b) (4) LINE #1 and #2 - NO VISCERA MONITORING LOG reflected a non compliance with regulatory requirement 9 CFR 381.76(a) (b) There was 5 consecutive failures on each line. This records reflected the establishment lack of control in the process and furthermore the failure to keep the (b) (4) - NO VISCERA standards. Line speed was reduced in the morning by USDA due to presentation failures and then increased to (b) (4) BPM in the afternoon as presentation checks got better. Line speed stayed at (b) (4) BPM because the "No Viscera" checks were not meeting the standards. Line 1 - Quality Control No Viscera monitoring records reflected the following. At 0822 hours QC performed a check at line speed (b) (4) BPM failing the line with 21 no viscera nonconformances out of 13 no viscera allowed. At 0840 hours QC performed a check at line speed (b) (4) BPM failing the line with 16 no viscera nonconformances out of 11 no viscera allowed. At 1027 hours QC performed a check at line speed (b) (4) BPM failing the line with 14 no viscera nonconformances out of 9 no viscera allowed. At 1229 hours QC performed a check at line speed (b) (4) BPM failing the line with 20 no viscera nonconformances out of 11 viscera allowed. At 1516 hours QC performed a check at line speed (b) (4) BPM failing the line with 15 no viscera nonconformances out of 11 viscera allowed. Line 2 - Quality Control No Viscera monitoring records reflected the following. At 0817 hours QC performed a check at line speed (b) (4) BPM failing the line with 31 no viscera nonconformances out of 13 no viscera allowed. At 0836 hours QC performed a check at line speed (b) (4) BPM failing the line with 30 no viscera nonconformances out of 13 no viscera allowed. At 1034 hours QC performed a check at line speed (b) (4) BPM failing the line with 20 no viscera nonconformances out of 11 no viscera allowed. At 1314 hours QC performed a check at line speed (b) (4) BPM failing the line with 19 no viscera nonconformances out of 11 viscera allowed. At 1511 hours QC performed a check at line speed (b) (4) BPM failing the line with 15 no viscera nonconformances out of 11 viscera allowed.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5618092 126N-2	09/26/2012	06D02	Other Inspection Requirements	C	<p>On 09/26/2012 from 0745 to 0800 hours, I was working the line in plant 1 given a break to one of the line inspectors. The birds seem bigger than usual and it was really difficult to properly inspect the carcasses at line speed (b) (4) BPM (birds per minute). I decided to verify the presentation compliance on both lines. Both lines keep failing presentation throughout the morning and therefore line speed had to be slowed down several times. During the afternoon when presentation got better line speed was increased to (b) (4) BPM and stayed at the same speed due to failing "no viscera" checks. I notified (b) (6) about my plans to perform presentation. She was present throughout the failures and therefore aware of the problem. At approximately 0815 hours, while performing a presentation check at line speed (b) (4) BPM on line 2 station #6, I failed with a total of 28 nonconformances. I observed (2) birds viscera not uniform and (1) bird viscera attached to carcass. At 0840 hours, I performed a recheck at (b) (4) BPM, failing station #5 with 52 nonconformances. I observed (2) birds with viscera not uniform, (3) birds with viscera attached to carcass. This exceeded the conformance level. Line speed was reduced to (b) (4) BPM. At 0900 hours line 2 failed at (b) (4) BPM with 38 nonconformances on station #5 and 25 nonconformances on station #6. Line speed was reduced to (b) (4) BPM. At approximately 0922 hours, I performed a passing recheck at (b) (4) BPM increasing line speed back to (b) (4) BPM. At 0950 hours, I performed a recheck at (b) (4) BPM to verify compliance at such speed. Line 2 failed again with 28 and 38 nonconformances putting the line back to (b) (4) BPM. Several checks were performed increasing and decreasing line speed from (b) (4) to (b) (4) BPM. At 1230 hours USDA Supervisor (b) (7)(C) performed a passing recheck at (b) (4) BPM line speed. Line stayed at that speed due to "no viscera" failures. At approximately 0825 hours, while performing a presentation check at line speed (b) (4) BPM on line 1 station #4, I failed with a total of 42 nonconformances. I observed (3) birds with viscera attached to carcass, (2) birds opening cut and (1) bird with contamination inside. This exceeded the conformance level. Line speed was reduced to (b) (4) BPM. At 0845 hours line 1 failed at (b) (4) BPM with 26 nonconformances on station #3 and three occurrences of the same error on station #1. Line speed was reduced to (b) (4) BPM. At approximately 0911 hours, line 1, failed at (b) (4) BPM. Line speed was reduced to (b) (4) BPM. At 1012 hours, I performed a recheck to verify compliance at such speed, failing the line again. From 1058 to 1115 hours, USDA Supervisor (b) (7)(C) performed passing rechecks increasing line 1 to (b) (4) BPM. Line stayed at that speed due to "no viscera" failures. My findings reflect the establishment failure to meet required standards and to keep process control. This represents a failure to comply with regulatory requirement of regulation 9 CFR 381.76(a)(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE531909 3826N-1	09/26/2012	01D01	SPS Verification	C	<p>On September 26, 2012 Dr. (b) (7)(C), CSI (b) (7)(C) and I (CSI (b) (7)(C)) conducted a Sanitation Performance Standards verification task at establishment P7632, Foster Farms. We inspected the establishment's lunchroom and lavatories. In the men's lavatory we observed numerous paper towels on the floor around the entrance and waste receptacle. Near the toilets we saw large pieces of toilet tissue on the floor, one of which had human waste on it. (b) (6) was immediately shown the condition of the restroom and informed of the forthcoming noncompliance. Mr. (b) (6) took immediate action by having the restroom cleaned. (b) (6) agreed that the condition of the bathroom was unacceptable. As a corrective action he indicated that more frequent cleaning and monitoring of the bathroom will be performed and tracked by a log sheet. He also indicated that management will talk with and further educate establishment employee about employee hygiene and the importance of maintaining sanitary conditions. He also indicated that the education will be followed by handing establishment employee a statement delineating the hygienic expectations. The establishment failed to comply with the following regulatory requirements. CRF 9 416.1 states "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." CFR 9 416.5(a) states "Cleanliness. All persons working in contact with product, food-contact surfaces, and product-packaging materials must adhere to hygienic practices while on duty to prevent adulteration of product and the creation of insanitary conditions." CFR 9 416.2(h)(1) states "Dressing rooms, toilets rooms, and urinals must be sufficient in number, ample in size, conveniently located, and maintained in a sanitary condition and in good repair at all times to ensure cleanliness of all persons handling any product. They must be separate from the rooms and compartments in which products are processed, stored, or handled."</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1513094 625N-1	09/25/2012	06D02	Other Inspection Requirements	C	On 09/25/2012 The (b) (4) LINE #1 - NO VISCERA MONITORING LOG reflected a non compliance with regulatory requirement 9 CFR 381.76(b). At 0814 hours QC performed a no viscera check in line 1, failing with 44 no viscera nonconformances. The line was running at (b) (4) BPM (birds per minute) which allows 13 or less no viscera to be in compliance. Maintenance was notified . At 0836 hours QC performed a recheck at (b) (4) BPM, failing with 27 no viscera nonconformances. The line speed was reduced to (b) (4) BPM. At (b) (4) BPM 11 or less no viscera nonconformances are allowed. At 1030 hours, QC performed a recheck at line speed (b) (4) BPM failing the line with 22 no viscera nonconformances. Production continued running line 1 at (b) (4) BPM the remainder of the day. There were two more failures during the afternoon at (b) (4) BPM. At 1311 hours, 30 no viscera nonconformances out of 11 no viscera allowed and at 1515 hours, 38 no viscera nonconformances out out 11 no viscera allowed. There was a total of 5 consecutive failures during the day. Maintenance was making adjustments to the equipment throughout the day. This adjustments were insufficient to correct the problem. Line did not slow down any less than (b) (4) BPM to corrected the noncompliance situation. My finding reflect the establishment's lack of process control.
5308	M6137	BXL5908090 025N-1	09/25/2012	06D02	Other Inspection Requirements	C	On 09/25/2012 at approximately 0117 hours while monitoring the establishments' carcass Presentation functions in Plant #1, line #2, I observed the following. I timed a standard 'no viscera' check for three minutes and counted 25 no viscera nonconformances. The line was running at (b) (4) bpm (birds per minute) which allows 13 or less 'no viscera' to be in compliance. I informed (b) (6) . He said the birds were very big and that he would slow the line down. A recheck by Quality Control personnel at 0157 hours failed with 20 'no viscera' nonconformances at (b) (4) bpm. At (b) (4) bpm 11 or less no viscera nonconformances are allowed. Attempts to correct the problem were unsuccessful and the line remained at (b) (4) bpm until the end of the shift. My findings indicated a noncompliance with 9 CFR 381.76 (a) & (b).
5333	P7632	HYE070309 5025N-1	09/25/2012	01D01	SPS Verification	C	At 0506 hours I observed a stack of nine wooden pallets staged for use with fecal material on the top pallet. These pallets where located next to the south chiller exit. I showed these findings to (b) (6) , and (b) (6) and informed them of the non-compliance with the regulation(s) cited above. I rejected the stack of pallets with the application of U.S. Reject Tag #B38495161. As a corrective action Mr. (b) (6) immediately had the stack of pallets removed from the production area and taken outside to be washed. After verification that the pallets where cleaned and acceptable sanitary conditions where restored, I removed the reject tag at 0657 hours. 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated."

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2713090 924N-1	09/24/2012	01B02	Pre-Op SSOP Review and Observation	C	While monitoring the Establishments' Pre-operational Sanitation Procedures in Plant #2, I found the following noncompliance with regulations 9CFR 416.1, 9CFR 416.4 (a) and 9CFR 416.13 (c). At approximately 0707 hours, I observed in Area #5, Unit # 20, FPS Tables of Lines # (b) (4), numerous particles of black and white UFM (Unidentified Foreign Material), the white UFM appeared to be paint chips. The drip pans that are connected to the (b) (4) cabinets for Line (b) (4) also had numerous pieces of black specks of UFM. I immediately tagged the area with U.S. Rejected/Retained Tag # B31 406447 and informed the (b) (6) and (b) (6) of the noncompliance. Company personnel rewashed the FPS tables and the drip pans. I re-inspected the area and released it. Sanitary conditions were restored at approximately 0714 hours.
5308	M6137	BXL3013094 424N-1	09/24/2012	06D02	Other Inspection Requirements	C	At approximately 1019 hours, I performed a presentation check on Line (b) (6). Station #1 had (1) viscera not uniform, (2) not reflected and 1 contamination inside the bird, total of 18 points. Station #2 had (1) viscera below the wing and (2) not reflected, total of 16 points. Station # 3 failed with (1) viscera on the shackle, (1) membrane and "(3) not reflected" total of 16 points, at Line speed of (b) (6) BPM. This exceed the limit of 3 occurrences of one error. At approximately 1033 hours Quality Control performed a recheck and station #1 failed with (2) viscera not uniform and (2) viscera on the shackle, total of 32 points. This exceed the limit of the 25 nonconformances for the process to be in control. (b) (6) was informed and the Line speed was reduced to (b) (6) BPM. At approximately 1048 hours Quality Control performed a Recheck at Line speed of (b) (6) BPM and passed it. At approximately 1054 hours at Line speed of (b) (6) BPM, Quality Control performed a Recheck and passed it, bringing the process back in control. This is a noncompliance with regulation 9CFR 381.76 (b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1109091 022N-1	09/22/2012	01C02	Operational SSOP Review and Observation	C	<p>On 09/22/2012 at approximately 0135 hours while performing a SPS Verification in Packaging Area #1, I observed the following. Establishment employees were unwrapping product labeled (b) (4) Boneless Skinless Thighs tagged Sept. 21 Night Shift with a second label stating "To Heavy". Approximately 20 racks of product were staged awaiting re-wrap. One employee was removing the packaged product from a rack of product baskets. The baskets are considered a non product contact surface and are seldom cleaned. The baskets were covered with varying amounts of black & brown UFM (Unidentified Foreign Material), and pieces of dried and semi-dried fat and tissue. She then cut open the packages with a knife. There was no sanitizer being used anywhere in the process. Then she placed the opened package into a blue plastic lined basket. A second employee was taking the open packages from the blue plastic lined basket and dumping out the product into a brown product tub. The outer packaging surfaces that are considered by the establishment to be contaminated were coming into contact with the unwrapped product already in the brown tub. I contacted (b) (6) and showed him my findings. The process was moved to Packaging area #2, the (b) (4) Room, where the packages were rinsed with (b) (4) before being opened. QC hold tags were placed on the brown tubs of contaminated unwrapped product awaiting reconditioning. I went to the QC office and reviewed the Establishments' SSOP titled (b) (4) ."</p> <p>" dated May 21, 2012. The document under 'Procedure' states (b) (4) ."</p> <p>There was no sanitizer being used before the packages were opened that would have restored them to a sanitary condition. A review of the establishments SSOP - Operational Sanitation procedures reveals that there is no procedure that explains how product must be handled to maintain it in a sanitary condition. There was no sanitizer used on the knife being used to open the packages although the knife was clearly coming into contact with the product. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), 9 CFR 416.13(b), and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0113091 021N-1	09/21/2012	03J02	Slaughter HACCP	C	At approximately 0923 hours while monitoring the Establishment's Post Chill Finished Products Standards at Chiller #3 in Plant #2, I observed the following noncompliance. After taking a 10 bird sample, I observed 1 carcass with visible fecal contamination. The fecal material was located on the leaf fat by the tail on the left side, it was approximately 1/8" x 1/2", brownish green in color and pasty in texture. There was a piece of intestine approximately 1" in length still attached to the left side of the tail and a piece of intestine approximately 1/4" in length still attached to the right side of the tail, the bursa was also still attached. This exceeded the limit of Zero Tolerance for the process to be in control. There was no Supervisor immediately available so I directed the employees at the rehang station for birds going to packaging to stop hanging carcasses. I found (b) (6) nearby and he started tanking carcasses coming from the chiller. I performed a recheck at approximately 0929 hours which passed with no visible fecal. QC placed hold tags on 2 tanks of carcasses to be held for rework. My findings indicate a noncompliance with 9CFR381.65(e) and 9CFR 417.2(c)(4).
5308	M6137	BXL0623090 521N-1	09/21/2012	01D01	SPS Verification	C	On 9/20/12 at approximately 0400 hours in the plant # 1 mens lavatory there was a leak or over flow of water in toilet stall . Plant 1 supervisors were informed several times at 0500 hours ,0630 hours and 0715 hours . Water stood on the floor for undetermined amount of time . Upon ending my shift at 0722 hours water was still standing US REJECTED/US RETAINED TAG # b31 407695 was applied ,(taped to the door) . This situation was a violation of regulation 416.4(h) which states that lavatories and toilets must be maintained in a sanitary condition and in good repair 416(e)(3) and 416.2(b)(2)
5308	M6137	BXL5004095 320N-1	09/19/2012	03J04	Poultry Zero Tolerance Verification	C	On 09/20/2012 at approximately 0040 hours while monitoring the establishments' Finished Products Standards in Plant #2, I observed the following. After taking a 10 bird random sample from line (b) (4), I found one bird with visible fecal contamination. The fecal material was inside on the left side approximately 1" below the tail near the kidneys. The fecal material was approximately a 1/2" by 3/4" smear, olive brown in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. (b) (6) was contacted and the protocol for fecal failure was implemented. A QC recheck passed at 0104 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4), and the critical limit of CCP-2 (b) (4) of the Plants HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5800093 519N-1	09/19/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 9/18/12 at approximately 2216 hours I observed the following while performing the Pre-Operational SSOP Review and Observation Task in Plant # 1 .The Vent Opener on line # 1 in area 13 had thick grease on the module portion of the Vent Opener covering approximately ¾ of the module area which appeared to be left from the previous shifts production . US RETAINED/REJECTED tag no. B 31 407686 was applied and (b) (6) was standing near and my findings was brought to his attention (b) (6) had one of his workers scrub and rinse all of the affected parts of the machinery . At approximately 2223 hours sanitary conditions were restored and the tag was removed , putting the establishment back in –compliance . At 2226 hours the Inside/Outside Bird Washer on line # 1 in area 22 was inspected . My findings in area 22 was the main pipe with a brass nozzle on the end of it was covered with grease approximately 3 to 4 inches . RETAINED/REJECTED tag # B 31 407688 was applied and (b) (6) was contacted once again (b) (6) had one of his workers scrub the brass nozzle and the portion of the connecting pipe that was affected . At approximately 2231 hours the Inside/Outside Bird Washer was re-inspected and found to be in clean and the tag was removed . At 2234 hours Sanitary conditions were restored , putting the company back in-compliance . At 2238 hours chillers # 1 and # 2 were inspected my findings on both chillers were the same having a build-up of grease on the paddles inspected .(b) (6) was once again notified (b) (6) had the reachable affected paddles scrubbed and wiped clean . The white PVC pipe draining into the small red water finishing chiller had black UMF (unidentified foreign material) on top of the drain pipe (b) (6) had an employee standing close wiped the top of the drain pipe clean , putting the establishment back in-compliance .My findings indicate non-compliances with the following regulations 9CFR 416.4(b) ,(CFR 416.13(c) ,9CFR 416.13(a) ,9CFR 416.14 and 9CFR 416.4(a) .</p>
5309	P6137A	NJN151609 3219N-1	09/19/2012	01C02	Operational SSOP Review and Observation	C	<p>On September 17, 2012 I was in the evisceration department at 0827 hrs. When I observed the following noncompliance: At the end of line A after the (b) (4) cabinet, water was dripping from the shackle rail directly onto the birds as they where passing below. I notified Mr. (b) (6) He immediately took control and stopped the line and condemned the effected birds and called Mr. (b) (6) and maintenance. To immediately correct the situation Mr. (b) (6) wiped the liquid off the rail and started the line at 0830. I informed Mr. (b) (6) of the forthcoming noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN481309 5119N-1	09/19/2012	01D01	SPS Verification	C	While conducting Good Commercial Practices inspection on the outside premises at approximately 1023 hours, I observed the following non compliance: I observed two employees dumping product into a trailer. I asked the employees if they had denatured the product they had emptied in the trailer and their response was "No because the denature pump was empty". I counted ten hard plastic, unlabeled bins full of chicken backs and none of the product had any denaturant on them. I took regulatory control and stopped them from emptying any more product into the trailer, until the product was denatured. I waited for approximately 10-15 minutes until Ms. (b) (6) was present and I informed her of the non compliance and released the control to her. She assured me that she would stay there till the denaturant was brought in. Regulation 9 CFR 381.95(c) Handling and Disposal of Condemned or other Inedible Products at Official Establishments states: Chemical denaturing shall be accomplished by the liberal application to all carcasses and parts thereof.
5333	P7632	HYE270809 1819N-1	09/19/2012	04A06	Poultry Finished Product Standards	C	At 0605 hrs. I was performing a FPS (Finished Product Standards) check on the reprocessing line in the eviscation department when I noted the following noncompliance: The establishment failed to remove airsacculitis exudate from carcasses identified by USDA for air sac removal. (3) of the (10) carcass sample identified for airsac removal with a split tail, contained air sac exudate. I informed (b) (6) who stopped the reprocessing line and initiated corrective actions. A recheck was performed at 0610 hrs. with no additional findings. 9 CFR 381.84 states in part: "less affected carcasses may be passed for food after complete removal and condemnation of all affected tissues including the exudate."

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3213093 018N-1	09/18/2012	06D02	Other Inspection Requirements	C	<p>At approximately 1014 hours while performing a scheduled Presentation check on line (b) (6) in Plant 2, I observed a noncompliance with regulatory requirement of 9 CFR 381.76(b). Inspection station 1, Line (b) (6), line speed (b) (6) birds per minute. I observed: 1 bird with no viscera = 20 points, 1 birds with viscera non uniform = 8 points adding up a total of 28 nonconformance points. Inspection station 3 Line (b) (6), I observed: 3 birds with viscera not free = 8 points each, 1 birds with membrane = 2 points and 1 bird with parts inside = 1 point adding up to 33 nonconformance points. I immediately notified (b) (6) and (b) (6).</p> <p>At approximately 1028 hours QC performed a re check failing station 2 with 27 nonconformance points (3 birds with viscera on the shackle = 8 points each, 1 bird not reflected = 2 points and 1 bird with parts inside = 1 point). Line speed was immediately reduced from (b) (6) to (b) (6) BPM. At approximately 1047 hours, QC performed a passing recheck at (b) (6) BPM putting the line speed back to (b) (6) BPM. At approximately 1053 hours QC performed a re check at (b) (6) BPM, failing station 2 with 32 nonconformance points (3 birds with viscera non uniform) and also failing station 3 with 38 nonconformance points (4 birds with viscera on a shackle = 32 points, 2 birds with membrane = 2 points each, and 1 bird not reflected = 2 points). Line went down to (b) (6) BPM until after lunch. According to (b) (6), maintenance would work on the eviscerator machine during lunch time. At approximately 1224 hours QC performed a passing recheck at (b) (6) BPM putting the line speed at (b) (6) BPM. At approximately 1231 hours QC performed another passing recheck at (b) (6) BPM, bringing the process back in control.</p>
5333	P7632	HYE121409 4818N-1	09/18/2012	04A06	Poultry Finished Product Standards	C	<p>On September 18, 2012, at 1051 hours in the cooler, I was performing a Finished Product Standards verification task at the salvaged parts station after the product went through all plant interventions and released by Quality Control personnel. While performing my task on one of the thigh salvage tubs I observed a thigh with cellulitis exudate. The exudate pieces measured approximately one inch in diameter at its greatest dimension. I took regulatory control of the affected tub by applying retain tag B38495169. I showed my findings to (b) (6), and (b) (6). As immediate corrective action the affected product was condemned as per the establishment decision. Upon reviewing Q.C. records, I noted that Quality Control personnel released and found the product acceptable at 1018 hours. The finding of cellulitis exudate in finished product represents a noncompliance as per 9 CFR 381.86 which states, "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned." Mr. (b) (6) was informed of the forthcoming noncompliance. Previous corrective actions failed to prevent reoccurrence: this noncompliance is linked to NR HYE1313093514N/1.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE570009 1517N-1	09/17/2012	01B02	Pre-Op SSOP Review and Observation	C	On Sept. 16.2012 at approximately 2159 hours I was performing Pre-operation sanitation Review & Observation task in area II item 31 and I observed the following noncompliance: a fly standing on the surface of a shackle. I immediately notified Mr. (b) (6) S, my finding and informed him of the forthcoming noncompliance. Immediately, Mr. (b) (6) Killed the fly, washed and sanitized the shackle when I found acceptable at 2201 hours. No US Rejected Tag was applied this time. This represent a noncompliance with the regulatory requirements of 9CFR 416.13 (c), 9 CFR 416.2(a) and 9 CFR 416.4(a).
5308	M6137	BXL0609092 815N-1	09/15/2012	04B03	Labeling - Net Weights	C	<p>On 09/14/2012 at approximately 2030 hours while monitoring the establishments' Net Weight procedures, I observed the following. A review of the establishments' computer records for the PM shift revealed that a check at 535 PM for account #604201 for product 510 had failed (-.02) by (b) (6). The 5 package variations included a +.02, +.03, +.02, -.19 and +.02. The check was for trays under 3 pounds. The establishments computer shows the check as acceptable, although less then average, as the low limit in the computer is set at -.062 which is the MAV (Maximum Allowable Variation) for an individual package in the class of product. The -.19 is a failure as the Maximum Allowable Variation was exceeded for that package size. I asked (b) (6) about the computer entry. She said that it appeared that a recheck should have been performed. The next check by (b) (6) was not performed until 619 PM. I checked the Quality Control - Reworked Product Log for the shift but found no entries for the 510 product. I reviewed Foster Farms (b) (4) dated November 27/ 2010 on file in Weigh & Price and found the following statement under Sample Plan: (b) (4)</p> <p>"</p> <p>As a recheck had not been documented as having been performed, the affected product may not have met Net Weight requirements when sent to NCDC for shipment. As the processes in Weigh & Price were completed I waited for the AM shift to arrive and discussed the issue with (b) (6). A check of the Weigh & Price product computer showed the 50 cases were involved. The product at NCDC was placed on hold until a representative sample was taken with the product at which time it was found in compliance and released by approximately 0620 hours. My findings indicated a noncompliance with 9 CFR 442.2.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4304095 214N-1	09/14/2012	01B02	Pre-Op SSOP Review and Observation	C	On 09/13/2012 at approximately 2225 hours while monitoring the establishments' Pre-Operational sanitation procedures after establishment SSOP and HACCP monitors completed their inspections, I observed the following. In Plant #1, there was black UFM (Unidentified Foreign Material) that appeared to be mold in and nearby a seam that runs the entire length of Chiller #2. I inspected the center section of the chiller nearest the maintenance shop. The UFM was approximately 1/2" to 2" wide and involves most of the section of the chiller that was inspected. There was a greasy film coating the paddles and support brackets associated with the area inspected and included several large patches of liquified fat to approximately 1/8" thick measuring several square feet. I showed (b) (6) of my findings. The reachable and accessible area of the paddles were wiped with paper towels and green scrub pads. The UFM was above the water line and will be addressed after the shift. The area was released by approximately 2235 hours. My findings indicated a noncompliance with 9 CFR 416.1 , 9 CFR 416.4(a), 9 CFR 416.13(c), and 9 CFR 416.14.
5309	P6137A	NJN240909 5414N-1	09/14/2012	04A06	Poultry Finished Product Standards	C	I was performing a FPS (Finished Product Standards) check at 0709 hours on the reprocessing line in the evisceration department when I observed the following noncompliance; The establishment failed to remove airsacculitis exudate from carcasses identified by USDA for air sac removal. (4) carcasses of the (10) carcass sample identified for air sac removal with a split tail contained air sac exudates. The establishments written procedure for air sac states "(b) (4)". The procedure also states; "(b) (4)". I initiated regulatory control by stoping the reprocessing line and immediately informed Mr. (b) (6) of the forthcoming noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE131309 3514N-1	09/14/2012	04A06	Poultry Finished Product Standards	C	<p>At 1040 hours I was performing the Review and Observation of a Finish Product Standards PHIS task at the salvaged parts station after the product went through all the interventions at the slaughter process and was inspected and released by Quality Control personnel. When I was performing my verification in one tub with thighs, I noted that one of thighs had cellulitis exudate between the fat tissue and the skin with an approximate measurement of 1 ½ inches in diameter in its greatest dimension. I took regulatory control action by applying retain tag #B38694335 to the tub with the affected product. I showed my finding to (b) (6) and (b) (6). As immediate corrective action the affected product was condemned as per the establishment decision. Upon reviewing the establishment records, I noted that Quality Control personnel released and found acceptable the affected product at 1004 hours. The finding of cellulitis exudate in finish product represents a noncompliance as per 9 CFR 381.86 which states, "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned". Mr. (b) (6) was informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>
5308	M6137	BXL0609094 913N-1	09/13/2012	06D02	Other Inspection Requirements	C	<p>On 09/13/2012 at approximately 0216 hours while monitoring the establishment carcass Presentation functions in Plant #1 Line #1, I observed the following. I timed a standard 'no viscera' check for three minutes and counted 22 no viscera nonconformances. The line was running at (b) (4) bpm (birds per minute) which allows 13 or less 'no viscera' to be in compliance. I informed (b) (6). Adjustments were made before break and during lunch with a Quality Control recheck at 0354 hours failing with 18 no viscera nonconformances. The line was slowed to (b) (4) bpm with a Quality Control recheck failing at 0619 hours with 19 no viscera. At (b) (4) bpm 11 or less no viscera nonconformances are allowed. A check of the establishments (b) (4) Lines - No Viscera Monitoring Log for the PM shift for the same day showed that at 0810 hours at (b) (4) bpm a Quality Control check failed with 17 no viscera nonconformances. At 0836 hours a Quality Control recheck failed with 23 no viscera. The line was slowed to (b) (4) bpm at 0838 hours. At 1020 hours at (b) (4) bpm a Quality Control check failed with 19 no viscera nonconformances. At 1304 hours at (b) (4) bpm a Quality Control check failed with 20 no viscera nonconformances. At 1456 hours at (b) (4) bpm a quality control recheck failed with 17 no viscera nonconformances. The establishment made no mechanical adjustments to correct the failure, nor was the line slowed further to correct the noncompliance situation. My findings indicated a noncompliance with 9 CFR 381.76 (a) & (b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1905093 613N-1	09/13/2012	01B02	Pre-Op SSOP Review and Observation	C	On 09/12/2012 at approximately 2355 hours while monitoring the establishments' Pre-Operational Sanitation procedures after establishment SSOP and HACCP monitors completed their inspections, I observed the following. In Packaging Area #1, there were numerous pieces of fat and tissue to approximately 1/4" on the inside surfaces of the cover associated with the tray dispenser on line (b) (6). There were several pieces of fat to approximately 3" on the tray flex belt on the bag fryer line side of line (b) (6). Also along the entire length of the same Line (b) (6) tray flex belt, there were large patches of pasty fat, tissue and black UFM (Unidentified Foreign Material) that appeared to be mold on the stainless and white nylon portions of the belts support brackets. The majority of the area was scrubbed with green pads and rinsed with (b) (4), however a detailed chemical application and cleaning will be accomplished for some of the non-food contact surfaces at a later time. The line was released by approximately 0022 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), and 9 CFR 416.13(c).
5309	P6137A	NJN221209 3613N-1	09/13/2012	01C01	Operational SSOP Record Review	C	On September 12, 2012 I was in the New Product room at 1135 hours reviewing SSOP records for Rotisserie Injection pick-up Verification Log when I noted that The (b) (6) recorded the checks 0926 hrs and the next one an 1123 hrs. The Establishment's SSOP states (b) (4) ". The establishment had not switched lots or product codes at the time observation was made. I informed Ms. (b) (6) of the non compliance.
5309	P6137A	NJN351309 4913N-1	09/13/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 0937 hours while performing PHIS task for zero tolerance on the reprocessing line I observed one carcass of a ten carcass sample with visible fecal material on the inside cavity of the bird by the left side of the keel bone. The fecal material was approximately 1/8 inch in diameter, dark green in color and had a paste-like consistency. I immediately took regulatory control action with the application of US Retained Tag #B21948349, stopping the line and informing Mr. (b) (6) of the forthcoming non compliance. That the establishment failed to prevent fecal material from entering the chilling system represents noncompliance with 9 CFR 381.65(e). The retest (recheck) was performed at approximately 1014 hours by (b) (6) due to mechanical failure on the Offline. This document serves as written notification that your failure to comply with regulatory requirement's could result in additional regulatory or administrative action.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE421809 1113N-1	09/13/2012	01C02	Operational SSOP Review and Observation	C	<p>While I was performing the Review and Observation of a Poultry Zero Tolerance Verification PHIS task at the salvage inspection station, I observed the following deficiency: At 1340 hours I was inspecting a tub that contained salvaged thighs; when I noticed that some of the pieces of ice that are used to bring the product's temperature down were contaminated with rail dust and cross-contaminating the product in the tub. The rail dust specks had an approximate measurement of 1 mm in their greatest dimension. I took regulatory control action by applying Retain tag # B386994336. I showed my finding to (b) (6)</p> <p>. At 1345 hours, the establishment decided to condemn the affected product. Upon reviewing the CCP-1B form, I noted that the thighs were released and found acceptable by Quality Control at 1302 hours. The finding of rail dust on ice and cross-contaminating finish product that went through all the interventions at the slaughter process does not meet the regulatory requirements of 9 CFR 416.13(c) which states, "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's". And 9 CFR 416.4(d) states, "Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments". The employees mentioned in this document were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above</p>
5308	M6137	BXL0018092 112N-1	09/12/2012	01C01	Operational SSOP Record Review	C	<p>At approximately 1115 hours while performing Operational SSOP Record Review I observed the following noncompliance. On the Establishments SSOP Monitoring and Implimentation log for 09-11-2012 on the AM shift in Plant #1 there was a monitoring check missing on the log. Only one monitoring check was documented at 2324 hours, according to the Establishment's SSOP's there is to be (b) (4)</p> <p>The log was signed by a Supervisor as correct and complete. My findings indicate a noncompliance with 9CFR 416.13(b) and 9CFR 416.16(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1210091 312N-1	09/12/2012	01C02	Operational SSOP Review and Observation	C	On 09/11/2012 at approximately 1050 hours while monitoring the packaging area, I noticed a lot of debris on the floor all around the bag fryer lines. I brought this to the attention of (b) (6). He mentioned that he would take care of it. At approximately 1908 hours while performing a routine Operational Sanitation verification check, I observed a noncompliance on the bag fryer line, Packaging area. There were giblets, plastic bags, packaging pads on the floor and overflowing trash containers. There were several stainless steel container overflowing with down grade birds causing the birds to fall on the floor. I also noticed several bagged whole body birds on the floor at the end of the line. I did not notice any sanitation employee taking care of cleaning the area. I approach (b) (6) and brought to her attention the insanitary conditions and notified her of a noncompliance being issued. She immediately instructed her sanitation employee to clean the area. All debris was picked up from the floor and the birds were picked up and reconditioned. The establishment SSOP records for the packaging area reflected no sanitary deficiencies through out the day. My finding reflect a noncompliance with regulatory requirements of regulations 9 CFR 416.1, 416.13(c) and 416.14.
5333	P7632	HYE341809 5012N-1	09/12/2012	01D01	SPS Verification	C	On September 12, 2012 Inspector (b) (7)(C) called me to inspection station one on Evisceration line two at approximately 1059 hours. Inspector (b) (7)(C) informed me that he had observed a build up of mold at his station on an electrical cord, and the outlet connected to it. I inspected the electrical cord that hangs under the station above the condemn barrel. The power cord had spots of mold on it, ¼ of the yellow power outlet's surface was covered in black mold. I informed (b) (6) of the noncompliance for the failure to meet the regulatory requirements cited above. I continued to inspect the remaining seven inspection stations and noted that on both evisceration lines one and two, stations one, two, and three, there was mold build-up on the power cords and outlets as well. I informed (b) (6) of my findings and Mr. (b) (6) purposed a corrective action of the establishment removing these power cords and outlets because they no longer served a purpose. In the Q.C. office I informed (b) (6) of the noncompliance and requested the Pre-Operational Sanitation records for September 11, 2012. Upon review of this record I noted that (b) (6) perform Pre-Op inspection on unit 23 (inspection stations) at 2148 hours and passed the unit.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1516090 011N-1	09/11/2012	03J02	Slaughter HACCP	C	While performing Slaughter HACCP procedure record keeping review, I found the following noncompliance with regulation 9CFR 417.5 (c). At approximately 1100 hours while reviewing the Establishments' HACCP Monitoring Log CCP-1B (b) (4) from 09/10/2012, I observed that Quality Control had a Fecal failure on Line # (b) (4) (reprocessing line) in Plant # 2 at approximately 1051 hours. The protocol for fecal failure was implemented (HACCP supplement # 26) for CCP-1B. The Recheck passed it at approximately 1105 hours. Quality Control completed corrective actions at approximately 1235 hours by performing Post-Chill checks every five minutes at the exit of Chiller # 3. The Pre-Shipment Records Review for CCP-1B (b) (4) Mid-Shift was signed at 1158 hours. The signed document certifies that all corrective actions were completed and the product is ready to be shipped. The Pre-shipment Records Review Mid-shift was signed before the corrective actions were completed. I informed (b) (6) of the noncompliance.
5308	M6137	BXL3607092 212N-1	09/11/2012	01D01	SPS Verification	C	On 09/12/2012 at approximately 00:46 hours, Inspector (b) (7)(C) brought to my attention an adult cockroach on the wall just above the apron rack, adjacent to evisceration line (b) (4) near the 3rd inspection station. I then killed the roach and showed it to (b) (6) and informed him of the location where the roach was found. Roaches are known to transport filth and disease. My findings indicate a noncompliance with 9 CFR 416.1 and 9 CFR 416.2.
5308	M6137	BXL4222092 211N-1	09/11/2012	06D02	Other Inspection Requirements	C	On 09/06/2012 at approximately 0154 hours while performing a scheduled Presentation check on line (b) (4) in Plant #2, I observed the following. At the first inspection station with the line speed at (b) (4) birds per minute, I observed (1) bird 'not hung by two legs', (1) bird with the 'viscera not uniform', (1) bird with the 'viscera on the shackle', (3) birds "not reflected", (1) bird with 'parts inside', and (1) bird with 'contamination inside' for a total of 42 nonconformance points. This exceeded the limits of process control of 2 or less occurrences of one error and 24 or less process control points. I informed (b) (6) of my observations and that as the total nonconformances exceeded 40 points an immediate 10 bird line speed reduction was required. Quality Control performed a recheck at 0202 hours at (b) (4) birds per minute that passed. The line was returned to (b) (4) birds per minute and the Quality Control recheck failed at 0210 hours at the first station with (3) 'viscera on the shackle' and (2) 'membranes not broken' for a total of 28 nonconformance points. Station #3 also failed with (3) 'viscera on the shackle' and (3) 'membranes not broken' for a total of 30 nonconformance points. The line was again reduced to (b) (4) birds per minute with a recheck at 0226 hours that passed and a recheck at 0233 hours at (b) (4) birds that passed bringing the process back into control. My findings indicated a noncompliance with 9 CFR 381.76(b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN510509 1910N-1	09/10/2012	01C02	Operational SSOP Review and Observation	C	<p>While performing an Operational Sanitation SSOP review and observation PHIS task at 02:40 AM, I observed the following noncompliance: At the end of B line in the evisceration department there were several leaks of water dripping from the ceiling. The water dripping was directly above the product. I observed it dripping on the product and notified (b) (6). He immediately took control of the issue by stopping the production line and alerting maintenance of the issue. Maintenance put up plastic liners above the line to divert the dripping onto the floor and the production was released at 03:02 AM. I informed (b) (6) of the forthcoming noncompliance record. By allowing the adulteration of product the establishment failed to follow the following regulatory requirements: CFR 9 416.2(b)(1) Establishment buildings, including their structure, rooms, and compartments must be of sound construction, be kept in good repair, and of sufficient size to allow for processing, handling, and storage of product in a manner that does not result in product adulteration or the creation of insanitary conditions. CFR 9 416.2(b)(2) Walls, floors, and ceiling within establishments must be built of durable materials impervious to moisture and be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions. CFR 9 416.2(e)(3) Prevent adulteration of product, water supplies, equipment, and utensils and prevent the creation of insanitary conditions throughout the establishment. CFR 9 416.4(d) Product must be protected from adulteration during processing, handling, storage, loading and unloading at and during transportation from official establishment. CFR 9 416.1 Each official establishment must be operated and maintained in a manner sufficient to prevent the creations of insanitary conditions and to ensure that product is not adulterated.</p>
5308	M6137	BXL3005093 408N-1	09/08/2012	04A06	Poultry Finished Product Standards	C	<p>On 09/08/2012 at approximately 0037 hours while monitoring Finished Products Standards at the Post- Chill location from Chiller #3 in Plant #2, I observed the following. After taking a random 10 bird sample, I accumulated 11 nonconformance points which exceeded the subgroup absolute limit of 10 points. I informed (b) (6) of my findings. A QC recheck failed with 6 points at 0047 hours. The limit at the Post-Chill for a recheck is Tolerance which is 5 points. At this point the process is judged to be out of control. (b) (6) informed me of the recheck failure and that product was being retained. Quality Control tanked and identified product exiting Chiller #3 that required rework and performed additional rechecks that also failed at 0052 hours with 6 nonconformances, at 0100 hours with 7 nonconformances, at 0106 hours with 6 nonconformances, and at 0112 hours with 7 nonconformances. The QC recheck at 0116 hours passed bringing the process back into control. A total of 10 tanks of product was placed on QC hold pending rework. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv)(e)(3).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0905091 807N-1	09/07/2012	01C02	Operational SSOP Review and Observation	C	On 09/07/2012 at approximately 0130 hours while monitoring Facilities, I observed the following. In the storage area of the rewrap room in the Weigh & Price cooler there was a rack of Backs & Necks labeled 08/13/2012. The product was a light brown color. Some of the packages had holes in the (b) (4) packaging material apparently caused from contact with the product baskets that make up the racks. The product exposed to the air in these areas had changed to a light gray color. The product staged at this location is product that is culled from the Weigh & Price cooler due to age or other defects. The product is staged and is normally awaiting down grade and rewrapping for freezing. I contacted (b) (6) and showed her my findings. A package was opened and the product gave off a pungent smell. She condemned approximately 100 packages. The product was placed in a gray inedible barrel by approximately 0155 hours. The establishments' HACCP Plan for Slaughter lists the shelf life of fresh product as (b) (4). The temperature of the Weigh & Price cooler at the products location was approximately 28 degrees. My findings indicated a noncompliance with 9 CFR 416.4(d).
5309	P6137A	NJN030209 1306N-1	09/06/2012	01C02	Operational SSOP Review and Observation	C	While performing my Operational Sanitation review and observation PHIS task at 23:40, I observed the following noncompliance. I observed four black objects floating in the paw chiller. There was product in the chiller at this time. I notified Evis. (b) (6) of the noncompliance. He attempted to remove the objects from the chiller water. He retrieved one and identified it as a Paw Picker. Once all the objects were removed I informed (b) (6) of the and Mr. (b) (6) of the forthcoming noncompliance record. Mr. (b) (6) at this point drained all water and product from the paw chiller. They reworked the product and sanitized the paw chiller. At 00:15 once sanitation was restored and they were back in compliance the paw chiller and product was released. By allowing the product to be adulterated they failed to comply with the following regulations that state: 9CFR 416.1, Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated. 9CFR 416.3(a), Equipment and utensils used for processing or otherwise handling edible product or ingredients must be of such material and construction to facilitate thorough cleaning and to ensure that their use will not cause adulteration of product during processing, handling, or storage. Equipment and utensils must be maintained in sanitary conditions so as not to adulterate product. 9CFR 416.4(a), All food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. 9CFR 416.4(d), Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishment.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1207094 904N-1	09/04/2012	03J04	Poultry Zero Tolerance Verification	C	While performing Pre-Chill Finished Products Standards Check, I observed noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). On 09/04/2012 at approximately 0410 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination inside the bird at the left side under the leaf fat area, close to the kidneys. The fecal material was a smear measuring approximately 1/4 " diameter in size, brownish green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0439 hours and it passed. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.
5309	P6137A	NJN391309 1601N-1	09/01/2012	04A06	Poultry Finished Product Standards	C	While performing a FPS (Finished Product Standard) check at approximately 0914 hours on the Reprocessing Line in the Evisceration Department I observed the following non compliance: The establishment failed to remove airsacculitis exudate from carcasses identified by USDA for airsacculities removal. (1) carcass of the (10) carcass sample identified for air sac removal with a split tail contained air sac exudate. The establishment's written procedure for for air sac removal states that (b) (4). During the recheck performed at approximately 0919 hours by (b) (6), (1) carcass of the (10) carcass sample identified with a split tail contained air sac exudate. The establishment's written procedure for air sac removal states (b) (4). I initiated regulatory control by stopping the reprocessing line and informing Mr. (b) (6) and (b) (6) of the non compliance.
5333	P7632	HYE230508 1930N-1	08/30/2012	01D01	SPS Verification	C	On August 29/2012, while I was performing SSOP in the Giblett Chiller area at 0004 hours I observed the following noncompliance: an employee picking up a glove off the floor, putting it on and grabbing a shovel by the handle from combo bin containing ice. He stirred the ice in the bin and then laid the shovel vertical inside the bin of ice. The ice wasn't affected. I immediately took regulatory control action by placing US Rejected Tag NO. B38 495190. Mr. (b) (6), was informed with my finding and forthcoming documentation of the failure to comply with the regulatory requirements cited above. At 0006 hours I released the shovel to (b) (6), after putting a QC hold tag on it to restore the sanitary condition of the shovel.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE510208 1329N-1	08/29/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>At approximately 2315 hours, after sanitation and QC performed preoperational sanitation and released area III for operations; I performed preoperational sanitation and observed the following noncompliances: a piece of meat approximately 1 inch by 1 inch, on the transfer conveyor belt at North Chiller Exit, from previous shift of production. The belt is product-contact surface. The floor underneath that belt had several pieces of fat. I immediately took regulatory control action and rejected the belt, the floor and applied US Rejected Tag NO. B38 494919. At approximately 2318 the belt and the floor were re-inspected found acceptable and released. In the same area and at 2320, I observed the following noncompliance: the floor underneath the Downgrade belt had numerous pieces of fat and meat particles from previous shift of production. I immediately took regulatory control action and applied rejected tag NO. B38494915. The floor was re-washed, re-inspected and released at 2329 hours. Mr. (b) (6), notified of my findings and the forthcoming NR. The requirements of 9 CFR 416.4 (a), 9 CFR 416.13(c), and Plant's written SSOP plan were not met. 9 CFR 416.4(a) States: "All food-contact surfaces, including food-contact surface of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". 9 CFR 416.13(c) states "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's". 9 CFR 416.2 (b)(2) states: "Walls, floors, and ceilings within establishments must be built of durable materials impervious to moisture and be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions. Plant's written SSOP procedures dated 03/13/12, page 2, Section 1 Evisceration, Subsection D Step # 2 states: (b) (4)</p>
5308	M6137	BXL3905084 128N-1	08/28/2012	03J04	Poultry Zero Tolerance Verification	C	<p>While performing a Zero Tolerance Check, I observed noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). On 08/28/2012 at approximately 0119 hours (b) (6) randomly removed a 10 bird sample from Line #29 in Plant #2, I found one out the ten birds with visible fecal contamination inside of the bird at the left side of the ribs area. The fecal material was a smear approximately 3/4" long and 3/8" wide, brown-green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a Recheck at approximately 0153 hours and it passed. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plants' HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE590908 0828N-1	08/28/2012	03J02	Slaughter HACCP	C	<p>On August 27, 2012 I was performing a SPS verification task in the Packaging Department, at 1419 hours, when I observed a large pile up of product (leg quarters) had accumulated on a drip pan. The drip pan is located under Auto Loader #2, Leg Processor #3. I requested from (b) (6) to measure the temperature of the product to verify that the temperature requirements were being met. With the calibrated thermometer # 49 we observed a saddle (unsplit leg quarters) at the temperature of 66.5 degrees F. (b) (6) had the pile moved to a brown tub to be washed and iced down, I took regulatory control by applying U.S. Retain tag B38495170 to the tub. Rather than reprocessing and icing the product the establishment chose to condemn the affected product. I then informed Mr. (b) (6) of the forthcoming noncompliance for the failure to meet the requirements cited above. The product was condemned and this was verified by (b) (6) and myself. Establishment P-7632 was granted a Salmonella Initiative Program Letter issued on September 2, 2011. The SIP program allows establishment P-7632 to use alternative chilling procedures in place of 9 CFR 381.66(b), provided the establishment: Assesses, modifies and validates as appropriate, the Hazard Analysis and Critical Control Points (HACCP) plan according to 9 CFR 381.22 and 417.4. The establishment failed to implement their SIP program by allowing the internal temperature of their product to rise above (b) (4) degrees F. SIP protocol states: (b) (4)</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>[REDACTED]</p> <p>This noncompliance is linked to NRs # HYE4415085406N dated 8/6/12 and # HYE5617085809N dated 8/9/12.</p>
5309	P6137A	NJN481408 3625N-1	08/25/2012	01C02	Operational SSOP Review and Observation	C	<p>While conducting Sanitary Operational Procedures in the New Products Room (Area #5, Section C, IQF #2, by the Pack Mac #1) at approximately 1228 hours I observed the following non compliance: I counted seven bags of frozen product (three pound bags of injected thighs) on the floor. Four of those bags were not sealed properly so the product was scattered on the floor underneath the table and some underneath the product conveyor. More bags were being tossed on to a table that was already stacked approximately two feet high with rejected bags, so more bags kept falling on the floor. An employee was trying to empty the bags of product onto the return conveyor with no avail indicating process out of control. Also the red trash receptacle stationed next to the product was overflowing with trash, creating insanitary conditions. I took regulatory control by stopping the line and applying US Retained Tag #B36336883 and informing Ms. (b) (6) and (b) (6) of the non compliance. After corrective actions and proper disposition of product was implemented, Regulatory control was released at approximately 1237 hours.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN100408 5524N-1	08/24/2012	01C02	Operational SSOP Review and Observation	C	<p>Approximately at 01:50 A.M. while conducting PHIS task Operational SSOP review and observation I found the following noncompliance: Two salvage parts tub, with product in them had foreign material on the inside of the the tub. I took regulatory control of the product by applying US retain tags B38495174 and B38495171. I informed (b) (6) of the noncompliance. He took corrective action by reworking the affected product and replacing the dirty tubs with clean ones. Product was released at 01:59 A.M. when sanitary conditions were restored. I informed Mr. (b) (6) of the forthcoming noncompliance. By allowing product to come in contact with insanitary surfaces the establishment failed to meet the following regulatory requirements: 9CFR 416.4(a)(d) states(a)"All food-contact surfaces, including food-contact surfaces, utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." (d)"Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishment." 9 CFR 416.1 "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated."</p>
5333	P7632	HYE230208 5523N-1	08/23/2012	04A06	Poultry Finished Product Standards	C	<p>I was performing a finished product standards (FPS) verification task on the reprocessing line in the evisceration department at 2248 hours. I selected ten carcasses marked for vacuum identified by the split tail. One of the ten carcasses contained a kidney, indicating an improper vacuum procedure. I informed (b) (6) and (b) (6). In thier presence I performed the required recheck of ten split tail carcasses at 2255 hours and found one carcass containing airsac exudate. I informed Mr. (b) (6) and (b) (6) of the forthcoming documentation of the failure to comply with the regulatory requirements cited above. In addition 9 CFR 381.76 table 1 #7 states: Lesion/condition subject to removal following an approved cleanout process: Aircacculitis condition requiring removal of the kidneys.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2908081 622N-1	08/22/2012	01B02	Pre-Op SSOP Review and Observation	C	While monitoring the Establishments' Pre-operational Sanitation Procedures in Main Packaging Area, I found the following noncompliance with regulations 9CFR 416.1, 9CFR 416.4 (a) and 9CFR 416.13 (c). On 08/21/2012 at approximately 2353 hours, I observed on Line #1 at the beginning of the line the white plastic line dividers at the point where they meet there was a red and brown thick layer of residue build-up and small pieces of fat from the previous day production. The triangle metal bracket that holds the two dividers apart had a large amount of black UFM (Unidentified Foreign Material) at the bottom. I immediately tagged the line with U.S. Retained/Rejected Tag # B31 406446 and informed (b) (6) and (b) (6) of the noncompliance. Company personnel scrubbed and rewashed the line. I re-inspected the area and released it. Sanitary conditions were restored at approximately 0015 hours.
5308	M6137	BXL4708082 422N-1	08/22/2012	03J04	Poultry Zero Tolerance Verification	C	While performing Zero Tolerance Fecal Check, I observed noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). On 08/22/2012 at approximately 0520 hours, I randomly removed a 10 bird sample from Line #1 in Plant #1, I found one out of the ten birds with visible fecal contamination. There was a cloaca attached to the carcass near the base of the tail at the left side of the leaf fat area. The fecal contamination was located at the left side of the leaf fat area by the tail. The fecal material was approximately 3/8" diameter in size, light brown in color and watery in texture. This exceeded the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0551 hours and it passed. The cause of the deviation was "body opener failed". This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL3104080 721N-1	08/21/2012	03J04	Poultry Zero Tolerance Verification	C	While performing Pre-Chill Finished Products Standards Check, I observed noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). On 08/21/2012 at approximately 0112 hours, I randomly removed a 10 bird sample from Line #1 in Plant #1, I found one out of the ten birds with visible fecal contamination inside the bird at the right side by the kidneys area. The fecal material was a smear measuring approximately 1/4" by 3/4" in size, dark green in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0141 hours and it passed. The cause of the deviation was "venter". This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE250708 1821N-1	08/21/2012	01C02	Operational SSOP Review and Observation	O	<p>At approximately 3:28 A.M. while performing PHIS task Operational SSOP review and observation, I observed the following noncompliance while walking through 1st processing: A pipe directly above the giblet staging area had condensation and it was dripping directly over exposed product . I informed (b) (6) who in turn called (b) (6) . I informed her of the noncompliance and she called (b) (6) . I informed (b) (6) . I informed him of the noncompliance. He then told me that they had already received an NR the night before and I confirmed that yes they had. I then asked him about what was going to be done with the affected product today. Mr. (b) (6) said that they would be condemning the product and wiping down the pipe. (b) (6) and Mr. (b) (6) were both informed of the forthcoming noncompliance. By allowing condensation to adulterate product the establishment failed to meet regulatory requirements of 9 CFR 416.1 which states "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to insure that product is not adulterated." 9 CFR 416.2(d) "Ventilation adequate to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product and the creation of insanitary conditions must be provided."</p>
5308	M6137	BXL0213081 320N-1	08/20/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 8/20/12 at approximately 0655 hours I observed the following while performing the Pre-operational SSOP Review and Observation Task in Plant # 1 . In the Paw room on line # 1 , the round shaft on the inter portion of the picker had a build-up of yellow grease .The area was approximately 2" by 4" , US Retained /Rejected tag # B 31 407672 was applied . I immediately notified (b) (6) . (b) (6) had one of his workers scrub the shaft and rinse it thoroughly . At 0702 sanitary conditions were restored and the area was ready for production . At approximately 0704 hours the Transfer Machine on line # 1 was inspected . The Drip pan that runs off onto the Transfer table , which is a food contact surface had a build-up of grease on the outer walls and there were several pieces of black fiber like material also pieces of fat inside the drip pan . (b) (6) was once again notified . (b) (6) had one of his men remove the grease from the walls of the drip pan and rinse the drip pan and transfer table also . The area was re-inspected and found to be in sanitary condition .My findings indicate non-compliances with the following regulations , 9 CFR 416.13(c) , 9 CFR 416.14 , 9CFR 416.4(a) and 9CFR 416.4(b) .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE210908 0420N-1	08/20/2012	01C02	Operational SSOP Review and Observation	C	<p>I was in the Packaging Department prior to start up on August 18, 2012 when I noted the following deficiencies: Two white mobile product conveyors had meat and fat particles from the previous day's production, one conveyor also had black water like foreign material in some spots. Both conveyors were tagged with the application of U.S. retain tags B39757024 and B38495131 at approximately 0840 hours. I continued my inspection of the area and observed that the product belts for Segment Lines one and two were both contaminated with meat and fat particles. Segment Line one also had the same black, water like, foreign material on the product contact surface of the belt. Segment Line One was retained with U.S. retain tag B38494925, Segment Line two was retained with U.S. retain tag B38494924. I informed (b) (6) and (b) (6) of the forthcoming noncompliance. After I reinspected the affected belts and confirmed sanitary conditions were restored I released the product conveyor at 0905 hours. I reviewed the establishment's Pre-Operational Sanitation Records in the Q.C. office. I noted that (b) (6) conducted Pre-Op inspection on both Segment Lines one and two and found them acceptable at 0224 hours on August 18, 2012.</p>
5333	P7632	HYE330508 3020N-1	08/20/2012	01D01	SPS Verification	C	<p>At approximately 02:00 A.M. on 08/20/12 I was performing the review and observation component of SPS task when I observed the following noncompliances: There was condensation on the bottom of the drip pans above the rehang area by the north chiller. There was exposed product directly underneath the condensation. There was also condensation on the pipes above the staging area for the giblets. I informed (b) (6) of the noncompliance. Mr. (b) (6) then instructed an employee to clean the area while he covered the product. Although no condensation was observed dripping on the product, the establishment chose to rework some of the product. I verified that sanitary conditions were restored immediately after they wiped down the areas. By allowing condensation to accumulate, the establishment failed to meet the regulatory requirements of 9 CFR 416.2(d) which states, "Ventilation adequate to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product and the creation of insanitary conditions must be provided". Mr. (b) (6) was informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE400608 0220N-1	08/20/2012	01C02	Operational SSOP Review and Observation	C	At 0002 hours on August 19th and after I performed Post-Chill checks on Noth Chiller I observed the following noncompliance at Segment 1 & 2 Re-hang Belt: an establishment employee grabbed a metal stand, adjusted underneath him, and then he proceeded and touched the carcasses on the Re-belt without washing and sanitizing his gloves. The products were transferred to combo bins. I immediately took regulatory control action by applying rejected tag No B38495146 on the Segment 1&2 Re-hang Belt and two Retained tag No B38495147 and No B38495145 on two combo bins filled with the affected product. The Segment 1&2 Re-hang Belt was washed, sanitized reinspected and released at 0010 hours. After the establishment took appropriate disposition of the affected product, the two combo bins were released to the company at 0045 hours and 135 hours respectively. Mr. (b) (6), was notified of the forthcoming documentation of the failure to comply with the regulatory cited above. As a proposed preventive measure, Mr. (b) (6) stated that he will train the employee.
5308	M6137	BXL0205081 318N-1	08/18/2012	01B02	Pre-Op SSOP Review and Observation	C	On 08/18/2012 at approximately 0020 hours while monitoring the establishments' Pre-Operational Sanitation Procedures in Packaging Area #2 after SSOP and HACCP monitors completed their inspections, I observed the following. There was a red flake that appeared to be paint on the large trim table adjacent to (b) (4) Deboning Line #1. The chip measured approximately 1/4" by 1/8". There were three red flakes that appeared to be paint chips on the main belt at the loading end of (b) (4) Deboning Line #1. The largest flake was approximately 3/8" by 1/4". There were two large white flakes that appeared to be paint on the belt that collects the carcasses adjacent to Line (b) (4). The flakes measured approximately 1/4" by 1/4". A large support pillar painted white nearby has similar flaking paint chips as the post appears to have been repainted with non-compatible paints. A shiny piece of metal was on the main belt at the loading end of (b) (4) Line (b) (4). The metal piece was approximately 1mm by 6mm's. It was partially imbedded in the belt surface. The reverse side was irregularly shaped and appeared to be a piece of welding slag. I discussed my findings with (b) (6). He was given most of the paint flakes. (b) (6) was shown the piece of metal. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(a), and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1800084 517N-1	08/17/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 08/16/2012 at approximately 1927 hours while monitoring Processing functions in the Packaging Department, I observed the following. A sanitation employee was washing stainless steel tanks in the area between the sorting & sizing lines and cooler #2. The washing was taking approximately 1-2 minutes per tank and no soap or sanitizer was being used. I looked inside the tanks which had up to approximately 50 pieces of giblets, necks, soaker pads plus pink to brown fluids from the previous days production. The tanks were then covered with blue plastic in preparation to being placed in the Plant #2 cooler. The blue plastic cover is used by the establishment as a marking system that identifies the tank as clean and ready for use. The tanks are used during production to store WOG's for rotisserie and to store excess birds exiting the chilling system. I placed USDA rejected tags on tanks 33-L, 56, 83-L, L28, and on one tank without a number. I contacted (b) (6) and discussed him my findings. A review of the establishments' SSOP for pre-Operational Sanitation Wet Clean-Up (food contact surfaces) under Clean: states (b) (4). The employee was only using a high pressure (b) (4) rinse at approximately (b) (4) degrees, no soap and was doing no scrubbing. Soap was applied and the tanks were recleaned by approximately 0740 hours. When asked if the bottoms and wheels of the tanks would be cleaned (b) (6) only has the wheels & tank bottoms cleaned on the weekends. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c), and 9 CFR 416.14.</p>
5333	P7632	HYE590208 1616N-1	08/16/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>While performing my pre operational sanitation inspection at 23:56 in second processing I observed the the following non compliances: Auto loader #1 manual feeder had 1/2 to 1 inch pieces of fat along the entire length of the belt. Three tub stands in between the stand and the production line had 1 inch pieces of fat and along the floor under the production line also had several pieces of fat . At the rotisserie packing belt and packing station I observed 1/2 to 1 inch pieces of fat in the chutes and the belts. Regulatory control of the area was taken with application of US Retain tag # B38495193 I informed (b) (6) of the non compliance. Regulatory control of the area was released at 00:13 once sanitary conditions were restored.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0409085 215N-1	08/15/2012	03J04	Poultry Zero Tolerance Verification	C	On 08/15/2012 at approximately 0345 hours while performing a Zero Tolerance check in Plant #1 on Line #2, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. The fecal material was inside on the left side of the carcass in the area where the leaf fat is located. The leaf fat had been removed. The fecal material was approximately 1/4" by 1/8" in size, olive green in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. I contacted (b) (6) who implemented the establishments' Protocol for Fecal Failure. A QC recheck passed at 0412 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4), and the critical limit of CCP-2B (b) (4) of the Plants HACCP Plan for Slaughter .
5308	M6137	BXL3316080 015N-1	08/15/2012	01D01	SPS Verification	C	At approximately 1110 hours while walking through the Plant #1 Packaging Rehang area I observed the following noncompliance. The drip pan directly over the end of the sizing lines where the carcasses are tanked was covered in heavy condensation that was dripping and running down the length of the drip pan. The long drip pan on the opposite side that is over the end of the sizing lines where the samples are taken and extends to the (b) (4) cabinet had condensation running then entire length. The drip pan that runs from the end of Chiller #1 and extends to the (b) (4) cabinet was covered in heavy dripping condensation, tanked product is passed under this drip pan to be dumped for rehang. I immediately informed (b) (6) the noncompliance. (b) (6) had a sanitation employee wipe down the drip pans restoring sanitary conditions by 1125 hours. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.2(d) and 9CFR 416.4(b).
5333	P7632	HYE180108 5315N-1	08/15/2012	01D01	SPS Verification	C	On the morning of 8/14/2012 at approximately 605 hours, food inspector (b) (7)(C), who was on station #4, line one, informed me about her observation of the trimmers' knife sharpener. She noticed that the knife sharpener was rusty and had brown foreign material. I immediately rejected the knife sharpener and continued on to check all of the knife sharpeners at all of the stations. At station #1, line one, I found that the knife sharpener was also rusted. I showed the rusty sharpeners to Mr. (b) (6), and informed him of the forthcoming NR. Mr. (b) (6) stated that he will discard the rusty sharpeners and replaces them with new ones. Upon review of the establishment operational sanitation log records, the last check for step #3 before my finding was 0558 hours: All relevant SSOP's performed? The answer was: Yes. All Sanitation Requirement's met? The answer was: Yes. The Requirements of 9 CFR 416.1, 416.4(b) and Plant's written SSOP were not met. Plant's written SSOP part II Operational page1 step #3 states: (b) (4)

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE491508 4715N-1	08/15/2012	04A06	Poultry Finished Product Standards	C	After observing a high percentage of birds presented for post-mortem inspection were being hung back on the Reprocessing line for pathology the establishment initiated their alternative On-Line Vacuuming/Air-Sac Removal Procedure. I elected to verify the effectiveness of the alternative procedure by selecting a ten bird sample from Evisceration Line One. I observed airsacculitis exudate adhering to the leaf fat, renal areas and thoracic cavities to two of the ten bird sample. I notified (b) (6) of my findings and at 1107 hours I performed the required recheck. I observed one of the ten bird sample to have airsacculitis exudates adhering to the thoracic cavity of the bird and notified (b) (6) of the forthcoming documentation of the failure to comply with the regulatory requirements cited above.
5309	P6137A	NJN440708 4114N-1	08/14/2012	04A06	Poultry Finished Product Standards	C	I was performing a FPS (Finished Products Standards) check at 0515 hours on the reprocessing line in the evisceration department when I observed the following noncompliance; The establishment failed to remove airsacculitis exudate from carcasses identified by USDA for air sac removal. (4) carcasses of the (10) carcass sample identified for air sac removal with a split tail contained air sac exudates. The establishments written procedure for air sac states "(b) (4) I ". The procedure also states; "(b) (4) ". I initiated regulatory control by stopping the reprocessing line and immediately informed Mr.(b) (6) and Ms.(b) (6) of the forthcoming noncompliance.
5308	M6137	BXL5117082 613N-1	08/13/2012	01D01	SPS Verification	C	At approximately 1115 hours while walking through the Packaging Paw Room located next to the loading dock I observed the following noncompliance. I observed several flies on walls and pipes in the room, I proceeded further to the small adjacent room where waxed boxes are put together and blue plastic liners are inserted and stored for use in the Paw Room to package product. There I observed approximately 13 more flies on the ceiling, walls and pipes throughout the room. I immediately informed the lead person and (b) (6) of the noncompliance. My findings indicate a noncompliance with 9CFR 416.1 and 9CFR 416.2(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1809081 111N-1	08/11/2012	04A06	Poultry Finished Product Standards	C	On 08/11/2012 at approximately 0553 hours while performing a HACCP Slaughter check on Line (b) (4) in Plant #2, I observed the following. After taking a random 10 bird sample, I observed two birds with split tails and visible Airsacculitis exudates. The establishments' marking system has the tails split on carcasses identified as needing vacuuming for whatever reason. I contacted (b) (6) who was nearby and showed him my findings. I informed him that I would be doing a recheck. A recheck at approximately 0559 had 2 of 10 carcasses with split tails and visible Airsacculitis exudates. (b) (6) immediately started tanking Line (b) (4) product. A recheck at 0613 hours brought the process back into control. The tanked product was reworked and released by approximately 0625 hours. My findings indicated a noncompliance with 9 CFR 381.84.
5308	M6137	BXL3008083 611N-1	08/11/2012	03J02	Slaughter HACCP	C	On 8/11/12 approximately 0547 hours I observed the following while performing the Finished Product Standards Post-Chill Task in Plant # 1 on the # 2 Chiller .Taking a ten bird sample I observed one bird with a attached cloaca and a dangling intestine Approximately 1' in length .There was a 1/8 " by 1/8" light brown spot of feces . The affected area was approximately 2" below the opening cut and was watery in texture .(b) (6) was notified at once . Once the spot was confirmed to be fecal the establishments Post Chill Fecal Failure protocol was implemented by the QC . Two tanks of birds were retained for re-work while a recheck was performed .The recheck passed at approximately 0558 . Chiller # 2 was monitored for approximately the next 60 minutes .My findings indicate non-compliances with the following regulations 9CFR 416.2(c)(4) and 9CFR 318.65(e) also the critical limits of CCP-2B and the (b) (4) of the Establishments' Haccp Plan for Slaughter .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0804082 409N-1	08/09/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 08/08/2012 at approximately 2220 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Plant #2 after SSOP and HACCP monitors completed their inspections, I observed the following. There were numerous specks and flakes of black UFM (Unidentified Foreign Material) to approximately 1/8", and a thick coating of pasty fat and tissue on the kick out and support brackets that drop birds onto a belt at the end of line (b) (4). Line (b) (4) is used to recondition contaminated and diseased birds. There were also numerous specks and flakes of black UFM of a similar size on the flex belt and stainless supporting brackets at that location. The flex belt transports reconditioned birds to chiller #3 or #4. There was a large amount of black UFM on the top and sides of the white sprocket that holds the line shackles while the bird is removed. There were numerous specks and flakes of black UFM to approximately 1/4" also on the associated drip pans at the same location. There was a thin layer of dried and semi-dried fat, tissue, black UFM and feathers on the guide bars associated with the unit. The area was cleaned with green pads, brown paper towels and rinsed with (b) (4) then released by approximately 2240 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.13(c), and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE561708 5809N-1	08/09/2012	03C02	Raw Intact HACCP	C	<p>While performing the Review and observation component of a SPS PHIS task; CSI, (b) (7)(C) and I, CSI, (b) (7)(C), observed approximately 7 carcasses that were over the Segment Line Rehang Belts located at the Rehang area and the North Chiller Exit. As part of the SIP Waiver that was granted to the establishment, we decided to take the temperature on the carcasses. We requested to (b) (6), to take the temperature with her calibrated thermometer #51. Two carcasses registered their internal temperature at 62.8 F and 61.4 F. The finding of temperatures above 59 degrees F does not comply with the SIP waiver granted to the establishment by USDA/FSIS. The SIP protocol using the alternative chilling procedures in place of 9 CFR 381.66(b), states, (b) (4)</p> <p>(b) (4)</p> <p>Mr. (b) (6) informed us that according to a training document, the employees responsible for this task are to condemn any left over carcasses during the lunch time clean up. We requested to see the training document, and we noticed that it states, "(b) (4)</p> <p>(b) (4)". We also reviewed a deviation report generated in response to NR#HYE4415085406N / 1 (carcass found with temperature over 59 F at the rehang area). The preventive measures proffered by the establishment were: "Training will be conducted for employees that stay over at lunch time for wash down to remove all birds or iced product left on the processing floor". The establishment failed to implement the preventive measures that were set to prevent product to be neglected and the internal temperature to rise over the parameters set in the SIP waiver. By not implementing its preventive measures, the establishment failed to meet the regulatory requirements of 9 CFR 417.3(a)(3). The establishment elected to condemn the affected product. Mr. (b) (6), was informed of the forthcoming documentation for the failure to comply with the establishment's SIP program and the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2603082 808N-1	08/08/2012	01B02	Pre-Op SSOP Review and Observation	C	On 08/07/2012 at approximately 2205 hours while monitoring the establishments' Pre-Operational Sanitation procedures in Plant #2 after SSOP and HACCP monitors completed their inspections, I observed the following. There is a light gray paint like material peeling and flaking from the ceiling above the Scalder for line (b) (4). The flakes are up to approximately 2" by 1" and cover an area approximately 15 feet by 20 feet on the kill line side of the Scalder. The prewash cabinet for the (b) (4) bird washer on line (b) (4) was still coated with fat and feathers from the previous days production. The hang back racks at the final trim station for line (b) (4) had numerous pieces of fat and tissue to approximately 1/4" on the product contact surfaces. The guide bar at the final trim station for line 4B had a heavy coating of black UFM (Unidentified Foreign Material). Sanitary conditions were restored by approximately 2230 hours. The ceiling above the Scalder will be addressed later. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), and 9 CFR 416.13(c).
5308	M6137	BXL3103081 008N-1	08/08/2012	01D01	SPS Verification	C	On 07/20/2012 at approximately 1935 hours while monitoring corrective actions for a Pre-Operational Sanitation issue in Plant #1, I observed the following. In the Plant #1 Cooler there was condensation spraying from the center refrigeration unit. The spray was condensing on the ceiling, pipes adjacent to the ceiling, and being blown out approximately 30 feet onto tanks of covered product. Production was in progress so bins of finished product passing through the area from the scale to the Staging Cooler for shipping could be contaminated by the spraying condensates. The bins of product were wrapped in plastic but any condensation that gets into the bin will be added to the product during dumping. Additionally, the defrosting condensation was leaking from the front of the unit and dripping onto two pallets of salvaged parts in brown product tubs located under the unit. The parts in the tubs and bins have already received their final microbial intervention. Again any moisture that collects on the product tubs can be added to the product during handling and dumping. I showed (b) (6) my findings. I stopped the flow of bins through the area until the refrigeration unit was turned off. I got a ladder and inspected the refrigeration unit. There was a layer of black UFM (Unidentified Foreign Material) on the fan blades. The defrosting condensation was not collecting in the units collection tray but was instead dripping from the stainless steel flashing under the fan. Nine plastics were replaced on the tanks in front of the unit. Two pallets of salvaged parts were moved and the 12 lids on the tubs were replaced. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), and 9 CFR 416.2(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4712080 206N-1	08/06/2012	06D02	Other Inspection Requirements	C	While performing a Finish Product Standard verification check on line 2 plant 2, I found a noncompliance with regulatory requirement of regulations 9 CFR 381.91(b) and 381.76(b). At approximately 0840 hours, I randomly removed a 10 bird sample from the reprocessing line in plant 2. I found one out of ten birds contaminated with a piece of visible ingesta measuring approximately 1/8" and also one out of ten birds affected with cellulitis. The cellulitis was located by the leaf fat area measuring approximately 1/4". I notified (b) (6) of my findings. The line was full of birds with one final trimmer at the end of the line at 275 BPM line speed. At approximately 0845 hours, I proceeded to perform a recheck finding 1/10 birds affected with several small pieces of ingesta on the breast by the neck area, each measuring approximately 1/16". At this point the process was deemed to be out of control. I gave the contaminated carcass to (b) (6) and notified her of the noncompliance. (b) (6) took corrective action by stopping the line, reducing line speed to (b) (4) BPM and tanking off product. At approximately 0857QC performed a passing recheck putting the process back in control. Retained product was put on hold by Quality Control, reworked by production, rechecked and released by Quality Control.
5333	P7632	HYE441508 5406N-1	08/06/2012	03C02	Raw Intact HACCP	C	While performing a post-chill Finish Product Standards check at the south chiller exit, at 1328 hours, I observed a whole body bird lodged between a wog line chute and the rail of the stand. I requested (b) (6) to take the temperature of the bird, with the calibrated and Q.C. verified thermometer #20. The temperature was 61.2 degrees F, I then retained the bird with the application of U.S. retain tag B38494923 and informed (b) (6) and (b) (6) of the forthcoming noncompliance. The bird was condemned by (b) (6). Establishment P- 7632 was granted a Salmonella Initiative Program Letter issued on September 2, 2011. The SIP program allows establishment P-7632 to use alternative chilling procedures in place of 9 CFR 381.66(b), provided the establishment: Assesses, modifies and validates as appropriate, the Hazard Analysis and Critical Control Point (Haccp) plan according to 9 CFR 381.22 and 417.4. The establishment failed to implement their SIP program by allowing their product internal temperature to rise above 97 degrees. SIP protocol states: "(b) (4) [REDACTED]"

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3504081004N-1	08/04/2012	04B04	General Labeling	C	<p>On 08/03/2012 at approximately 2200 hours while monitoring the establishments' HACCP plans, prerequisite programs and supporting documents, I observed the following. The Retained Moisture Evaluation document dated 08/03/12 Plant #2 from Chiller #3 PM shift at 0836 hours indicated a moisture gain of 10.16 %. The establishments procedure for Chiller Moisture Gain Monitoring dated February 3, 2012 states under #2 Corrective Action (a.) "(b) (4) [REDACTED]</p> <p>" The 10.16% exceeded the acceptable percentage. There are no corrective action logs or recheck documents on file. The Dwell Time was not entered on the 0836 hour log so it is impossible to determine if the carcasses were held in the chiller for an extended period. However, other moisture evaluations documented on 08/03/12 documented dwell times from 85 to 99 minutes. I reviewed the Retained Moisture Evaluation logs for 1-4 August 2012 and found the following issues. On 08/02/2012 in Plant #2 from Chiller #4 on the AM shift at 0115 hours the Retained Moisture Evaluation log indicated a moisture gain of 12.73%. On 08/02/2012 AM shift at 0152 hours from chiller #4 the moisture gain was documented as 12.64%. On 08/02/2012 on the AM shift from Chiller #3 at 0613 hours the moisture gain was documented as 11.24%. On 08/02/2012 in Plant #2 AM shift from Chiller #4 at 0620 hours the moisture gain was documented as 10.37%. On 08/03/2012 in Plant #2 from Chiller #3 PM shift at 1001 hours the moisture gain was documented as 10.16%. On 08/04/2012 AM shift at 0330 hours from Chiller #3 the moisture gain was documented as 10.31%. On 08/04/2012 AM shift from Chiller #3 at 0543 hours the moisture gain was documented as 10.38%. On 08/04/2012 in Plant #1 from Chiller #1 on the AM shift at 0034 hours the moisture gain was documented as 10.39%. Again there were no corrective action logs or recheck documents on file. My findings indicated a noncompliance with 9 CFR 381.1(b)(viii) and 9 CFR 441.10.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2704082 603N-1	08/03/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 08/02/12 at approximately 2225 hours while monitoring the Establishments' Pre-Operational Sanitation Procedures in Plant #1 after SSOP and HACCP monitors completed their inspections, I observed the following. The paper towel dispenser at the end station (4) on line #1 and the lead station (5) on line #2 have large patches of black UFM (Unidentified Foreign Material) inside that appeared to be mold. An attempt to clean the dispensers was made, however a detailed cleaning will be conducted Saturday. The reuse water tank associated with Line #1 Inside/Outside bird washer had numerous pieces of fat and tissue to approximately 1/4" and a thin layer of white product grease measuring approximately 6" by 15" on two sides near the bottom of the tank. There were numerous pieces of fat and tissue to approximately 1/4" inside the reuse water tank at the bird washer for line (b) (4). The tanks were wiped with brown paper towels then rinsed with (b) (4). There was also a thick layer of pasty fat and tissue on the guide bar also associated with the line (b) (4) bird washer. The bar was cleaned with a green scrub pad and rinsed. There were numerous pieces of black UFM to approximately 1/2" on the first paddle at the inflow side of chiller #1. There were also several large areas of dried and semi-dried fat and froth on the first six paddles of Chiller #1 at the same location on the side adjacent to Line #1. The accessible and reachable areas of the chiller paddles were cleaned with green pads and brown paper towels. The area was released at approximately 2245 hours. At approximately 2305 hours in Packaging Area #1, the Rotisserie Room, there were several pieces of fat to approximately 1" on the center gray product belt on the main line. There was also greasy white fat pooled in several locations on the incline belt. The belts were rinsed with potable water and released by approximately 2318 hours. At approximately 2345 hours there was a thick layer of black UFM on two flex belts in Plant #1 associated with the sorting & sizing line. The UFM was on the white nylon support brackets, on the internal belt surfaces and on the sprocket at one end of the each belt. A tank of disinfectant was brought from the main packaging area and the belts were recleaned. There were 5 stainless tanks staged in the area. The tanks were brought out of Plant #1 cooler by production personnel. The tanks were covered with blue plastic. The blue plastic is used by the establishment to identify tanks that are clean and ready for use. The tanks had numerous pieces of tissue to approximately 1/4", feathers to approximately 1", pieces of coagulated blood to approximately 1/4", and large areas of white greasy product fat from previous days use. The area was released by approximately 0015 hours. At approximately 0016 hours there was a layer of a medium brown slimy substance at least 1/8" thick on the base of the vertical door going from the Plant #1 cooler to the Packaging area. This is the main avenue that is used to transport product into and out of the cooler. The base of the door was cleaned and released by approximately 0030 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4 (a) & (b), 9 CFR 416.13(c), and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0505080 101N-1	08/01/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 07/31/2012 at approximately 2230 hours while monitoring the Establishments' Preoperational Sanitation Procedures in Plant #1 and after Establishment SSOP and HACCP personnel completed their inspections, I observed the following. There were patches of dried and semi-dried pasty fat and tissue measuring up to approximately 6" by 3" on the chute that guides the birds into chiller #1. There was also black UFM (Unidentified Foreign Material) that appeared to be mold ,and patches of dried/semi-dried fat and tissue measuring up to approximately 12" by 2" on the kickout and supporting brackets at that location. There were also large patches of dried and semi-dried fat and tissue on the first three paddles of chiller #1 at the carcass inflow side adjacent to line #1. The patches were up to several square feet in size. The first paddle also had several pieces of black UFM as well as pieces of coagulated blood to approximately 1/2" . Reachable and accessible areas were cleaned with green pads and brown paper towels. The area was released by approximately 2245 hours. At approximately 2355 hours in Packaging Area #1 there was a coating made of feathers fragments, fat and tissue on the stainless product contact surfaces of a pallet jack located near the edible dump room. There was dried/semi-dried pasty fat and tissue on the stainless brackets associated with the overhead belt adjacent to the crust tunnel. Approximately a 10 foot section of both lines were rinsed with (b) (4) per establishment policy. In Packaging Area #2, the (b) (4) Deboning Room, there were numerous pieces of fat and tissue to approximately 2" on a belt adjacent to line (b) (4) that collects skin from all (b) (4) lines. The belt has a white nylon divider that runs the length of the belt making it very difficult to clean. There were numerous pieces of fat and tissue to approximately 3" on the white product cones associated with lines (b) (4). There are numerous cones along lines (b) (4) that had dried and semi-dried pierces of fat and tissue to 1/2" imbedded in the cracks and scrapes, and adhering to the rough deteriorated surfaces . The condition of the cones makes the cleaning process very inefficient. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(a), and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1816080 801N-1	08/01/2012	03J04	Poultry Zero Tolerance Verification	C	While performing a zero tolerance fecal verification on line 1 Plant 1, I found a noncompliance with regulatory requirement of regulations 9CFR 381.65(e) and 417.2(c)(4) At approximately 1400 hours, I randomly removed 10 birds from line 1 plant 1 and performed a scheduled zero tolerance verification check. I found one out of ten birds contaminated with feces. The fecal material was inside of the bird cavity near the tail and kidney area. It was dark brown in color and pasty in texture measuring approximately 1/4" in diameter. I immediately notified (b) (6) and (b) (6) of the noncompliance. The establishment proceeded to implement the zero tolerance protocol as part of their immediate corrective action. Venter was established to be the cause of deviation. Maintenance adjusted the settings on the venter machine. Quality control performed a passing re check at 1432 hours, putting CCP 2B under control. Extra fecal checks were performed at the end of the line by (b) (6). Post chill checks were performed at the chiller 1 exit from 1512 hours to 1612 hours. All product coming out of the chiller was found acceptable. Pre shipment review was sign and dated after all corrective actions had taken place.
5308	M6137	BXL1308075 031N-1	07/31/2012	03J02	Slaughter HACCP	C	On 07/31/2012 at approximately 0539 hours while monitoring the Establishments' Post-Chill Finished Products Standards in Plant #1 from Chiller #1, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. There was a cloacae with approximately 6" of intestine attached. The intestine was attached to the carcass near the base of the left side leaf fat. The fecal material was located inside the carcass on the left side leaf fat. The fecal material was a smear approximately 3/4" by 3/8", medium brown in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. There were no supervisors immediately available so I directed the employees at the rehang station for birds going into Packaging to stop hanging carcasses. I had a lead person nearby tank the carcasses coming from Chiller #1. (b) (6) and (b) (6) arrived and I showed them my findings. A QC recheck passed at 0545 hours. Two and one-half tanks of carcasses coming out of chiller were placed under USDA hold. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), 9 CFR 381.65(e), and the critical limit of CCP-2B (b) (4) of the Plants HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5820072 730N-1	07/30/2012	01B02	Pre-Op SSOP Review and Observation	C	While performing Pre Operational Sanitation in plant 1, I observed two noncompliances. At approximately 700 hours while inspecting plant 1, area 3, unit 15 (Eviscerator and viscera shackle washer), I noticed a layer of thick white and gray residue building up on the white plastic brackets surround the unit. I notified (b) (6) the non compliance and proceeded to place a US. tag NO B31 407656 on the affected equipment. Sanitation employees cleaned the equipment and made it acceptable. Unit 15 was released to production at approximately 0720 hours. This is a noncompliance with regulatory requirement of regulation 9 CFR 416.4(b). On Monday, at approximately 0710 hours, while inspecting area 5, unit 21 (giblet chiller), I noticed half of a liver left from the previous production day on the bottom of the giblet chiller. It was light brown in color measuring approximately a square inch. (b) (6) was notified of the noncompliance. Liver was immediately taken out by sanitation. Water in the giblet chiller was treated with (b) (4) as production started running. This is a noncompliance with regulatory requirement of regulation 9CFR 416.4(a).
5309	P6137A	NJN301907 2030N-1	07/30/2012	01D01	SPS Verification	C	At approximately 1542 hours while conducting a verification procedure Sanitary Performance Standard (SPS) in the Packaging Department, by the (b) (4) Line I observed the following non compliance: Three flies on top of a liner covering a hard plastic bin that was half full of chicken thighs of product that was staged to be used. Two of the flies were dead and one was moving around. Regulatory Control of the bin was taken with the application of US Reject Tag #B39415805 and informed Mr. (b) (6) and (b) (6) of the forthcoming non compliance. Regulatory control was released at approximately 1547 hours. Sanitary conditions were restored after the liner with the flies was removed carefully and was discarded. A clean liner was applied to cover the product. No product was affected.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1009071 228N-1	07/28/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 7/27/12 at approximately 2354 hours I observed the following in the Packaging Area .The rehang area in Plant # 2 was inspected first .Upon inspecting the rehang area at end of Chiller # 4 I observed pieces of fat floating in the water in the drip pans behind the rehang table . Inspecting the chiller #3 area I found pieces of fat on the lower portoin of the flex conveyor that tranfers product to the sizing lines . (b) (6) was notified immediately (b) (6) had the drip pans and the flex conveyor belt rinsed thourghly . At approximately 0006 the area was re -inspected .Sanitary conditions were restored and the area was released for production . At approximately 0009 hours the Leg Processors were inspected . The large white sprocket that is used to sperate the drum from the leg had a large piece of fat lodged in the center grove . The piece of fat was approximately 2" by 3" in size (b) (6) was notified immediately (b) (6) had the piece of fat removed by one of his employees .At approximately 0014 sanitary conditions were restored and the leg processor was ready for production . At appropriately 0016 Line (b) (6) was inspected .Line (b) (6) is a flex conveyor that transfers trays to be packed with product . The flex conveyor had pieces of fat on the top side of the belt ,the guide bars and under the conveyor belt , the outer casing of the conveyor also had debris and pieces of fat on it . (b) (6) was once again contacted . He had two of his men re-rinse the entire line thourghly . At 0029 Line (b) (6) was re-inspected and found to be in sanitary condition and Line (b) (6) was ready for production . At 0031 the (b) (6) Room was inspected .The Tender Transfer Line had pieces of fat on it and also in the drip pan underneath the flex conveyor (b) (6) was notified of my findings immediately . (b) (6) had one of his workers rinse the flex conveyor and the drip pan underneath . At 0037 the Tender Transfer conveyor line was re-inspected and found to be in sanitary condition . My findings indicate noncompliances with the following regulations 9CFR 416.13(a) ,9CFR 416.13(c) ,9CFR 416.16(a) ,9CFR 416.1 , 416.4(a) and 416.4(b) .</p>
5333	P7632	HYE051407 5628N-1	07/28/2012	04A06	Poultry Finished Product Standards	C	<p>I was performing a Finished Product Standards verification task in the cooler , at 1122 hours, on the staged salvaged parts after all plant interventions were implemented when I observed the following noncompliance. In one of the salvage tubs I observed cellulitis exudate in between the skin of a chicken leg and the muscle. I then took regulatory control of the salvage tub with the application of U.S. retain tag B38495157 and informed (b) (6) of my findings. (b) (6) were also shown the affected product and notified of the noncompliance. Mr. (b) (6) proffered corrective actions that the product would be reconditioned at the product wash station and for a preventive measure a training would be conducted with the employees involved. I released the product at approximately 1200 after I reinspected it to confirm sanitary conditions were restored and the wholesomness of the product.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE531107 0628N-1	07/28/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0900 hours while performing the Review and Observation component of an Operational Sanitation PHIS task, the following noncompliance was noted: At the North Chiller Exit, I noticed a combo bin with a new liner which appeared to be ready to be loaded with edible product. Upon closer investigation, I noticed that beaded condensation was formed underneath a white pipe that was located right above the combo bin. When I was inspecting the combo bin, I noticed that condensation was dripping on the liner, which is edible product contact surface. I showed the deficiency to (b) (6) and (b) (6), and inquired in what was the intended use for the combo bin, and they replied to me that in case of a breakdown, they would be able to load it with carcasses to prevent pile ups of product on the floor. For immediate corrective action, the establishment removed the combo bin away from the area and replaced the dirty liner with a clean liner. By allowing condensation on direct product contact surface, the establishment failed to meet the regulatory requirements of 9 CFR 416.1 which states, "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated". 9 CFR 416.3(a) states, "... Equipment and utensils must be maintained in sanitary condition so as not to adulterate product". 9 CFR 416.4(a) states, "All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". 9 CFR 416.4(b) states, "Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". 9 CFR 416.13(c) states, "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's". Upon reviewing the SSOP Daily Implementation Monitor Log from night shift, I noted that the last acceptable check for condensation (Step#6: (b) (4)) was at 0832 hours and for day shift no checks were performed previous to the noncompliance. (b) (6) and (b) (6) were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0909072 527N-1	07/27/2012	03J04	Poultry Zero Tolerance Verification	C	On 07/27/2012 at approximately 0553 hours while monitoring Finished Products Standards in Plant #2, I observed the following. After removing a 10 bird random sample from line (b) (6), I observed one bird with visible fecal contamination. There was a gizzard with approximately 5" of intestine attached. The fecal material was leaking from the end of the intestine into the area of the kidneys. The fecal material was medium yellow in color, pasty in texture and approximately 1/4" in size. This exceeded the Zero Tolerance limit for the process to be in control. I contacted (b) (6) who implemented the protocol for fecal failure. A recheck at 0521 passed. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), and 9 CFR 381.65(e), and the critical limit of CCP-2 (b) (4) of the Plants HACCP Plan for Slaughter.
5308	M6137	BXL4604071 327N-1	07/27/2012	01B02	Pre-Op SSOP Review and Observation	C	On 7/26/12 at approximately 2216 hours I observed the following while performing the Pre-Operational Review and Observation Task in Plant #1 . Inspecting the breast plates on the Vent Opener on line # 1 after the Quality Control inspection I found approximately ½ dozen breast plates with white grease from the previous shifts production . US Retained/Rejected tag B31 407675 was applied the the area . My findings were brought to the attention of (b) (6) and (b) (6) who were both standing near . Both (b) (6) and (b) (6) began scouring the affected areas . Once the breast plates were cleaned and rinsed they were reinspected . At approximately 2223 hours sanitary conditions were restored and the Vent Opener was ready for production . These noncompliances were a violation of the following regulations 9CFR 416.13(a) , 9CFR 416.1 ,9CFR 416.13 (c) and 9CFR 416.14 .
5309	P6137A	NJN230307 2327N-1	07/27/2012	04C05	Poultry Good Commercial Practices	C	At 0015 hrs on 7/27/12 Inspector (b) (7)(C) called me to station 3 on B line to examine a bird he had hung back on the USDA rack. I diagnosed it as a DOA based on the following signs: 1. Carcass purple in color on dorsal surface, pale on ventral surface. 2. Decomposition of back muscle tissue. 3. Congestion and degeneration of kidneys and liver; remaining viscera had not been presented for inspection. 4 Foul odor. This is a violation of regulation 9CFR 381.71(a). I immediately informed (b) (6) of the forthcoming NR.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2105074 726N-1	07/26/2012	01C02	Operational SSOP Review and Observation	C	<p>On 07/26/2012 at approximately 0125 hours while monitoring Packaging Department processes, I observed the following. There were several gizzards on the rehang belt for line (b) (4) with varying amounts of ingesta on the internal and external surfaces, and several had partial stomachs attached. One of the gizzards had a piece of intestine attached with light brown pasty fecal material inside. The belt had Organic carcasses on it at the time. Organic carcasses at this point in the processes have already received final microbial intervention. I contacted (b) (6) and showed him my findings. Hanging was stopped. The carcasses on the belt were tanked. The line was rinsed with (b) (4) and returned to production by approximately 0135 hours. There were approximately 35 gizzards on the belt. The tanked birds were reconditioned and released by approximately 0220 hours. Two additional carcasses were found during reconditioning with intestines attached. A check of the establishments computer records revealed that a chlorine check at 0119 hours in Packaging was at (b) (4) PPM total chlorine. The establishment does not monitor Free Available Chlorine at this location so it is unclear if the belt rinse and product reconditioning had any desirable affect (b) (6) were informed. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), and 9 CFR 416.14.</p>
5308	M6137	BXL5016074 926N-1	07/26/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0959 hours, while performing a Finished Product Standards procedure at Post Chill for Chiller #3 in Plant #2, I observed the following noncompliance. I observed multiple gizzards on the belt with the carcasses when I noticed some of them had pieces of intestine to 3" long still attached. One of the gizzards had approximately a 3" long piece of intestine attached was leaking fecal material on the belt with carcasses sliding around the belt. I immediately informed (b) (6) and (b) (6) of the noncompliance, they immediately took corrective actions by tanking off two tanks of carcasses to be reworked. I attached USDA retain tags #B31406758 and #B31406759 to the tanks of product. As the belt is continuously washed with (b) (4) after a few passes around the washer the belt was clean and sanitary with no fecal material visible. The carcasses were reprocessed and on reinspection I released the carcasses back to production. My findings indicate a noncompliance with 9CFR 416.4(a) and 9CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2909074 425N-1	07/25/2012	01C02	Operational SSOP Review and Observation	C	<p>On 07/25/2012 at approximately 0255 hours while monitoring Packaging Department processes, I observed the following. The exit conveyor belt from chiller #4 was emptying for the scheduled company break, I observed at least 25 gizzards going around on the belt. The gizzards had varying amounts of ingesta on the internal and external surfaces, and the inside of several gizzards also contained what appeared to be yellow digestive fluids. The gizzards were removed as part of cleanup. I proceeded to Line 014 rehang belt where the retail grade birds from Chiller #4 are hung going into packaging for cutup. There were an additional 15 gizzards at that location. Several of the gizzards had partial stomachs attached and one gizzard had a piece of intestine attached. There was also a separate piece of intestine including the pancreas. The separate intestine was approximately 6" long and had light brown pasty fecal material leaking from two places. Concerned about fecal cross contamination, I had approximately 10 birds removed from the belt that were near the intestine. As there were no supervisors nearby, I contacted (b) (6) and showed him my findings. The line has a continuous chlorine rinse which upon checking the establishments computer showed a level of 291 PPM total chlorine at 0114 hours. The establishment does not monitor Free Available Chlorine so it is unclear if the chlorine rinse has any desirable affects. (b) (6) were informed. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE172007 5125N-1	07/25/2012	01D01	SPS Verification	C	<p>At approximately 1735 hours while performing the Review and Observation component of an Operational Sanitation PHIS task, I observed a sanitation employee washing down hearts, livers and gizzards that were piled up on the floor underneath the giblet chiller exit. While he was washing the floor, a combo bin filled up with whole carcasses that was staged approximately 6 feet away from the chiller exit was getting overspray on the outside of the plastic liner, I also noticed a pile of hearts and livers underneath the combo bin in between the pallet's frame. I took regulatory control action by applying Retain Tag# B38495154 to the combo bin. Although, the product in the combo bin was not affected, an insanitary condition was created by over spraying with dirty water a container with edible product. The establishment failed to meet the regulatory requirements of 9 CFR 416.1 which states, "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated". 9 CFR 416.4(b) states, "Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". 9 CFR 416.4(d) states, "Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments". The establishment switched the product to a clean combo bin as immediate corrective action to prevent the adulteration of product. After verifying that the carcasses were not cross-contaminated, the regulatory control was withdrawn at 1750 hours. (b) (6), and (b) (6), were informed of the forthcoming documentation for the failure to comply with the regulatory requirements cited above.</p>
5308	M6137	BXL0218072 324N-1	07/24/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1510 hours while walking through the Packaging area I observed the following noncompliance. The drip pan at the end of the Breast Fillet Pack Out Line had a large area of heavy beaded condensation that was dripping on the blue transfer belt that takes the breast fillets to the line. The breast fillets were falling on one side of the blue transfer belt and the condensation was dripping on the opposite side so no product was contaminated at the time. The blue transfer belt is continuously washed with chlorinated water as it goes around maintaining sanitary conditions after one time around. I immediately notified (b) (6) and (b) (6) of the noncompliance. They immediately took corrective action by covering the line with blue plastic to protect the product from being contaminated. The condensation was cleaned restoring sanitary conditions by approximately 1525 hours. My findings indicate a noncompliance with 9CFR 416.2(d) and 9CFR 416.4(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4604073 524N-1	07/24/2012	01C02	Operational SSOP Review and Observation	C	<p>On 07/24/2012 at approximately 0055 hours while monitoring the Establishments' processing procedures in Packaging, I observed the following. There were dark gray specks and flakes to approximately 1/4" on the carcasses on the Organic bag fryer line^{(b) (4)} I removed 5 affected birds from the line and showed them to (b) (6) ^{(b) (6)}. The UFM (Unidentified Foreign Material) was on the birds saddle area, backs, and hock. There was also numerous pieces on the tray between the giblet storage areas where unacceptable giblets are discarded. The neck area of the carcasses in the packaging process drag through this discarded material. There were also numerous pieces on the carousel at the end of the line where the packaged product collects. The line was stopped. Birds were removed from the front of the line. The line was washed. Three racks of finished wrapped product were retained for inspection and reconditioning as necessary. The line was restarted at approximately 0105 hours. As specks of UFM were still showing up on the carcasses, an employee was placed at the front of the line to remove affected birds. Birds should be processed in a sanitary manner using good commercial practices. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).</p>
5309	P6137A	NJN571307 3724N-1	07/24/2012	01C02	Operational SSOP Review and Observation	C	<p>While conducting an Operational Sanitation Procedure in the Fillet Department at approximately 0924 hours, I observed the following non compliance: A pile of rib cages on the floor (approximately 30 to 40 pieces) underneath Cone Lines^{(b) (4)} and ^{(b) (4)}. Upon closer observation I observed another pile of rib cages on the floor half way down line^{(b) (4)} That pile was so high that it was coming in contact with the return cones as they passed by and nobody was taking action. Another pile of the same kind of product was observed at the end of the line. Regulatory control of the line was taken with the application of US Reject Tag #B38495138 and informed Ms. (b) (6) ^{(b) (6)} and (b) (6) ^{(b) (6)} of the non compliance of the failure to protect product from adulteration during processing as stated in regulation 9 CFR 416.4(d). Regulatory control of the line was released at approximately 0935 after sanitary conditions were restored, product on the floor was condemned (one and a half barrels of product) and maintenance adjusted the rubber fingers at the end of line as preventive measures.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0521075 023N-1	07/23/2012	01C02	Operational SSOP Review and Observation	C	While monitoring the Establishments' Operational Sanitation Procedures, I observed the following noncompliance with regulation 9 CFR 416.4 (d). At approximately 1834 hours, I observed along the west wall of the Plant #1 cooler, two brown tubs full of drums. These tubs had the lids only covering part of the tub. There were numerous black specks of UFM (unidentifiable foreign material) on the top of the lids. I inspected the product and I found UFM on the drums also. I immediately attached a U.S. Retained/Rejected Tag # B31 406258 to the tubs and Informed (b) (6) of the noncompliance. (b) (6) elected to condemn the product in the tubs. I removed my tag at approximately 1840 hours and observed the product being condemned and the tubs were sent to the tub wash room.
5308	M6137	BXL4508074 421N-1	07/21/2012	03J02	Slaughter HACCP	C	On 07/21/2012 at approximately 0540 hours while monitoring the Establishments' Post-Chill Finished Products Standards from Chiller #1 in Plant #1, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. There was a cloacae attached just inside the carcass at the tail with approximately 3" of intestine. The fecal material was located inside the carcass on the left side kidney area and on the left side adjacent to the keel bone. The fecal material at both locations was approximately 1/2" by 1/8", dark green in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. There were no supervisors immediately available so I directed the employees at the rehang station for birds going into packaging to stop hanging carcasses. A lead person nearby started to tank the carcasses coming from the chiller. I performed a recheck that passed at approximately 0551 hours. Two tanks of carcasses were placed under US Retained tags which were replaced by Establishment QC hold tags for rework. (b) (6) and (b) (6) arrived and I showed them my findings. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), 9 CFR 318.65(e), and the critical limit of CCP-2B (b) (4) of the Plants HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5522074 620N-1	07/20/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 07/20/2012 at approximately 1915 hours while monitoring production processes in Plant #1, I observed the following. A sanitation employee was washing stainless steel tanks in the reprocessing room (Line (b) (4)). The washing was taking less than a minute per tank and no soap or sanitizer was being used. I looked inside the tanks which had varying amounts of fat, tissue, giblets, necks and pink fluids from previous days of production. The tanks were being covered with blue plastic and placed into the Plant #1 cooler. The blue plastic cover is used by the establishment as a marking system that identifies the tank as clean and ready for use. The tanks are used during production to store ice and WOGs for rotisserie, for parts collected and shipped for MDP, and for parts that are disposed of in the edible dump room. I placed U.S. Rejected tags on the tanks labeled N-20,58-I, #112, and #11. A review of the establishments' SSOP for Pre-Operational Sanitation Wet Clean-Up (food contact surfaces) under Clean: states "(b) (4)"</p> <p>(b) (4). The employee was only using a high pressure (b) (4) rinse. I contacted (b) (6) and showed him my findings. An available portable dispenser of sanitizer was brought from the main packaging area to used on the tanks. I tipped the first tank over after cleaning. The wheels on the tank were still coated with fat and tissue, and the bottom of the tank was covered with black UFM (Unidentified Foreign Material) that appeared to be mold. Sanitary conditions were restored by approximately 2000 hours. The tanks are in continuous use so they are seldom empty and available for cleaning using the SSOP Pre-Operational procedure as ice and WOG's are refilled throughout the shifts and filled at the end of the second shift for the next days use. A review of the Establishments SSOP shows that there is no reference made to Less Than Daily cleaning procedures Per FSIS Dir 5000.5 Verification of Less than Daily (Ltd) Sanitation Procedures in Processing Operations. The Establishments' SSOP under Operational Sanitation states "(b) (4)"</p> <p>(b) (4)." During the shift I observed the tanks in use in Plant #1. The tanks when emptied are only rinsed with (b) (4) by the ice house employee before being refilled with ice. The tanks used for WOG's in Rotisserie are refilled repeatedly without a rinse. The tanks in the Edible Dump Room are again simple rinsed for less than a minute with water that registered on a company calibrated thermometer at approximately 140°F. The Edible Dump Room is not maintained as a product contact surface. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4a, 9 CFR 416.12(a), 9 CFR 416.13(a) & (c), and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0209073 319N-1	07/19/2012	01B02	Pre-Op SSOP Review and Observation	C	On 7/18/12 at approximately 2219 hours while performing the Preoperational Sanitation Procedure task in Plant # 2 I observed the following . In area # 3 section # 1 there was a black build -up which appeared to be mold on the insulation surrounding the edges of the over head drip pan against the wall . The wash sink below the over head drip pan had a build-up of black scum in the right hand corner which appeared to have been there for awhile . The bottom and back portion of the soap dispenser had a build-up of grease . USDA Retained/Rejected tag B 31 407604 was applied to the area . I immediately informed (b) (6) who had one of his workers hose the build-up off the insulation and clean the bottom and back of the soap dispenser . The area was reinspected and found to be in sanitary condition . At approximately 2232 the area was released for production . My findings indicate noncompliances with the following regulations 9CFR 416.1 , 9CFR 416.4(b) , 9CFR 416.13(a) , 9CFR 416.13(c) and 9CFR 416.14 .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1009074 719N-1	07/19/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 07/18/2012 at approximately 2225 hours while monitoring the Establishments' Preoperational Sanitation Procedures after QC and SSOP inspections were completed, I observed the following. In Plant #1 there was pasty fat and tissue, and black UFM (Unidentified Foreign Material) that appeared to be mold on the bottoms of two support brackets on the inside half at the out flow end of Chiller #1. There were several pieces of black UFM (Unidentified Foreign Material) with the consistency of blackened dust on the top of the chiller paddle at the same location. I proceeded to the opposite side of chiller #1 to the out flow end. Near the ceiling there is a large fan. The screen on the front of the fan is coated with a similar looking black dust like substance. The issue was discussed with (b) (6). The fan screen will be cleaned after production. The reachable areas of the chiller were cleaned by approximately 2240 hours using green scouring pads and brown paper towels. At approximately 2330 hours in Packaging Area #1 at the rehang area from Plant #1 there was pasty fat on the inside surfaces along the entire length approximately 35 feet of the return belt that collects birds from the sorting & sizing line and delivers then back to the rehang belt. There were numerous pieces of fat and tissue to approximately 1/4" on a tray that guides carcasses from the sorting and sizing line to the cutup line belt. Soap was applied followed by a (b) (4) rinse to breakup the fat on the conveyor belt and sanitary conditions were restored by approximately 0000 hours. At approximately 2355 hours there were a few specks to approximately 1/8" of black UFM (Unidentified Foreign Material) along a small area on the product collection belts for leg processor #8. I proceeded to leg processor #8 where there were also several black specks of (UFM) on the white cutting wheels. Two black rubber hydraulic lines associated with the unit are severely deteriorated and when touched give off a similar black grease like substance. The hoses will be addressed by the mechanics. Sanitary conditions were restored by approximately 0008 hours. At approximately 0009 hours in Packaging Area #2 the (b) (4) Deboning Room along Line #1 there was fat and tissue to approximately 3" on the light blue belt and stainless/white nylon support brackets that collect the skin. Adjacent to Line #1 there were numerous pieces of fat and tissue to approximately 1/4" with a strong sour smell on a section of the belt that collects breast tenders for lines 1-4. Also in the area of Line #1 there were numerous pieces of fat and tissue to approximately 1/4" on the belt used to remove the wing tips from all four lines. The areas were rinsed with (b) (4) per establishment procedure and released by approximately 0025 hours.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE221807 3019N-1	07/19/2012	01C02	Operational SSOP Review and Observation	C	<p>On Wednesday July 11, 2012, at approximately 1435 hours, while I was performing Operational SSOP Review and observation in 2nd processing, I observed regulatory noncompliance with CFR 416.4 (a), and CFR 416.13 (d). I observed establishment employee handling non-sanitary surface, opening and handling boxes, then immediately handling product, necks, in a pan. I immediately notified the (b) (6), of the operational SSOP violation. (b) (6) inquired about the potentially contaminated product. When I identified the pan containing the potentially contaminated product, (b) (6) immediately disposed the product in the pan in a clearly labeled inedible can. (b) (6) also removed the pan that contained the potentially contaminated product out of the processing area. The establishment personnel implicated in the incident was halted from handling any food contact surface or product. In conclusion, sanitary conditions were restored and potentially contaminated product was properly disposed. CFR 416.4 (a) states "All food-contact surface, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." CFR 416.13 (d) states "Product must be protected from adulteration during processing, handling, storage, loading and unloading at and during transportation from official establishments." The establishment SSOP for Packaging, Section 2C, Step # 3 states "(b) (4) (b) (6) and (b) (6) were informed of the forthcoming documentation for the failure to comply with CFR 416.4 (a) and CFR 416.13 (d).</p>
5308	M6137	BXL0505070 218N-1	07/18/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 07/17/2012 at approximately 2355 hours while monitoring the establishments' Preoperational Sanitation Procedures after establishment SSOP and HACCP inspections, I observed the following. In Packaging Area #1 there was black UFM (Unidentified Foreign Material), and dried and semi-dried pasty tissue on the shackles above the rehang belt from chiller #4 that directs carcasses to sorting & sizing. There were numerous pieces of fat and tissue to approximately 1/2" on the blue wheel that supports the chain/shackles at the chiller outflow side above the rehang belt for chiller #4. I showed my findings to (b) (6). The Lockout/Tagout for the line was released so that the line could be started for cleaning. The area was released by approximately 0025 hours. At approximately 0015 hours there was an accumulation of a yellowish pasty substance on the overhead conveyor that runs parallel to the Crust Tunnel. The substance was on the entire length of the line which is approximately 60' long. The line transports breast fillets from the (b) (4) Deboning Room to X-Ray machine #2. Sanitary conditions were restored by approximately 0030 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (a), 9 CFR 416.13(c), and 9 CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1218074 318N-1	07/18/2012	01D01	SPS Verification	C	<p>At approximately 1400 hours, while performing a Post chill check in plant 1, I noticed a noncompliance with regulatory requirement of regulation 9 CFR 416.1 and 416.2(a). I observed an adult fly which was barely alive inside of a gray combo bin located near chiller #2 exit. This combo bins are utilized to store edible product. Even though, a plastic liner is placed in this combo bins, they still need to be kept in sanitary conditions free of any contaminants and pests. I immediately placed a US Rejected/Retained tag NO. B31 406858 on the affected container. I then, notified (b) (6) of the noncompliance. He took immediate corrective action by washing and sanitizing the combo bin. I removed the US tag after rechecking the container and finding it clean. At approximately 1500 hours, while walking through the Packaging Paw Room located next to the loading dock, I also found a non compliance with regulatory requirement of regulations 9 CFR 416.1 and 416.2(a). There was approximately 10 adult flies inside of the Paw room. This flies were standing on the sealing, walls and pipes throughout the production area. I notified the lead person and (b) (6) of the noncompliance. Flies were carefully killed to avoid product contamination. (b) (6) mentioned that he would have the whole area fogged during the weekend and that more fly traps would be put in place in the surrounding areas of the paw room. He also mentioned that the air curtain at the door entrance was properly working.</p>
5308	M6137	BXL3123072 218N-1	07/18/2012	01D01	SPS Verification	C	<p>On 07/18/2012 at approximately 2000 hours while monitoring Facilities, I observed the following. In the Plant #1 Cooler there was condensation spraying from the overhead refrigeration unit located over the Plant #1 door. Up to approximately 1 cup of condensation and several pieces of black UFM(Unidentified Foreign Material) with the consistency of blackened dust to approximately 1/2" was collecting on cover tanks up to approximately 20 feet from the unit. I contacted (b) (6) and showed him my findings. A mechanic was called and said that the unit was in normal defrost mode. I got a ladder and inspected the unit. There are numerous pieces of blue plastic stuck to the front screen which is also coated with black UFM. The drip tray that collects the defrosted condensates includes a drain pipe. The drain hole for the drip tray is at least a foot away from the end of the pooling fluids in the tray so no drainage was occurring. The units fan was still picking up the fluids at approximately 2020 hours and spraying it on the ceiling, pipes and tanks of product. The plastic on approximately 12 tanks were replaced, several tanks were moved out of the area, and the condensation was dried from the ceiling and pipes. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(d) and 9 CFR 416.2(b)(1)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0818073 117N-1	07/17/2012	06D02	Other Inspection Requirements	C	On 7/17/2012, while performing "No viscera" presentation check on the Nu-Tech system in Plant 1. I observed noncompliance with the regulatory requirements of regulations 9CFR 381.76(a) and 9CFR 381.76(b). Inspection Personnel informed me that on Line 2 there was an excessive amount of birds coming to their inspection stations with no viscera to inspect. At approximately 1510 hours I performed a "No viscera" presentation check on Line 2. I found 18 "no viscera" during the 3 minute allotment of time for the check. I immediately informed (b) (6) that my check had surpassed the 13 "No viscera" allowed for the process to be in control. At approximately 1524 hours Quality Control personnel performed a recheck of the system. Quality Control personnel recorded 21 "No viscera" during the allotted time period, the process was deemed to be out of control and the line speed was slowed down to (b) (4) birds per minute. I informed (b) (6) that I was documenting a noncompliance. The establishment elected to leave the line speed at (b) (4) birds per minute for the rest of the day.
5308	M6137	BXL1621073 717N-1	07/17/2012	04B04	General Labeling	C	While monitoring the Establishments' Operational Sanitation Procedures in Main Packaging Area, at approximately 1709 hours, I observed the following: In the old breast aged cooler next to the Halvers Machine #2 there was a stainless steel tank covered with a blue plastic. I looked inside and it was half full of parts and whole birds, pieces of fat and skin with a lot water mixed with blood. The product was emitting a strong rancid or putrefy like odor. The tank did not have any tag or label to identify product name, date and time. I attached a U.S. Rejected/Retained Tag # B31 406257 to the tank and informed (b) (6) and (b) (6) of the noncompliance. (b) (6) informed me that this cooler is used only by (b) (6) condemn the product in the edible condemn room at approximately 1718 hours. My findings indicate a noncompliance with 9 CFR 381.145(b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2903075 817N-1	07/17/2012	01D01	SPS Verification	C	<p>On 07/16/2012 at approximately 2030 hours while monitoring Facilities, I observed the following. There was a large puddle of fluid on the floor of the Plant #2 Cooler. As sanitation had started the between shift cleanup, I contacted (b) (6) and showed him my findings. There was approximately 12 pallets of giblets, 25 pallets of salvaged parts, and 25 tanks of birds in the cooler. The puddle extended from the giblets palletized near the cooler wall adjacent to the door on the Plant #2 side of the cooler to approximately 6 feet from the Packaging side Cooler door. The puddle was to approximately 2" deep near the drain and several feet wide. The fluid was pinkish in color and probably a collection of blood and melted ice from the PM shift. (b) (6) came by and said he had been in the cooler 30 minutes earlier but saw nothing. I informed him that the pallets and tank wheels should be treated as contaminated. Several pallets were moved to gain access to the drain. A mechanic pumped several gallons of gray colored sour smelling fluid from the drain trap. (b) (4) was sprayed on the floor inside and outside the Plant #2 side cooler door to reduce the spread of putrid contaminants. The drain was still clogged at approximately 2200 hours when I had to go to Plant #1 as production was starting. I returned at approximately 2300 hours and found some residue still on the floor. I had more antimicrobial soap applied and the cooler rinsed before releasing it back to production. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(e)(4).</p>
5308	M6137	BXL2700074 614N-1	07/14/2012	01D01	SPS Verification	C	<p>On 07/13/2012 at approximately 0730 hours while monitoring Facilities at the end of the shift in Plant #2, I observed the following. There was a juvenile cockroach on the wall just above the apron wash soap container adjacent to Evisceration line 4B near the Inside/Outside washers. The roach was killed and shown to (b) (6) who said he was busy and to show the roach to (b) (6) in the office, which I did. Roaches are known to transport filth and disease. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5619070 913N-1	07/13/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1250 hours while performing a Finish Product Standard check at the Pos-Chill area, I observed a non compliance with regulation 9 CFR 416.4(d) at the exit of chiller 4 in plant 2. I observed a bird on the drip pan located above the sorting blue conveyor belt at the chiller 4 exit. The bird was blocking the drip pan's draining pipe, causing the water to pour out on to the rail, moving chain, shackles and finally on the blue conveyor full of product. As mentioned previously, this water was touching several non food contact surfaces prior showering the product underneath, which at this point was deemed to be contaminated. I took immediate control action by instructing the employees working at the area to stop hanging birds. I then, notified Quality Control who was also at the chiller exit collecting the moisture birds. (b) (6) was also notified of the noncompliance. He immediately removed the bird from the drip pan allowing the water to run freely through the drain pipe. A stainless steel tank full of product was placed on hold by Quality Control. Conveyor was allowed to run and be sprayed by the line prayers, making it acceptable. Production was resumed. All contaminated product was reconditioned and made acceptable.
5309	P6137A	NJN161007 4013N-1	07/13/2012	01D01	SPS Verification	C	At approximately 1840 hours while conducting a verification procedure Sanitary Performance Standard (SPS) in the Weigh and Price department, I observed the following non compliance: Numerous flies on the stack of pallets that were staged for use, numerous flies on production line (b) (6). More flies were observed on the southeast door jam of that department. I took regulatory control of the area with the application of US Reject Tag #B39415806 and informed Mr. (b) (6) and QC Tec in charge of the area of the forthcoming non compliance.
5308	M6137	BXL3014070 612N-1	07/12/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1425 hours, while performing a Operational Sanitation verification task in Plant 2, I found a non compliance with regulatory requirement of regulation 9 CFR 416.4(a). I observed a couple of dirty gray salvage tubs located at the end of line (b) (6) in plant 2. These tubs are a product contact surface utilized for salvage parts at the final trimmer station. They were contaminated with multiple shiny silver specks of foreign material. I took regulatory control action by placing two U.S Rejected/Retained tags No. B31 407544 and B31 407545 on the affected containers. I then, notified (b) (6) of the noncompliance. She took immediate corrective action by washing the gray tubs. I re-inspected the containers, finding their condition to be sanitary. US tags were removed at approximately 1433 hours.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3704073 612N-1	07/12/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 07/11/2012 at approximately 2215 hours while monitoring the establishments' Preoperational Sanitation Procedures after establishment SSOP and HACCP QC checks, CSI (b) (7)(C) observed the following. The transfer belt for line (b) (7)(C) where birds are transferred from the kill line to the eviscerating line is frayed to approximately 2" and the top surfaces has numerous blackened spots which appear to be have been melted caused by welding sparks or other hot maintenance procedure. The belt is severely deteriorated making it extremely difficult to clean and inspect. There were numerous large patches of dried and semi-dried fat and froth on the four chiller paddles associated with the center inside section (near the center walkway) of chiller #3. The fat and froth residue was near the water line on the main structural brace that attaches the paddle to the chiller. There was also dried fat and froth on the tines on the dry paddles that are above the chiller. It is obvious which way the high pressure water was applied as the dried fat and froth is on the back side of the structures. Accessible and reachable sections were cleaned with scouring pads and wiped off with paper towels. The chiller was released by approximately 2242 hours. The establishments' Preoperational Sanitation Daily Procedures under 'before start of operations ...' and 'wet clean-up(food contact surfaces)' states in part (b) (4)</p> <p>" After finding considerable dried and semi dried product from the previous days production the effectiveness of the procedure as it is currently being performed is questionable. The chiller was checked by SSOP personnel with in plant #2 and was found acceptable at 917 hours (2117). The second shift worked overtime so the chillers would not have been empty of product until approximately 1930 hours. SSOP forms were verified by the establishments' Sanitation Superintendent. My findings indicated a noncompliance with 9 CFR 416.2(b)(1), 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c) and 9 CFR 416.14. On 07/11/2012 while monitoring the Establishments' Preoperational Sanitation Procedures in Plant #1, CS (b) (7)(C) found the following noncompliance with regulations 9 CFR 416.1, 416.4(a), 416.13(c) and 416.14. At approximately 2234 hours, I observed pasty dried and semi-dried fat on a large section of the two support brackets for the paddles on the center of the right side of the Chiller #1, also on one of the paddles there was white slimy residue. I immediately attached a U.S. Rejected/Retained Tag # B31 405256 to that area. On Chiller #2 at the end of left side on one of the paddles was also with white slimy residue. I informed (b) (6) and (b) (6) of the noncompliance. The reachable areas of the brackets and the paddles were cleaned with a green pads and brown paper towels. The area was released at approximately 2244 hours.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5518070 712N-1	07/12/2012	01D01	SPS Verification	C	At approximately 1050 hours, while performing a Operational Sanitation verification task, I found a non compliance with regulatory requirement of regulation 9 CFR 416.4(a) and 416.1 On the hallway leading into the receiving loading dock located next to the supply room and packaging, I observed a couple of medium size cardboard boxes. These boxes were opened, exposing the white soaking pads inside of them. These pads are a product contact surface utilized to absorb excessive product moisture on the tray pack. As I got closer, I noticed that the top layer of soaking pads was contaminated with black foreign material. I took immediate regulatory control action by placing a U.S Rejected/Retained tag NO. B31 407543 on the affected product contact surface packaging materials. I then notified (b) (6) of the noncompliance. He took immediate corrective action by disposing of the contaminated pads. U.S tag was removed after sanitary conditions had been restored.
5308	M6137	BXL2214073 411N-1	07/11/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1021 hours while walking through the packaging area I observed the following noncompliance. On the drip pan over the Breast Halver that is across from the Bag Fryer line there was heavy beaded condensation. A company employee started to mop the condensation and while doing so he dripped dirty mop water all over the ice inside of a cardboard bin that they were using to put on product in the brown tubs to cool the product. I immediately took regulatory control action by applying USDA Reject tag #B31406757 to the bin of ice. I then notified (b) (6) of the noncompliance. The bin of ice was condemned and dumped at approximately 1032 hours restoring sanitary conditions. My findings indicate a noncompliance with 9CFR 416.2(d) and 416.4(a).
5309	P6137A	NJN571207 1410N-1	07/10/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 0925 hours while performing PHIS task for zero tolerance on the reprocessing line, I observed the third carcass of the sample with visible fecal material. The fecal material were two small smears on the right side of the tail next to the oil gland approximately 1/16 inch in diameter individually and was dark green in color and had a paste-like consistency. I immediately took regulatory control of the line with the application of US Retained Tag #B38495112 and informed Mr. (b) (6) of the forthcoming non compliance. Mr. (b) (6) asked for a second opinion and SCSi Mr. (b) (7)(C) confirmed my finding in front of Mr. (b) (6). That the establishment failed to prevent fecal material from entering the chilling system represents noncompliance with 9 CFR381.65(e). Noncompliance NJN1414063025N/1 recorded on 6/25/2012 is with similar cause, fecal on reprocessing line.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3802072 609N-1	07/09/2012	04B03	Labeling - Net Weights	C	<p>On 07/07/2012 at approximately 0615 hours while monitoring Establishment Net Weight procedures in Weigh & Price, I observed the following. A review of establishment computer records for the shift revealed that a check at 2330 hours for account #604201 for product 509 had failed (-.01). A check at 2352 hours for account #603803 for product 508 had failed (-.01). A check at 0456 hours for account #703802 for product 528 had failed (-.02). The three checks were for trays under 3 pounds. I asked (b) (6) at the first station if procedures had changed. He said that the failures were not at his station but from the entries made it appeared that a recheck should have been performed. I reviewed the Foster Farms Net Weight Content Compliance Testing Program dated November 27, 2010 on file in Weigh & Price and found the following statement under Sample Plan: (b) (6)</p> <p>"I asked the (b) (6) making the checks and she said she had no failures for the shift and had retained no product. The computer shows the checks as acceptable, although less than average, as the low limit in the computer is set at -.062. As a recheck had not been performed it was clear that the affected product had not met Net Weight requirements when sent to NCDC for shipping. I contacted (b) (6) and showed him my findings. Eleven pallets totaling approximately 600 cases were placed on hold at NCDC. The product was released by approximately 0905 hours after a representative sample per established procedures revealed that the product was in fact in compliance. My findings indicated a noncompliance with 9 CFR 442.2.</p>
5308	M6137	BXL0213074 005N-1	07/05/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 1530 hours while walking through the Packaging rehang area in Plant #1 I observed the following noncompliance. There was heavy condensation running the entire length of the drip pan that connects to the (b) (4) cabinet near the chiller exit and is directly over the short sizing belts. There were approximately 6 whole carcasses on belts #2 and #4 with condensation dripping heavily on the belts and carcasses, I immediately informed (b) (6) of the noncompliance. A company employee was instructed to rinse the carcasses with chlorinated water and wipe down the condensation on the drip pan. The area was cleaned and the carcasses reworked by 1545 hours, restoring sanitary conditions. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5104073 905N-1	07/05/2012	03C02	Raw Intact HACCP	C	<p>On 07/05/2012 at approximately 0050 hours while monitoring the Establishments' Operational Sanitation Procedures in Packaging Area #1, I observed the following. There were approximately 35 birds from chiller #3 on the rehang belt for line (b) (4). The line was not being used at the time. I checked the birds and found seven with one to several metal flakes on the carcass exterior surfaces and on the neck skin area of the carcass. Most of the metal flakes were in the range of 2-4mm, however, three carcasses had shiny metal flakes that measured to approximately 8-9 mm by from 1 to 3mm. I contacted (b) (6) and showed him my findings. I proceeded to line (b) (4) where the whole carcasses from chiller #3 are wrapped. At approximately 0110 hours I randomly checked approximately 5 birds finding one with a shiny metal flake measuring approximately 8mm by 3mm. I showed (b) (6) then again contacted (b) (6). (b) (6) and USDA DVM (b) (7)(C) were also informed. According to FDA guidance metal in a food product in excess of 7mm is considered to be a health hazard. The 8-9mm metal pieces that I observed exceeded that limit. I reviewed the Establishments' Hazard Analysis-Raw Not Ground-Packaging at step #8 'Packaging' under 'Potential Hazard Introduced, Controlled or Reduced at this step' the plan lists (b) (4). Under "Justification for Decision" there are no supplemental supporting documents provided. My findings indicated a noncompliance with 9 CFR 417.2(a)(1).</p>
5308	M6137	BXL5511071 305N-1	07/05/2012	01D01	SPS Verification	C	<p>On 7/5/15 at approximately 0734 hours while performing the SPS task I observed the following in the packaging area . Underneath the Plant # 2 Halver the entire drip pan was saturated with thick beaded condensation . I immediately brought my findings to the attention of (b) (6). (b) (6) had one of his workers mop the condensation . Sanitary conditions were restored at approximately 0750 hours .My findings indicate noncompliances with the following regulations 9CFR 416.2(d) 9CFR 416.4(d) and section two of SSOP Plan which states (b) (4)</p>
5308	M6137	BXL5412065 330N-1	06/30/2012	01D01	SPS Verification	C	<p>At approximately 0915 hours while walking from Plant #2 to the packaging area I observed the following noncompliance. The overhead drip pan above the sizing lines was covered in heavy condensation and dripping all around the lines. There was also condensation on the end of the drip pans in the walkway where the double drip pans end by the Gib Chiller. I immediately informed (b) (6) and (b) (6) of the noncompliance. (b) (6) immediately told sanitation to wipe down the drips and sanitary conditions were restored by 0925. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.2(d) and 416.4(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5516061 530N-1	06/30/2012	04A06	Poultry Finished Product Standards	C	At approximately 1325 hours, while monitoring the establishment's Pre-Chill Finish Product Standard in Plant #2, I found the following noncompliance. After randomly removing a 10 bird sample from line (b) (6), I documented a total of 38 weighted nonconformance points under processing category. This exceeded the subgroup absolute limit (30) for the process to be under control. I immediately informed (b) (6) who did a recheck at approximately 1335 hours to verify sample validity. She failed the recheck with a total of 31 weighted nonconformance points. This exceeded the tolerance (25) allowed for the recheck. At that point the process is considered out of control. I informed (b) (6) of the noncompliance so that corrective action could be taken. By approximately 1412 hours QC had performed two consecutive passing Pre-chill checks on line (b) (6) bringing the process back in control at the pre chill area. QC performed Post Chill rechecks (b) (4) starting at 1429 hours to 1512 hours. The Pre-Chill criteria for the processing category was applied to the Post-Chill rechecks. all Post- Chill checks passed. Product was deemed to be acceptable for shipping. My findings indicate a noncompliance with regulatory requirement of regulation 9CFR 381.76(b).
5308	M6137	BXL2109065 729N-1	06/29/2012	03J04	Poultry Zero Tolerance Verification	C	While performing Pre-Chill Finished Products Standards Check, I observed noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 417.2 (c)(4). At approximately 0416 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination located at the right side of the abdominal cavity of the bird. The fecal material was a smear, approximately 1/4" diameter in size, dark green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6), (b) (6) and (b) (6) of the noncompliance, the protocol for Fecal Failure was implemented. Quality Control performed a Recheck at approximately 0444 hours and it passed. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plants' HACCP Plan for Slaughter.
5308	M6137	BXL2813065 629N-1	06/29/2012	01D01	SPS Verification	C	On 6/29/12 at approximately 0811 hours I observed the following in plant # 1 . Directly above the sizing lines there was beads of condensation on the drip pan directly above the sizing conveyors . I immediately contacted the (b) (6) . (b) (6) had the condensation monitor mop the affected areas . At approximately 0826 hours sanitary conditions were restored . My observation indicates a noncompliance with the following regulation 416.2(d) and 416.1 and Section # 2 of the SSOP Plan , which states (b) (4) " .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2512064 128N-1	06/28/2012	01D01	SPS Verification	C	On 6/28/12 at approximately 0919 hours I observed the following in plant # 1 . Directly above the sizing lines there were beads of condensation on the drip pan directly above the sizing conveyors . I immediately contacted the closest (b) (6) which happen to be (b) (6) who contacted (b) (6) by radio . (b) (6) had the condensation monitor mop the affected areas . At approximately 0936 hours sanitary conditions were restored . My observation indicates a noncompliance with the following regulation 416.2(d)
5308	M6137	BXL5514060 628N-1	06/28/2012	06D02	Other Inspection Requirements	C	While performing a Finish Product Standard verification check on line 5 Plant 2, I found a noncompliance with regulatory requirement of regulation 9CFR 381.91(b) and 381.76(b). At approximately 0916 hours, I randomly removed a 10 bird sample from the reprocessing line in plant 2. I found one out of ten birds contaminated with a piece of visible ingesta measuring approximately 1/16". I notified (b) (6) of my findings. The line was full of birds with one final trimmer at the end of the line. As I was pulling birds of the line to perform my recheck, the supervisor started helping the employee at the end of the line. Both of them were pulling birds off the shackles and on to the table which was filled with birds immediately. Even though this check did not reflect line's true process, I still found another bird with several visible ingesta contaminants. At this point the line had already failed even when the Supervisor was interfering with my inspection check by making temporary changes on the process. I gave the contaminated carcass to the Supervisor whom immediately stopped the line and went to talk to all employees working on the line. After a while she came back and turned the line back on and continues helping the employee at the end of the line. She failed to start tanking off the birds. I asked the Supervisor if she was to keep only one employee at the end of the line. She mentioned that at 94 BPM line speed there is no need to have 2 employees at the end of the line. I requested her to stop helping the final trimmer so that I could perform a recheck that would actually reflect the true process of the reprocessing line. At approximately 0920 hours, I perform a valid recheck finding one out of ten birds contaminated with ingesta. I then, notified (b) (6) of the noncompliance and the need to start tanking off product. (b) (6) stoped the line and went to talk to the employees again. She added and extra employee at the end of the line and then she started the line. I place a US. Rejected/Retained tag NO. B31 406264 on the affected product. At approximately 0926 hours I perform a passing recheck putting the process back in control. Production stoped tanking off product. At approximately 1010 hours, I perform a recheck on the reworked product. US tag was removed after the product was found acceptable.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3207065 327N-1	06/27/2012	01B02	Pre-Op SSOP Review and Observation	C	On 06/26/2012 while monitoring the Establishments' Pre-operational Sanitation Procedures in Packaging Area at the exit of the Chiller #1 and Chiller #2, I found the following noncompliance with regulations 9CFR 416.1, 416.4 (a) and 416.13 (c). At approximately 2358 hours, I observed numerous particles of black UFM (Unidentified Foreign Material) on the blue sorting conveyors belts at the exit of Chiller #1 and Chiller #2. The black UFM was covering approximately almost the entire length area of the blue sorting conveyors belts. I immediately attached a U.S. Rejected/Retained Tag # B31 404653 to both conveyors belts and informed (b) (6) of the noncompliance. He immediately washed and rinsed the sorting blue conveyors belts. I reinspected and released the area at approximately 0007 hours.
5308	M6137	BXL3014062 325N-1	06/25/2012	01B02	Pre-Op SSOP Review and Observation	C	On 6 /25/12 at approximately 0705 hours while performing the Preoperational SSOP Review and Observation task I observed the following In Plant #1. The Liver Harvester on line #2 in area #4 had a large piece of liver laying on the connecting drip pan which was approximately 2" by 3" in size and gave out a very foul odor , which appeared to be left from last weeks production .I immediately informed (b) (6) . (b) (6) had the piece of liver removed and the drip pan rinsed . Sanitary conditions were restored ay approximately 0710 hours . At 0713 hours the Inside Out Side washer in area # 5 was inspected ,the bottom of the washer had a build- up of grease which appeared to have been there for a while . (b) (6) had the affected guide bars underneath scrubbed and rinsed . The packaging Area was inspected at approximately 0825 .At approximately 0855 the Leg processors were inspected the three conveyor belts that transport product to the packaging area had pieces of fat on them ranging in size from 1/8 " to 3/4 " (b) (6) was informed immediately . She had the three conveyors rinsed of all fat particles . The conveyors were rechecked and found to be in sanitary condition at approximately 0906 hours .My findings indicate noncompliance with the following regulations 416.13(a) , 416.13(c) , 416.4(a) and 416.4(b) .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN141406 3025N-1	06/25/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 0910 hours while performing PHIS task for zero tolerance on the reprocessing line I observed one carcass of a ten carcass sample with visible fecal material on the inside of a carcass at the rib area. The fecal material was approximately 1/4 inch in diameter, dark green in color and had a thick paste-like consistency. I immediately took a regulatory control action to the reprocessing line and notified Mr. (b) (6), and the QC technician assigned to the area, showed them my findings and informed them of the forthcoming noncompliance. That the establishment failed to prevent fecal material from entering the chilling system represents noncompliance with 9 CFR 381.65(e). This document serves as written notification that your failure to comply with regulatory requirement's could result in additional regulatory or administrative action.
5333	P7632	HYE020806 1725N-1	06/25/2012	03J04	Poultry Zero Tolerance Verification	C	I was in the evisceration department performing a Zero Tolerance verification task at the line one Pre-Chill Evaluation Station at 0023 hours when I observed fecal material on one of the ten carcass sample. The fecal material was located on the leaf fat inside the carcass. It was approximately 1/8 inch in diameter, dark green in color, and had a paste like consistency. I took regulatory control of the product with the application of U.S.Retain tag B38495142, I then had to find and informed Ms. (b) (6), of my finding. Mr.(b) (6) and (b) (6) were also informed of the noncompliance.
5308	M6137	BXL1505060 622N-1	06/22/2012	01C02	Operational SSOP Review and Observation	C	On 06/22/2012 at approximately 0035 hours while monitoring Packaging Department processes, I observed the following. At Line #1 immediately after the X-Ray machine there were several boneless skinless breast fillets from the (b) (4) Deboning Room that had smears of black UFM (Unidentified Foreign Material). The contaminated breasts were those rejected by the X-Ray machines and sent to a trim station before returning to line #1. I collected the fillets into a gray product tub and contacted (b) (6) who was setting up the boneless breast packaging line. I explained the monitoring steps I followed. She had a line sanitation employee wash the two small belts that collect breast meat from the X-Ray machine. The UFM was smears and specks to 3" by 1". Approximately 15 fillets were collected before a washing of the line stopped the contamination. I contacted (b) (6) and showed him my findings. The affected product went to the rewash station for reconditioning. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), and 9 CFR 416.15(b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2016064 822N-1	06/22/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>The Noncompliances listed below were observations made by EIAO's while conducting a Food Safety Assessment (FSA). On 5/31/2012 during preoperational sanitation inspection, the EIAO's observed the plastic divider on the conveyor table in the paw room heavily worn including chunks of white plastic hanging off the belt with the potential to contaminate product. The divider was replaced prior to production. In the (b) (4) room, the EIAO's observed a small piece of loose plastic on a cutting board. The (b) (6) immediately inspected all cutting boards and removed three from production. This describes noncompliance with 416.1, and 416.4(a). Additionally, EIAO's observed preoperational sanitation inspection on 5/31/2012. The establishment employees observed multiple equipment with product residue from previous day's production including a product belt in the (b) (4) room, product belt in the packaging room, and a giblet table in plant 2. Product residue from the previous days production was found in multiple non food contact locations including the floors and drains in both plant 1 and 2, Cropper 1 in plant 1, on hand railings at the inspection stations and around the giblet chiller in plant 2, on the sides of the giblet chiller in plant 2, and on the floor in the corner of the Rotisserie Room near the lock out tag out area. The EIAO's observed cutting boards being stored in inedible barrels after being cleaned. The establishment had released the room for USDA inspection prior to these observations being made. The EIAO's discussed this with the (b) (6).</p> <p>Ms. (b) (6) and the EIAO's observed product residue on the cutting boards. Ms. (b) (6) had all cutting boards re-cleaned and inspected for product residue. The EIAO's reviewed preoperational records for 5/31/2012 and found that no deficiencies or corrective actions taken were documented on the records. The establishment did not maintain daily records associated with the corrective actions taken. This is a noncompliance with Title 9 CFR 416.16(a). The establishment has failed to evaluate the effectiveness of their SSOP's to keep them effective in preventing insanitary conditions that may result in direct contamination and adulteration of products. The establishment conducts sanitation procedures daily and conducts preoperational monitoring daily by randomly selecting equipment in each area to be inspected. In reviewing establishment SSOP records, the establishment is not always documenting and identifying deficiencies. However, FSIS In plant inspection personnel have documented 30 Noncompliance Records (NRs) from 11/17/2011-5/17/2012 for findings of insanitary conditions on food contact surfaces identified during preoperational inspection. FSIS has identified multiple instances in which the establishment's implementation and monitoring of the SSOP has been insufficient in preventing insanitary conditions. The establishment has not demonstrated that they are evaluating the SSOP's to determine the effectiveness of their sanitation procedures is being maintained. Based on the noncompliances issued and the observations during preoperational inspection during the FSA, the establishment is not routinely evaluating the effectiveness of the Sanitation SOP's and the procedures therein in preventing</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							direct contamination or adulteration of products. This is a noncompliance with Title 9 CFR 416.14

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3715064 022N-1	06/22/2012	01D01	SPS Verification	C	<p>The Noncompliances listed below were observations made by EIAOs while conducting a Food Safety Assessment (FSA). On 5/30/2012, the EIAO's observed operational sanitation. On the thigh deboning machine in the processing room beaded condensation was observed over product being placed in an edible container. There was also beaded condensation over the belt carrying the boneless thighs to packaging. An employee was observed wiping the beaded condensation with a mop reserved for wiping condensation. The EIAO's observed water dripping from the mop as the employee wiped condensation over product. The dripping water did not touch exposed product or direct product contact surfaces at this time. The (b) (6) was notified of the condensation. Ms. (b) (6) informed us that the product being placed into an edible container was sent directly to inedible rendering and the employees were trained to wipe all condensation with clean paper towels instead of the mop to prevent dripping water onto exposed products. On 5/31/2012, the EIAO's observed beaded condensation under the newly installed chillers in plant 2. The condensation was above the exit of the chiller and above the B grade belt. On 6/8/2012, the EIAO's observed condensation on the pipes and light cover above the giblet chiller in Plant #2. The establishment immediately removed all condensation. These instances of condensation above product demonstrates the establishment is not maintaining adequate ventilation to control condensation to prevent the creation of insanitary conditions. This describes a noncompliance with Title 9 CFR 416.2(d). On 5/31/2012, EIAO's observed live and dead flies in the condemn room leading into the Paw Room. Upwards of 60 live flies were observed crawling on the un-operational UV Fly light and upwards of 30 dead flies observed in the un-operational UV Fly Light and on the floor surrounding the light. This describes a noncompliance with title 9 CFR 416.2(a) and 416.4(b). The un-operational UV fly light demonstrates that the establishment's pest management procedures are not being fully implemented. The EIAO's observed no other pest activity during the FSA.</p>
5308	M6137	BXL4316060 622N-1	06/22/2012	03J04	Poultry Zero Tolerance Verification	C	<p>While performing Pre-Chill Finished Products Standards Check, I observed noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 417.2 (c)(4). At approximately 1008 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination inside the bird on the back right side area, between the kidneys and the tail. The fecal material was a smear measuring approximately 1/4" diameter in size, dark green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance, the protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1033 hours and it passed. The cause of the deviation was "(b) (4) bird washer plug up module". This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5623063 322N-1	06/22/2012	01B02	Pre-Op SSOP Review and Observation	C	On 06/21/2012 at approximately 0015 hours in Packaging Area #2, the (b) (4) Deboning Room, while performing Preoperational Sanitation Procedures after establishment SSOP and HACCP QC checks, I observed the following. The conveyor belt that collects breast fillets from Line #1 had a large amount of fat and tissue debris to approximately 2" on the inside of the belt near the sprocket. I checked several white product cones associated with lines 1,2 & (b) (4) and found numerous pieces of fat and tissue on the inside and outside surfaces to approximately 1" on most of the cones inspected. Sanitary conditions were restored on the items checked by approximately 0035 hours. Line (b) (4) in the (b) (4) Room was being repaired by maintenance and was not ready for preop inspection U.S. Rejected tag #B31407642 was applied to the line until approximately 0845 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), and 9 CFR 416.13(c).
5309	P6137A	NJN570506 4921N-1	06/21/2012	01D01	SPS Verification	C	I was verifying operational sanitation in the evisceration department at 0248 hours when I noted the following non compliance: There were several gray inedible barrels at various locations in the department in disrepair, containing cracks and holes. These cracks and holes ranged in size from approximately two square inches to twelve inches in length. I informed (b) (6) of the non compliance. Inedible receptacles must be maintained in good repair to prevent the creation of insanitary conditions per 9 CFR 416.3(c).
5308	M6137	BXL1318063 519N-1	06/19/2012	01C02	Operational SSOP Review and Observation	C	On 6/19/12 at approximately 1535 hours while performing the Operational SSOP Review & Observation task I observed the following . The drip pan over the sizing line in plant # 2 was dripping large drops of condensation into a full bin of product. I immediately brought my findings to the attention of (b) (6) . (b) (6) tagged the bin so the product would be reworked by a plant employee, which was completed at approximately 1640 hours . She also contacted (b) (6) , who had the drip pan moped of all condensation . Sanitary conditions were restored at approximately 1547 hours . My findings indicate noncompliances with the following regulations 9CFR 416.2(d) 9CFR 416.4(d)) .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3508061 319N-1	06/19/2012	04A06	Poultry Finished Product Standards	C	At approximately 0522 hours, while monitoring the establishments' Pre-Chill Finished Products Standards in Plant #2, I observed the following noncompliance. After randomly selecting a ten bird sample from line (b) (6), I documented a total of 31 weighted nonconformance points under Processing Nonconformance. This exceeds the subgroup absolute limit (30) for the process to be in control. I immediately informed QC, who performed a recheck at approximately 0526 hours to verify sample validity and documented 28 weighted nonconformance points. This exceeds the tolerance (25) allowed for recheck and at that point the process is considered to be out of control. I informed (b) (6) of the noncompliance. Corrective actions were implemented. All rechecks at Pre-Chill and Post-Chill passed bringing the process back in control. My findings indicate a noncompliance with 9 CFR 381.76 (b).
5333	P7632	HYE120806 1519N-1	06/19/2012	01B02	Pre-Op SSOP Review and Observation	C	I was performing the Pre-Operational Sanitation Review and Observation task when I noted the following failures that generated this noncompliance. In Area III, (b) (4) cabinet one had fat residue from the previous day production on the outside surfaces of the cabinet above the segment line rehang belts and inside the (b) (4) cabinet. The drain in the cabinet was clogged with a white clump of fat and yellow skin pieces from leg hocks. I then, at 2327 hours, retained the cabinet with the application of U.S. Retain tag B40193569 and informed (b) (6) of my findings and the noncompliance. Mr. (b) (6) implemented corrective actions; with sanitary conditions restored I released the area at 2345 hours. In Area IV, I observed an insanitary state, around the floor of ossids five and six. The surrounding floor had fat and meat pieces from the day before's production. Fat and meat pieces were on the platform for Segment Line two, back conveyer belt and thigh belt. The overhead light was contaminated with dried blood and fat particles on it as well. This area was also retained with the application of U.S. Retain tag B38495133 at 0004 hours. (b) (6) and (b) (6) were informed of the noncompliance and began corrective actions. I verified that sanitary conditions were restored in this area and then released it at 0018 hours. During my inspection there was no Q.C. representative present but I did inform (b) (6) at a later time of the situation.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4316060 518N-1	06/18/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>While monitoring the Establishments' Pre-operational Sanitation Procedures in Main Packaging Area, I found the following noncompliance with regulations 9 CFR 416.1, 416.4 (a) and 416.13 (c). At approximately 0854 hours, I observed numerous pieces of black UFM (Unidentified Foreign Material) and reddish brown dust on Line (b) (4). The UFM material were on both sides of the line were the livers, hearts, necks and gizzards are staged to be placed into whole body birds (Gib Tables) and also between the Gib tables. The reddish brown rail dust was on the end of the section between the Gib Tables, before the red Conveyor Belt and Tipper Tie Machines. I immediately tagged the line with U.S. Rejected Tag # B31 406361 and informed (b) (6)</p> <p>(b) (6) of the noncompliance. Company personnel washed the Gib Tables and the section between the Gib Tables with potable water. I reinspected the area and released it at approximately 0909 hours.</p>
5308	M6137	BXL4920065 818N-1	06/18/2012	01C02	Operational SSOP Review and Observation	C	<p>On 06/18/2012 at approximately 1712 hours while monitoring processes in Main Packaging Area, I observed the following. There were numerous pieces of black UFM (Unidentified Foreign Material) on a white cutting board and on the stainless steel portion between the Gib Tables on Line (b) (4). The UFM had the consistency of rail dust. The birds going down the line were being dragged through the UFM with the wings and the skin around the neck area coming into direct contact with this area just prior to being packaged. I immediately tagged the Line with U.S. Rejected/Retained Tag # B 31 407652 and contacted (b) (6) and (b) (6) and showed them my findings. The line was stopped. The affected area was cleaned with a bottle labeled Surface Sanitizer D2 and paper towels. I inspected the product and released to production. The Establishments SSOP under Operational Sanitation states that (b) (4)</p> <p>(b) (6)". The area was released at approximately 1718 hours. My findings indicated a noncompliance with regulation 9CFR 416.4(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN451006 3216N-1	06/16/2012	03J02	Slaughter HACCP	C	At approximately 1545 hours while performing the recordkeeping component of the slaughter HACCP task for PHIS I elected to review the plant records for the morning lot of production on June 14, 2012. The establishment states in their program that the HACCP monitor will verify the (b) (4) [REDACTED]. The plant HACCP monitor recorded a check at 10:21 hours and then again at 12:11 hours for a total of one hour fifty minutes. The total time between checks exceeded the (b) (4) [REDACTED] as required by the plants HACCP plan. The pre-shipment review question that states "Were all critical limits in compliance?" was answered "Yes" and was signed by Mr. (b) (6) [REDACTED] at 1157 hours. That the establishment failed to record a check every hour represents noncompliance with 9CFR 417.5(b) and 417.5(a)(3). I informed Mr. (b) (6) [REDACTED], Evis/Pkg Dept. Supervisor Days, of the forthcoming noncompliance.
5308	M6137	BXL1704060 015N-1	06/15/2012	01C02	Operational SSOP Review and Observation	C	On 06/15/2012 at approximately 0045 hours while monitoring Packaging Department processes, I observed the following. At line #1 immediately after the X-Ray machine there were several boneless skinless breast fillets from the (b) (4) [REDACTED] Deboning Room that had smears of black UFM. I collected the fillets on a brown product tub lid and contacted (b) (6) [REDACTED]. One fillet on the breast fillet packaging line was also found with a gray flaky substance measuring approximately 1/2" by 1/2" that had the consistency of dried paint. Two partial tubs of breast fillets were collected/retained by production and placed under a Q.C. hold tag for reconditioning. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).
5308	M6137	BXL2104063 015N-1	06/15/2012	01C02	Operational SSOP Review and Observation	C	On 06/15/2012 at approximately 0125 hours while monitoring Facilities in Plant #2, I observed the following. An Establishment employee was about to place chickens from a brown product tub into Chiller #4. The birds are missed at the front of the Chiller where birds are automatically dropped into the chiller. The birds are collected at the rehang station and placed in the brown product tub. There were approximately 20 birds in the tub. After sorting through the birds approximately 10 of the birds had varying size patches of black and brown UFM (Unidentified Foreign Material). Smears and specks were located on varied parts of the carcasses and measured up to approximately 3" by 5". The UFM collects on the carcass when in contact with the drip trays and support brackets associated with the return line prior to the auto-rehang station. The drip trays are not treated as product contact surfaces and are seldom cleaned. I showed (b) (6) [REDACTED] my findings. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2404060 815N-1	06/15/2012	01B02	Pre-Op SSOP Review and Observation	C	On 06/14/2012 at approximately 2225 hours while monitoring the Establishments' Preoperational Sanitation Procedures in Plant #2, I observed the following. There were numerous areas of rust and corrosion on the top visible paddle of the Chiller #3 Finishing Chiller. I showed (b) (6) my findings. A work order was placed with maintenance. During production the Finishing Chiller contains a (b) (4) which is used as a backup antimicrobial step. The rust areas measure up to 1/2" and some are raised to over 1/8". My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.13(c), and 9 CFR 416.2(b)(1).
5308	M6137	BXL5416060 615N-1	06/15/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1059 hours, while walking through the packaging area to Plant #2 I observed the following noncompliance. The 2 overhead drip pans running down the walkway in front of the sizing lines in Plant #2, by the (b) (4) machine were covered with condensation at the end of the sizing lines, sanitation started to clean the drip pans and as I was walking by I observed a large amount of dirty mop water flying off of the mop and onto a tank of whole birds, contaminating them. I immediately took regulatory control action and tagged the tank with USDA Retain tag #B31406760 and told (b) (6) of the noncompliance. (b) (6) had a company employee rework the tank of birds restoring sanitary conditions by approximately 1125 hours at which time I removed my tag. My findings indicate a noncompliance with 9CFR 416.2(d), 416.4(d) and 416.4(b).
5333	P7632	HYE080106 4315N-1	06/15/2012	01D01	SPS Verification	C	At approximately 2049 hours while conducting a verification procedure Sanitary Performance Standard (SPS) in the Wet Dock area, I observed the following non compliance: I saw flies on the door frame and the wall inside the buiding next to the elevator. Some flies were observed on the wall by the Dry Ice machine (13 flies were counted). Regulatory Control of the area was taken with the application of US Reject Tag #B38495113 and informed Mr. (b) (6) and showed (b) (6) a the non compliance. Regulatory control was released at approximately 2214 after employee killed and disposed of flies and washed and sanitized the area. 9CFR 416.2(b)(3) states: Walls, floors, ceilings, doors, windows, and other outside openings must be constructed and maintained to prevent the entrance of vermin such as flies, rats, and mice.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE280906 2115N-1	06/15/2012	04C05	Poultry Good Commercial Practices	C	On the morning of June 14, 2012 at approximately 0340 hours, I was informed by SCSI (b) (7)(C) of a poultry carcass suspected to be dead-on-arrival (DOA) that had been hung back by a food inspector on the USDA rack behind station 2 on line 2 for veterinary disposition. After being notified I confirmed the disposition of the carcass to be a DOA. The carcass was slightly reddish in color with a limp neck, friable liver, dark purple lungs, and a slight putrid odor. I notified (b) (6) of the finding who then summoned (b) (6) and (b) (6). I discussed the disposition of the carcass with Mr. (b) (6) and Mr. (b) (6) and later informed them that I would be documenting the incident on a non-compliance record. A memorandum of interview (MOI) was issued to Mr. (b) (6) on June 12, 2012 documenting similar occurrences. The repetitive occurrence of DOAs entering into the evisceration department demonstrates a of loss of process control and the creation of insanitary conditions in accordance with 9 CFR 381.71(a) and 416.4(d).
5308	M6137	BXL0619062 714N-1	06/14/2012	03J02	Slaughter HACCP	C	While performing a Post-Chill Finished Products Standards Check at the exit of the Chiller #2 in Plant #1, I observed the following noncompliance with regulations 9CFR 417.2 (c)(4) and 381.65 (e). At approximately 1233 hours, I randomly select a 10 bird sample, I found one of the ten birds with visible fecal contamination inside the bird on the right leaf fat area by the tail. The fecal material was a smear measuring approximately 3/16" diameter in size, dark green in color and pasty in texture. Since there was no Packaging Supervisor available, I informed the Lead Person. The Lead Person started tanking the birds coming from Chiller #2, then he informed (b) (6). I showed (b) (6) my findings. I also informed (b) (6) and (b) (6) of the noncompliance. Three tanks of product were placed under QC red hold tags pending for rework. At approximately 1239 hours Quality Control performed a recheck and it passed.
5308	M6137	BXL2513062 114N-1	06/14/2012	06D02	Other Inspection Requirements	C	At approximately 1028 hours, I performed a presentation check on line (b) (4). I failed the line with 41 nonconforming points (b) (4) station #11, I observed one bird with viscera not uniform (8 nonconforming points); one bird not hung by two legs (9 nonconforming points) and three birds with viscera on the shackle (24 nonconforming points). On the same line, station 12 also failed with three birds swinging (18 nonconforming points). This exceeded the limit of 3 occurrences of one error. I notified (b) (6). Line speed was reduced down to (b) (4) BPM. At approximately 1043 hours QC performed a passing check at (b) (4) BPM, Line speed went back to (b) (4) BPM. At 1049 hours QC performed another passing recheck at (b) (4) BPM, bringing the process back in control. This is a noncompliance with regulation 9CFR 381.76(b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4403062 314N-1	06/14/2012	06D02	Other Inspection Requirements	C	<p>At approximately 2300 hours, I was in Plant 2 evaluating the evisceration lines. I noticed that on all three inspection stations on Line (b) (7)(C), that all the "Hang High" hang back racks were full. Inspector (b) (7)(C) was working on the second station. He informed me that a lot of birds were being presented to him with the heart and liver still inside the bird. I could see that there was an issue with the presentation and performed a presentation check to evaluate the performance of the system. At approximately 2333 hours, I performed a presentation check on Line (b) (7)(C). The first inspection station failed with 3 "not reflected" errors and 5 "parts inside" errors at (b) (7)(C) birds per minute. At this time I noticed that Line (b) (7)(C) had slowed down in speed. I checked and the line speed had been slowed to (b) (7)(C) birds per minute. The second station failed at (b) (7)(C) birds per minute with 1 "viscera not uniform" error, 1 "viscera on shackle" error, 3 "not reflected" errors and 4 "parts inside" errors, for a total of 26 points. The third station failed at (b) (7)(C) birds per minute with 1 "viscera on shackle" and 5 "parts inside". This exceeds the limits of process control of 2 or less occurrences of one error and 24 or less process control points. I informed (b) (6) of the failure and he informed Quality Control personnel that a recheck would need to be performed. Quality Control personnel performed a recheck at approximately 2346 hours. The first inspection station failed with 2 "viscera on shackle" error, 1 "no viscera" error and 4 "not reflected" errors, for a total of 44 process control points. This exceeds the retest limits of process control of 2 or less occurrences of one error and 24 or less process control points and Line (b) (7)(C) was slowed to (b) (7)(C) birds per minute. Quality Control personnel performed a recheck at approximately 2353 hours and the first station failed at (b) (7)(C) birds per minute with 3 "not reflected" errors and 6 "parts inside" errors. The establishment elected to leave the line at (b) (7)(C) birds per minute, until maintenance could be performed. I informed (b) (6) and (b) (6) of the noncompliance with regulatory requirements of regulation 9CFR 381.76(b). At approximately 0034 hours Quality Control personnel performed a recheck at (b) (7)(C) birds per minute and it passed. Quality Control personnel performed rechecks at approximately 0041 hours, 0047 hours and 0053 hours. All rechecks passed bringing the process back into control and the line speed was increased to (b) (7)(C) birds per minute.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE450406 2913N-1	06/13/2012	04A06	Poultry Finished Product Standards	C	I was performing a Poultry Finished Product Standards check in the ⁰⁷¹⁹ degree cooler on the salvage products from the Evisceration department production line at 0216 hours, after all plant interventions and Quality control checks had been performed. I observed the following noncompliance: In a salvage tub of thighs I found one thigh with cellulites exudate attached to the muscle and fat tissue. In a second salvage tub of chicken legs, drums, I found cellulitis exudate covering half the leg on the muscle tissue under the skin. I then notified (b) (6) and (b) (6), of my findings and the noncompliance. Both tubs of salvage parts were retained with the application of U.S. retain tag B38495135, and B38495136. The product was reworked and I reinspected it to confirm wholesomeness then released it at 0515 hours. Preventive measures were proffered that employees involved would be retrained.
5309	P6137A	NJN350306 4212N-1	06/12/2012	04A06	Poultry Finished Product Standards	C	I was performing a Finished Products Standards check (FPS) at 0508 hours on the reprocessing line in the evisceration department when I noted the following noncompliance; The establishment failed to remove airsacculitis exudate from carcasses identified by USDA for air sac removal. (3) carcasses of the (10) carcass sample identified for air sac removal contained air sac exudate. The establishment's written procedure for air sac removal states (b) (4) I initiated regulatory control by stopping the reprocessing line and informing Mr. (b) (6), and Ms. (b) (6) of the noncompliance. Regulatory control was relinquished to Quality Control so that corrective actions could be implemented to regain process control and perform rechecks in order to identify all affected product associated with the failure.
5309	P6137A	NJN210806 1311N-1	06/11/2012	01D01	SPS Verification	C	I chose to verify the conditions of the outside premises (SPS Check) at 0416 hours when I noted the following non compliance: There where three cardboard combo bins left over from Saturdays production that contained inedible product. The bins had a putrid offensive odor. One of the bins was torn on the bottom leaking fat and liquid onto the ground creating an unsanitary condition. I informed (b) (6) and (b) (6). Grounds and outside premises of an establishment need to be maintained in a manner to prevent the creation of insanitary conditions to prevent attracting pests, rodents and vermin as per 9 CFR 416.2(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1205062 207N-1	06/07/2012	01B02	Pre-Op SSOP Review and Observation	C	On 06/06/2012 at approximately 2222 hours while monitoring the establishments' Preoperational Sanitation Procedures in Plant #1, I observed the following. On the center section of Chiller #1 on the side adjacent to Chiller #2, there was pasty and semi-dried fat and debris on two support brackets for the paddles. On the outflow section of Chiller #1 also on the side adjacent to Chiller #2 there was semi-dried yellowish fat and chiller froth on large sections of two paddles. The heaviest reachable areas of the chiller paddles were cleaned with a green scouring pad and paper towels by approximately 2230 hours. There is a drip pan at the inflow side of chiller #2 that slopes towards the chiller and appears to drain into the tray that guides birds into the chiller #2. The drip tray is considered a non-food contact surface and should drain to a floor drain. I showed (b) (6) my findings. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.2(b)(1), and 9 CFR 416.13(c).
5309	P6137A	NJN160206 4407N-1	06/07/2012	04C05	Poultry Good Commercial Practices	C	On the morning of Tuesday June 5, 2012 at approximately 0715 hours I was notified by SCS (b) (7)(C) of two poultry carcasses suspected to be dead-on-arrival (DOA) that had been hung back by two line inspectors for veterinary disposition. At approximately 0735 hours I confirmed the disposition of the two carcasses that were hanging on the USDA rack behind station #2 on line "A" to be DOAs. Both carcasses were reddish in color with limp necks, friable livers and had a putrid odor. One carcass also had a friable spleen with a purplish discoloration in the intestines. (b) (6), was notified on two separate occasions by the line inspectors at the time of their findings. I informed the establishment during the weekly Establishment Awareness Meeting that I would be documenting the incidences on a non-compliance record. The repetitive occurrence of DOAs entering into the evisceration department demonstrates a loss of process control and the creation of insanitary conditions in accordance with 9 CFR 381.71(a) and 416.4(d).
5308	M6137	BXL4416063 706N-1	06/06/2012	01C02	Operational SSOP Review and Observation	C	At approximately 0918 hours while performing my Post Chill procedure for Chiller #3 in Plant #2, I observed the following noncompliance. A company employee was wiping down condensation with a mop, off of the drip pan above the transfer belt that carries the carcasses to be hung for line (b) (6) (the cut up line) in Packaging, as he did so he splashed dirty mop water on the belt and the product on the belt. I immediately notified (b) (6) and (b) (6) of the situation. They had employees on the belt stop hanging the carcasses and started tanking them until all affected product was removed. As the belt is continuously washed with (b) (4) from beneath sanitary conditions were restored after 1 pass over the washer. The tank of birds was reworked and sanitary conditions were restored by approximately 0946 hours. My findings indicate a noncompliance with regulations 9CFR 416.2(d) and 9CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5316061706N-1	06/06/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 1034 hours, I randomly removed 10 carcasses from line 2 in Plant 1 to perform a Zero tolerance Fecal Inspection. I found one of the ten carcasses contaminated with feces. The fecal matter was located inside of the birds cavity near the tail area. It was light yellow in color and pasty in texture measuring approximately 1/8" in diameter. I immediately notified (b) (6) of the noncompliance. The establishment began implementing the Zero Tolerance Protocol. At approximately 1103 hours, QC performed a passing recheck. From 1125 hours to 1240 hours Post Chill checks were performed on the suspect lot coming out of chiller #2. All product was found acceptable. Pre shipment Review Record was sign at 1247 hours, releasing the product. My findings indicate a noncompliance with regulation 9CFR 361.65(e) and 417.2(c)(4)
5333	P7632	HYE2116061406N-1	06/06/2012	01C02	Operational SSOP Review and Observation	C	On June 5, 2012 at approximately 0709 hours, while performing an unscheduled Operational Sanitation in 2nd processing I noticed the following non-compliance, fatty residual build-up on the product-contact surfaces of the blue rotisserie incline conveyor. Pre-Operational sanitation had been preformed at 2315 and released at 2342. The (b) (6) said the line had not been used by the previous shift. No Regulatory control action was necessitated because Quality Control took control of the line upon notification. Mr. (b) (6) was informed of my findings and of the forthcoming non-compliance. At 0740 the conveyor was washed and sanitized prior to the start of production. The same non-compliance was observed on May 31, 2012. This was documented on Non Compliance record #HYE3816051531N/1. Regulation 416.4(a) states; sanitary operations. All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.
5308	M6137	BXL4704060305N-1	06/05/2012	01B02	Pre-Op SSOP Review and Observation	C	On 06/04/2012 at approximately 0055 hours while monitoring the establishments' Preoperational Sanitation Procedures in Packaging Area #1, I observed the following. There was a white product shovel laying on the floor grating at the Plant #1 Halving Machine. A white cutting wheel at the same location was also on the floor grating. While using a wrench to remove the wheel currently attached to the unit, an establishment employee stepped on the wheel that was on the floor grating. The white shovel and white cutting wheel are considered product contact surfaces and should be stored in a sanitary manner in their designated location. (b) (6) was informed of my findings. The items were returned to sanitary condition by approximately 0005 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN090206 0205N-1	06/05/2012	01C02	Operational SSOP Review and Observation	C	I was walking thru the "new" loading dock at 2330 hours when I noted the following non compliance: At door 2, trailer # 2479 had pallets of brown tubs containing carcass front halves. One of the tubs on the top layer did not have a lid on it exposing the product in the tub. The regulatory requirements of 9 CFR 416.4(d) where not being met by allowing product to be exposed during loading, unloading or transportation. I informed (b) (6), who then applied a QC hold tag to the tub. I also informed (b) (6) of the non compliance.
5308	M6137	BXL2712061 904N-1	06/04/2012	01B02	Pre-Op SSOP Review and Observation	C	While monitoring the Establishments' Pre-operational Sanitation Procedures in Plant #2, I found the following noncompliance with regulations 9 CFR 416.1, 416.4 (a) and 416.3 (c). At approximately 0712 hours, I observed in Area #4, Unit #46 the Inside/Outside Bird washer recycle water tank had in it UFM (unidentified foreign material). I notified (b) (6) about the noncompliance. The tank was washed. At approximately 0714 hours sanitary conditions were restored. At approximately 0715 hours, I observed in Area #5, Unit #1 the blue conveyor belt that catches the birds from Line (b) (6) it had numerous black specks of UFM (unidentified foreign material) and also the conveyor belt that connects the conveyor belt that catches birds for line (b) (6) to the chiller had four strips of metal measuring approximately 6" long by 1/8" wide. I attached a U.S. Rejected/ Retained Tag # B31 406363 to that area and informed (b) (6) about the noncompliance. Sanitation personnel washed the belts and removed the metal strips. Sanitary conditions were restored at approximately 0722 hours, then I removed the tag.
5308	M6137	BXL5202065 802N-1	06/02/2012	01B02	Pre-Op SSOP Review and Observation	C	ON 06/01/12 at apprximately 2255 hours while preforming the Preoperational Sanitation Procedure in the Packaging area #1 I observed the following . The Plant # 1 Halver had pieces of fat from the pervious days production on the flex belt that carries product from the (b) (4) room to the packaging area the pieces ranged from 1/8 " to 1" in Diameter, the drip pan also pieces of fat floating on the water in the drip pan which also ranged from 1/8 " to 1". There were also large beads of condensation on the entire ceiling above the area . I immediately brought my findings to the attention of (b) (6) . U.S. Rejected /U.S. Retained tag #B31 407605 was immediately applied to the area . (b) (6) had one of his workers thoroughly rinse the flex belt and drip the condensation was also removed .The area was rechecked and found to be in sanitary conditon . The tag was removed at approximately 0008 and the area was ready for production . My findings indicate noncompliances with the following regulations 9CFR 416.13(c), 9CFR 416.14 , 9CFR 416.13(a) ,9CFR 416.4(b) ,9CRF 416.4(a) .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE370506 2502N-1	06/02/2012	01C02	Operational SSOP Review and Observation	C	While walking through the chiller rehang area performing an Operational Sanitation inspection task on June 1, 2012 at 0350 hours I observed the following noncompliance: a pile of whole birds product had accumulated on the belt and floor below the incline belt for the North chiller exit. During this time the north chiller paddle was continuing to push more whole body birds out onto the belt piling on the floor. The product pile-up was too heavy for the belt to operate and plant employees were picking up product off the floor and placing them into a large gray combo bin that was tagged by establishment Q.C. for rework . Clean product that was on top of the pile was also placed in this bin, thus contaminating the clean product. I then observed a lead mechanic shout "The belt is to heavy to move," after which the establishment employees began removing clean product from the belt putting it on to the floor. This product was placed in the bin after the product belt began to move. The affected product was retained by Q.C. in two large gray combo bins to be reworked. (b) (6) and (b) (6) were informed of the noncompliance. The preventive measures proffered was to have a meeting with supervisors and employees to train them in proper product handling procedures.
5308	M6137	BXL3503064 501N-1	06/01/2012	06D02	Other Inspection Requirements	C	On 05/30/2012 at approximately 0206 hours while monitoring Presentation at the third station on line 9 in Plant #2, I observed the following. A standard sample revealed the following nonconformances and corresponding valves : one bird with viscera Front or Side (11), one bird with Viscera on Shackle(8), one bird with No Viscera(20), three birds with intact Membranes (6), two birds with the fat flap Not Reflected (4), one bird with Parts Inside (1) for a total on 50 nonconformance points. Total nonconformances over 40 points indicates that the process is out of control. A line Supervisor was contacted. The line was slowed down to 10 birds per minute and a retraining was conducted. Quality Control conducted a recheck at 10 and 10 birds per minute bring the line back into compliance by 0224 hours. My findings indicated a noncompliance with 9 CFR 381.76(b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3403053 631N-1	05/31/2012	01B02	Pre-Op SSOP Review and Observation	C	On 05/30/2012 at approximately 2220 hours while monitoring the establishments' Preoperational Sanitation Procedures in Plant #2, I observed the following. There was dried greasy black UFM(Unidentified Foreign Material) along the entire length of the guide bars inside the the last bird washer on line ^{(b) (6)} . The area was cleaned with a green scouring pad, paper towels and rinsed with ^{(b) (4)} by approximately 2225 hours. The guide bars are not considered a product contact surface but are directly above the open product at the last wash point before entering the chilling system. There were large patches of dried and semi-dried yellowish UFM(Unidentified Foreign Material) on the paddles located on the midsection on the Sorting & Sizing Line side of Chiller #3. Inspection of the chiller at that location is difficult as air hoses and other design issues limit access and visibility. The heaviest reachable areas were wiped with paper towels by approximately 2245 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.13(c), and 9 CFR 416.3(b).
5333	P7632	HYE381605 1531N-1	05/31/2012	01C02	Operational SSOP Review and Observation	C	At approximately 0748 hours, while performing an unscheduled Operational Sanitation in 2nd processing I noticed fatty residual build-up on the product-contact surfaces of the blue rotisserie incline conveyor. Pre-Operational sanitation had been preformed at 2315 and released at 2325. No product had been introduced to the area prior to my findings. The ^{(b) (6)} said the line had not been used by the previous shift. No Regulatory control action of the noncompliance was necessitated because Quality Control took control of the line upon notification. Mr. ^{(b) (6)} was informed of my findings and of the forthcoming non-compliance. At 0812 the conveyor was washed and sanitized prior to the start of production. A similar non-compliance was observed on May 19, 2012. The blue conveyor belt located on the south wall in the packaging department used to move backs into bins had a build up of residue from the previous shifts production. This was documented on Non Compliance record # HYE1410050019N/1. Regulation 416.4(a) states; sanitary operations. All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0813050 629N-1	05/29/2012	06D02	Other Inspection Requirements	C	At approximately 0900 hours, I performed a presentation check on line (b) (4). I failed the line with 36 nonconforming points. (b) (6) station #8, I observed one bird with viscera not uniform (8 nonconforming points); one bird with viscera below wing (12 nonconforming points) and two birds with viscera on the shackle (16 nonconforming points). I notified (b) (6) and (b) (6). At approximately 0914 hours, QC performed a recheck, failing with 44 nonconforming points. (b) (6) station #7, She observed three birds with viscera non uniform (24 nonconforming points); one bird with viscera below wing (12 nonconforming points) and four birds not reflected (8 nonconforming points). This exceeded the limit of 3 occurrences of one error and the 25 nonconforming for the process to be in control. Line speed was reduced down to (b) (6) BPM. At approximately 0958 hours QC performed a passing check at (b) (6) BPM, Line speed went back to (b) (6) BPM. At 1014 hours QC performed another passing recheck at (b) (6) BPM, bringing the process back in control. This is a noncompliance with regulation 9CFR 381.76(b).
5308	M6137	BXL1109052 729N-1	05/29/2012	01C02	Operational SSOP Review and Observation	C	At approximately 0650 hours, I observed noncompliance with the regulatory requirements of 9CFR 416 (d). At the end of the Plant 1 chiller grading belts, I observed a stainless steel tank. The tank was staged at the end of the grading belts and under returning empty lines from packaging, numbers 8, 9 and 11. The tank was half full of birds. There were numerous birds in the tank with numerous black specks (unidentifiable foreign material) on them. The black specks ranged in size from 1/32 to 1/16 inches in diameter and smeared when touched. The black specks appeared to be rail dust. I attached USDA Retain Tag # B1406374 to the tank. I informed (b) (6) of the noncompliance. The birds were reworked and the tank was rinsed. I removed the USDA Tag and released the product back to production at approximately 0715 hours.
5308	M6137	BXL3903053 929N-1	05/29/2012	03J04	Poultry Zero Tolerance Verification	C	On 05/29/2012 at approximately 0038 hours while monitoring the Establishments' Finish Product Standards on Line (b) (4) in Plant #2, I observed the following. After selecting a random 10 bird sample, I observed one bird with visible fecal contamination. There was a partial stomach connected to a complete gizzard that had approximately 5" of intestine attached. There was fecal contamination leaking from the cut end of the intestine into the area of the kidneys. The fecal material was approximately 1/2" by 1/8" in size and was yellowish brown in color. This exceeded the limit of Zero tolerance for the process to be in control. I showed (b) (6) my findings. He implemented the protocol for fecal failure. The recheck passed at 0107 hours. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), 9 CFR 381.65(e), and the critical limit of CCP-2B (b) (4) of the Plants HACCP Plan for slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4514050 229N-1	05/29/2012	03J04	Poultry Zero Tolerance Verification	C	While performing a Zero Tolerance Check, I observed a noncompliance with the following regulatory requirements of regulation 9 CFR 381.65 (e) and 417.2 (c)(4). At approximately 1018 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination inside the bird on the right side under the leaf fat area by the kidneys. The fecal material was a smear approximately 3/16" diameter in size, green and white in color and pasty in texture. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (b) (6) of the noncompliance, the protocol for fecal failure was implemented. Quality Control performed a Recheck at approximately 1053 hours and it passed. The cause of the deviation was that the water sprayers were plugged. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plants' HACCP Plan for Slaughter
5309	P6137A	NJN260205 5229N-1	05/29/2012	01D01	SPS Verification	C	I was on the east side of the building at 2339 hours, returning from performing a good commercial practice task when I made the following observation: Next to the dumpster was an excessive amount of trash piled on the ground. I counted 14 red trash cans, one gondola, 4 combo bins and 14 large blue trash bags. I came inside and had (b) (6) contacted by radio to meet me outside at this area. I showed this area to Mr. (b) (6) and informed him of the non compliance. I also informed (b) (6) of the non compliance. The trash and debris on the ground indicates an area that is not maintained in a sanitary condition as stipulated in 9 CFR 416.2

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0405050 326N-1	05/26/2012	01C02	Operational SSOP Review and Observation	C	<p>On 05/26/2012 at approximately 0150 hours while monitoring Facilities, I observed the following. In the Rewrap Room there were two establishment employees rewrapping bag fryers. One employee was removing bag fryers from gray product baskets. The internal surfaces of the product basket was covered with numerous pieces of dried and semi-dried fat and tissue to approximately 1/4", and a layer of brown and black UFM(Unidentified Foreign Material) specks. The employee then used a brown paper towel to wipe off the brown colored UFM (Unidentified Foreign Material) from the outside of the bag fryer packaging. The UFM typically adheres to packaged product when they come in contact with the Weigh & Price Cooler floor. The cooler floor was last cleaned on the weekend of 5/12/2012 . The employee then took a knife from a gray plastic pan that contained an unknown sanitizing solution that was approximately 3/4" deep. The sanitizing solution used and its concentration is not part of the establishments CP or SSOP monitoring. The gray pan that the solution was in had a large brown ring around its entire interior surface approximately 1" wide. The brown ring started approximately 1" above the sanitizing solution in use. The knife was used to cut open the packaged carcasses. The chicken carcass was removed, the absorbent pad was removed from the bottom of the carcass and the chicken was placed on a stainless table. At no time was the employees gloves sanitized after touching the soiled bag prior to handling the carcasses. A second employee was handling the gray product baskets that the rewrapped birds were being stacked into. The surfaces of the gray product baskets are considered a non-product contact surface and are seldom cleaned. The gray basket again had numerous pieces of dried and semi-dried fat and tissue to approximately 1/8", and numerous brown and black specks. The second employee was taking the unwrapped carcasses and placing them into fresh packages and placing them onto the contaminated gray product basket. Again more contaminants were added to the carcass as no glove sanitizer was used by the second employee although there is a sanitizing unit immediately adjacent to the bagging process. After making observations for several minutes, I proceeded to the rack storage area and found over 25 racks of bag fryers waiting to be rewrapped. Visible labels indicating that the kill dates ranged from 5/17 thru 5/24. 25 racks is approximately 3500 carcasses. At this time I contacted (b) (6) , showed her the SSOP procedure which she apparently had not seen before. I discussed the cross contamination issues that I observed, tagged the affected the product, and shut down the process by approximately 0205 hours. A review of the SSOP procedure dated May 21, 2012 for 'Handing of Rework' under procedure states that (a) "(b) (4) ." The procedure does not state how this will be accomplished. Then (b) (b) (4) .</p> <p>However, the establishment SSOP last updated May 22, 2012 does not list any requirements for product handling. Then (c) (b) (4) .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							<p>(b) (4). " Again the SSOP does not say how this is to be accomplished. The only reference to Reworked product in the SSOP states that (b) (4)</p> <p>" A review of the establishments 'SSOP (b) (4)</p> <p>" for the shift documented that a check was made at 0123 hours by SSOP (b) (6) and indicates that the following items were found to be acceptable. " (b) (4)</p> <p>" (b) (6) was contacted and a temporary procedure was implemented and the rewrap room was reopened. The affected product was rinsed with (b) (4) per establishment SSOP procedure in the Rotisserie Room product wash sink and was sent back to rewrapped by approximately 0430 hours. A check of establishment computer records indicates that the (b) (4) used to 'recondition the product per company procedure' in the Rotisserie room rewash sink is not routinely monitored so it is unclear if the wash used had any beneficial affect. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), 9 CFR 416.5(a), and 9 CFR 416.12(a).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN560505 3426N-1	05/26/2012	03J02	Slaughter HACCP	C	<p>I was in the evisceration department at 0235 hours when I noted the following noncompliance; the HACCP monitor was not monitoring CCP 1-B parts from "A" and "B" evisceration lines at the designated inspection area as stated in the establishment's written HACCP plan. The establishment's written HACCP plan states the (b) (4)</p> <p>. I observed the HACCP monitor conducting the HACCP monitoring check CCP 1-B, at the salvage station for the evisceration "B" line and not at the designated reinspection station. After conducting the check I noted the HACCP monitor documenting the HACCP monitoring CCP 1-B for salvaged product from evisceration lines "A" & "B" as acceptable at 0236 hours. At the time the HACCP monitor was conducting the CCP monitoring check there was no salvaged product staged at the designated CCP 1-B monitoring reinspection station. I informed Mr. (b) (6), and Ms. (b) (6) of the noncompliance. In response to the monitoring noncompliance that occurred on 5-26-12, (b) (4) as stated in the establishment's written HACCP plan. I reviewed the corrective actions, preventive measures and the preshipment review to verify compliance with the recordkeeping requirements as per 9 CFR 417.3 and 9 CFR 417.5. While reviewing the HACCP records and the preshipment review associated with the product involved I noted the following recordkeeping noncompliance; the establishment did not document corrective actions associated with the affected product, and the establishment failed to document the monitoring failure for CCP 1-B at 0236 for the "A" and "B" evisceration lines when completing the preshipment review. The establishment documented that performing the CCP monitoring check while the product is still in process is acceptable because the check was performed under the proper lighting. Additionally by performing the CCP monitoring checks at the salvage stations the establishment is not following the CCP monitoring procedures as written in the establishment's written HACCP plan, therefore monitoring the CCP at the salvage stations is not acceptable as written the establishment's HACCP plan. The section of the preshipment review step #3 were all entries made at the required frequency and step #4 the results of the Pre-shipment are acceptable were documented and signed as acceptable. I informed Mr. (b) (6) of the noncompliance</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2904054 625N-1	05/25/2012	03J04	Poultry Zero Tolerance Verification	C	On 05/25/2012 at approximately 0122 hours ,while performing Pre- Chill Finished Product Standards check, I observed noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 417.2 (c)(4). and the critical limits of CCP-2B,(b) (4) of the Plant's HACCP Plan for Sluaghter. I randomly removed 10 bird sample from line # 1 in Plant # 1, the first bird of the 10 bird sample had visible fecal contamination on the leaf fat , and approximately 3 inches intestine inside the cavity with visible fecal on the cloaca side. The fecal material measured approximately 1/4 inch in diameter , brownish green in color and pasty in texture. This exceeds the limit of Fecal Zero Tolerance for the process control. I informed (b) (6) and (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0145 hours and it passed .
5308	M6137	BXL0216053 924N-1	05/24/2012	04A06	Poultry Finished Product Standards	C	While monitoring the establishments' reprocessing procedure on Line (b) (6) in Plant #2, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.84 (airsacculitis). At approximately 0958 hours, I randomly removed a 10 bird sample for my reprocessing test, I found one out the ten birds with split tail in the sample that contained Airsacculitis exudates. I then performed a recheck at approximately 1004 hours, in which two out the ten birds with splits tails contained Airsacculitis exudates. As (b) (6) was close, she immediately stopped the line. I showed her my findings and then she began to retain the product in a tank. Quality Control did a recheck at approximately 1024 hours and it passed bringing the process back in control. Quality Control placed a hold tag on the tank. The retained product was reworked and released at approximately 1050 hours. I informed (b) (6) and (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE521705 5124N-1	05/24/2012	04A06	Poultry Finished Product Standards	C	<p>At 1234 hours I was called out to Evisceration Line 1 by Food Inspector (b) (7)(C) who was performing bird-by-bird post-mortem inspection at Station 4. Inspector (b) (7)(C) explained to me that she called four birds for airsacculitis-salvage and that her trimmer marked them per the establishment's Air-Sac Salvage Procedure with (b) (4)</p> <p>The carcasses were collected by the salvage employee who took them to the offline salvage station. Because there were numerous gaps in the line where the shackles were empty, Inspector (b) (7)(C) was able to observe the salvage employee wash out the carcasses and cut the skin away from the back of the carcasses. The employee then brought the carcasses back and hung them on the reprocessing line. Inspector (b) (7)(C) managed to retrieve two of the carcasses and observed that they were two of the carcasses she had previously identified as having interclavicular air sac lesions and had hung back for Air Sac Salvage. I inspected the birds and confirmed the presence of airsacculitis exudate inside the thoracic cavity and also evidence of interclavicular involvement. The skin was removed from the entire backs of both carcasses from the posterior opening to the neck and wings. The establishment's Airsacculitis Salvage procedure states (b) (4)</p> <p>[REDACTED]</p> <p>. That the establishment failed to follow the written procedures of their Air Sac Salvage program and circumvented the marking system designated in the program represents noncompliance with the protocols of the program. The failure to remove all air sac exudate and affected tissue represents noncompliance with 9 CFR 381.84. (b) (6) was notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1223054 623N-1	05/23/2012	01C02	Operational SSOP Review and Observation	C	<p>On 05/23/2012 at approximately 0335 hours while monitoring Establishment Facilities in Plant #1, I observed the following. There was black UFM (Unidentified Foreign Material) on ice flakes being collected at the location adjacent to Chiller #2. The ice is manufactured at a location on the roof and is collected from a dispenser into stainless steel tanks. I contacted (b) (6) and showed him my findings. The ice was condemned and dumped in the edible dump room. A mechanic was called, the machine and dispenser were cleaned. A quantity of brown and black coated ice flakes came from the dispenser chute during the cleaning process included a piece of black UFM approximately 1" by 3/8" that contained shiny flakes that appeared to be metal shavings. I checked the ice in use at several locations but found nothing. When the ice was clear it was again collected. I returned again at approximately 0410 hours and found ice flakes being collected that contained brown UFM. I again contacted (b) (6) who condemned the ice. A mechanic was called and at this time the process was shifted to a second ice machine. My findings indicated a noncompliance with 9 CFR 416.2(g)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN250605 1623N-1	05/23/2012	01C01	Operational SSOP Record Review	C	<p>I elected to perform a SSOP records review task to verify the establishment had met the regulatory requirements set forth in 9 CFR 416.16 for product adulteration that occurred on the morning of 5-22-12 when a hydraulic hose broke during production in the Food Service department. The establishment initiated corrective actions, identified all affected product, segregated product that had not been affected, took measures to restore sanitary conditions, and documented measures to prevent recurrence. I noted several recordkeeping noncompliances while performing the SSOP records review in regards to identity of the affected product. 1. The tags used to identify the affected product were filled out incorrectly. The QC technician filled out 4, 3 part QC tags, numbers 43671, 43672, 43673, and 43674. Documented on each tag was "one bin" & "pending." The establishment stated the tags should have been filled out 3 tags with "one bin" & "pending" and one tag stating "one tub" & "pending". 2. The QC tags placed on the affected product did not match the amount of affected product documented on the SSOP implementation and monitoring log. The QC technician documented on the SSOP implementation and monitoring log that 3 combo bins and 1 tub of product were affected while the QC 3 part retain tags placed on the product were all documented as 4 tags each identifying the affected product as "one bin". 3. The amount of affected product documented on the SSOP implementation and monitoring log did not match the amount of affected product documented on the establishment's non routine SSOP observation form. The SSOP implementation and monitoring log has 3 combo bins and 1 tub documented on it, while the non routine SSOP observation form has 3 combo bins documented as the amount of affected product. The non routine SSOP observation form is used by the establishment to document "cause of the deviation, affected product, corrective actions, and preventive measures" to meet the regulatory requirements outlined in 9 CFR 416.15 and 9 CFR 416.16. 4. One of the combo bins of affected product had 2 different types of QC tags on it. It had 2 QC 3 part tags plus an orange QC tag. Documented on the non routine SSOP observation form "3 combo bins to be condemned" were retained with QC 3 part tags and labeled "disposition pending" on the tag. Documented on the non routine SSOP observation form "product not affected by the hydraulic oil was segregated (5 combo bins) and retained". The 5 combo bins were retained with orange QC tags which stated "needs secure and pending." The combo bin had QC tags with conflicting product dispositions. Documented on the non routine SSOP observation form is that after sanitary conditions were restored the 5 combo bins of unaffected product were to be run through the (b) (4) treatment and placed back into production. Based on my review of the establishment's documented SSOP records and inspecting the affected product and QC tags applied to the affected product in cooler #5 I elected to apply USDA retain tags B39415973, 74, 75 & 76 to 4 combo bins of product. The 4 combo bins are listed in the order they were arranged and the type of QC tag, or tags each bin contained. Bin #1, one combo bin of wogs with one QC 3 part tag. Documented on the QC 3 part tag was "one</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							bin" & "pending". Bin #2, one combo bin of wogs with a brown tub of cut up product placed in the corner of the combo bin on top of the wogs. Bin #2 had 3 QC tags applied to it, one orange QC tag and two QC 3 part tags. Both QC 3 part tags had "one bin" & "pending" documented on them. The orange QC tag was glued to the top of the liner and had "needs (b) (4) and pending" documented on it. There was no tag placed on the brown tub of cut up product inside the combo bin. Bin #3 was partially filled and contained boneless skinless breast fillet. There was no QC tag, production tag, or any other type of product identification on the bin of breast fillets. Bin #4 contained wogs. Documented on the QC 3 part tag was "one bin" & "pending". After reviewing the records and inspecting the product I notified Mr. (b) (6) and Ms. (b) (6) on the noncompliance.
5308	M6137	BXL4812052 722N-1	05/22/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1552 hours, while walking through the packaging area to Plant #2 I observed the following noncompliance. The 2 overhead drip pans running down the walkway in front of the sizing lines in Plant #2, by the (b) (4) machine were covered with heavy condensation that was actually dripping heavily around the tanks at the end of the sizing lines. I immediately informed (b) (6) and (b) (6) of the noncompliance. They had sanitation start to clean the drip pans and as (b) (6) and I were standing there we observed a large amount of dirty mop water flying off of the mop and onto a tank of whole birds, adulterating them. I immediately took regulatory control action and tagged the tank with USDA Retain tag #B31406119. (b) (6) and a company employee reworked the tank of birds restoring sanitary conditions and I removed my tag at approximately 1605 hours. My findings indicate a noncompliance with 9CFR 416.2(d), 416.4(d) and 416.4(b).
5308	M6137	BXL5604051 422N-1	05/22/2012	01C02	Operational SSOP Review and Observation	C	On 05/22/2012 at approximately 0030 hours while monitoring the Establishments' processing procedures in Packaging area #1, I observed the following. There was black UFM (unidentified foreign material) on several breast fillets on a conveyor belt just prior to a final trim station. I also found two breast fillets with similar UFM on the conveyor belt immediately after the xray machine. The UFM specks measured up to 1/8" and the smears to approximately 2". I contacted (b) (6) and showed him my findings. A few breast fillets with the UFM continued to come down the conveyor belt just before the final trim station until approximately 0105 hours. The affected product approximately 35 fillets were reconditioned per establishment SSOP procedure with chlorinated water by approximately 0130 hours. My findings indicated a noncompliance with 9 CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN020205 1522N-1	05/22/2012	01C02	Operational SSOP Review and Observation	C	<p>On 05/21/2012 at 0700 hrs. in the evisceration department I had completed the on-line inspector breaks and I was walking towards the auto rehang area when I noticed the following non compliance: I observed that birds moving down evisceration line A were coming into contact with condemned carcasses in a gray condemn barrel. The two gray condemn barrels located on either side of the carcass conveyor belt were full of condemned carcasses. The barrels were placed next to the line and coming into contact with the carcasses on the evisceration line. Regulatory control was not initiated because only the necks were coming into contact with the condemned carcasses. The necks are not harvested for edible purposes however this represents an unsanitary practice because the necks are not deemed inedible until removal from the carcass at a later point in the process. I noted another non compliance while in the re-hang area. I observed approximatley 15 carcasses on the floor under the auto rehangers covered with blood and feces. The carcasses had been on the floor for several minutes. That the carcasses were not being picked up in a timely manner represents an unsanitary operational condition. The birds were falling on the floor because the chutes underneath the auto rehang machines were backed up with carcasses. I informed (b) (6) and (b) (6)</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN500805 1722N-1	05/22/2012	04A06	Poultry Finished Product Standards	C	<p>I was performing a Finished Products Standards check at 0538 hours on the reprocessing line in the evisceration department when I noted the following noncompliance; The establishment failed to remove airsacculitis exudate from carcass identified by USDA for air sac removal. (5) carcasses of the (10) carcass sample identified for air sac removal contained air sac exudate, and (1) carcass of the (10) carcass sample contained cellulitis lesions. The establishment's written procedure for air sac removal states if (b) (4)</p> <p>(b) (4)</p> <p>(b) (4). I initiated regulatory control by stopping the reprocessing line and informing Mr. (b) (6) and Mr. (b) (6) of the noncompliance. Regulatory control was relinquished to Quality Control so that corrective actions could be implemented to regain process control and perform rechecks in order to identify all affected product associated with the failure.</p>
5308	M6137	BXL5011051 921N-1	05/21/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>While performing Pre Operational Sanitation Inspection in the second processing area I found two noncompliances: At approximately 0845 hour, while inspecting the (b) (4) Room area, I found a noncompliance with regulatory requirement of regulation 9 CFR 416.4(a). On the wing line, there was pieces of fat and also a substantial accumulation of fat residue on the bars located under the blue conveyors. I immediately placed a retained/Rejected U.S. Tag NO. B31 406251 on the affected equipment. I then notified (b) (6). All affected areas were scrubbed and rinsed by sanitation employees. Area was released at approximately 0910 hours, after sanitary conditions were restored. At approximately 0850 hours, while inspecting the Packaging area, I found a noncompliance with regulatory requirements of regulations 9 CFR 416.4(a) and 416.2(a). On the Deboning Line, there were several 1/2" pieces of dried meat on the thigh deboning equipment. There were also several mosquitos on the cutting white boards of the deboning table. I immediately notified (b) (6) of my findings. All affected areas were immediately rinsed restoring sanitary conditions. Area was released to production at approximately 0905 hours.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE141005 0019N-1	05/19/2012	01C02	Operational SSOP Review and Observation	C	At approximately 0745 hours. I performed an unscheduled Operational Sanitation. The following non compliance was observed in 2nd Processing on equipment not in use; the blue incline conveyor located on the south wall in packaging department used to move backs into bins had a build up of fat and residue from the previous shifts production. Mr. (b) (6) was informed of my findings and of the forthcoming non-compliance. At 0758 Quality Control hold Tags were placed on conveyor until such time that conveyor can be properly cleaned. On April 21, 2012 the same non-compliance was observed and documented on Non Compliance record # HYE2310041N/1. Regulation 416.4(a) states; sanitary operations. All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.
5308	M6137	BXL3104052 619N-1	05/18/2012	04A06	Poultry Finished Product Standards	C	On 05/19/2012 while performing Pre-Chill Finished Product Standards, I observed noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b). At approximately 0013 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1 for Pre-Chill Finished Product Standards Check. I documented 35 points on the Processing Nonconformance's from the 10 bird sample. This exceeds the subgroup absolute limit of 30 points for the Processing Nonconformance's to be in control. I informed Quality Control of the failure and at approximately 0024 hours she performed a Recheck. Quality Control documented 34 points, this exceeds the tolerance of 25 points allowed for the recheck, at this point the process is considered out of control. I informed (b) (6) of the noncompliance. Corrective actions were implemented. All rechecks at Pre-chill and Pos-chill passed bringing the process back in control.
5308	M6137	BXL4204052 518N-1	05/17/2012	01B02	Pre-Op SSOP Review and Observation	C	On 05/17/2012 at approximately 2210 hours while monitoring the Establishments' Preoperational Sanitation Procedures in Plant #2 after Establishment SSOP and HACCP monitors completed their checks and before the start of production, I observed the following. There was a buildup of black UFM (unidentified foreign material) to approximately 1/8" on the guide bars inside the final wash cabinet for Line 01A. The UFM on the top bar was up to approximately 1/8" thick along its entire length. There were several pieces of fat and tissue to approximately 2" on one spray head and the associated support bracket associated with the first wash cabinet on Line 01A. There were numerous black specks and a piece of bone to approximately 1/2" on top of the lower sprocket assembly where birds are dropped for Chiller #3. Sanitary conditions were restored by approximately 2230 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4205053 918N-1	05/17/2012	03J04	Poultry Zero Tolerance Verification	C	While performing Pre-Chill Finished Products Standards Check, I observed noncompliance with the following regulatory requirements of regulation 9 CFR 381.65 (e) and 417.2 (c)(4). On 05/18/2012 at approximately 0131 hours, I randomly removed a 10 bird sample from Line #1 in Plant #1, I found one out the ten birds with visible fecal contamination inside the bird on the left side of the ribs. The fecal material was a piece measuring approximately 1/2" long and 3/8" wide, dark green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance, the protocol for fecal failure was implemented. Quality Control performed a Recheck at approximately 0153 hours and it passed. The cause of the deviation was the ball valve, (valve and metal shower heads targeting saddle cavity area partially closed. valve was weighted down). This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL0318053 816N-1	05/16/2012	01D01	SPS Verification	C	At approximately 1512 hours, while walking through the packaging area I observed the following noncompliance. The 2 drip pans that run the length of the Cut Up line were covered in heavy condensation that was running to the center seam and dripping off of the drip pan. At both ends of the line there are drip pans that go across the line, one end having product on it and the other end crossing over the package sealing machine also had heavy condensation. I immediately informed (b) (6) and (b) (6) of the noncompliance and (b) (6) had sanitation come to wipe down the drip pans, restoring sanitary conditions. My findings indicate a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(d).
5308	M6137	BXL0708050 216N-1	05/16/2012	01B02	Pre-Op SSOP Review and Observation	C	On 05/16/2012 while monitoring the Establishments' Pre-operational Sanitation Procedures in Main Packaging Area, I found the following noncompliance with regulations 9CFR 416.1, 416.4 (a) and 416.13 (c). At approximately 0020 hours, I observed the following: Line #4, four removable metal trays had numerous pieces of fat, one metal tray had numerous pieces of ingesta and the drum dropper had pieces of fat measuring approximately 1" long and 1/2" wide from the previous day production. I immediately attached a U.S. Rejected Tag # B31 406364 to the Line. I notified (b) (6) of the noncompliance. He had Sanitation Personnel wash the entire area. I reinspected Line #4 and found it acceptable. Sanitary conditions were restored at approximately 0030 hours, I then removed the tag from the line. Establishments Pre-operational Sanitation Records showed that Line #4 was inspected and found acceptable by Quality Control Personnel before USDA inspection.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4808052 015N-1	05/15/2012	03J02	Slaughter HACCP	C	On 05/15/2012 while performing a Post-Chill Finished Products Standards Check at the exit of the Chiller #2 in Plant #1, I observed the following noncompliance with regulations 9 CFR 417. 2 (c)(4) and 381.65 (e). At approximately 0344 hours, I randomly select a 10 bird sample, I found one of the ten birds with visible fecal contamination inside the bird on the right leaf fat area by the tail. The fecal material was a piece measuring approximately 1/4 inch diameter in size, dark green in color and pasty in texture. I immediately asked the establishment personnel hanging birds from Chiller # 2 to stop hanging. Since there was no Packaging Supervisor available, I asked a Lead Person to tank the birds coming from Chiller #2. The Lead Person informed (b) (6), I then showed him my findings. I also informed (b) (6) and (b) (6) of the noncompliance. Eight tanks of birds were on hold for rework. Quality Control did a recheck at approximately 0400 hours and it passed.
5308	M6137	BXL4408054 415N-1	05/11/2012	03J02	Slaughter HACCP	C	On 05/12/2012 at approximately 0043 hours while monitoring the Establishments' Post-Chill Finished Products Standards, I observed the following. After taking a random 10 bird sample at the exit from Chiller #2 in Plant #1, I observed one bird with visible fecal contamination. There was a piece of intestine approximately 3" long outside the carcass. The intestine was attached to the carcass inside near the tail. There was fecal material leaking from the cut end of the intestine onto the exterior front side of the breast. The fecal material was medium brown in color, past in texture, and measured approximately 1/4". I contacted (b) (6) who was nearby. Hanging of birds going into packaging was stopped and four tanks of product were placed under QC hold tags pending rework. A recheck passed at 0048 hours. My findings indicated a noncompliance with 9 CFR 381.65(e) and 9 CFR 416.2(c)(4).
5309	P6137A	NJN340505 1211N-1	05/11/2012	01D01	SPS Verification	C	I was in the rack cooler at 2322 hours when I observed the following SPS noncompliance; There is an area of the concrete floor in the rack cooler, approximately 15 feet by 15 feet, in disrepair. There are loose rocks, dirt and "patches" of concrete missing from the floor creating an insanitary condition. This area is located just west of the entrance to the blast tunnel. No USDA reject tag was applied because the condition of the floor represents an SPS noncompliance and no product was involved. It is an SPS noncompliance because the floor is not being maintained in good repair as outlined in Regulation 9 CFR 416.2(b)(1). I notified (b) (6) and (b) (6).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5706055 411N-1	05/10/2012	04A06	Poultry Finished Product Standards	C	While performing directed PHIS procedure Poultry Finished Product Standards, I observed noncompliance with the regulatory requirements of regulation 381.76(b). At approximately 2325 hours, I randomly removed a 10 bird sample from Line (b) (6) in Plant 2 for my Pre-Chill Finished Product Standards test. I accumulated 33 points on the Processing Nonconformance's from the 10 bird sample. This exceeds the limit of 30 points for the Processing Nonconformance's to be in control. I informed (b) (6) (b) (6) of the Processing Nonconformance failure and she immediately performed a recheck. At approximately 2332 hours (b) (6) (b) (6) performed a recheck of the Processing Nonconformance's and it failed with 33 points. I informed (b) (6) (b) (6) of the noncompliance. Quality Control Personnel performed rechecks of the Processing Nonconformance's at the Pre-Chill and Post-Chill. All subsequent rechecks passed bringing the Processing Nonconformance's for Line (b) (6) back into control.
5333	P7632	HYE181105 2009N-1	05/09/2012	01C02	Operational SSOP Review and Observation	C	At 0840 hours on May 09, 2012, while performing an operational sanitation inspection procedure I observed an establishment employee gather up five birds from the floor in front of the chiller exit tables and between the rehang table and the sorting tables. He carried two in one hand and three in the other to the reprocessing station where he put the birds on the "To Be Reprocessed" table which also had other product from the department. Regulatory control of the product was taken with the application of US Retain Tag #B38495104 and (b) (6) (b) (6) was notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above, including 9 CFR 416.4 which states, "Product must be protected from adulteration during processing, handling, storage, loading and unloading at and during transportation from official establishments." This also represents noncompliance with Step #7 of Part II, Section Two of the Establishment's SSOP Plan which states, "(b) (4) (b) (4)." The Product Reconditioning Procedure states in Line 5 under Post-Chilling - Whole Birds, Parts and Paws, "(b) (4) (b) (4)." At 0858 hours regulatory control of the product was relinquished with the acceptance of effective corrective actions to restore sanitary conditions, make appropriate disposition of product and the proposed preventive measure that a department retraining would be performed so that all associates understood the importance of proper sanitary handling of product.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE550605 4009N-1	05/09/2012	01C02	Operational SSOP Review and Observation	C	<p>While conducting Operational SSOP Review & Observation procedure, I observed the following non compliance: In 2nd Processing Department Segment Line #2, approximately 0334 hours, I observed a plant associate dumping an inedible yellow tub container half way filled with product that was staged on the floor underneath the Breast Processors onto an edible brown tote on a cart. I followed him to see what he was going to do with the product, he came to a stop in front of the Chicken Backs bone conveyor and dumped the contents of the brown tote onto moving conveyor. After closer inspection I observed many black specks of (UFM) unidentified foreign material and two wood splinters up to 1/4 inch in length on the product on the conveyor. I took Regulatory Control of the moving conveyor with the application of US Reject tag #B38495114 and the full bin of product with US Retained tag #B38494968. Another empty cardboard bin was set to catch the rest of the contaminated product and I tagged that bin with US Retained tag #B38494999. (b) (6) and Mr. (b) (6) were informed of the non compliance. Regulatory control was released at approximately 0343 after the belt was washed and sanitized to restore sanitary conditions. The product was released to QC for proper disposition to condemn the product and preventive measures were proffered by Mr. (b) (6) to retrain the employee.</p>
5308	M6137	BXL1904050 308N-1	05/08/2012	03J04	Poultry Zero Tolerance Verification	C	<p>While performing a Zero Tolerance Check, I observed noncompliance with the following regulatory requirements of regulation 9 CFR 381.65 (e) and 417.2 (c)(4). On 05/08/2012 at approximately 0123 hours, (b) (6) randomly removed a 10 bird sample from Line #2 in Plant #2, I found one out the ten birds with visible fecal contamination inside of the bird on the left side of the ribs area. The fecal material was two pieces, one approximately 3/16" and the other one 1/16" diameter in size, dark green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a Recheck at approximately 0150 hours and it passed. The cause of the deviation was the bird turner not working properly. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plants' HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2305051009N-1	05/08/2012	01B02	Pre-Op SSOP Review and Observation	C	On 05/08/2012 at approximately 2355 hours while monitoring the Establishments' Preoperational Sanitation Procedures in Packaging Area #1 after Establishment SSOP and HACCP monitors completed there checks and before the start of production, I observed the following. There was a thick layer of white fatty paste along the entire length on the white nylon support brackets associated with the short conveyor belt nearest the dumper in the Plant #2 sorting and sizing line. There were numerous pieces of fat and tissue to 1/4" on two of the stainless chutes that direct birds to a rehang line at the same location. Sanitary conditions were restored by rinsing with potable water per establishment policy by approximately 0005 hours. At approximately 0010 hours I observed numerous pieces of fat and tissue to approximately 3" on two chutes associated with Breast Processor #10. The chutes direct cut product to the collection belts below the machine that deliver the product to the packaging area. The chutes were rinsed with potable water restoring sanitary conditions by approximately 0015 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) , and 9 CFR 416.13(c).
5308	M6137	BXL0813051207N-1	05/07/2012	01B02	Pre-Op SSOP Review and Observation	C	On Monday May 7th 2012, while performing Pre-Operational Sanitation Inspection in Plant 1, I found the following noncompliance: At approximately 0650 hours, while inspecting the Gizzard Harvester Deffater located on line 2, I noticed numerous pieces of ingesta and small pebbles inside of the gizzard Harvester Deffater's cover. According to the establishment's Pre-Operational records, this equipment was inspected and found acceptable by (b) (6) prior to USDA inspection. I placed a U.S.Rejected/Retained tag No. B31 407639 on the affected equipment and then notified (b) (6) . At approximately 0655 hours, while inspecting the Liver tumbler located on line 2, I noticed 1/2" piece of liver inside of the tumbler. This is a product contact surface. According to the establishment's Pre Operational records, this equipment was inspected and found acceptable by (b) (6) prior to USDA inspection. I placed a U.S. Rejected /Retained tag No. B31 407640 on the affected equipment and then notified (b) (6) . My findings indicate a noncompliance with regulatory requirement of regulation 9CFR 416.14 and 9CFR 416.4(a) At approximately 0708 hours, while inspecting the (b) (4) located at the chiller's exit plant 1, I found all the piping system full with pasty fat residue. There was also decaying fat residue inside of the filter located next to the system's pump. I placed a U.S Rejected/Retained tag No. B31 406266 on the affected system. (b) (6) was notified of the noncompliance. My findings indicated a noncompliance with regulatory requirement 9CFR 416.4(a). All affected equipment was properly scrubbed and washed by sanitation. U.S. tags were removed by USDA. Area was released by 0745 after sanitary conditions were restored.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4409051 107N-1	05/07/2012	01B02	Pre-Op SSOP Review and Observation	C	On 5/7/12 at approximately 0655 hours while performing the establishments Preoperational Sanitation Procedure in Plant # 2 , I observed the following in area # 3 . The Rehang Transfer Table on line #4 had a build up of white chicken fat and grease underneath the top side of the belt . The area was approximately 18 " in length and about 3 " wide . I immediately placed RETAINED/REJECTED Tag # B31 406231 on the belt and informed (b) (6) , he had two of his workers scrub and rinse the area . Once the area was clean it was reinspected . At 0703 the table was found to be in sanitary condition and the tag was removed . My findings indicate non compliances with the following regulations CFR 416.1,CFR 416.13(a), 416.13(c), 416.14 and 416.4(a)
5308	M6137	BXL0808052 504N-1	05/04/2012	01B02	Pre-Op SSOP Review and Observation	C	On 05/03/2012 while monitoring the Establishments' Preoperational Sanitation Procedures in Main Packaging, I found the following noncompliance with regulations 9CFR 416.1, 416.4(a) and 416.13 (c). At approximately 2358 hours, I observed the following: Line #1 all the chutes that are associated with the white removable cutting tables that lead to the white conveyor belt, had slimy residue and numerous pieces of fat and meat from the previous day production. These chutes are consider to be product contact surface. I immediately attached a U.S. Rejected Tag # B31 406365 to the Line. I notified (b) (6) and (b) (6) of the noncompliance. They had Sanitation Personel scrub and rinse the chutes. Sanitary conditions were restored at approximately 0012 hours, I then removed my tag.
5309	P6137A	NJN110805 3504N-1	05/04/2012	01C02	Operational SSOP Review and Observation	C	I was performing operational sanitation in the packaging department at 0705 hours when I noted the following noncompliance; I observed a plant employee overspray a stack of product trays, approxiamtely 300 trays, while washing down the hopper for the polar massager. The plant employee was washing down the polar massager to remove the spice mixture and product residue when he oversprayed the stack of uncovered trays. I applied USDA Reject tag B13468938 to the stack of trays at 0707 hours and notified (b) (6) and (b) (6) of the noncompliance. The trays were released at 0750 hours after corrective actions were implemented. No product was involved.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3209053 104N-1	05/03/2012	04A06	Poultry Finished Product Standards	C	On 05/04/2012 at approximately 0515 hours while monitoring the Reprocessing Line ^{(b) (6)} procedures in plant #2, I observed the following. After selecting a random 10 bird sample from the location after the final house inspectors, I found three of the ten birds with visible airsacculitis exudates. One bird had visible airsacculitis exudates measuring approximately 1/2" by 1/2" on the left fat flap. The fat flaps are normally removed as part of the Reprocessing Line process. The other two birds had extensive visible exudates on the left side from the abdominal air sac to the thoracic air sac region. At that point the process is judged to be out of control. As a foreman was not available, I proceeded to the rehang station and found (b) (6). I showed him my findings. Line ^{(b) (6)} was stopped and birds were tanked until a retraining was conducted. A recheck passed at approximately 0527 hours. A partial tank of product was reworked and released by approximately 0557 hours. My findings indicated a noncompliance with 9 CFR 381.76(2) and 9 CFR 381.84.
5308	M6137	BXL1918052 101N-1	05/01/2012	01D01	SPS Verification	C	At approximately 1552 hours, while walking through the Packaging area I observed the following noncompliance. At the Breast Halver machine across from the Bag Fryer line there was a large area of heavy beaded condensation on the drip pan directly above the tank of ice used to ice product as it is put into brown tubs and put on pallets. I immediately had a company employee move the almost full tank of ice and clean the area before the condensation dripped into the ice and contaminated it, restoring sanitary conditions. I then contacted (b) (6) and told him about the condensation and we walked to the area, the employee was still cleaning the area and the tank of ice was returned to it's original position for use. (b) (6) said that he had instructed the employees to keep the area wiped down and that he had turned a fan toward the area to keep the condensation problem down. This is a repetitive noncompliance with 9 CFR 416.1 and 9 CFR 416.2(d).
5309	P6137A	NJN280605 3201N-1	05/01/2012	01C02	Operational SSOP Review and Observation	C	I was verifying operational sanitation conditions in the new product room at the I Q F line # 2 at the start up of operations when I observed the following noncompliance: there were several pieces of fat on the sorting belt from the previous day's productions. The belt is a direct food contact surface. I retained the belt by applying the US reject tag #B39415971 at 2334. I notified the (b) (6) and the (b) (6). The US Reject tag was removed after the sanitary condition was restored at 2339. There was no product involved.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN410505 2001N-1	05/01/2012	04A06	Poultry Finished Product Standards	C	<p>I was performing a FPS (Finished Product Standards) check at 0241 hours on the reprocessing line in the evisceration department when I noted the following noncompliance; The establishment failed to remove airsacculitis exudate from carcasses identified by USDA for air sac removal. (1) carcass of the (10) carcass sample identified for air sac removal with a split tail contained air sac exudate. The establishment's written procedure for air sac removal also states that (b) (4) . During the recheck performed at 0248 hours I noted (1) carcass of the (10) carcass sample identified with a split tail contained air sac exudate. The establishment's written procedure for air sac removal states (b) (4) . I initiated regulatory control by stopping the reprocessing line and immediately informing (b) (6) , and (b) (6) of the noncompliance.</p>
5309	P6137A	NJN370304 3027N-1	04/27/2012	01C02	Operational SSOP Review and Observation	C	<p>On 04/27/2012 I was performing an operational sanitation verification task in the packaging department at 0056 hrs. On the product belt of (b) (4) line #1 there where boneless/skinless thigh fillets in the process of being bulk packed. I found two boneless/skinless thighs on the product belt that contained black specks, one thigh had a black grease smear on the outer surface. I immediately informed (b) (6) and (b) (6) as well as (b) (6) . The immediate corrective actions by the establishment was to stop the production line and wash and sanitize the product belt. The product on the belt, including the product already bulk bagged was put on hold for reprocessing. I applied U.S. Retained Tag #B13468958 to the four stacked tubs of product. The belt was washed sanitized, reinspected and released. After the involved product was reprocessed, I inspected and found it to be acceptable. I then removed the retain tag and gave control of the product back to the establishment.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN381404 3027N-1	04/27/2012	04A06	Poultry Finished Product Standards	C	<p>At approximately 0834 hours while performing PHIS task for Finished Product Standards on the reprocessing line I observed five carcasses of a ten carcass sample with ingesta both in the cavity and in the crop area. I removed the carcasses from the line and showed my findings to (b) (6), and had him notify the QC technician on the floor to (b) (4) as per the plant reprocessing procedure which states (b) (4).</p> <p>(b) (6). The subsequent retest performed at 0845 hours by the QC technician found two carcasses with ingesta. All product was diverted from the line and was sent for further processing by the establishment. At 0855 hours another recheck was performed and at which time the check passed. Production was then allowed to continue as normal. I informed Mr. (b) (6), of the forthcoming non-compliance. 9 CFR 381.91(b)(1) states "Any carcass of poultry accidentally contaminated during slaughter with digestive tract contents shall not be condemned if promptly reprocessed under the supervision of an inspector and thereafter found not to be adulterated. Contaminated surfaces that are cut shall be removed only by trimming. Contaminated surfaces that are not cut may be cleaned by trimming alone, or at an approved reprocessing station away from the main processing line, by any method that will remove the contamination, such as vacuuming, washing, and trimming, singly or in combination. All visible specks of contamination must be removed, and if the inner surfaces are reprocessed other than solely by trimming, all surfaces of the carcass shall be treated with chlorinated water containing (b) (4).</p>
5333	P7632	HYE021604 2327N-1	04/27/2012	04A06	Poultry Finished Product Standards	C	<p>At 1316 hours after observing that a high percentage of birds presented for post-mortem inspection were being hung back on the Reprocessing Line for pathology and that the plant had initiated their alternative On-Line Vacuuming/Air Sac Removal procedure, I elected to verify the effectiveness of the alternative procedure. I went to the FPS Pre-Chill Station on Evisceration Line I and collected a ten-bird sample which had been vacuummed in the alternative procedure. I observed airsacculitis exudate adhering to the leaf fat, renal areas and thoracic cavities of six of the ten birds in the sample. I notified (b) (6) of my findings and at 1321 hours I performed the required retest and observed airsacculitis exudate adhering to the leaf fat, renal areas and thoracic cavities of two of the ten birds in the sample. I notified (b) (6) of the forthcoming documentation of the failure to comply with the regulatory requirements cited above.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2809045 626N-1	04/26/2012	06D02	Other Inspection Requirements	C	<p>On 04/26/2012 at approximately 0523 hours, I performed a presentation check on Line ^{(b) (6)}, station #3 failed with 3 not reflected at line speed ^{(b) (6)} BPM. At approximately 0603 hours QC performed a recheck at line speed ^{(b) (6)} BPM and station #1 failed with 3 membrane, 3 not reflected, 1 viscera on shackle, 2 viscera not free, total of 40 points. Station #2 failed with 3 viscera on shackle, total of 24 points and station #3 failed with 3 viscera on shackle, 1 not reflected, total of 26 points. This exceeded the limit of 3 occurrences of one error and the 25 nonconformances for the process to be in control. (b) (6) was informed and the Line speed was reduce to 81 BPM. At approximately 0617 hours QC performed a recheck and failed. The Line speed was reduced to 70 BPM. At approximately 0633 hours the rechecks passed bringing the process back in control. At approximately 0611 hours, I performed a presentation check on Line ^{(b) (6)}, station #1 failed with 3 viscera on shackle, 2 not reflected, total of 28 points. Station #2 failed with 2 viscera not uniformed, 2 viscera on shackle, 3 not reflected, total of 38 points. At approximately 0628 hours QC performed a recheck at Line speed of ^{(b) (6)} BPM and station # 2 failed with 2 viscera not uniform, 3 viscera on shackle, total 40 points. Station #3 with 3 viscera on shackle, total of 24 points. This exceed the limit of 3 occurrences of one error and the 25 nonconformances for the process to be in control. (b) (6) was informed and the Line speed was reduced to 81 BPM. (b) (6) informed me at approximately 0635 hours that for the rest of the shift the Line speed will stay at 81 BPM. This is a noncompliance with regulation 9CFR 381.76 (b).</p>
5308	M6137	BXL3905043 127N-1	04/26/2012	01D01	SPS Verification	C	<p>On 04/26/2012 at approximately 2200 hours while monitoring Facilities, I observed the following. I entered the Plant #2 Dressing Room/Lavatories and on the stainless partitions used by both Packaging and Slaughter employees to hang their aprons while on break there were numerous pieces of dried and semi-dried fat and tissue, and a layer of greasy fat covering must of the surface of the partitions. The bottom lip of the partition acts as a catch tray for filth and had a layer of black/brown (UFM), and dried and decaying tissue at least 1/8" thick. There were raisins on a bench located near the wall indicating that food might be consumed at this location. The floor in the hand wash sink area was covered with large patches of liquified and semi-dried brown greasy filth. The toilet/urinal area floor was covered with the same greasy brown (UFM) as well as a layer of black (UFM) that appeared to be coming from the toilets. Several of the toilets were covered with the same black (UFM). I contacted (b) (6) after Preoperational Sanitation was completed and showed him my findings. He said that the restrooms are cleaned with soap only on Mondays. Two sanitation workers cleaned the restroom for approximately 30 minutes until (b) (6) was satisfied. He said a more though cleaning would be performed on 04/27. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(h)(1).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN200704 5526N-1	04/26/2012	01C01	Operational SSOP Record Review	C	I was verifying operational sanitary conditions in the evisceration department at the start up of operations when I noted the following noncompliance; two of the brown salvage tubs used to chill and store the salvaged product had fat and meat particles on them from the previous days production. I noted one tub on "B" line at 2318 hours and one tub on "A" line 2320 hours. The tubs were staged for use at the salvage stations and had ice in them. The brown tubs are a direct product contact surface area. I notified (b) (6) and (b) (6) of the noncompliance. No USDA tag was applied because the establishment implemented immediate corrective actions and no product was involved.
5333	P7632	HYE001604 3126N-1	04/26/2012	04A06	Poultry Finished Product Standards	C	At 0948 hours after observing that a high percentage of birds presented for post-mortem inspection were being hung back on the Reprocessing Line for pathology and that the plant had initiated their alternative On-Line Vacuuming/Air Sac Removal procedure, I elected to verify the effectiveness of the alternative procedure. I went to the FPS Pre-Chill Station on Evisceration Line I and collected a ten-bird sample of birds which had been vacuummed in the alternative procedure. In the thoracic cavities of the third and eighth birds I observed affected lung tissue with hemorrhagic lesions adhering to the ribcage. At 0956 hours, I performed the required retest and observed affected lung tissue adhering to the ribcage in the thoracic cavity of the sixth bird. I notified (b) (6) of the forthcoming documentation of the failure to comply with the regulatory requirements cited above.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0605040 826N-1	04/25/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 04/26/2012 at approximately 0005 hours while monitoring the establishments' Preoperational Sanitation Procedures, I observed the following. In Packaging area #1, there were several pieces of fat and tissue to approximately 2" on a sprocket associated with the overhead belt that transfers product from the (b) (4) Deboning Room to Packaging Area #1. The sprocket was at a location at the beginning of a belt located near the elevator. The tissue gave off a strong sour odor. There were numerous black specks of (UFM) dried on a white cutting wheel associated with Line (b) (4) at a point on the Plant #1 Halving Machine where the front halves (Breast & Wings) are dropped. There were numerous pieces of fat and tissue to approximately 1/4" on the stainless and white support brackets associated with the collection belt for line (b) (4) also at the plant #1 Halving Machine. There was a layer of yellowed product dried in an area measuring approximately 2' by 6" on the line (b) (4) top catch tray associated with the plant #1 Halving Machine. There were numerous pieces of fat and tissue to approximately 2" on the white cutting wheel, stainless cutting blade and other parts associated with Line (b) (4) at the plant #1 Halving Machine. The area of Line (b) (4) adjacent to the Plant #1 Halving Machine, approximately 40', had numerous pieces of fat and tissue to approximately 4" on the rail and rail supports, chain, shackles, and drip pan. Sanitary conditions were restored by approximately 0020 hours by rinsing the area with potable water per establishment policy. In Packaging Area #2, there were approximately 10 pieces of white paint to approximately 1/4" on a product belt near line #1. The belt collects carcasses from all four lines. The carcasses are ground (MDP) and used for further processed products. Sanitary conditions were restored by approximately 0030 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2213041 824N-1	04/24/2012	04A06	Poultry Finished Product Standards	C	On 04/23/2012 at approximately 0905 hours in Plant #2, I found the following noncompliance, while performing a Finished Product Standards check at Gib Chiller #3. After randomly selecting a sample of 10 necks exiting the Gib Chiller I found a total of 6 major nonconformance points which exceeds the absolute limit of 5 major nonconformance points for necks. I immediately notified QC of the noncompliance, QC then put a hold tag on the tank of necks while she proceeded to do a recheck of the necks. QC failed her recheck of the necks with 6 major nonconformance points at 0925 hours, which exceeds the tightened criteria for necks of 3 major nonconformance points. At that point the process is considered to be out of control. QC proceeded to have the tank of necks that had been placed on hold condemned and they were dumped at approximately 0930 hours. QC did a recheck on the new tank at approximately 1011 hours which passed with 2 major nonconformance points and another recheck at approximately 1101 hours, which also passed with 2 major nonconformance points. A new second tank was then put in place and QC did a third recheck on the second tank at approximately 1120 hours, which also passed with 2 major nonconformance points, bringing the process back in control. The hold tags were removed from the tanks at that point, allowing product to proceed back into production. My findings indicate a noncompliance with 9 CFR 381.76(b).
5308	M6137	BXL0416042 323N-1	04/23/2012	04A06	Poultry Finished Product Standards	C	At approximately 0930 hours, while monitoring the establishment's Pre-Chill Finish Product Standard in Plant #1, I found the following noncompliance. After randomly removing a 10 bird sample from line 2, I documented a total of 36 weighted nonconformance points under processing category. This exceeded the subgroup absolute limit (30) for the process to be under control. I immediately informed QC, who did a recheck at approximately 0937 hours to verify sample validity. She failed the recheck with with a total of 29 weighted nonconformance points. This exceeded the tolerance (25) allowed for the recheck. At that point the process is considered out of control. I informed (b) (6) of the noncompliance so that corrective action could be taken. By approximately 1020 hours, QC had performed two consecutive passing Pre-Chill checks on line 2 bringing the process back in control at the pre chill area. QC performed Post-Chill rechecks every half hour starting at 1035 hours to 1145 hours. The Pre-Chill criteria for the processing category was applied to the Post-Chill rechecks. All Post-Chill checks passed. Product was deemed to be acceptable for shipping.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1519040 723N-1	04/23/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 1558 hours, while performing a Pre-Chill Finish Product Standard check on line 2 plant 1, I found one out of the 10 birds contaminated with feces. The Fecal matter was inside of the bird cavity on the right side of the rail area. The feces were light yellow in color and pasty in texture measuring approximately 1/8" in diameter. I immediately notified (b) (6) of the noncompliance. She took immediate corrective action by ensuring proper implementation of the establishment's zero tolerance fecal protocol. Venter was found to be the cause of deviation. Quality control performed a passing recheck at approximately 1622 hours bringing CCP2B back into control. Post-Chill checks were performed from 1641 hours to 1742 hours. All product was found acceptable for shipping.
5308	M6137	BXL2512045 223N-1	04/23/2012	01C02	Operational SSOP Review and Observation	C	On 4/21 while monitoring the Establishments Operational Sanitation Procedure at approximately 0523 in Plant # 1 I observed the following . The tray underneath the chiller rehang belt was full of birds which caused birds to fall on the floor there were also birds laying on the metal stands , there were approximately 15-20 birds on the floor . workers were stepping on some birds while trying to maneuver their way around others . I immediately contacted a supervisor . (b) (6) was close , so the situation was brought to his attention . The foreman was notified . (b) (6) had the birds cleared off the stands and the tray beneath the rehang table cleared also . Putting the establishment back in compliance at approximately 0546 . The SSOP plan states that (b) (4) . My findings indicate non compliances with the following regulations CFR 416.13(b) CFR 416.14 and CFR 416.1 .
5309	P6137A	NJN170204 2923N-1	04/23/2012	01C01	Operational SSOP Record Review	C	On April 21, 2012 I was in the New Products Room at 1737 hours reviewing SSOP records for (b) (4) production when I noted that the SSOP records (The General Sanitation Log and the Daily Implementation and Monitoring Log for the Daily Production) had both been verified, pre-signed and dated by the supervisor prior to the end of production. Production did not finish until 1921 hours. I informed (b) (6) of the non compliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN261604 5123N-1	04/23/2012	04A06	Poultry Finished Product Standards	C	While performing PHIS task Finish Product standards I performed a verification inspection procedure of the establishment's "(b) (4)" program in the evisceration department at 1126 hours when I observed a rack of birds staged for inspection prior to being put back on the line. The rack did not have the "Production Hold" tag applied, thus indicating the carcasses were ready to be introduced back into production. I examined the carcasses and noted one carcass with cellulitis affected tissue. I applied US Retained Tag # B4019355 to the rack. I informed (b) (6) and QC technician on the floor of my findings and the Forthcoming noncompliance. At 1130 hours I removed the tag so the establishment could initiate corrective actions. The requirements of 9 CFR 381.86 and the establishment's cellulitis SOP program were not met. 9 CFR 381.86 states; "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned. The establishment's cellulitis SOP program Part 2(h), sub section (b) states;" "(b) (4)"
5333	P7632	HYE320704 3323N-1	04/23/2012	04A06	Poultry Finished Product Standards	C	I was in the First Processing department conducting a Poultry Finished Product verification task on the reprocessing line at approximately 0447 hours when I observed the following non compliance: I selected ten birds marked with a split tail for air sac reprocessing, two of the ten carcass sample had large amounts of yellow air sac exudate inside the cavity along the rib cage of the carcasses. I took regulatory control of the reprocessing line with th appilcation of U.S. retain tag B 38495130 and informed (b) (6), of my findings and the forthcoming noncompliance. (b) (6) performed the recheck and passed. Regulatory control was relinquished at 0453 hours.
5333	P7632	HYE231004 1221N-1	04/21/2012	01C02	Operational SSOP Review and Observation	C	At approximately 0725 hours. I performed an unscheduled Operational Sanitation. The following non compliance was observed in 2nd processing, on equipment not in use; the blue incline conveyor located on the south wall in packaging department used to move backs into bins, had a build up of fat and residue from the previous shifts production. U.S. rejected tag #B38494992 was applied. Mr. (b) (6) was informed of my findings and of the forth coming non-compliance. At 0820 regulatory control was released to Quality Control. QC hold tags were placed on conveyor until such time that conveyor can be properly cleaned. Regulation 416.4(a)states; Sanitary operations. All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5704040221N-1	04/20/2012	01C02	Operational SSOP Review and Observation	C	On 04/21/2012 at approximately 0140 hours while monitoring Facilities, I observed the following. There is rust developing on the exterior surfaces of chiller #4 at the outflow end, on the underside of the catch tray that directs product from the Finishing Chiller for Chiller #4 to the rehang belt, on the exterior support brackets of the rehang belt from Chiller #4, on the exterior surfaces of the Finishing Chillers for Chiller #4 & #3, and on the support brackets of the outflow conveyor from Chiller #3. There was a small puddle of light yellow fluid on a bracket associated with the outflow conveyor for Chiller #3. The fluid was pooling and dripping onto the conveyor belt directly below which moves product from the rehang belt for Chiller #4 to a cutup line in Packaging. I contacted (b) (6) and showed him my findings. A plastic sheet was placed directing the light yellow fluids on Exit Chiller #3 conveyor belt to the floor. My findings indicated a noncompliance with 9 CFR 416.4(d) and 9 CFR 416.3(a).
5333	P7632	HYE0104045020N-1	04/20/2012	01C02	Operational SSOP Review and Observation	O	<p>While in the Rack cooler at 2102 hours, I was performing the PHIS task review and observation of Operational SSOP when I observed the following noncompliance: there was one pallet of Rotisserie Chicken Marinade mix not in the spice cage and without a Q.C. hold tag. I inspected the pallet and found one bag opened and half used with an unknown liquid pooled in the creases of the crumpled up package. (b) (6), was informed of the noncompliance and proffered that the product would be retained in the spice cage. I reviewed the establishment's SSOP plan and it states Part 2 Operational Sanitation Section 4 Dry Storage Step # 4 : (b) (4)</p> <p>(b) (6) I went to the Weigh and Price department's office and informed (b) (6), of the noncompliance. (b) (6) was also notified and he retained the open bag. The establishment's corrective action was discarding the open bag of Chicken Marinade. In response to the SSOP operational sanitation noncompliance, dated 4-20-12, in the Rack cooler I reviewed the establishment's SSOP records to verify compliance with the regulatory requirements for record keeping. I noted that upon USDA request the establishment did not have records of documenting corrective actions or preventive measures for the noncompliance dated 4-20-12. I notified Mr. (b) (6) of the record keeping noncompliance. In response to the establishment's appeal dated 4/25/12 I have agreed with the establishment that the applicable requirement in the SSOP Section 4 Step #3 which states "(b) (4)." The SSOP was implemented but it did not prevent the unknown liquid from being present on the opened spice bag. This represents noncompliance with 9CFR 416.4 (d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3816040 319N-1	04/19/2012	01C02	Operational SSOP Review and Observation	C	On 04/17/2012 at approximately 1458 hours while monitoring the Establishments' Operational Sanitation Procedures in Packaging, I observed the following. There were numerous black specks of foreign material to approximately 1/8" in size on several birds on the top layer of a partially filled bin with blue plastic liner at the #258 Drop for whole birds. Most of the black specks were on the skin of the breast, back and legs. I attached USDA Retain Tag #B31406218 to the bin and contacted (b) (6) to inform him of my findings. He immediately took corrective action and had the bin of birds reworked, which restored sanitary conditions. I released the bin back to production at approximately 1545 hours after rechecking the birds and finding them acceptable. My findings indicate a noncompliance with 9 CFR 416.4(d).
5308	M6137	BXL0805044 618N-1	04/18/2012	03C02	Raw Intact HACCP	C	On 04/17/2012 at approximately 0040 hours while monitoring the Establishments' Operational Sanitation Procedures in Packaging Area #1, I observed the following. After checking a few of the birds coming out of the Chillers from Plant #2 and finding nothing, I proceeded to the end of Packaging Line (b) (4) where Organic birds were beginning to be wrapped. I checked approximately 15 birds at random and found one of the birds with a piece of shiny metal. Using a ruler from the establishments' nearby office the metal shard measured approximately 8mm by 1mm. The metal shard was located on the breast near the right wing. I contacted (b) (6) and showed him my findings (b) (6) was called. According to FDA guidance metal in a food product in excess of 7mm is considered to be a health hazard. The 8mm metal shard that I observed exceeded that limit. I reviewed the Establishments' Hazard Analysis-Raw Not Ground-Packaging at Step 8 'Packaging' under 'Potential Hazard Introduced, Controlled or Reduced at this step' the plan list (b) (4). My findings indicated a noncompliance with 9 CFR 417.2(a)(1).
5308	M6137	BXL0904043 119N-1	04/18/2012	01D01	SPS Verification	C	On 04/18/12 at approximately 2325 hours while monitoring the Establishments' Facilities, I observed the following. There were numerous specks of black and brown (UFM) to approximately 1/4" with the consistency of rust on the tops of several pallets of brown product tubs in the Plant #2 aged breast cooler. The product with the heaviest concentration of UFM was under the first overhead compressor by the door. I contacted (b) (6) and showed him my findings. The lids on approximately 20 tubs were replaced. Two gray containers used for salvaged parts were covered with the UFM. The containers were taken to the tub wash room. The plastic bags covering bulk wrapped wing sections in a gray product basket was rinsed. Sanitary conditions were restored by approximately 2335 hours.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5202041 718N-1	04/18/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 4/17 at approximately 2336 hours I observed the following while performing the Preoperational Sanitation Procedure task in Plant # 1 . In the Paw Room the bottom side of the flex belt that carries product to the Condemn Room had a thick layer of fat and grease covering a 4'- 5' span of the middle section of the belt . I immediately placed US Retained/Rejected tag # B-31406342 and contacted (b) (6) . (b) (6) had two of his workers rewash and rinse the belt . The belt was then reinspected. Once sanitary conditions were restored the tag was removed . At approximately 2243 the establishment was back in compliance . At 2245 hours the Auto transfer Tables on line 1 and 2 were inspected. The table one line 1 was unacceptable . The Belly Pan on the bottom side of the table had a thin layer of grease from the previous days production , my findings were the same on the conveyor on line # 2 . I once again contacted (b) (6) . (b) (6) had one of his workers clean the inside of the Belly Pan , the lines were reinspected after they were cleaned , restoring sanitary conditions at approximately 2249 . At 2254 Chiller # 1 was inspected , it was also dirty there was a yellowish film on the outer edge of one of the paddles which was approximately 3 " by 5" in size . (b) (6) was notified at once . (b) (6) had the outer edge of the paddle scrubbed and wiped clean sanitary conditions were restored at approximately 2306 and the establishment was ready for production . PACKAGING PLANT # 1 At approximately 0010 hours the leg processors were inspected . The yellow wiring on the processors had a build-up of mold and black scum . I immediately informed (b) (6) of my findings . (b) (6) had the wires scrubbed and rinsed. At approximately 0015 sanitary conditions were restored . The (b) (4) Room was inspected at approximately 0020 . In the (b) (4) Room there were pieces of meat from the previous shifts production on the Wing Transfer Conveyor on line # (b) (6) was notified of the noncompliance (b) (6) had the conveyors rewash and rinsed , putting the company back in compliance . At 0027 the (b) (4) Wing Conveyors were inspected . There were pieces of fat and bone between the plastic guide bars under the belt . I immediately placed US RETAINED/REJECTED tag # B-34106341 on the conveyor and contacted (b) (6) . (b) (6) had the belt rewash and rinsed . At approximately 0035 sanitary conditions were restored and the area was ready for production .My findings indicate non compliances with the following regulations 9CFR 416.14,9 CFR 416.4(b), 9 CFR 416.4(a), 9CFR 416 , and 9CFR 416.13(c) .</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN140804 3418N-1	04/18/2012	01C01	Operational SSOP Record Review	C	<p>I was in the evisceration department verifying operational sanitation at 0415 hours when I observed the following noncompliance: I noted the north end of the evisceration department was full of steam and there was an offensive odor. I also noted there was an excessive amount of condensation on the overhead pipes. The pipes above the paw chiller had beaded condensation that was dripping into the paw chiller. The fan located above the south end of the paw chiller was covered with beaded condensation and was spitting droplets of condensation into the chiller, and onto the product conveyor located beneath it. The overhead pipes above the auto rehanger had beaded dripping condensation located directly above the product conveyors and evisceration lines. I applied USDA retain tag to the evisceration department at 0416 hours and notified (b) (6) and (b) (6) of the noncompliance. After corrective actions the auto rehang area was released at 0440 hours. The paw chiller and product conveyors were released at 0600 hours. The affected product was released the following day after corrective actions were implemented by the establishment. In response to the SSOP operational sanitation noncompliance, dated 4-18-12, in the evisceration department I reviewed the establishment's SSOP records the following day to verify compliance with the regulatory requirements for record keeping. As part of my SSOP records review I noted the establishment had identified a record keeping error for the SSOP failure which occurred on 4/18/2012, and that the records had been signed off as acceptable at the end of the shift by the authorized establishment employee. The establishment did not have records documenting corrective actions or preventive measures for the two record keeping errors as required by 9 CFR 416.16. I notified Ms. (b) (6) of the record keeping noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE2016043017N-1	04/17/2012	01C02	Operational SSOP Review and Observation	C	<p>At 1218 hours on April 17, 2012, while performing a Finished Products Standards Post Chill procedure at the South CHiller exit, I observed that the chiller rehang table was backed up with birds. I observed that the catch-basket designed to prevent product overflow beneath the incline belt feeding the rehang table was full and overflowing. I went to the north side of the rehang table and observed 28 birds on the floor around the catch-basket. In less than ten seconds I observed 8 more birds fall from the table to the floor before I observed a plant employees pick up two birds from the floor. I observed no one taking any effective measures to regain control of the process to stop birds from falling to the floor. Regulatory control of the rehang table was taken with the application of US Reject Tag B38 494936 and (b) (6) was noified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above. While observing production pick up the birds around the catch-basket, I observed a plant associate use a long wire hook to drag birds across the the floor and the water flowing across it and place them into a pile on the floor next to the reprocessing cart. Regulatory control of this product was taken and Ms. (b) (6) was notified of the forthcoming documentation of the failure to comply with the regualtory requirements cited above including Line 7 of the establishment's Reprocessing Procedures, which state that (b) (4) . The affected product was released to QC and taken to reprocessing for reconditioning. Regulatory control was relinquished at 1226 hours with the acceptance of effective corrective actions to restore sanitary conditions, appropriate disposition of product and the following proposed preventive measures: The product overflow reaching the floor was attributed to staffing issues and in the future when there are such staffing issues, additional combo bins will be staged in the department to better enable effective product flow management. The employee dragging product across the floor will received additional training on the importance of handling product to be reconditioned in a more sanitary manner. NR HYE02316045403N documents a similar noncompliance on 04/03/2012 where product backing up on the rehang belt led to product pile-up on the floor and no effective measures being taken to stop more product from falling. The preventive measure of training of a supervisor monitoring the area during surges until other modifications could be made did not prevent product pile-ups at the rehang table from recurring.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3819040 016N-1	04/16/2012	04A06	Poultry Finished Product Standards	C	At approximately 1603 hours, while monitoring the establishment's Pre-Chill Finished Products Standards in Plant #2, I found the following noncompliance. After randomly selecting a 10 bird sample from Line #9, I documented a total of 55 weighted nonconformance points under processing. This exceeds the subgroup absolute limit (30) for the process to be in control. I immediately informed QC, who did a recheck at approximately 1611 hours to verify sample validity and documented a total of 31 weighted nonconformance points. This exceeds the tolerance (25) allowed for the recheck and at that point the process is considered out of control. I informed (b) (6) and (b) (6) of the noncompliance so that corrective actions could be taken. QC then did a Post Chill recheck at 1623 hours which passed with 14 nonconformance points and proceeded to do another Pre-Chill recheck at 1629 hours which passed with 15 nonconformance points and again at 1638 which passed with 8 nonconformance points. QC performed subsequent Post Chill rechecks every half hour starting at 1713 hours to 1823 hours, which all passed. The Pre-Chill criteria for the processing category was applied to the Post Chill rechecks, bringing the process back into control.
5308	M6137	BXL4120042 516N-1	04/16/2012	01C02	Operational SSOP Review and Observation	C	At approximately 0936 hours while performing Post-Chill Finished Product Standards, I observed the following noncompliance with regulations 9CFR 416.4 (d). I found numerous birds with UFM (unidentified foreign material) which was a black grease like substance on the membrane and on the skin of the carcasses at the end of Chiller #1. At approximately 0940 hours, I took regulatory control action by retaining all the product that were coming out of the chiller. I placed a U.S. Rejected/Retained Tag # B31 405423, B31 406255, B37 946300, B39 505562, B39 505563, B39 505564, B39 505580, B39 506275, B39 506276, B39 506277 on the tanks, 10 in total. At approximately 0950 hours SCS (b) (7)(C) inspected the birds coming out of the Chiller #2 and he found UFM on the birds also, he then began retaining all the product. QC personnel placed Red Hold Tags on the tanks, 9 in total. At approximately 1020 hours SCS (b) (7)(C) inspected the birds on Chiller # 2 and it passed. At approximately 1025, I inspected the birds on Chiller #1 and it passed. I informed (b) (6) about the noncompliance. At approximately 1100 hours (b) (6) discussed with SCS (b) (7)(C) about what reprocessing methods they going to use for the adulterated product. At approximately 1230 hours (b) (6) contacted me and I went to the tank cooler in Plant #1 and released the product to QC. QC placed a Red Hold Tags on the 10 tanks that were tagged with U.S. Rejected/Retained Tags.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5005045 117N-1	04/16/2012	01C02	Operational SSOP Review and Observation	C	On 04/17/2012 at approximately 0040 hours while monitoring the Establishments' Operational Sanitation Procedures in Packaging Area #1, I observed the following. After checking a few of the first birds coming out of the Chillers from Plant #2 and finding nothing, I proceeded to the end of Packaging Line (b) (4) where Organic birds were beginning to be wrapped. I checked approximately 15 birds at random and found 6 with numerous specks of black (UFM) to approximately 1/8" on the skin and tissue in the area of the neck. Several of the other birds had only a few specks which I removed. On one of the birds there was also a flat piece of gray material measuring approximately 3/4" by 1/2" that crumbled like paint. The gray material was located between the skin and tissue in the neck area. I contacted (b) (6) and showed him my findings. (b) (6) was called. As the blacks specks were no longer present only the first rack of product was retained under a QC hold tag pending rework. My findings indicated on noncompliance with 9 CFR 416.4(d).
5308	M6137	BXL5918045 916N-1	04/16/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1045 hours, I observed the following noncompliance at the gib chiller exits in plant 2. There was foreign material inside of the brown tubs and lids being utilized for hearts, livers and gizzards. These utensils are a product contact surface that at this point was adulterating the gibs coming out of the chillers. The foreign material looked like black, silver and gray specks measuring approximately 1/16" to 1/8" in diameter. I immediately placed the affected product on hold by issuing a Reject/Retained tag NO: B31 406377 on 16 tubs full of gibs. I then, proceeded to inspect the rest of the tubs and lids located near by, finding them contaminated with the same type of foreign material. I immediately place a U.S. rejected/Retained tag NO: B31 406378 and B31 406376 on the affected containers. I then notified (b) (6) of the nocompliance. At approximately 1105 hours, Inspector (b) (7)(C) and I decided to go to the Second Processing area to monitor the brown tubs/lids being utilized throughout the area. At approximately 1110 hours, at the halver machine located near the bag fryer line, I found a dolly holding a stack of lids that were also affected with black, silver and gray specks. I immediately placed U.S. Rejected/Retained tag NO: B31 406270 on the affected lids. I then, notified (b) (6) of the noncompliance. At approximately 1115 hours, at the wing line, Inspector (b) (7)(C) found a stack of brown tubs also affected with the same type of foreign material. She place the edible containers on hold by issuing a U.S. Rejected/Retained tag No: B31 406214. She notified (b) (6) of the noncompliance. All contaminated tubs and lids were taken to the tub wash room, where they were washed and released by USDA. 16 tubs full with gibs contaminated with foreign material, were condemned in my presence. USDA tag was removed by me after sanitary condition were restored. Cleaned tubs were assigned at the gib chillers exit. My findings indicate a noncompliance with regulation 9CFR 416.4(a) and 9CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1005040 814N-1	04/13/2012	01B02	Pre-Op SSOP Review and Observation	C	On 04/14/2012 at approximately 0010 hours while monitoring the Establishments' Preoperational Sanitation Procedures in Packaging Area #1, I observed the following. There was a thick layer of dried fat and tissue approximately 1/8" thick and several inches high on approximately a 40 foot section of the stainless steel portion of an overhead conveyor belt that transfers breast fillets from the deboning room to the packaging room at a location adjacent to the Crust Tunnel door. The dried tissue was at a point where product on the belt contacts the stainless steel. There was also a large amount of tissue directly on the product contact surface of the belt and in the sprocket area associated with the same overhead product belt at a location near the elevator. At approximately 0030 hours after releasing the majority of Packaging Area #1, a supervisor started removing the stainless carts and gray product baskets stored in the bulk side of the Crust Tunnel. The carts and baskets are used in packaging to hold finished wrapped product. The stainless carts (18) were covered with a thick layer of fat and tissue to approximately 3". A rack of empty baskets also had numerous pieces of fat to 3". Sanitary conditions were restored by approximately 0040 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.13(c), and 9 CFR 416.14.
5308	M6137	BXL3220045 013N-1	04/13/2012	01C02	Operational SSOP Review and Observation	C	While performing a routine Operational Sanitation verification check in the Packaging area, I observed a noncompliance with regulatory requirement of regulation 9CFR 416.4 (d). Product falling on drip pans is considered to be adulterated and have to be recondition according to the establishments SSOP program. Drip pans are a non food contact surface. At approximately 1800 hours, while standing at the bag fryer's line and looking at the halvers equipment located near by, I observed a sanitation employee walking on top of the halver's drip pan. He was picking up front halves from the drip pan and tossing them into the shoot that leads the product into brown edible tubs. There was a couple of employees underneath the drip pan, one of them was shoveling ice on the tubs full product and the other employee was stacking them on a wood pallet. The sanitation employee came down from the drip pan after he was done picking up all the product. When they were ready to take the product into the cooler. I stopped the employee and placed a U.S. Rejected/Retained tag N0. B31 406118 on the contaminated product. There was a total of 10 tubs. I then notified (b) (6) of the noncompliance. All the affected product was washed with chlorinated water. USDA tag was removed by me, after sanitary conditions were restored.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN150704 4013N-1	04/13/2012	04C05	Poultry Good Commercial Practices	C	At 0305 hrs on 04/13/12 Inspector Jesse Ruiz called me to station 3 on B line to examine a bird he had hung back on the USDA rack. I diagnosed it as a DOA based on the following signs: 1. Carcass purple in color. 2. Lungs completely congested, blackish color, friable. 3. General congestion in viscera, decomposition of kidneys. 4. Decomposition of breast muscle tissue. 5. Foul odor. This is a violation of regulation 9CFR 381.71(a). I immediately informed (b) (6) of the forthcoming NR.
5308	M6137	BXL1218043 812N-1	04/12/2012	04A06	Poultry Finished Product Standards	C	While performing procedure 04C04 (On-line Reprocessing Procedures), I observed noncompliance with the following regulatory requirements of regulation 381.84 "Airsacculitis" which states in part "Less affected carcasses may be passed for food after complete removal and condemnation of all affected tissue including exudate". At approximately 1325hrs I removed a 10 bird sample of split-tail birds (marking for vacuum of airsacculitis) from Line (b) (6) in Plant 2. I found three of ten birds with airsacculitis exudates inside the birds. I informed (b) (6) of the noncompliance. She immediately suspended the on-line reprocessing and counseled plant personnel. I performed a recheck at approximately 1343hrs and found two of ten birds with airsacculitis exudates inside the birds. (b) (6) informed me that she would retain all split-tail birds after the final trim station. At approximately 1408hrs I performed a recheck and found the process back in control. The retained birds were reworked and at approximately 1415hrs I rechecked them and released them. All birds affected with exudates were reworked on the reprocessing line.
5308	M6137	BXL5714040 912N-1	04/12/2012	01C02	Operational SSOP Review and Observation	C	On 04/12/2012 at approximately 1105 hours Dr. (b) (7)(C) observed a noncompliance. I was walking from evisceration in Plant #2 through Packaging at approximately 1107 hours when Dr. (b) (7)(C) informed me about the noncompliance. We observed numerous beads of condensation formed on the bottom of the drip pans which are directly over the conveyors belts at the end of the Chiller #3 and Chiller #4. The conveyors belts are used to transfer product from the Chillers to the grading tables and line (b) (6), line (b) (6) to packaging for cut up. The condensation was dripping directly onto the product on line (b) (6). We immediately took regulatory control action by informing (b) (6) (b) (6) immediately stopped the line. He had company personnel wipe the condensation from the drip pans, he washed the conveyor belts and tanked the adulterated product. I attached a U.S. Retained/Rejected Tag # B31 407548 to the tank. Dr. (b) (7)(C) informed (b) (6) and I informed (b) (6) about the noncompliance. The adulterated product was reworked. SCS (b) (7) at approximately 1230 hours when company personnel finished the rework of the product removed the tag. This is a noncompliance with regulations 9CFR 416.2 (d) and 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN080804 5612N-1	04/12/2012	01B02	Pre-Op SSOP Review and Observation	C	I was performing the hands on observation component of a pre-operational sanitation inspection procedure in the evisceration department at 2230 hrs after the QC technicians had performed their preoperational sanitation inspection and released the area for production when I observed the following noncompliance; I observed a build-up of fat and feathers from the previous days production's on the fingers of the paw scalders. I applied U.S. Retain Tag # B39415972 to the Paws scalders at 2240 hrs and notified the (b) (6) of the noncompliance. After sanitary condition was restored the area was released at 2255 hrs.
5309	P6137A	NJN390504 5212N-1	04/12/2012	04A06	Poultry Finished Product Standards	C	On April 12, 2012, I performed a verification inspection procedure of the establishment's (b) (4) " program in the evisceration department at 0150 hours when I observed a rack of 10 birds staged at the viscera removal station just prior to the cropper machine. The rack did not have the "Production Hold" tag applied, thus indicating the carcasses were ready to be introduced back into production. I examined the ten carcasses and noted one carcass with cellulitis affected tissue. Part 2(h), sub section (b) of the cellulitis program states: (b) (4) . I notified (b) (6) and (b) (6) of the non compliance.
5308	M6137	BXL1501044 811N-1	04/11/2012	01B02	Pre-Op SSOP Review and Observation	C	On 4/10/12 at approximately 2248 hours I observed the following While performing the establishments Preoperational Sanitation Procedure in Plant #2 . while inspecting the middle portion of Chiller # 3 . The paddles along the outer edge of the cat walk had a thick layer of chicken grease which appeared to be from the previous shift. I immediately notified (b) (6) of my findings (b) (6) had the paddles cleaned , putting the establishment back in compliance .My findings indicate noncompliances with several regulations 9CFR 416.16(a),9CFR 416.13(c),9CFR 416.13(a),9CFR 416.4(a) and 9CRF 416.14

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2017041 211N-1	04/11/2012	01C02	Operational SSOP Review and Observation	C	On 04/11/12 at approximately 0805 hrs I was walking through the packaging area I observed the following noncompliance. At the bird halver machine for Plant #1 across from the bag fryer line there was heavily beaded condensation falling from the drip pan located directly above the tank of ice used for icing the product in tubs. This is a noncompliance with the following regulations. 9CFR 416.2(d) Ventilation adequate to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product and the creation of insanitary conditions must be provided. 9CFR 416.4(d) Product must be protected from adulteration during processing, handling storage, loading, unloading, and during transportation from official establishments. I immediately notified (b) (6) who removed the tank of ice and had it condemned. At approximately 0810 hrs the condensation was removed, restoring sanitary conditions. He instructed the employees to keep the area wiped down throughout the day as it seems to be a problem area.
5308	M6137	BXL2105042 111N-1	04/10/2012	01C02	Operational SSOP Review and Observation	C	On 04/11/2012 at approximately 0300 hours while monitoring the Establishments' Operational Sanitation Procedures in Packaging, I observed the following. There were numerous black specks (UFM) to approximately 1/8" on several birds on the top of a partially filled tank at the first collection station near the dumper on the Plant #2 sorting and sizing line. I contacted (b) (6) and showed him my findings. Most of the black specks were located on the skin and fatty tissue around the neck area. I checked several other tanks in the area but found nothing. (b) (6) arrived and took charge of the corrective action placing a QC hold tag on the tank of product pending rework. My findings indicated a noncompliance with 9 CFR 416.4(d).

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5308	M6137	BXL3105045 511N-1	04/10/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 04/10/2012 at approximately 2240 hours while monitoring the Establishments' Preoperational Sanitation Procedures, I observed the following. In Plant #1, there was a light coating of white fat on approximately a 4' section of a chute associated with the Line #2 auto rehang machine. The chute directs birds from the machine to the manual rehang station. There was white greasy fat on the interior surfaces of the reuse water tank associated with the Line #2 Cropper. There was black (UFM), fat and tissue to 1/8" on a portable cart located at the Line #2 final trim station. (b) (6) was informed of my findings. Sanitary conditions were restored by approximately 2302 hours. At approximately 2325 hours when Packaging Preoperational Sanitation was to begin I informed (b) (6) that I would check the Rewrap room. I proceed to the area and found the room would not be ready for approximately 5-10 minutes. I proceeded to Packaging Area #1 to check the outflow area for Chillers 3 & 4 from Plant #2. I again was told that the area was not ready. I returned to the Rewrap Room and observed 5 people cleaning the room. They were using a spray bottle marked 'Glass Cleaner' and paper towels. At approximately 2348 hours when the space was ready I asked (b) (6) why SSOP procedures were not being used to clean the product contact surfaces in the room. The spray bottle apparently had no cleaner but contained only water. I asked if soap or sanitizer was available to treat the product contacted surfaces. The Establishments' SSOP under Preoperational Sanitation - Daily Procedures (food contact surfaces) lists the following process. (b) (4)</p> <p>" Sanitizer was applied to the stainless counter and portable table. The room was released by approximately 2352 hours. In Packaging area #1 at approximately 2355 hours there were numerous pieces of fat and tissue to approximately 2" on the sprocket and approximately 6' of white support bracket associated with the product belt that takes birds from chiller #4 outflow to the cutup line. There was a portable stainless tray with a layer of dried on fat and tissue on the post-chill finished product standards table. There were numerous pieces of fat and tissue to 1/8" on the middle chute associated with the outflow conveyor for chiller #4. There was a layer of pasty fat and tissue on approximately a 6' section of the white support bracket associated with the outflow conveyor belt for Chiller #4. There was a thick layer of pasty yellow fat and tissue on a sprocket associated with the outflow conveyor belt for Chiller #3. (b) (6) was informed of my findings. Sanitary conditions were restored by approximately 0010 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) , 9 CFR 416.13(b) & (c), and 9 CFR 416.14.</p>

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5308	M6137	BXL4216041 910N-1	04/10/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1100 hours, while performing Operational Sanitation verification procedure, I noticed the following noncompliance by the ice machine located in plant 1. There were two stainless steel tanks each 1/3 full of ice. The ice in these two tanks had numerous black (UFM) specks measuring approximately 1/16" to 1/4". I immediately placed U.S Rejected/Retained tags NO. B31 407577 and NO. B31 407576 on the affected tanks. I then, notified (b) (6). He took immediate corrective action by condemning the contaminated ice. The affected tanks were also washed by the employee working at the area. Ice coming out of the ice dispenser shoot was acceptable. I observed the ice in use at several station and found no visible UFM. USDA tags were removed by USDA inspector after sanitary conditions were restored.
5333	P7632	HYE360404 3910N-1	04/10/2012	01B02	Pre-Op SSOP Review and Observation	C	After the department was inspected and released as acceptable by QC, I performed the hands-on observation component of Preoperational Sanitation Inspection procedure in Second Processing Department, I observed the following noncompliance: At approximately 2358 hours, at Area IV, unit number 10, (Main Dark Meat Belts and Chutes), I observed numerous meat and fat particles from previous days production on top of the belt and in between the roller and bottom of belt, ranging from approximately 1/8 of an inch to two inches in length. The right side of the chute wall had a large smear of meat and fat on the inside wall, approximately 6 inches in length. Both deficiencies are direct product contact surfaces. Regulatory control was taken with the application of US Reject Tag #B38494969 and Mr. (b) (6) was notified of the forthcoming NR. At 0007 hours after the unit was washed and sanitized and after re-inspection, regulatory control was released to production.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1517042 809N-1	04/09/2012	01C02	Operational SSOP Review and Observation	C	<p>On April 9, 2012 at approximately 1330hrs Dr. (b) (7)(C) asked me to investigate a possible adulteration of product in Plant 1. She informed me that she had witnessed water spraying from the first inside/outside bird washer on Line 1 into a bin of front halves staged for packaging near the grading belts. At approximately 1335hrs I contacted (b) (6) to get information about what type of water is being used by the first inside/outside bird washer. (b) (6) informed me that the first inside/outside bird washer was using recycled water to rinse the birds. (b) (6) and I went to the end of Line 1 to observe the situation. We could see that water from the first bird washer was indeed squirting into the combo bin of front halves. Some of the water was splattering off the drip pans, guide bars and metal braces into the combo bin as well. At this time (b) (6) informed us that the shroud around the inside/outside bird washer was broken and that maintenance was unable to fix it until swing shift. At this point I informed (b) (6) that the recycled water was causing an adulteration of product. (b) (6) instructed maintenance to hang plastic around the bird washer to contain the spray. I then placed USDA Retain tag # B31 407593 on the combo bin of front halves that water was spraying into. I asked (b) (6) to call someone from packaging. At approximately 1350hrs (b) (6) arrived. I informed him that the combo bin of product that had been staged next to the bird washer had been cross contaminated with recycled water that had also contacted non-food contact surfaces. (b) (6) informed me that the front halves would be reworked. The product was reworked and the USDA retain tag was removed at approximately 1400hrs. My findings indicate a non-compliance with the regulatory requirements of 9CFR 416.4(d).</p>
5308	M6137	BXL3714041 109N-1	04/09/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>While monitoring the Establishments' Pre-operational Sanitation Procedures in Plant #2, I found the following noncompliance with regulations 9CFR 416.1, 416.4 (a), 416.4 (b) and 416.13 (c). At approximately 0738 hours, I observed in Area #5 section #1 the catch tray and the blue conveyor belt for Line # (b) (6) and (b) (6) it had numerous pieces of fat and meat from the previous day production. The blue conveyor belt that catches the birds from Line (b) (6) also had numerous pieces of fat. I found a grease black permanent marker on the conveyor belt, these conveyors belts transfers the birds to the chiller. The end of a drain pipe that is located next to the catch tray and drains into the drip pan under the blue conveyor belt had fat and yellow residue on it. I immediately attached a U.S. Rejected/Retained Tag # B31 407556 to that area. I informed (b) (6) about the noncompliance. The marker was removed from the conveyor belt and the catch tray, conveyors belts and the end of the pipe were washed. Sanitary conditions were restored at approximately 0745 hours, then I removed the tag.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1110040106N-1	04/06/2012	04A06	Poultry Finished Product Standards	C	On 04/05/12 while monitoring the establishments reprocessing procedure on line (b) (4) in Plant#2 I observed a noncompliance the following regulatory requirements of regulation 9 CFR 381.76 and 9 CFR 381.84. At approximately 1515 hours, I randomly removed a 10 bird sample for my reprocessing test. I found 1 out of four birds with split tails in the sample that contained Airsacculites exudates. I notified Q.C. and performed a recheck at 1525 hours, I removed another 10 bird sample and found two of five birds with split tails to contain airsacculites exudate. Q.C. immediately took action by retaining the product into a tank and placed a hold tag on the tank. I informed (b) (6) of the noncompliance. At approximately 1529 hours Q.C. performed a retest and it passed. The retained product was reworked and released at approximately 1530 hours. This is a repetitive noncompliance.
5308	M6137	BXL2523044009N-1	04/06/2012	01C02	Operational SSOP Review and Observation	C	<p>On 04/07/2012 at approximately 0220 hours while monitoring Facilities in Plant #2, I observed the following. Line (b) (4) had stopped. However, the (b) (4) cabinet for line (b) (4) did not shut off. I started a stop watch to record the time that the birds were left in the cabinet. At approximately 7 minutes 10 seconds the (b) (4) machine operator manually shut the valve to the cabinet on line (b) (4). I waited to see what would be done with the birds in the cabinet but when the line started, I removed the 5 affected birds placing U.S. Retained tag #B31407587 on the carcasses. The Establishments' HACCP Plan for Slaughter in Plant 2 Step 22 'Carcass Wash' identifies (b) (4)</p> <p>(b) (4)</p> <p>(b) (4) The birds that were removed from the cabinet were a pale white color with several blackened patches on the wings and backs of the carcasses. There were also numerous blackish specks to 1/8" that crumbled to the touch and were probably from cooked blood building up in the pipes of the (b) (4) machine. I showed the birds to (b) (6) and he condemned the birds disposing of the carcasses in a gray inedible barrel. (b) (4) concentration as documented at 0202 hours was 11.7%. The (b) (4) cabinets were recently reinstalled as part of a construction project. The (b) (4) cabinet has been staying on all week whenever line (b) (4) stops. My findings indicated a noncompliance with 9 CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN550704 0406N-1	04/06/2012	01C02	Operational SSOP Review and Observation	C	<p>I was verifying operational sanitation in the fillet department at 2226 hours when I observed the following non compliance; the plant employee reprocessing product that falls onto the floor failed to follow the establishment's SOP procedures for reprocessing product that falls onto the floor. I observed the employee washing multiple pieces of breast fillets at the same time. The establishment's written procedure "Reprocessing product that falls" onto the floor states step 5: "(b) (4) [REDACTED]".</p> <p>Regulation 9 CFR 416.12(a) states: "The establishment shall describe all procedures an official establishment will conduct daily, before and during operations, sufficient to prevent direct contamination or adulteration of product(s). Regulation 9 CFR 416.13(c) states: "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's". I informed Mr. (b) (6) [REDACTED], and (b) (6) [REDACTED] of the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1912042 705N-1	04/05/2012	03J02	Slaughter HACCP	C	<p>(b) (4) is an approved antimicrobial agent used in On Line Reprocessing(OLR) of Raw Poultry Carcasses (b) (4) acts as a surfactant and prevents bacteria from attaching to the carcass. On April 04, 2012, at approximately 1340 hours, I found the following noncompliance: While performing a Finish Product Standard check on line (b) (4) plant 2, I noticed the (b) (4) sprayers on lines (b) (4) were turning off and on. Carcasses going through the (b) (4) cavinets were dried. I immediately stop all the lines. I then proceeded to notify (b) (6) of the noncompliance. He mentioned that there was electrical problems. Production was aware of the problem but failed to take corrective action. The establishment failed to go back to Off-Line Reprocessing. I notified IIC Dr (b) (4) of the noncompliance. He immediately instructed each one of the USDA on line inspectors to mark all the contaminated birds and place them on the Off-Line reprocessing line. Maintenance was notified of the problem and production was resumed. At approximately 1420 hours after the problem had been fixed, Dr (b) (4) instructed all the on line inspector to go back to On Line Reprocessing. (b) (4) was properly working under maintenance supervision. Under The establishment's biological hazard analysis, Process step #22/Carcass Wash / Pathogen, i.e. Salmonella is NOT significant. The establishment's address (b) (4) as a justification for this decision: (b) (4)</p> <p>" Establishment P6137 was granted a waiver for regulation 9CFR 381.91(b) (Off-Line reprocessing) on September 2011. Under the establishment's alternative procedures for waved regulation 381.91(b) states: (b) (4)</p> <p>" Location in Food Safety system, Pre-requisite Program. My findings indicate a noncompliance with regulation 417.5(a) and 381.3(b). The establishment is failing to follow alterantive procedure, Pre-requte Program and supporting decisions made in the hazard analysis.</p>
5308	M6137	BXL3613041 905N-1	04/05/2012	01B01	Pre-Op SSOP Record Review	C	<p>While Monitoring the Establishments' Pre-operational Sanitation Records Review, I found a noncompliance with 9CFR 416.16 (a). At approximately 1140 hours while reviewing the Pre-operational Sanitation Records for 04/02/2012 and 04/03/2012 AM shift and PM shift, I noticed that the SSOP Pre-op Daily Implementation and Monitoring Log for Plant #2 AM shift for 04/02/2012 was missing. I found the SSOP Pre-op Daily Implementation and Monitoring Log for Plant #2 but dated with the wrong date of 04/01/2012. I informed (b) (6) about the noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3715040 205N-1	04/05/2012	01C01	Operational SSOP Record Review	C	<p>On 04/03/2012 and 04/04/2012 at approximately 1030 and 1340 hours SCSi (b) (7)(C) went to review the Establishments' prior days activity reports for the Pre-operational and Operational daily monitoring logs and reports. All findings and reports dated 04/02/2012 and 04/03/2012 for Pre-operational and Operational in Plant 2's Rehang/Weigh/Sort Areas, corrective actions of the adulterated product from the affected chillers, reworking of product, monitoring the adulterated product and any further planned actions were not obtainable and not in the establishment filing system for reviewing. Due to the severity of the noncompliances for the past 2 days, accessibility to these recorded documentations was essential and crucial to the USDA's food safety mission. On 04/04/2012 at approximately 1150 hours while reviewing the Operational Sanitation Records for 04/02/2012 PM Shift, I observed the following. The SSOP Preliminary Corrective Action Log for that day was missing. I talked to (b) (6) approximately 1400 hours and she was not able to provide the records at that time. This is a noncompliance with 9CFR 416.16 (a) that states " Each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the Sanitation SOP's and any corrective actions taken".</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4802042 505N-1	04/05/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 4/4/12 at approximately 2234 hours while performing a Preoperational Sanitation Procedure in Plant # 1, I observed the following. Picker # 1 had grease on and between the black fingers. There was also a thin build-up of grease on the lid of the picker. I placed US Rejected tag # B31406236 on the picker. (b) (6) had two of his workers clean and rinse the entire inside of the picker restoring sanitary conditions. At approximately 2249 hours at inspection station # 7 there was thick grease and debris from the previous days production on approximately a 3' length of the over head guide bar to the right of the inspector station. (b) (6) had the guide bar cleaned and rinsed restoring sanitary conditions. At approximately 2252 hours at the last Salvage Station there was a thick build-up on UFM on the knife sanitizer. (b) (6) had the inside of the knife sanitizer scrubbed and rinsed restoring sanitary conditions. PLANT- # 2 At approximately 2255 hours in plant # 2 CSI (b) (7)(C) observed the following. The Finishing Chiller # 4 had numerous pieces of tissue and fat to approximately 1/4" on the paddle and internal surfaces above and below the surface the water. The unit was emptied and recleaned. There was pasty fat and tissue to approximately 1/8" above the water line in patches 4"-8" high and several feet long at more than one location on the exit end of Chiller # 4 on the side adjacent to the wall. There were also numerous pieces of fat and feathers floating in the water. Sanitary conditions were restored to a satisfactory condition by approximately 2305 hours. PACKAGING AREA: At approximately 2350 in Packaging Area # 1 there was grease and pieces of fat floating in a puddle of water on a tray under the flex belts at the rehang tables at the end of the Chiller 3 and 4. (b) (6) was contacted. The area was recleaned restoring sanitary conditions. At approximately 2357 hours the entire platform and floor area under the Breast Processors was covered with small pieces of fat and debris. (b) (6) was contacted and had the platform rewashed bringing the area back into compliance. My findings indicated a noncompliance with 9 CFR 416.13(c), 9 CFR 416.4(a) &(b), 9 CFR 416.1, and 9CFR 416.14.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5513042 405N-1	04/05/2012	01C02	Operational SSOP Review and Observation	C	<p>On 4/5/12 at approximately 0945 hours while observing operational sanitation procedures, I observed a plant employee take a metal hook and drag multiple chickens across the floor and then pick them up and throw them back onto the floor underneath the conveyor belt at the chiller exit to two other plant employees who were then taking them and placing them into a brown tub. I immediately informed (b) (6), who was standing close to me, of my observations. He then went over and spoke with the guys. I asked him what he planned to do with the adulterated product that was drug and thrown back onto the floor. He said he was planning to recondition the product and asked what I would suggest be done. I informed him that it states in their SSOPs that (b) (4) . I suggested it be condemned. He then decided to condemn the product. I also informed him of this noncompliance. This is a violation of 9 CFR 416.4(d) and 416.13(b).</p>
5309	P6137A	NJN470304 4605N-1	04/05/2012	01C02	Operational SSOP Review and Observation	C	<p>I was performing an Operational Sanitation verification activity in the Packaging Department at 0059 hours when I noted the following noncompliance: I observed water dripping from a seam of an overhead drip pan onto a roll of blue plastic liners below. This drip pan was located below the chick weigh line as it exited the body halfer. I informed (b) (6) and (b) (6) as well as (b) (6) of the noncompliance. The establishment implemented immediate corrective actions by installing a temporary sheet of plastic to redirect the dripping water onto an adjacent drip pan until the completion of production when maintenance can perform a more permanent solution. On 04/04/2012 the establishment documented a non routine incident for this same occurrence, which included corrective actions of maintenance repairing the seam in the drip pan. That corrective action was either not implemented or ineffective in preventing the same occurrence.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1119044 304N-1	04/04/2012	03J02	Slaughter HACCP	C	On April 2, 2012, a deviation or unforeseen hazard of metal was identified on product at the end of the first cycle of the newly installed chillers. Metal continued to be identified on product throughout the days production following product chilling. These hard and some sharp metal fragments, shavings, and pieces were found adhering to the skin and muscle of over 45 tanks of product that were placed on hold by the establishment. This was visible to the USDA IPP: Dr. (b) (7)(C) SPHV, SCSIs (b) (7)(C) , and all CSIs during the inspection of the product as the product was dumped from the chillers on to the receiving rehang conveyors. On 4/4/12, when asked about the HACCP reassessment due to chiller installation, (b) (6) informed Dr. (b) (7)(C) SPHV that a reassessment would take place on Friday, 4/6/12. No reassessment had been performed at this time. This is a violation of 417.3(b)(4). Due to this deviation or unforeseen hazard of metal found adulterating product and the increase in monitoring steps throughout the process on 4/2/12, reassessment was essential and necessary prior to the usage of this equipment and following the deviation or unforeseen hazard to determine and evaluate for any potential food safety hazards. On 4/4/12 after reviewing the HACCP Plan, SCSIs (b) (7)(C) noted the lack of this documentation. This is a violation of 9 CFR 417.3(c).
5308	M6137	BXL4512040 904N-1	04/04/2012	01C02	Operational SSOP Review and Observation	C	On 4/2/12 at approximately 1400 hours while observing operational sanitation procedures, I observed a plant employee pick up multiple whole chickens from the processing floor underneath the conveyor belt leading to the B grade cut up line, and throw them onto that same conveyor belt without properly reconditioning the product. I immediately went over to observe up closer what the employee was doing and observed him continuing to separate out some bird to be condemned and throw some birds from the floor onto the conveyor belt to continue to processing. I immediately informed Mr. (b) (6) of my observations and this noncompliance. He immediately went over to speak with the employee and he said he would make sure that the birds got condemned right away. Your SSOPs state that (b) (4) . Therefore, you have failed to implement your reprocessing procedures. Your failure to do so is a noncompliance with 9 CFR 416.4(d) and 416.13(b).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN470304 2804N-1	04/04/2012	01B02	Pre-Op SSOP Review and Observation	C	I performed pre-operational sanitation inspection in the New Products Room at 2230 hrs. after QC had performed pre-operational sanitation inspection and released the room for production when I noted the following non compliance: There were several pieces of fat and product particles on the walkway and a chicken piece (wing segment) inside the drip pan. These findings were located at unit #14 of IQF line #1. I informed (b) (6), of these findings at 2240 hrs. A U.S. Reject tag was not applied since sanitary conditions were immediately restored. Once sanitary conditions were restored to the unit I reinspected and released the area for production at 2249 hrs.
5333	P7632	HYE231604 5403N-1	04/03/2012	01C02	Operational SSOP Review and Observation	C	At 0937 hours on April 03, 2012, while performing an Operational Sanitation inspection procedure in the chiller exit rehang area, I observed that the rehang table was backed up with birds. I went to the north side of the rehang table and observed 20+ birds on the floor around the catch pan designed to catch product overflow beneath the incline belt feeding the rehang table. I observed plant employees picking up the product but no one was taking any effective measures to regain control of the process so that birds would stop falling to the floor. In less than ten seconds I observed 14 more birds fall from the table to the floor. Regulatory control of the rehang table was taken with the application of US Reject Tag B38 494935 and (b) (6) were notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above. The affected product was released to QC and taken to reprocessing for reconditioning. Regulatory control was relinquished at 0942 hours with the acceptance of effective corrective actions to restore sanitary conditions, appropriate disposition of product and the proposed preventive measure that a supervisor would be assigned to monitor the area until the maintenance issue which caused the back-up of product could be addressed and a better response plan could be put into place. NR HYE0617034409N documents a similar noncompliance on 03/09/2012 where product backing up on the rehang belt led to product pile-up on the floor and no effective measures being taken to stop more product from falling. The preventive measure of training the Day Shift Chiller Rehang Lead person to adjust their schedule to provide coverage during breaks and lunches to better address product flow surges at those times did not prevent product pile-ups at the rehang table from recurring.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1510042 402N-1	04/02/2012	01B02	Pre-Op SSOP Review and Observation	C	At approximately 0600 hours, while performing Pre operational inspection verification in the Condemned Room and Live Hang Welfare areas located in plant 2 slaughter area, SCSI (b) (7)(C) found the following noncompliance: There was a putrid and rancid odor coming from the inside of the condemn room. The auger and 1/4 of the dump bin in the condemn room were found decaying with chicken body parts, feathers and fat debri. All these poultry remaining were left in there since March 23rd 2012 at 1530 hours. (b) (6) was notified of the noncompliance. He took immediate corrective action by having the dumpbin and the auger unlocked and washed. Condemned Room was released to production after sanitary conditions were restored.
5308	M6137	BXL1510042 402N-2	04/02/2012	01B02	Pre-Op SSOP Review and Observation	C	While performing Pre Operational inspection in plant 2 slaughter area, Dr. (b) (7)(C) and I found the following non compliances: 1- At approximately 0720 hours while inspecting area 2, we observed a white feather approximately 1" in size outside of picker #1 line (b) (7)(C) and also several feathers approximately 1" in size inside of picker #1 line (b) (7)(C). 2- At approximately 0725 hours while inspecting area 3, we noticed multiple particles of black foreign material ranging from 1/16" to 1/8" in size affecting the Automatic Transfer Machine Line (b) (7)(C) and (b) (7)(C) and Transfer Table line (b) (7)(C) which are consider product contact surfaces. There were also 3 stainless steel tanks affected with back and sandy foreign material. 3- At approximately 0735 hours while inspecting area 4, Dr. (b) (7)(C) and I noticed a brownish build up on the liver/heart machine line (b) (7)(C). There was also a couple of white edible barrels affected with foreign material. These equipment and utensils are product contact surfaces. 4- At approximately 0745 hours while inspecting the gizzard puller on line (b) (7)(C) area 4, Dr. (b) (7)(C) noticed a brownish build up. Each of these non compliances was pointed out to the sanitation lead person at the times specified previously. All insanitary conditions were corrected immediately by sanitation as pre operational inspection was taking place. Slaughter area was released at approximately 0751 hours.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4813044 702N-1	04/02/2012	01B02	Pre-Op SSOP Review and Observation	C	While monitoring the Establishments' Pre-operational Sanitation Procedures in Main Packaging Area, Dr. (b) (7)(C) SCS (b) (7)(C) and I observed the following noncompliance with regulations 9CFR 416.1, 416.4 (a), 416.4 (b) and 416.13 (c). At approximately 0830 hours, we observed in the entire rehang area and weigh/sort lines in Plant #2 a noncompliance. The belts, conveyors, drip pans, dividers and conveyors sides were covered with fine dust of metal flakes, small and large metal flakes, pieces of metal and welding material. All created from welding and installation friction movement of tools and metal of the new Chillers. The entire location had U.S. Rejected/ Retained Tags # B31 407557, # B31 407594 and # B31 407595. We informed (b) (6) about the noncompliance. Sanitation Personnel scrubbed, washed and rinsed all food contact and non- food contact surfaces of the entire rehang and weigh/sort area. The rehang area was released after sanitary conditions were restored at approximately 0906 hours by SCS (b) (7)(C) and the weigh/sort was released after sanitary conditions were restored at approximately 0920 hours by Dr (b) (7)(C) and I.
5333	P7632	HYE010704 3702N-1	04/02/2012	03J04	Poultry Zero Tolerance Verification	C	I was in the evisceration department performing a Zero Tolerance verification task on evisceration line # 2 at 0443 hours when I observed fecal material on one carcass of the ten carcass sample. The fecal material was located on the left wing of the carcass. It was approximately 1/16 of an inch in diameter, dark green in color, and had a paste like consistency. I immediately notified Ms. (b) (6), and Mr. (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2003031031N-1	03/31/2012	01C02	Operational SSOP Review and Observation	C	<p>On 03/30/2012 at approximately 2005 hours while monitoring the establishments' Weigh & Price and Rewrap Room procedures, I observed the following. There were establishment employees unwrapping packages of Foster Farms half breasts (506) and placing the product on to different size trays Foster Farms half breasts (951). I observed the process for approximately 5 minutes. The packaged product was being removed from gray product baskets that are assembled into racks in Packaging and sent to Weigh & Price. I examined several of the baskets being emptied and found that the baskets all had a thick coating on the interior surfaces of the baskets of black & brown (UFM), and pieces of dried and partially dried fat and tissue to approximately 1". The baskets are treated as a nonproduct contact surface and are seldom cleaned. An establishment employee wearing gloves was removing the product (506) from the contaminated baskets, unwrapping the product with the gloves touching the exterior top and potentially contaminated bottom of the (b) (4) wrapper around the package then dumping the product and arranging the breast pieces onto a larger size tray with the same contaminated gloves. At this point the contamination from the gray basket was transferred to the breast halves. The exterior of the wrapped product and the knife being used were not being sanitized in any manner. A hand wash sink and glove sanitating unit is available but was not being used. Other employees were selecting breast halves from a pile and filling up the rest of the larger tray before passing the repacked product through the wrapping machine. I went to the QC office to reviewed the SSOP and Hazard Analysis. The establishment SSOP Section II: Operational sanitation 'Daily Procedures' states that "(b) (4) _____," but does not state how this will be accomplished. The Establishments Flow Chart for Packaging Step 15 noted (b) (4) _____." The Establishments HACCP Plan-Raw Not Ground(Packaging) Step 15(rework) identifies under (b) (4) _____." Supplements 6,21 and 33 are listed as supporting documents. The supplements reference temperature and bacterial growth concerns. There were no QC personnel present to monitor the process. Hundreds of packages are rewrapped daily. After the rewrap process the items are returned to the Weigh & Price cooler for shipping. I took a basket to (b) (6) _____ and showed him my concerns with the process in the rewrap room. He stopped the process and said he would discuss the matter with management. I attached B31407586 and B31407578 to two racks, approximately 192 packages, being worked in my presence. My findings indicated a noncompliance with 9 CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2019030631N-1	03/31/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 0940 hours while performing a Zero Tolerance fecal check on line #2 plant 1, I found feces in one of the 10 randomly selected birds. There were two particles of feces located inside of the bird's cavity by the tail area, each measuring approximately 1/8" in diameter. These particles were light yellow in color and soft in texture. I immediately notified (b) (6) of the noncompliance. She started the establishment's zero tolerance protocol. Quality control performed a passing recheck at approximately 1025 hours. The cause of deviation was the Venter Machine. Post chill checks were performed from 1031 hours to 1135 hours. This is a violation of the critical limit CCP2B, (b) (4) of the Plant's HACCP Plan for slaughter.
5333	P7632	HYE3915031931N-1	03/31/2012	01C02	Operational SSOP Review and Observation	C	At approximately 0709 hr while performing PHIS task for review and observation of Operational SSOP in 2nd processing, a stack of tub lids were in the east sink behind the Breast Processors. I observed a plant employee pick the stack of lids up and place them on a cart with clean tubs and lids. The employee then took one of the lids from the stack of contaminated lids and placed it on a tub of whole chicken breasts. I placed U.S. Retained tag # B38494957 on the tub. Mr. (b) (6) was informed of the situation and of the forth coming Noncompliance record. Control of product was returned to plant at 0715 affected product was tagged by plant to be washed and reworked; lids were removed from the cart to be properly washed. Mr. (b) (6) informed me that the employees would be trained on not using the hand wash station as a holding area for the tubs and lids.
5333	P7632	HYE2608033930N-1	03/30/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 0545 hours while performing the hands-on observation component of a Poultry Zero Tolerance Verification inspection procedure on the reprocessing line, in the presence of Ms. (b) (6) I observed the following non-compliance: On the fourth bird of my inspection, a smear of fecal material, approximately one quarter of an inch in length by one eighth of an inch wide on the inside cavity by the Keel bone of the right breast. It was dark green in color, paste like consistency. Regulatory control of the line was taken with the application of US Retained tag #B38495000. Ms. (b) (6) and Mr. (b) (6) was shown the fecal material and notified of the forthcoming NR. QC, Production and Maintenance went into immediate actions per the corrective action procedures prescribed in the Establishment s HACCP Plan. Regulatory Control of the line was released at 0558 hours after a recheck on the reprocessing line was performed and was acceptable. That the establishment would have failed to prevent fecal material from entering the chilling system represents a non-compliance with 9 CFR 381.65(e) which states, Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0205031 430N-1	03/29/2012	01B02	Pre-Op SSOP Review and Observation	C	On 03/29/2012 at approximately 2241 hours while monitoring the establishments' Preoperational Sanitation Procedures in Plant #1, I observed the following. There were several large patches of white fat on the internal surfaces of the tank at the auto rehang station for line #2. The tank is used during production to collect birds when the line is stopped. Sanitary conditions were restored by approximately 2250 hours. At approximately 2355 hours in Packaging Area #1, there was a pallet jack located adjacent to line #1. The pallet jack had several large pieces of fat and tissue on the front of the unit. There was also a layer of fatty tissue on the stainless arms of the pallet jack. The arms extend into the product when the tank is grasped prior to moving. Sanitary conditions were restored by approximately 0015 hours. In Packaging area #2 the red piping for the fire fighting system directly above the lines has patches of rusting, chipping, and peeling paint. The piping directly above line #2 is the worst with large pieces of paint to approximately 1" missing in numerous locations. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.13(c), and 9 CFR 416.2(b)(1).
5308	M6137	BXL1806034 430N-1	03/29/2012	01C02	Operational SSOP Review and Observation	C	While monitoring the Establishments' Operational Sanitation Procedures in Main Packaging, I observed the following noncompliance with regulations 9CFR 416.4 (a), 416.12 (a), 416.13(c). At approximately 1107 hours, I observed maintenance personnel working on the Dumper Conveyor in Main Packaging, after maintenance personnel completed their work at 1124 hours, I waited to observed if Supervisor Production, SSOP, HACCP or QC personnel would check the conveyors for sanitary conditions because company personnel were on break. At approximately 1137 hours company personnel came back from break and I checked the conveyors. The conveyors had black residue that looks like grease. Company personnel started the conveyor and I told them to stop. I took regulatory control action by attaching a U.S. Rejected/Retained Tag # B31 407472 on the conveyors and called the Supervisor. At approximately 1139 hours (b) (6) and (b) (6) came and I informed them about the noncompliance. Both Supervisors took corrective action by washing the conveyors and condemning the product involved. At approximately 1147 hours, after sanitary conditions were restored, I released the area.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5315032 729N-1	03/29/2012	01C02	Operational SSOP Review and Observation	C	On 03-29-2012 at approximately 1120 while performing a SSOP review and observation procedure in the wing sizing room I observed the following, (1) Condensation on the ceiling, the air supply ducting, the flashing at the wall to ceiling joint, the structural metal beams and the overhead piping. (2) A sprayer on the (b) (4) system was spraying up through the line onto the overhead pipes and falling back onto the conveyor which is a food contact surface. The room was at break so no product was involved. (3) A drip pan was leaking water through the silicone at the edge and onto the floor. The silicone sealant was growing mold in a yellowish and brown color at three spots along the bead approximately one to two inches in length each. I notified (b) (6), (1) He had the condensation removed from the effected areas, (2) The sprayer was adjusted and the conveyor was then washed and resanitized before production resumed. (3) Maintenance removed the silicone, the mold was cleaned and fresh silicone was applied to the drip pan. This a noncompliance with regulations CFR 416.2(d) Ventilation, CFR 416.13(c) Plant monitors implementation of SSOP procedures, CFR 416.4(a) Food contact surfaces, CFR 416.4(b) Non-food contact surfaces.
5308	M6137	BXL3611031 228N-1	03/28/2012	04A06	Poultry Finished Product Standards	C	At approx 1036 hours on March 27, 2012 while performing an AQL check on the giblets in Plant #1 I found the following noncompliance. I took a sample of 10 livers coming out of the gib chiller and found 5 of the 10 livers with whole spleens and gallbladders still attached. I immediately notified QC and (b) (6) of the noncompliance. QC did a recheck at 1043 hours which also failed and another recheck at 1049 hours which also failed. These findings show that the process was out of control. QC put a hold tag on 2 tubs of livers for rework before a recheck finally passed. QC did a recheck at 1052 which passed and another at 1054 which also passed showing the process was back in control. The 2 tubs of livers that were held were reworked and released by QC at 1156 hours and 1158 hours respectively.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4112032 528N-1	03/28/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1118 hours while walking through the (b) (4) Room I observed the following noncompliance. There was an establishment employee washing breast fillets at the product reprocessing sink and I stopped to observe the process to verify the proper reprocessing procedure was performed as she was almost finished reworking the product. During the process no ice was added to the product at any time. As soon as she was finished another employee walked up and loaded 3 tubs of product onto a dolly and started to take the tubs to the line to be put back into production without waiting 5 minutes for Quality Control reinspection. As this is not the protocol to be followed, as stated in the SSOP Plan, I immediately took Regulatory Control action and stopped him and attached USDA Retain Tag #B31406210 to the stack of tubs. I then notified (b) (6) of the noncompliance. He said he would talk to the employee and QC. As stated in the establishments SSOP Plan the protocol to be followed states under PROCEDURES: (b) (4). As this did not happen it is a failure of the establishment to properly implement it's reprocessing procedure.
5309	P6137A	NJN411403 2828N-1	03/28/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1124 hours while performing PHIS task for Operational Sanitation in the packaging area I observed a plant employee washing the floor during a company break. Water from the floor was allowed to spray into one bin (approximately 1000 lbs.) of whole chickens at the end of the chiller exit conveyor thus cross-contaminating the product within the bin. I applied US Retain Tag # B39 415888 to the affected product and informed Mr. (b) (6) and the QC technician assigned to the area. All of the product was moved to reprocessing area to be washed in accordance with the plant's reprocessing procedure. After reprocessing the affected product and after re-inspection I released the product back to production at 1225 hours. That the establishment failed to protect the product during processing represents a non-compliance with 9CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE150303 4229N-1	03/28/2012	01D01	SPS Verification	C	<p>While conducting SPS (Sanitary Performance Standards) at the start of the shift at the Weigh and Price department after employees started running transfer lines and computer scales were being set, I observed the following non compliance: The floor by the scales had all kinds of trash and debris from previous day's production. Dirty paper towels, pieces of crumbled paper and cardboard, wood splinters, crumbled plastic wrap, styrofoam, pieces of meat and fat, metal screws and plastic shavings along the transfer belt from robot cages. Some of the transfer belts by the scales had dirty paper towels caught between the belts. The computer scales on line two had an accumulation of dust and dirty paper towels on top. The stainless steel box carts tables had dirty paper towels and used priced stickers on top of plastic bag liners used to bag product. Regulatory control of the area was taken at approximately 2140 hours with the application of US Reject tag # B40193561 and Ms.(b) (6) was notified of the non compliance. After sanitary conditions were restored, the area was released for production at 2153 hours. Plants SSOP's step #2 states:(b) (4)</p>
5308	M6137	BXL1805031 027N-1	03/26/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 03/26/2012 at approximately 2355 hours while monitoring the Establishments' Preoperational Sanitation Procedures in Packaging Area #1, I observed the following. There was a line approximately 1/4" wide of pasty fat and tissue to 1/8" along the entire width, approximately 24", of a wing line product belt. There were numerous pieces of dried on fat and tissue to 1/4" on the removable tray associated with the automatic tray drop mechanism. There was a coating of black (UFM) with the appearance of grinding dust on two small tables located adjacent to the wing line. There was a layer of black (UFM) with the consistency of grinding dust on the bottom tray of leg processors 1, 2 & 3. Miscut leg quarters collect on the tray. There was also numerous pieces of back (UFM) to 1/8" on the white cutting wheel of the leg processors. Sanitary conditions were restored by approximately 0015 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4 (a) & (b), and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1514033 923N-1	03/23/2012	03J04	Poultry Zero Tolerance Verification	C	While performing a Finish Product Standard check in plant 1 line 2, I found a Zero tolerance fecal failure. At approximately 0920 hours, I randomly removed 10 birds from line #2 for my FPS check. I found one out of the ten bird contaminated with feces. The bird had an attached cloaca with a 1" long piece of intestine. There was fecal matter on the base of the tail area affecting part of the right leaf fat of the carcass. The fecal matter was light yellow in color and liquid in texture. There was two fecal smears each measuring approximately 1/8" in diameter. I immediately notified (b) (6) of the noncompliance. This is a failure to keep CCP 2B under control. The establishment implemented the zero tolerance protocol. Quality control performed a passing recheck at approximately 0946 hours. Maintenance worked on the venter machine during break time (1000 hours to 1015 hours). Suspect lo was from 1013 hours to 1036 hours. Quality control performed post chill checks at the end of chiller #2. All suspected product was deemed acceptable.
5308	M6137	BXL4009033 623N-1	03/23/2012	01C02	Operational SSOP Review and Observation	C	On 03/22/2012 at approximately 0612 hours while monitoring Facilities after a scheduled establishment break, I observed the following. Line ^{(b) (4)} was stopped as the courtesy washdown was not completed. There were no supervisors present. I went to the automatic rehang station where birds are moved from the kill line to the eviscerating line. The conveyor belt for line ^{(b) (4)} was full and to that point approximately 50 birds were on the floor. I proceeded to the office and contacted (b) (6). Establishments' response to a similar noncompliance dated 02/23/2012 under Management Response (Further Planned Action) stated that " A modified tank has been fabricated for the underneath the rehang line. The tank is designed to allow production to operate the line in reverse when the line experiences down time. This will prevent carcasses from falling on the floor. The tank was installed on 3/15/12. In addition production employees were verbally counseled regarding reconditioning procedures." The modified tank was present however the tank and the reverse feature on the conveyor belt was not being used. The floor at this location is covered with varying amounts of debris from the kill line. At approximately 0635 hours supervisors arrived to start corrective action by starting the conveyor in reverse to fill the modified tank that kept the birds on the conveyor belt. Birds on the floor were reconditioned and rehung by approximately 0640 hours. Rehangng was completed by approximately 0645 hours. The establishments' SSOP Reconditioning Procedures under #1 states (b) (4). " Birds should be slaughtered in a sanitary manner using Good Commercial Practices. My findings indicated a noncompliance with 9 CFR 416.15(b) and 9 CFR 416.4(d).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4317031 122N-1	03/22/2012	03J04	Poultry Zero Tolerance Verification	C	While performing a Finish Product Standard inspection check, I found a zero tolerance fecal failure. At approximately 1035 hours, I randomly selected 10 birds from line #1 in plant #1. I found one out of the ten birds contaminated with feces. The fecal matter was dark brown in color and pasty in texture. There were two fecal spots measuring approximately 1/8" each. One of the fecal spots was located by the kidney area and the other fecal spot was located on the left leaf fat area. I immediately notified (b) (6) of the noncompliance. The establishment implemented the zero tolerance protocol. Quality control performed a passing recheck at 0958 after a temporary corrective action was put in place (showers prior the (b) (6) cabinet were turned on). According to (b) (6) the cause of deviation was broken leaf fat lifters. The deficiency was fixed during break time (1000 to 1015 hours). Quality control performed a passing CCP2B check at 1029 hours. Suspect lot was from 1011 hours to 1139 hours. All post chill checks performed by quality control were found acceptable.
5309	P6137A	NJN390703 3722N-1	03/22/2012	01C02	Operational SSOP Review and Observation	C	I was performing an Operation Sanitation verification activity in the Packaging Department at 0230 hours when I noted the following noncompliance; I observed a plant employee overspray water from the floor and drain onto the product conveyor located under the polar massager exit, while he was washing down the floor. The conveyor belt was not running however, the hopper was full of marinated product. The product conveyor is a direct product contact surface. I initiated regulatory control at 0235 hours and retained the product and the hopper/conveyor with USDA retain tag B39415954. I notified Mr. (b) (6) and Mr. (b) (6) of the noncompliance. After corrective actions to restore sanitary conditions were implemented and measures to prevent recurrence were proffered the product and unit were released at 0430 hours.
5308	M6137	BXL3306032 021N-1	03/21/2012	01B02	Pre-Op SSOP Review and Observation	C	On 03/20/2012 while monitoring the Establishments' Preoperational Sanitation procedures in Plant #1, I found the following noncompliance with regulations 9 CFR 416.1, 416.4 (a) and 416.13 (c). At approximately 2251 hours, I observed in Area #4 the recycle water tank that captures the Inside/Outside Bird Washer water, had slimy residue, fat and feathers in it. This tank is a Food contact surface. I immediately attached a U.S. Rejected Tag # B31 407496 to the tank. I notified the (b) (6) and the (b) (6) of the noncompliance. The tank was scrubbed and rinsed. Sanitary conditions were restored at approximately 2300 hours then I removed the tag.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2415033 720N-1	03/20/2012	03J02	Slaughter HACCP	C	At approximately 915 hours while performing a Post-Chill Finish Product Standard check in Plant #1 on line #1, I found one out of the 10 birds contaminated with feces. The fecal matter was inside the bird cavity by the kidney area. There were three fecal spots each measuring approximately 1/8" in diameter and there was also a piece of feces measuring approximately 1/4" in diameter. The fecal matter was light yellow in color and soft in texture. I took immediate regulatory control action by having the establishment personnel working at re hang area to stop hanging birds. I then, notified (b) (6) of the noncompliance. From 915 hours to 925 hours, 4 tanks full of carcasses were put on hold by Quality Control as part of their immediate corrective action. Suspect lot was from 915 hours to 1025 hours. Post chill checks were performed by Quality control from 925 hours to 1035 hours. All product on hold was reworked by the establishment, reinspected and released by quality control. My findings indicate a failure to keep CCP 2B under control. The establishment's monitoring frequencies were not effective in preventing feces from entering the chiller.
5308	M6137	BXL0915035 419N-1	03/19/2012	01C02	Operational SSOP Review and Observation	C	On 3/19 at approximately 0937 while performing a Finished Product Standard check I observed the following non compliances. After pulling a ten bird random sample I noticed two out of the ten birdshad grease smears, one bird had a smear on it's breast approximately 2-3 sq inches the other bird had a smear on it's back about 2" wide and about 3" long I notified (b) (6) of my findings. The QC notified (b) (6) who had (b) (6) preform a recheck .The QC's Findings were consistent with mine finding several more birds with grease smears. At 0955 (b) (6) had his people stop hanging, and began to tank off birds . The product was tagged by QC and held to be reworked .At 1006 QC preformed another recheck which was found to acceptable butting the company back in compliance.My findings indicate noncompliance with regulations with 416.14(d) 416.4(d) and 416.13(c) .

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2420035 619N-1	03/19/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>While performing Pre Operational Sanitation Inspection on the ground chicken area, I found a noncompliance with regulatory requirement of regulation 9CFR 416.4(b). At approximately 0838 hours, I noticed a rotten smell coming from the stack of black plastic divider. These egg shell shaped dividers are utilized for palletized ground chicken cases. The first 5 dividers on top of the stack were clean, however most of the dividers underneath were dirty. There was stagnant cloudy and smelly water mixed with blood from the previous production day. I immediately placed US Rejected/Retained tag NO B31 407553 on the insanitary stack of dividers. I notified (b) (6) of the noncompliance. The pallet holding these dividers was taken to the loading dock area to be washed by sanitation in the afternoon shift. After sanitary conditions were restored, US tag was released by USDA on night shift. While performing Pre Operational Sanitation inspection on the packaging rehang area plant 1, I found a noncompliance with regulatory requirement of regulation 9CFR 416.4(a). At approximately 0848 hours, I noticed a stainless steel tank with several chunks of fat measuring approximately 1/8". This tank is a product contact surface utilized to hold carcasses coming out of the chiller. This tank was washed immediately by sanitation as I pointed out the noncompliance. (b) (6) was notified as well. I reinspected the tank and found it to be acceptable. Area was released after sanitary conditions were restored.</p>
5308	M6137	BXL1605033 916N-1	03/16/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>On 03/16/2012 at approximately 0000 hours while monitoring the Establishments' Preoperational Sanitation Procedures in Packaging #1, I observed the following. There was a layer of dried brown (UFM) on most of the accessible shackles along approximately 100 ft of line (b) (6) at the plant #2 halving machine. The line conveys birds to the halving and other processing machines for cutup. (b) (6) decided to use the shackle washers so Lockout/Tagout was released and no US Reject tag was applied. Sanitary conditions were restored by approximately 0035 hours. At approximately 0005 hours the following items were found along the thigh deboning line. There were several pieces of fat to approximately 1/2" on the product contact surfaces of the catch tray at the tub dumper. There were numerous pieces of fat and tissue to approximately 2" on the short conveyor belt associated with the dumper catch tray. There were numerous pieces of fat and tissue to approximately 1/2" on the two white conveyor belts associated with the skin removers. There were numerous pieces of fat and tissue to approximately 2" on the white nylon and stainless belt assembly that feeds product into the #1 (b) (4). There were numerous pieces of fat and tissue to approximately 1/2" along the entire length of the collection belt that removes the trim from the line. Sanitary conditions were restored by rinsing with potable water per establishment policy by approximately 0020 hours. My finding indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), and 9 CFR 416.13(c).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5218034 816N-1	03/16/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 1534 hours, I found a zero tolerance fecal failure. I randomly selected 10 birds from line 2 plant 1. I found one out of the ten birds contaminated with feces. The fecal matter was light yellow in color and pasty in texture measuring approximately 1/4" in diameter. It was located inside of the bird cavity near the tail area close to the right leaf fat. I immediately notified (b) (6) of the noncompliance. My findings reflect the establishment's failure to maintain CCP 2B under control even after the established monitoring frequencies are followed. The establishment's zero tolerance protocol was implemented. According to (b) (6) and (b) (6) the cause of deviation was the Inside/outside Bird Washer. Quality Control recheck passed at approximately 1608 hours after the cause of deviation had been established and deficiency had been fixed by maintenance. Suspect lot was determined to be from 1626 hours to 1718 hours. Quality Control performed rechecks at the post chill for chiller 2. All of the rechecks were found acceptable. Product coming out of the chiller was deemed to be acceptable.
5308	M6137	BXL2811032 315N-1	03/15/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1455 hours while walking through the packaging area I found the following noncompliance. At the end of the breast fillet line (b) (6) I observed condensation on the drip pan directly above the transfer belts. These belts bring product to Line (b) (6) for tray pack. There was also a leak in a welded seam on the pan dripping onto the metal sides of the lower transfer belt splashing water onto the belt and product. I immediately notified (b) (6) of the problem. He immediately called maintenance about the leak and got a piece of blue plastic to use to divert the welded seam leak away from the belt. I had (b) (6) notified and when he came he took over handling the leak problem and talked to mechanics and told (b) (6) to get the condensation cleaned up. (b) (6) got a mop and while he was wiping condensation off of the drip pan the mop splashed dirty mop water onto the belts and product going to Line (b) (6). I immediately took regulatory control action and had (b) (6) stop the line. (b) (6) stopped the line and took corrective action by having all of the product on the line taken off and put in tubs to be reprocessed. I applied USDA Retain tag #B31406209 to the pallet of 13 brown tubs. QC was notified to monitor the reprocessing of the pallet of product. The product was reprocessed and sanitary conditions were restored. The USDA retain tag was removed and product was released back to production by USDA at 1705 hours.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3515030 915N-1	03/15/2012	01D01	SPS Verification	C	At approximately 1145 hours while walking through the packaging area I found the following noncompliance. At the breast halver machine across from the bag fryer line there was condensation on the drip pan directly above the tank of ice used for icing the product in tubs and directly above the roller belt the tubs of product are filled on. I immediately contacted (b) (6) I informed him of the problem and he had the condensation removed, restoring sanitary conditions. He also had the tank of ice moved from the area condensation seems to form and had a fan turned to that area to help with the condensation problem. He told the employees and (b) (6) to have the area wiped down every 5 to 10 minutes throughout the day as it seemed to be a problem area.
5308	M6137	BXL0510031 014N-1	03/14/2012	01D01	SPS Verification	C	On 03/14/2012 at approximately 0720 hours while monitoring Facilities, I observed the following. On the loading dock there was rain water dripping between the truck trailer and door seal attached to the building. The area is not treated as a product contact surface. There were pallets of product being certified for temperature which would have been loaded onto the affected trailers. As the bins are not covered any fluids that gets in the bins or on the liner could be transferred to the product when dumped. Or the fluids could contaminate the boxed product during unwrapping by the receiver. I contacted (b) (6) and showed him my concerns on doors 10,14 and 15. There was product loaded on the three trailers but as I did not observe them being loaded I do not know if the bins, pallets of brown tubs and bulk boxed product were loaded before or after it started to rain. Doors 14 & 15 had the most leakage with a continuous flow of water across the entire door way. (b) (6) had the product ready for loading put temporarily back into the staging cooler while the truck driver moved the trailers to a door that was not leaking. By approximately 0755 hours, (b) (6) decided that if the doors could not be repaired in a timely manner that pallets being loaded would be covered with plastic during the loading process. With this understanding the area was released to production. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(2).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN250503 4614N-1	03/14/2012	01C02	Operational SSOP Review and Observation	C	At 0251 hrs. I observed a stack of nine wooden pallets staged for use, with numerous particles of visible fecal material (bird feces) on the top pallet. These pallets were located in the new products room at the end of the rotisserie line. I informed and showed these findings to (b) (6) and (b) (6) and informed them of the non-compliance with the regulation cited above. Mr. (b) (6) immediately put a QC tag on the stack of pallets. The pallets were then removed from the production area under QC control. 9 CFR 416.4(b) states that "non food contact surfaces of facilities, equipment, and utensils used in operation of establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
5333	P7632	HYE530603 4314N-1	03/14/2012	04C05	Poultry Good Commercial Practices	C	While performing the observation component and following instructions of District Veterinarian Medical Specialist Dr. (b) (7)(C) on Good Commercial Practices, at approximately 0340 hours, just prior to birds entering the scalding for line #2, I observed a live bird with the eyes wide open, the neck was not hanging and no blood was observed. I grabbed the bird and it responded with a twitching and squaking sound. Ms. (b) (6) was notified of the occurrence. The bird was identified as a cadaver approximately 6 minutes after it exited the pickers in the presence of Mr. (b) (6) and he was notified of the non compliance. NR number HYE4311022528N was recorded on 02/28/2012 with same occurrence of live birds going into scalders. 9 CFR 381.65 (b) states in part; Poultry must be slaughtered in accordance with good commercial practices in a manner that will result in thorough bleeding of the carcasses and ensure that breathing has stopped prior to scalding.
5309	P6137A	NJN210803 4113N-1	03/13/2012	01B01	Pre-Op SSOP Record Review	C	While performing a Pre-Operational sanitation record review in the Q.C. office at 0145 hrs, for the production date 3/10/2012, I noticed the following noncompliance. The SSOP Daily Implementation and Monitoring Log for the break room was not signed and dated by the sanitation supervisory personnel and/or designee. I informed (b) (6) of the forthcoming documentation of the noncompliance. The establishment's SSOPs state: (b) (4) . 9CFR 416.16(a) states: The establishment employee (s) specified in the sanitation SOP as being responsible for the implementation and monitoring of the procedure(s) specified in the sanitation SOPs shall authenticate these records with his or her initials and the date.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0615033 512N-1	03/12/2012	01C02	Operational SSOP Review and Observation	C	On 3/12 at approximately 0955 , while performing a Finished Product Standard check at the post chill area in plant 2 on line (b) (6) I observed the following noncompliances. After pulling a ten bird random sample I noticed 4 out of the ten birds had numerous tiny black specks on the breast, thigh, and the back area. I immediately notified (b) (6) (b) (6) had his workers stop hanging birds and started tanking off birds (three tanks), the tanks were held by QC, who had them reworked and also placed a hold tag on the product .At approximately 1012 after performing a recheck the birds were free of foreign material, and the company was allowed to return to production. My finding indicate noncompliances with the following regulations 416.1 416.4(d) and 416.13(c) .
5308	M6137	BXL2701032 410N-1	03/10/2012	01B02	Pre-Op SSOP Review and Observation	C	On 03/08/2012 while performing Pre-operational Sanitation Procedures in the Rotisserie Room, I observed noncompliance with regulations 9CFR 416.1, 416.2 (d) and 416.4(a). At approximately 2332 hours, I observed heavy beads of condensation formed on the ceiling above the Injector Machine, Metal Detector and the Conveyor belt. I informed (b) (6) and (b) (6) of the noncompliance. The Lead Person immediately took corrective action by sending Sanitation Personnel to wipe off the condensation. When Sanitation Person was wiping the condensation from the ceiling, the condensation was dripping on the conveyor belt between the Injector Machine and the Metal Detector. I informed (b) (6) . Sanitation Person after finished wiping off the condensation, washed the conveyor belt. At approximately 0043 hours sanitary conditions were restored and I released the area.
5309	P6137A	NJN430303 1010N-1	03/10/2012	01C02	Operational SSOP Review and Observation	C	I was in the Evisceration department at start up of operations when line inspector, Ms. (b) (7)(C) , called me to her station on "B" line station #1. The inspector had informed me that there was foreign material that looks like gray dust covering the entire station. Upon further investigation I noted that both lines "A" and "B" from the oil gland machine to the neck popper machine, including the drip pans and over head lights of the six USDA stations, were covered in this gray dust like foreign material. I took regulatory action by stopping and applying my USDA Reject/Retain tag # B38494981 to "A" line, "B" line, at 2310 hours. I informed Mr. (b) (6) of the noncompliance. After corrective actions the evisceration lines were reinspected and released at 2339 hours. No product was effected because both lines were stopped prior to the product reaching the effected area.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4409033 909N-1	03/09/2012	03J04	Poultry Zero Tolerance Verification	C	While performing Pre-Chill Finished Product Standard Check, I found a noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 417.2 (c)(4). On 03/09/2012 at approximately 0057 hours, I randomly removed a 10 bird sample from Line 9 in Plant #2, I found one out the ten birds with visible fecal contamination on the right side of the abdominal flap on the bird. The fecal material was a smear approximately 3/8" long and 1/4" wide and a chunk approximately 1/8" diameter, brownish green in color and pasty texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance. Fecal was contested and confirmed by Dr. (b) (7)(C). The protocol for fecal failure was implemented. Quality Control performed a Recheck at approximately 0131 hours and it passed. This is a violation of the critical limits of CCP-2B, (b) (4) of the Plant's HACCP Plan for Slaughter.
5333	P7632	HYE061703 4409N-1	03/09/2012	01C02	Operational SSOP Review and Observation	C	At 1316 hours while en route to perform a post chill finished products standards procedure at the exit of the north chiller, I observed that the birds had piled on the chiller rehang table to the point of overflowing. I proceeded to the north side of the table where I observed nineteen carcasses on the floor around the catch pan created to catch product overflow and on the grates where rehang employees stand. I observed three more birds fall to the floor with no one taking any effective corrective actions to regain process control. Regulatory control was taken of the process with the application of US Reject Tag B40193592. Regulatory control of the product was taken with the application of U.S. Retain Tag B40193593. (b) (6) was notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above. At 1318 hours regulatory control of the process was relinquished the acceptance of effective corrective actions to restore sanitary conditions, and the proposed preventive measure that the lead person and other employees responsible for the area would undergo additional training on how to more effectively handle product flow surges during returns from breaks and/or lunch. Regulatory control of the product was relinquished at 1330 hours after appropriate disposition was made. On 01/09/2012 a similar noncompliance was documented where product surge in the chiller rehang area resulted in product pile up on the floor around the chiller rehang table. The preventive measure of "training supervisors and leads on management practices in Chiller Rehang to aid in proper bin flow" failed to prevent the recurrence of this noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE472003 2609N-1	03/09/2012	01C02	Operational SSOP Review and Observation	C	<p>At 1328 hours on March 09, 2012, while verifying the corrective actions of an earlier noncompliance in the Chiller Rehang area, I observed thick sheets of water pulsating out of the top of the neck chiller exit chute. I observed that this was the result of a backlog of necks which had accumulated and plugged the mouth of the exit chute. The thick streams of water shooting out of the top of the chute washed across the insanitary surfaces of the overhead pipes, all-thread, brackets and other nonproduct-contact surfaces and fell into the two bins of edible necks which were being collected chiller exit. The water also fell into an uncovered tote filled with edible gizzards. Regulatory control of the two bins of necks and the tote of gizzards was taken with the application of U.S. Retained Tags B38494989, B38494990 and B38494991, respectively. (b) (6) was notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above as well as Step Two of the Establishment's SSOP Plan for the department which states, (b) (4).</p> <p>" At 1340 hours regulatory control was relinquished with the acceptance of effective corrective actions to restore sanitary conditions, make appropriate disposition of product and the proposed preventive measure that the associate assigned to the area will undergo training to ensure that the chute is not plugged prior to leaving the area.</p>
5308	M6137	BXL2606034 208N-1	03/08/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 2315hrs, I observed maintenance personnel working on the venting machine on Line 914 in Plant 2. After maintenance personnel completed their work, an evisceration supervisor washed the machine with water and the production line was started. After running for a few minutes the line was stopped again for more repairs. This scenario was repeated three times, because maintenance personnel were having difficulty figuring out the problem. At no time did a SSOP, HACCP or QC personnel check the venting machine for sanitary condition or release the venting machine to production. At approximately 2330hrs, the line was started after the venting machine was washed down a final time and everything was working properly. The establishment failed to follow the procedures of their SSOP program. In the SSOP Program: Section II-Operational Sanitation; Operational Sanitation Procedures: Implementation, states in part (b) (4).</p> <p>" In the SSOP Program, the "Equipment Breakdown Procedure" Revised on 11/04/11 states in part (b) (4).</p> <p>"</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN431003 0007N-1	03/07/2012	01C02	Operational SSOP Review and Observation	C	<p>On March 5, 2012 at approximately 1835 hours, while performing the PHIS task for review and observation of Operational SSOPs in the establishments fillet department, I observed a regulatory noncompliance of 9 CFR 416.15(b) and 416.4(a). Previously, at 1715 hours, I had observed a broken sprinkler on the ceiling of the fillet room. The sprinkler sprayed water and an unidentifiable black foreign material all over cone lines 5 through 12 and the product on these lines. The establishment had already stopped production and a QC representative had all affected product and equipment on hold. The establishment indicated that they would take complete corrective actions and restore sanitary conditions prior to resuming operations in the fillet room. At 1830 hours, according to the Operational SSOP records, all affected equipment had been returned to sanitary conditions by the QC. At this time I elected to verify the establishments implementation of the SSOP corrective actions. As described in 9 CFR 416.15(b), regarding the appropriate corrective actions to be taken in response to direct product contamination, "corrective actions include procedures to ensure appropriate disposition of product(s) that may be contaminated, restore sanitary conditions, and prevent the recurrence of direct contamination or adulteration of product(s)." I inspected the cone lines and determined that sanitary conditions had not been restored. I observed several pieces of fat and meat on the food contact surfaces of affected cone lines 5 through 12. The conveyor belts were operational when the sprinkler started spraying water and unidentifiable black foreign material on cone lines 5 through 12 and the product on these lines. The establishment did not completely restore sanitary conditions, as they failed to remove all fat and meat residues from the contaminated product on the belts and cones for lines 5 through 12. In addition, as described in 416.4(a) "all food contact surfaces, including food contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of an insanitary condition and the adulteration of product." I immediately notified Mr. (b) (6) that the establishment failed to fully restore sanitary conditions and also notified him of the forthcoming noncompliance record. At 2030 hours CSI, (b) (7)(C) inspected the affected equipment and found that sanitary conditions had been restored and released the area for production. The establishment elected to condemn all 3703 pounds of affected product.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1105031 606N-1	03/06/2012	03J04	Poultry Zero Tolerance Verification	C	While performing Pre-Chill Finished Product Standard check, I observed noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 417.2 (c)(4). On 03/06/2012 at approximately 0038 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination inside the bird under the left fat area by the cavity of the kidneys. The fecal material was a smear measuring approximately 3/4 inch diameter in size, brownish green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance, the protocol for fecal failure was implemented. Quality Control performed a Recheck at approximately 0106 hours and it passed. The cause of the deviation was the Inside/Outside bird washer. This is a violation of the critical limits of CCP-2B (b) (4) of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL2115031 905N-1	03/05/2012	01B02	Pre-Op SSOP Review and Observation	C	While performing Pre Operational Sanitation Inspection in the Packaging area, I found the following noncompliances:1- At approximately 0840 hours, while inspecting the debonning Line, I found pieces of meat and fat ranging from 1/8" to 1/4" all through out the conveyors; and also, approximately 70% of the white cutting boards around the debonning table, were dirty with meat particles and contained a dark build up of fat residue. Conveyor and cutting board on the debonning line are consider product contact surfaces. I immediately placed a U.S. Rejected tag NO. B31 406224 on the affected line. I notified (b) (6) of the noncompliance. 2- At approximately 0850 hours, while inspecting the tub wash room area, I noticed pieces of fat and meat affecting all the inside area of the Tub Wash Machine. These pieces of dried meat measured approximately 1/8' to 1/4" in size. I placed a U.S. rejected tag NO. B31 407519 on the affected equipment and then, proceeded to notify (b) (6) of the noncompliance. 3- At approximately 0855 hours while inspecting the Conveyor/Dumper area located in the packaging area next to the Tub Wash Room, I found two pieces of concrete each measuring approximately 1/4" in diameter. They were on top of the blue conveyor which is consider a food contact surface. I immediately placed a U.S. Rejected Tag NO. B31 406225 on the affected line. I notified (b) (6) of the third noncompliance. All affected areas were rewashed by sanitation. U.S.rejected tags were removed by USDA after sanitary conditions were restored. All areas were released at approximately 0920 hours.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2619032 402N-1	03/02/2012	01D01	SPS Verification	C	At approximately 1315 hours, I notice a noncompliance with regulatory requirement of 9 CFR 416.4(b) which states "Non-Food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." On the wall behind station #6 in plant 1, there was a squeegee holding a filthy sponge. This utensil is utilized to dried overhead condensation. The sponge was no longer yellow in color but black. It was torn and full of foreign material. I proceeded to place a U.S. Rejected tag NO. B31 407550 on the dirty squeegee. I then, notified (b) (6) of the noncompliance. She took immediate corrective action by disposing the dirty sponge and placing a new cleaned one in the squeegee. U.S. Tag was released by USDA after sanitary conditions had been restored.
5308	M6137	BXL4018030 602N-1	03/02/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 1114 hours, I found a zero tolerance fecal failure. I randomly selected 10 birds from line 1 plant 1. I found one out of the ten birds contaminated with feces. The fecal matter was dark yellow in color and pasty in texture. There were several smears of feces measuring approximately 1/16" on the bird's right leaf fat. There was also a chunk of feces measuring approximately 1/4" in diameter inside of the bird cavity by the kidney area. I immediately notified (b) (6) of the noncompliance. (b) (6) requested the Veterinarian's opinion. Dr (b) (7)(C) inspected the affected carcass finding it to be contaminated with fecal matter. The establishment fecal protocol was implemented. According to (b) (6) the cause of deviation was the sprayers of the Inside Out Bird Washer. Quality Control recheck passed at approximately 1128 hours after the cause of deviation had been established and the deficiency had been corrected by maintenance. Suspect lot was determined to be from 1146 hours to 1238 hours. Quality Control performed rechecks at the post chill for chiller 1. All of the rechecks were found acceptable. At 1248 hours, product was deemed to be acceptable for shipping.
5308	M6137	BXL5409032 802N-1	03/02/2012	03J02	Slaughter HACCP	C	On 03/02/2012 at approximately 0700 hours while performing a HACCP Slaughter supporting documentation review, I observed the following. The HACCP Monitoring Log CCP-2B (b) (4) dated on 02/28/2012 PM for Plant #1 was missing the Performed of Records Review, signature and time by the QC monitor. The Plant's HACCP Plan states (b) (4) ". My findings indicate a noncompliance with regulations 9CFR 417.5(a)(3) and 417.4 (a)(2)(iii). I notified (b) (6) of the noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN420903 0002N-1	03/02/2012	04A06	Poultry Finished Product Standards	C	<p>I was performing a FPS (Finished Products Standards) check at 0239 hours on the reprocessing line in the evisceration department when I noted the following noncompliance; The establishment failed to remove airsacculitis exudate from carcasses identified by USDA for air sac removal. (4) carcasses of the (10) carcass sample identified for air sac removal with a spit tail contained air sac exudates. The establishment's written procedure for air sac removal states;(b) (4)</p> <p>The procedure also states states;(b) (4)</p> <p>. I initiated regulatory control by stopping the reprocessing line and immediately informed Ms.(b) (6), and Mr.(b) (6) of the noncompliance.</p>
5333	P7632	HYE450503 5402N-1	03/02/2012	01C02	Operational SSOP Review and Observation	C	<p>While performing an Operational Sanitation Review and Observation task in the Packaging Department at 0158 hours I observed the following noncompliance: Above Tray pack line^(b) condensation was present and dripping onto the product contact surface while establishment employees were tossing down grade chicken drums from line^(b) over the small divider to line^(b) cross contaminating the product. I took Regulatory control of Tray pack line^(b) with U.S. retain tag # B38494966 and informed(b) (6) of the noncompliance. Mr.(b) (6) took immediate action by having the affected product removed from the line to a reprocessing brown tub to which I applied my U.S. retain tag B38494980. Control of Tray pack line^(b) was relinquished at 0208 hours after the product contact surface was resanitized and sanitary conditions were restored. The affected product was released after it was reprocessed per establishments procedure and passed FSIS reinspection. This noncompliance is linked to NR record number HYE1203012926N/1</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN590903 5801N-1	03/01/2012	03J02	Slaughter HACCP	C	<p>I was performing the slaughter HACCP verification task when I noted the two following noncompliance. I was reviewing the establishment HACCP records for CCP 1-B zero tolerance checks at 0723 hours in the evisceration department to verify the establishment was meeting the regulatory requirements as per 9 CFR 417.5(b) when I noted the following noncompliance. The HACCP designee documented the incorrect time for the HACCP CCP 1-B monitoring check conducted 0712 hours. The establishment's written HACCP plan states the (b) (4)</p> <p>(b) (4). The HACCP monitor documented the monitoring check for parts CCP 1-B at 0643 hours, the monitoring check for the reprocessing line CCP 1-B at 0656 hours, and the monitoring check for the paws CCP 1-B at 0612 hours. I notified the (b) (6) of the recordkeeping noncompliance. I was performing a records review verifying the establishments chilling procedures identified in a prerequisite program to verify compliance with the regulatory requirements when I noted the following noncompliance; The actual kill time of the carcass is not correctly identified and documented on the monitoring form associated to the temperature of the paws being verified. The correct time is required in order the verify that the paws have been chilled (b) (4) degrees F or below, in (b) (4) as outlined in the establishment's written procedures. The records I verified at the start of the shift show the first QC check for CP 3B paws to be acceptable at 2350 hours, with a temperature of 34.1 and a kill time of 2335. The actual kill time was approx. 2300 hours. I notified Mr. (b) (6) and Ms. (b) (6) of the recordkeeping noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1805023 229N-1	02/29/2012	01C02	Operational SSOP Review and Observation	C	On 02/28/2012 at approximately 2015 hours while monitoring the Establishments' temperatures in the Plant #1 Cooler, I observed the following. A mechanic was repairing the ceiling mounted refrigeration unit closest to the staging cooler door. I returned at approximately 2200 hours and found numerous pieces of black (UFM) to approximately 1/8" on a pallet of clean tubs. The tubs are used to store finished product. The pallet was directly under the unit and a large amount of UFM had gotten inside of the protective plastic wrap. There was also a tank of WOG's, without the normal protective plastic covering, staged for (b) (4) that had several specks of UFM to approximately 1/8". There were numerous specks of UFM to approximately 1/8" on a portable table used to clean cartilage in the (b) (4) Deboning Room. There were specks to numerous to count to approximately 1/4" on the lids of a partial pallet of giblets. (b) (6) had available sanitation personnel take the pallet of clean tubs to the tub wash room. The portable table was removed to the (b) (4) Deboning Room of cleaning. The lids on 9 tubs of giblets were replaced. I later contacted (b) (6) who had the WOG's removed to the (b) (4) Room for reconditioning with chlorinated water. Sanitary conditions were restored by approximately 0030 hours. My findings indicated a noncompliance with 9 CFR 416.4(d).
5333	P7632	HYE191102 2829N-1	02/29/2012	06D02	Other Inspection Requirements	C	At 0710 hours on February 29, 2012, while performing bird by bird antemortem inspection on Evisceration Line One, I observed an inordinate amount of birds being presented to me with the viscera still attached to the carcass. Due to the number of birds I received in this manner in succession and the manner in which the viscera were pinned between the carcass and the guide chain and/or forced the posterior opening closed, my ability to properly inspect these carcasses was impeded to the point that some had to be hung back so that they could be presented in a manner conducive to appropriate inspection. This, along with carcasses being hung back for salvage, caused my hangback rack to become full and required line stoppage so that the rack could be cleared. During the time that the line was stopped I observed that the floor employee was removing the viscera from the carcasses hung back for improper presentation and tossing the viscera down the drain prior to rehanging the birds back on the line to be inspected. This does not comply with 9 CFR 381.76 [a] which clearly states, "Apost-mortem inspection shall be made on a bird-by-bird basis on all poultry eviscerated in an official establishment. No viscera or any part thereof shall be removed from any poultry processed in any official establishment, except at the time of post-mortem inspection, unless their identity with the rest of the carcass is maintained in a manner satisfactory to the inspector until such inspection is made." (b) (6) was notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE421602 3829N-1	02/29/2012	04A06	Poultry Finished Product Standards	C	<p>At 1050 I observed a plant associate performing the on line vacuum procedure. I immediately asked the on line inspectors (b) (7)(C) and (b) (7)(C) if they had been informed that the company was going to implement the on line vacuum procedure. They had not been informed. The plants on line vacuum procedure, Document #: E-14 (10/21/2009), Revision #: 008 (12/05/2011), states; (b) (4)</p> <p>(b) (4)</p> <p>I informed (b) (6) and (b) (6) of the plants failure to follow the written procedures to inform Inspection Personal of the implementation of the on line vacuum procedure and of the forth coming documentation of the non-compliance.</p>
5308	M6137	BXL4013023 728N-1	02/28/2012	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 1048 hours, I found a zero tolerance fecal failure. I randomly selected 10 birds from line 2 plant 1. I found one out of the ten birds contaminated with feces. The fecal matter was light yellow in color and pasty in texture measuring approximately 1/2" in diameter. It was located inside of the bird cavity near the tail area. I immediately notified (b) (6) of the noncompliance. The establishment's zero tolerance protocol was implemented. According to (b) (6) the cause of deviation was the Inside Out Bird Washer. Quality control recheck passed at approximately 1103 hours after the cause of deviation had been established and deficiency had been fixed by maintenance. Suspect lot was determined to be from 1145 hours to 1215 hours. Quality control performed rechecks at the post chill for chiller 2. All of the rechecks were found acceptable. Product was deemed to be acceptable.</p>
5308	M6137	BXL5909021 828N-1	02/28/2012	03J02	Slaughter HACCP	C	<p>On 02/28/2012 at approximately 0544 hours while performing a Post-Chill Finished Products Standards test in Plant #1 on Line #1, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. There was a cloaca attached inside the carcass at the tail with approximately 4" of intestine. The fecal contamination, a smear approximately 1/4" in size, was located on the left side leaf fat. The fecal material was light brown in color and sticky in texture. As there were no Packaging Department Supervisors available, I asked the establishment personnel hanging birds from Chiller #1 going to sorting and sizing to stop hanging. I asked a lead person nearby to tank the product coming from chiller #1. I contacted Plant #1 (b) (6) and showed him my findings. A recheck passed at 0547 hours. Two tanks of birds were placed on hold for rework. My findings indicated a noncompliance with 9 CFR 417.(c)(4) and 9 CFR 381.65(e).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE431102 2528N-1	02/28/2012	04C05	Poultry Good Commercial Practices	C	During a Good Commercial Practice visit by District Veterinary Medical Specialist Dr. (b) (7)(C), she and IIC Dr. (b) (7)(C) toured the live hang and kill area of the establishment. At 0825 hours, they observed a breathing bird entering the scalders. At 0828 hours, they observed a second breathing bird entering the scalders. These birds were later identified as cadavers as they exited the pickers. The cuts on both birds were insufficient to allow for effective bleed-out. (b) (6) was present during the event and was immediately notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above. Ms. (b) (6) performed an immediate correlation with the appropriate supervisory staff.
5308	M6137	BXL2909025 424N-1	02/24/2012	03J04	Poultry Zero Tolerance Verification	C	On 2/24/2012 at approximately 0240 while performing a Zero Tolerance Fecal check in plant 1 on line 2, I observed the following. After taking a ten bird random sample, I observed the following one bird out of the ten contaminated with visible fecal in two separate areas. There was fecal covering the tip of the hock in a 1/8 to 3/8" area the other site was on the left side of the opening cut also ranging from 1/8 to 3/8". the fecal was watery in texture and greenish brown in color. I notified (b) (6) who notified (b) (6) and also (b) (6) of my findings. The company's fecal protocol was immediately implemented. Quality Controls recheck passed at 0303 putting the company back in compliance. My findings indicate a noncompliance with CFR 381.65(e) and 417.2(c) (b) (4) of the company's HACCP plan.
5308	M6137	BXL4509023 224N-1	02/24/2012	03J04	Poultry Zero Tolerance Verification	C	On 02/24/2012 at approximately 0540 hours while performing a Finished Products Standards check on line 2 in Plant #2, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. There was a gizzard with a piece of intestine approximately 12" long inside the carcass. There was visible fecal contamination to approximately 1/2" at several spots in the kidney area. The fecal material was medium brown in color and was starting to dissolve into the (b) (4). I contacted (b) (6) who implemented the Establishments' protocol for mainline fecal failure. A recheck passed at 0618 hours. My findings indicated a noncompliance with 9 CFR 417.(c)(4), 9 CFR 381.65(e), and the critical limit of CCP-2B (b) (4) of the Plants Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE121502 2124N-1	02/24/2012	01C02	Operational SSOP Review and Observation	C	<p>At 1049 hours on 02/24/2012 while performing the review and observation component of an operational sanitation inspection procedure in the drumstick tray-pack area in 2nd Processing, I observed an associate washing down the floor with a high pressure hose. As he washed the floor he sprayed water and debris from the floor across, over and on two totes of uncovered drumsticks situated on a stand next to the tray-pack lines. Regulatory control of the product was taken with the application of U.S. Retained Tag B34776917 and (b) (6). [REDACTED] z was notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above. This includes the establishment's SSOP plan which states, "(b) (4) [REDACTED]". At 1251 hours regulatory control of the product was relinquished with the acceptance of effective corrective actions including the restoration of sanitary conditions, appropriate disposition of product and the proposed preventive measures that the associate would undergo training on the importance of protecting product during rinse downs.</p>
5308	M6137	BXL0710022 723N-1	02/23/2012	03J04	Poultry Zero Tolerance Verification	C	<p>On 02/23/2012 at approximately 0548 hours while performing a Finished Products Standards check on Line (b) (6) in Plant #2, I observed the following. After taking a random 10 bird sample, I observed one bird with visible fecal contamination. There was a piece of intestine approximately 12" long attached at the tail. Fecal material, approximately 3/8" by 1/4", had leaked from the cut end onto the mid joint of the right wing. The fecal material was olive brown in color and pasty in texture. I contacted (b) (6) [REDACTED] who implemented the establishments protocol for mainline fecal failure. A recheck passed at 0632 hours. My findings indicated a noncompliance with 9 CFR 417.(c)(4), 9 CFR 381.65(e), and the critical limit of CCP-2B (b) (4) [REDACTED] of the Plants HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1310024 723N-1	02/23/2012	01C02	Operational SSOP Review and Observation	C	<p>On 02/23/2012 at approximately 0310 hours while monitoring the establishments' Operational Sanitation Procedures in Plant #2, I observed the following. Lines were stopped due to multiple pieces of malfunctioning equipment. Tanks were full at the rehang station, where birds are moved from the kill line to the eviscerating line. An empty backup tank is normally located between lines (b) (4) but that tank had already been filled. A tank was brought from Packaging Dept by (b) (6) and shoved over approximately 30 birds in a pile on the floor increasing the level of contamination of the affected birds. The birds were rinsed and rehung onto the eviscerating line. At approximately 0408 hours, birds were brought into the eviscerating floor before plant employees scheduled lunch was over. Line (b) (4) was stopped causing a pileup again at the rehang station. The birds were dropping on the floor as all the tanks were full with over scalded birds condemned by the establishment before lunch. At approximately 0435 hours the kill line was reduced by 12.5% or (b) (4). At approximately 0442 hours the kill was reduced to 25% allowing birds on the floor, approximately (b) (4) birds, to be rinsed and hung onto the eviscerating line. The last birds were picked up be approximately 0457 hours. As there is only one bird wash hose at the (b) (4) rehang station birds are tossed across space of several feet to condense the piles. The floor at the rehang area is contaminated with varying amounts of blood and debris from the kill line. The establishments' SSOP 'Reconditioning Procedure' under #1 states "(b) (4) and (a) states that "(b) (4) " Birds should be slaughtered in a sanitary manner using Good Commercial Practices. My findings indicated a noncompliance with 9 CFR 416.4(d).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5003021 623N-1	02/23/2012	01C02	Operational SSOP Review and Observation	C	<p>On 02/22/2012 at approximately 0128 hours while monitoring the Establishments' Operational Sanitation Procedures in Plant #2, I observed the following. Line 4B had stopped causing a backup at the rehang station where birds from the kill line are transferred to the processing line. The tank, catch tray, and the conveyor belt were full with birds. Approximately (b) (4) birds were on the floor in an area extending from the tank to the rehang belt. (b) (6) observed what I saw and reduced the live hang by 12.5% or (b) (4) birds. Three tanks were filled with excess birds before the kill was reduced by 25%. At 0138 hours birds were again falling on the floor as the rehang belt and all available tanks were full. Not until approximately 0144 hours was the kill reduced to less than 50% so that the pileup could start to be reduced. The last birds were picked up by approximately 0151 hours. As there is only one bird wash hose at the (b) (6) rehang station birds are tossed across a space of several feet to condense the piles. Birds that end up under equipment are dragged out using a hook. The floor area involved is contaminated with varying amounts of blood and debris from the kill line. The establishments SSOP 'Reconditioning Procedure' under #1 states (b) (4) ."</p> <p>" and (a) states that (b) (4) ."</p> <p>" Birds should be slaughtered in a sanitary manner using Good Commercial Practices. My findings indicated a noncompliance with 9 CFR 416. 4(d).</p>
5308	M6137	BXL3309022 118N-1	02/18/2012	03J04	Poultry Zero Tolerance Verification	C	<p>On 02/18/2012 at approximately 0654 hours while conducting a Finished Products Standards check, I observed the following. After taking a random 10 bird sample from Line #1 in Plant #1, I observed one bird with visible fecal contamination. There was a cloaca and approximately 4" of intestine. The intestine was attached at a point approximately 3" inside the carcass. Fecal material, approximately 1/8" in size, was leaking from the cut end of the intestine into the area of the kidneys. There was also a tear in the intestine approximately 1" from the cloaca and fecal material approximately 1/4" by 1/16" in size had leaked onto the inside of the carcass at the base of the tail. I contacted (b) (6) who implemented the Protocol for mainline fecal failure. A QC recheck passed at approximately 0717 hours. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), 9 CFR 381.65(e), and the critical limit of CCP-2B (b) (4) of the Plants HACCP Plan for Slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN361502 3217N-1	02/17/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 1050 hours while performing the PHIS task for zero tolerance on the reprocessing line I observed one carcass of a ten carcass sample with visible fecal material on the carcass. The fecal material was located on the carcass at the area were the breast and thigh is joined together and was approximately one quarter of an inch in diameter with a paste-like texture and brownish in color. I immediately took regulatory control of the reprocessing line and showed my findings to Mr. (b) (6), and the QC technician assigned to that area. That the establishment would have allowed a carcass with visible fecal material to enter the chilling tank represents non-compliance with 9 CFR 381.65(e). A similar non-compliance was documented on 01/25/2012 NR # NJN5216011625N in which the establishment proffered the further planned action of retraining the employees. This further planned action was not effective in the elimination or reduction to an acceptable level the recurrence of this non-compliance. This document serves as written notification that your failure to comply with regulatory requirement's could result in additional regulatory or administrative action.
5308	M6137	BXL4205023 016N-1	02/16/2012	01B02	Pre-Op SSOP Review and Observation	C	On 02/15/2012 at approximately 2355 hours while monitoring the establishments' Preoperational Sanitation Procedures, I observed the following. In Packaging Area #1, there was a large amount of soured tissue to approximately 2" in size on the stainless and white support brackets under the transfer conveyor after the x-ray machines and on the first couple of feet of the associated incline conveyor that transports product to the final trim station. There was dried blood and tissue on the stainless frame on at least a 20' section of the overhead boneless breast conveyor belt adjacent to the crust tunnel. Per their policy the affected areas were rinsed with potable water restoring sanitary conditions by approximately 0015 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE080702 0816N-1	02/16/2012	01D01	SPS Verification	C	This non compliance record replaces non compliance record HYE5202010210N. This non compliance record has been reclassified from an SSOP verification to a SPS verification non compliance record which was previously recorded on 1/10/12. At approximately 0020 hours while performing the SPS verification task in the second processing department (bag line), I observed the following non compliance; during the start of the bag line, baskets were being brought in from the 0°F degree cooler which had fat particles and frozen blood from previous days production. One of the baskets had a part of a gizzard in it which I observed employees using these baskets to put bagged product onto. I informed (b) (6) of the forthcoming non compliance record. 9CFR.4 (b) states; "Non food contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product."
5333	P7632	HYE381202 5516N-1	02/16/2012	01C02	Operational SSOP Review and Observation	C	At 0938 hours on February 16, 2012, while performing an operational sanitation inspection procedure in 2nd Processing I observed a night shift employee handle a wooden pallet. Without sanitizing his hands he started placing liners into 2 bulk product cases and then proceeded to place 10 lb. bags of leg quarters into the cases. I placed US Retained Tag #B38 494958 on the cases. Mr. (b) (6) was informed of this situation, the case of product with the leg quarters was removed from the pallet to be reworked and the liner was removed from the other case. At 0945 hours regulatory control was relinquished after effective corrective actions which included restoration of sanitary conditions.
5308	M6137	BXL5403023 515N-1	02/15/2012	01B02	Pre-Op SSOP Review and Observation	C	On 02/15/2012 at approximately 0000 hours while monitoring the Establishments' Preoperational Sanitation Procedures, I observed the following. In Packaging Area #1, there were numerous pieces of fat to 3" all along both the product and tray belts associated with line 01. The line was returned to service by approximately 0016 hours. In Packaging area #2, the (b) (4) deboning room, there were several red paint chips to approximately 1/8" on a small portable table used near line #1 to trim miscut wings. There were several pieces of fat and tissue to 2" on the large belt that collects the skin from line 01. There was a thick layer of black (UFM) that appeared to be mold on the stainless and white nylon support brackets of the same belt. Also on line 01 there was a patch, approximately 3" in diameter, of black (UFM) with the consistency of mold on the stainless vertical bracket associated with the belt that transports the skin from line (b) (4) to the boxing area. There were also two red paint chips to approximately 1/4" on a small conveyor belt associated with line 01. Sanitary conditions were restored by rinsing the affected items with potable water per establishment policy by approximately 0036 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3609021 914N-1	02/14/2012	01C02	Operational SSOP Review and Observation	C	On 02/14/2012 at approximately 0335 hours while monitoring HACCP Raw Intact functions in Packaging, I observed the following. There was a partial rack of five baskets containing bulk wrapped breast meat in the bulk side of the Crust Tunnel. The baskets were mis-stacked causing product to be forced out of the bags and through the sides of the baskets. The exposed product had changed color to light brown and had become a semi-solid mass due to the chilling process. As the baskets are not considered to be a product contact surface, I attached U.S. Retained Tag #B31407506 to the rack labeled #14660, Day Shift, Feb 13,2012 and product code #227. I contacted (b) (6) who sorted the product that was still wrapped and condemned the rest. Approximately 80 pound of product was placed in a inedible container. My findings indicated a noncompliance with 9 CFR 416.4(d).
5308	M6137	BXL5713020 613N-1	02/13/2012	04A06	Poultry Finished Product Standards	C	At approximately 0918 hours, while performing a Finish Product Standard check at the post chill area of chiller #2, I found the following noncompliance: I observed foreign material on the carcasses coming out of the chiller. Black speck were very noticeable on the breast area near the neck. I notified Packaging (b) (6) and SCS (b) (7)(C) of my findings. I extended my check finding several more birds affected with foreign material. USDA took immediate corrective action by having production tank off the product coming out of chiller #2. There were 7 tanks retained for rework. Each one of these tanks was identified by the establishment with a red hold tag. At approximately 0945 hours, carcasses coming out of the chiller were found to be acceptable by USDA. Production was resumed. All retained carcasses were reworked birds by bird by the establishment. USDA performed several rechecks on the reworked product, finding it acceptable.
5308	M6137	BXL3614024 411N-1	02/11/2012	01C02	Operational SSOP Review and Observation	C	On Saturday at approximately 1210 hours while walking by the packaging storage area located next to the weigh and price office, I found the following noncompliance. I noticed a clear plastic bag full of approximately 140 yellow trays labeled 52P325P. This bag was on a pallet located under the box conveyor leading to weigh and price. These yellow trays are utilized to pack edible product, therefore they are consider to be product contact surfaces. The boxes being transported on the upper box conveyor create cardboard dust that could contaminate any uncovered edible material located underneath. As I got closer, I noticed fresh chunks of fat and bloody moisture on these trays. These trays had been used by packing during the night shift and stored to be used the next working day, Monday. I Immediately placed a U.S. Rejected/Retained Tag No. B31 407451 on the affected packaging material. I then, proceeded to notified (b) (6) of the noncompliance. He took immediate corrective action by disposing of the contaminated trays. The U.S. Tag was released by USDA after sanitary conditions had been restored.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN010702 4210N-1	02/10/2012	03J02	Slaughter HACCP	C	<p>I was performing a Slaughter HACCP verification procedure, verifying the establishment's prerequisite program for the use of an OLR (On Line Reprocessing) agent (b) (4) when I noted the following non compliance. The supporting documentation does not state the significance of the (b) (4) temperature to carcass temperature, the (b) (4) solution is not applied as described in the SIP letter, and the establishment does not have records documenting the temperature of carcasses at the time the (b) (4) is applied. The protocol listed in the establishment's Salmonella Initiative Program (SIP) letter dated February 7, 2012 states: (b) (4)</p> <p>(b) (4)</p> <p>To verify the implementation of the SIP program I reviewed the establishment's records monitoring the (b) (4) temperatures and performed a hands on verification task. I reviewed several weeks of records and noted the temperature of the (b) (4) solution fluctuates from (b) (4) degrees F to (b) (4) degrees F on a daily basis but the establishment had no records documenting the temperature of the carcasses. I took the temperature of a carcass prior to entering the (b) (4) cabinet using a calibrated thermometer and compared it to the temperature of the (b) (4) solution. The internal breast temperature of the carcass was (b) (4) degrees F and the (b) (4) solution temperature was (b) (4) degrees F. The (b) (4) solution exceeded the carcass temperature. This is a deviation from the SIP protocol. I informed (b) (6), of the non compliance.</p>
5333	P7632	HYE572102 1810N-1	02/10/2012	01D01	SPS Verification	C	<p>On January 13, 2012, at approximately 0157 hours while virifying Sanitary Performance Standard (SPS) Requirements in the (b) (4) degree cooler I observed the following non compliance: I observed two employees pushing racks of product onto the robot cage track with their boots. Upon closer observation at the end of the transfer belt at line (b) (4), I noted grimme and dirt on two of the baskets and dirt and grimme on some of the packages of product inside baskets that were ready to be placed on the line to be priced. I took regulatory control of the two baskets and the product with the application of U.S. Reject Tags #B40219474 and #B39415933, and informed Mr. (b) (6) and (b) (6), of the non compliance. By the request of the establishment this NR was reclassified from SSOP to SPS to replace NR #HYE2406011714N/1 recorded on January 13,2012</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3308021 809N-1	02/09/2012	01C02	Operational SSOP Review and Observation	C	On 02/09/2012 at approximately 0230 hours while monitoring the Establishments' Operational Sanitation Procedures, I observed the following. In the Plant #2 Cooler there were numerous specks of black (UFM), several to approximately 1/2", on the lids of two pallets of salvaged parts tubs located under the refrigeration unit closest to the Packaging Department door. There were also several tanks with numerous specks of black (UFM) and pieces to 3/8" on the plastic used to cover the tanks. The larger pieces of UFM had a consistency of blackened dust. I contacted (b) (6) who had the lids on approximately 15 tubs and the plastics on 6 tanks replaced by approximately 0236 hours. As Packaging production normally starts by 0030 hours, I checked several tanks in use but found no UFM. I returned at approximately 0410 hours and again there were numerous pieces of black (UFM) ranging in size from specks to 3/8" on the plastic covers of 8 tanks in front of the refrigeration unit closest to the Packaging Department door. I contacted (b) (6) who was again nearby. The plastics were replaced and all the tanks were moved to the other side of the cooler. The plastic covers on two tanks of ice had holes where the pallet jack grabs onto the tank. There was black (UFM) in the ice directly under the hole in the plastic covers. The affected ice was discarded. Sanitary conditions were restored by approximately 0425 hours. My findings indicated a noncompliance with 9 CFR 416.4(d).
5308	M6137	BXL3514023 809N-1	02/09/2012	01C02	Operational SSOP Review and Observation	C	On 02/08/2012 at approximately 1840 hours, I observed the following noncompliance in plant 2 cooler. There was a wood pallet holding 5 brown tubs full of product. The lids covering this product were affected with foreign material (dust, dirt and wood chips). I placed a US Retained/Rejected Tag No: B31 407495 on the edible containers. I also noticed four cardboard bin with edible ice, a couple of cleaned empty stainless steel bins covered with blue liners and a partially covered tank with dirty ice. All of these containers were affected with foreign material. I proceeded to tape around the affected containers and placed a US Retained/Rejected Tag No. B31 407475. I notified (b) (6) of the noncompliance. He took immediate corrective action by disposing of the affected ice and contaminated liners. Dirty lids covering edible brown tubs were replaced by cleaned lids. USDA tags were removed after sanitary conditions had been restored.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5208021 709N-1	02/09/2012	01D01	SPS Verification	C	On 02/09/12 at approximately 0204 Hr's while performing SPS verification checks in the rotisserie room I observed the following non-compliance to 9 CFR 416.2(d) and 9 CFR 416.1. I observed heavy beaded condensation under the box conveyor line leading from the box assembly machine to the packing area. I immediately took regulatory control by applying U.S Reject tag # B31407225 to the area under the conveyor line and informing (b) (6) of my observation. Ms. (b) (6) took immediate corrective action in my presence by having the condensation wiped off to restore sanitary conditions. Regulatory control was relinquished at 0216 Hr,s after sanitary conditions were restored
5308	M6137	BXL5914021 909N-1	02/09/2012	01D01	SPS Verification	C	On 02/08/2012 at aproximately 1900 hours, I observed a noncompliance in the Rotisserie Room. There was a wood pallet holding approximately 20 dusty and sandy (b) (4) bags. There was a couple of open bags on top of the pallet. The (b) (4) inside of this bags was contaminated with black specks. I immediately placed a US Reject/Retained tag No: B31 407474 on one of the bags and also a Tag No. B31 407494 on the second bag (b) (4) is a restricted ingredient which is diluted in water and utilized as a prechill antimicrobial intervention for carcasses. On 02/09/2012 I notified (b) (6) of the noncompliance. She took immediate corrective action by properly disposing of the contaminated (b) (4) USDA tags were removed after sanitary conditions had been restored.
5308	M6137	BXL4205020 307N-1	02/07/2012	03J04	Poultry Zero Tolerance Verification	C	On 02/07/2012 at approximately 0056 hours while performing a Finish Products Standards check on line (b) (6) in Plant #2, I observed the following. After selecting a 10 bird random sample, I observed one carcass with visible fecal contamination. There was a cloaca attached by a small piece of tissue at the tail with approximately 3" of intestine. There was visible fecal material leaking from the cloaca on to the outside of the carcass at a point approximately 1" below the tail. I showed (b) (6) my findings. He contacted (b) (6) who implemented the protocol for fecal failure. The fecal material was approximately 3/8" in size, olive green in color and pasty in texture. The recheck passed at approximately 0135 hours. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), 9 CFR 381.65(e), and the critical limit of CCP-2B (b) (4) of the Plants HACCP Plan for Slaughter.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE071202 1003N-1	02/03/2012	01D01	SPS Verification	C	<p>At 0754 hours on January 26, 2012, while performing an operational sanitation inspection procedure in 2nd Processing, I observed a machinist working on the Enhanced Line. I observed him handle equipment and other various nonproduct-contact surfaces with his soiled, bare hands. After making adjustments to the machine, he did not wash or sanitize his hands or put on gloves. He went immediately to the end of the line and picked up three packages of product and inspected them for effective sealing. He then tossed the packages back into the process flow without washing, wiping, or sanitizing the packages, nor did he take any other action to demonstrate that sanitary conditions had been maintained. The employee at the end of the line commingled the packages with the other product in the baskets to be sent to shipping. The SPS regulation in 9 CFR 416.5(a) requires persons working in contact with product, food-contact surfaces, and product-packaging materialsto adhere to hygienic practices while on duty to prevent adulteration of product and the creation of insanitary conditions. The machinist took no steps to demonstrate that his hands were maintained in sanitary condition after handling nonproduct contact surfaces. This does not comply with the regulatory requirement. No steps were taken to demonstrate that this did not create insanitary conditions on the packages which could contaminate the product when the customer opened them. This does not comply with 416.4[b] which states that nonproduct-contact surfaces must be cleaned and sanitized as often as necessary to prevent the creation of a sanitary condition. Regulatory control of the the affected product (48 packages in four baskets) was taken with the application of US Retain Tag #B38 494939 and (b) (6) was notified of the forthcoming documentation of the noncompliance. At 0800 hours, regulatory control of the product was relinquished to the QC department for appropriate disposition. This noncompliance was originally documented as an operational sanitation noncompliance on NR HYE5710010326N/1. On 01/30/2012, the plant appealed the classification of the noncompliance, contending that the outside of a sealed package is not considered to be a product contact surface. Consultation with PDD supported this position. Therefore this noncompliance is being documented more appropriately as an SPS noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3705024 102N-1	02/02/2012	04B04	General Labeling	C	<p>On 01/28/2012 at approximately 2100 hours while monitoring Establishment HACCP, prerequisite programs and supporting documents, I observed the following. The Retained Moisture Evaluation document dated 01/27/2011 PM shift, Plant #2, chiller #3 indicated a moisture gain for the sampled product of 10.47%. I review the Establishments' documents in the Moisture Protocol binder but could not find a current protocol that would show the maximum moisture gain percentage allowed and corrective action if that percentage was exceeded. I contacted (b) (6) who after consulting with (b) (6) determined that the existing protocol was out dated but that the revised protocol would be based upon previous testing and that the maximum moisture gain would be established at (b) (4), at which time in the future corrective actions would be implemented. The 10.47% gain on 01/27/2012 exceeded the acceptable percentage and no corrective action was taken. A review of the Retained Moisture Evaluation file for the week of 1/23 to current revealed that on 02/01 PM shift plant #2 chiller #3 therecorded moisture gain for the shift was 10.35%, on 01/25 PM shift Plant #2 Chiller #3 the recorded moisture gain for the shift was 11.48%, on 01/24 PM Plant #2 Chiller #3 therecorded moisture gain for the shift was 11.73%, and for 1/23 PM Plant #1 chiller #2 the recorded moisture gain was 11.06%. My findings indicated a noncompliance with 9 CFR 441.10 (a).</p>
5333	P7632	HYE180702 4002N-1	02/02/2012	04A06	Poultry Finished Product Standards	C	<p>I was conducting the Poultry Finished Product Standard verification task in First Processing on the reprocessing offline at approximately 0437 hours when I observed the following non compliance: I selected ten birds marked for cellulitis reprocessing with a horizontal slash across the back after all plant interventions had taken place. Two of the ten birds had yellow flakes of cellulitis exudate on the inner thigh of the birds. I then stopped the line and applied U.S. retain tag B3849463 and showed my findings to (b) (6) (b) (6) performed two rechecks and found one out ten with cellulitis exudate in both rechecks, both failed. The third recheck passed and regulatory control of the Offline was relinquished at 0450 hours and (b) (6) was informed of the non compliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE001201 2328N-1	01/28/2012	01D01	SPS Verification	C	At 9:25 am while performing an SPS (sanitation performance standards) procedure, in 2nd processing, I observed the following non compliance. In the small storage room to the west of the tub wash area, mold was observed approximately 4 foot high by 3 foot wide on the west wall. I informed (b) (6) of the finding and of the forth coming non-compliance. Mr (b) (6) informed me that he would notify sanitation to have the walls properly cleaned. The requirements of 9CFR 461.1 and 9 CFR 416.2(b) (2) were not met. 9CFR 416.1 states; " Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." 9CFR 416.2(b)(2) states; "Walls, floors, and ceilings within establishments must be built of durable materials impervious to moisture and be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions."
5308	M6137	BXL0305013 528N-1	01/27/2012	03J04	Poultry Zero Tolerance Verification	C	On 01/28/2012 at approximately 0105 hours while performing a Finished Products Standards check on Line (b) (4) in plant #2, I observed the following. After selecting a 10 bird random sample, I observed one bird with visible fecal contamination. There was a cloaca attached at the tail. Approximately 2" of intestine was attached to the cloaca with approximately 1/4" of fecal material leaking from the cut end onto the exterior upper thigh area. The fecal material was light brown in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. I showed (b) (6) my findings. He implemented the protocol for fecal failure. The recheck passed at 0131 hours. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), 9 CFR 381.65(e), and the critical limit of CCP-2B (b) (4) of the Plants HACCP Plan for Slaughter.
5333	P7632	HYE120301 2926N-1	01/26/2012	01C02	Operational SSOP Review and Observation	C	While performing an Operational Sanitation Review and Observation task at 0021 hours in the Packaging Department I observed the following noncompliance: Above tray pack lines (b) (4) a large amount of condensation was present and dripping directly onto product. The two over head light structures above tray pack lines (b) (4) were also contaminated with dry particles of meat, fat, and blood from the previous day's production. I took regulatory control of both tray pack lines (b) (4) with the application of retain tag #B39415922. The affected product, seven brown tubs of bulk salvaged product, was retained with retain tag #B39415926. I informed (b) (6) of the noncompliance. Control of lines (b) (4) was relinquished at approximately 0041 hours after sanitary conditions were restored. Product was released at 0245 hours after I reinspected the seven brown tubs and product acceptable.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE571001 0326N-1	01/26/2012	01C02	Operational SSOP Review and Observation	C	At 0754 hours on January 26, 2012, while performing an operational sanitation inspection procedure in 2nd Processing I observed a machinist working on the Enhanced Line. I observed him handle nonproduct-contact surfaces with his unsanitary, bare hands. After making adjustments to the machine, he went to the end of the line without washing or sanitizing his hands or putting on gloves. He picked up three packages of product to inspect them for effective sealing. After inspecting the packages, he tossed them back into the production process without wiping or sanitizing the packages. A second employee collecting the packaged product at the end of the line did not wipe, wash or sanitize any of the three packages prior to placing the packages into product baskets with the other packaged product which had been tray-packed under sanitary conditions, nor did he wash or sanitize his gloves prior to handling other package product going into the product baskets. This commingled the three packages exposed to conditions whereby they may have been adulterated with product which had not been previously exposed to unsanitary conditions. Regulatory control of the affected product - 48 packages in four baskets - was taken with the application of US Retain Tag #B38 494939 and (b) (6) was notified of the failure to comply with their regulatory requirements cited above. At 0800 hours regulatory control was relinquished with the acceptance of the effective corrective actions which included restoration of sanitary conditions, product released to QC for appropriate disposition, and the proposed preventive measure that maintenance personnel would undergo training to ensure that they handle product in a sanitary manner. On 01/30/2012, the establishment appealed to have the NR reclassified to an SPS noncompliance based on the contention that once packages were sealed, the exterior of the package was no longer considered a product-contact surface. Consultation with PDD confirmed this position and it was determined that it was a SPS noncompliance. A new NR documenting this as a SPS noncompliance will be issued.
5309	P6137A	NJN521601 1625N-1	01/25/2012	03J04	Poultry Zero Tolerance Verification	C	While performing PHIS Task (Fecal Zero Tolerance) at 0919 hours on the reprocessing line, I observed one carcass in a ten carcass sample with visible fecal, greenish brown in color of a paste-like material, approximately 1/4 inch in length and 1/8 inch in width on the inside of the carcass at the keel bone area. I immediately took a regulatory control action and stopped the line. Mr. (b) (6), was called over and agreed with my findings. I informed him of the forthcoming noncompliance and released the bird to production.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4109015 625N-1	01/24/2012	04A06	Poultry Finished Product Standards	C	<p>On 01/24/2012 at approximately 0230 hours while monitoring Establishment Finished Product Standards in Plant #2, I observed the following. The Finished Products Standards log for line 916 documented that a Quality Control failure occurred at 0138 hours with 51 weighted nonconformance points in the Processing Category. At that point CUSUM had reached the Action Number and the process is judged to be out of control. The last passing check by QC on line 916 was done at 0004 hours. A required recheck had been done at the Post-Chill location at 0149 hours. A recheck was done at the prechill station at 0205 and 0210 hours bringing the process back into control. However, the Establishment was still responsible for the failed product in the chilling system. I reviewed the logs toward the end of the shift and found that a second post-chill recheck had been done at 0225 hours. Based upon a moisture check on chiller #4 for the shift dwell time for product in chiller #4 at 0512 hours was 63 minutes. I used that time as an estimate of the time product was in the chilling system at the timer of the failure. Meaning that failed product in the chilling system for Chiller #4 should have been monitored for 63 minutes after the prechill recheck passed at 0205 hours until approximately 0308 hours. 9 CFR 381.76 (b) states that corrective action shall be taken as set forth in 9 CFR 381.76 (b)(3)(iv)(d)(4) which states that "In no case shall the time between retests exceed 30 minutes of production time." The rechecks performed do not meet that requirement. The post-chill retests documented at 0149 hours and 0225 hours reflects a period of 36 minutes between tests. Plus the time between 0225 hours and the end of the failed product exiting the chilling system estimated at 0308 hours allows another 43 minutes between tests. This 43 minutes also includes the time at approximately 0240 hours when the product identified by the 0138 hours initial failure would have been exiting the chiller. Consequently no product was retained or reworked based upon the post-chill rechecks taken. I discussing the issue with (b) (6). My findings indicated a noncompliance with 9 CFR 381.76(b).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1709010 021N-1	01/20/2012	01D01	SPS Verification	C	On 01/21/2011 at approximately 0405 hours while monitoring Establishment shipping temperatures, I observed the following. There was a trailer on the loading dock #7415 with heavy dripping condensation. There were 7 bins and 4 pallets of tubs on the trailer. I observed no product being loaded. The trailers are not treated as product contact surfaces. The bins are not covered and any contaminant that gets into the bin or on the liner could be transferred to the product during dumping. I checked the other trailers on the dock and they were all operating normally. As the loading dock personnel were on break, I went to Packaging and contacted (b) (6) and showed him the trailer. The only visible difference between the trailers was that the white tarp that runs from the compressor to the rear of the truck was not attached at the compressor end on trailer #7415. The condensation was wiped from the rear of the trailer. The bins were removed from the left side of the trailer. The tarp on the front end of the trailer, approximately 20', was dry. The tarp was reattached to the compressor. The product was removed from the right side of the trailer and the remaining condensation that was still in a liquid state was removed restoring sanitary conditions by approximately 0435 hours. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).
5308	M6137	BXL1705014 520N-1	01/19/2012	01B02	Pre-Op SSOP Review and Observation	C	On 01/20/2012 at approximately 0015 hours while monitoring the Establishments' Preoperational Sanitation Procedures in Packaging Area #1, I observed the following. There were several small pieces of tissue on a removable tray on Breast Processor #12. The tray directs wings to a collection belt below the machine. I removed the tray and gave it to an Establishment employee to rewash. The breast processor machine under the tray was covered with a large amount of liquified fat and several pieces of tissue to 3". At approximately 0012 hours there were numerous pieces of fat and tissue to 2" on the chain and front loading area on Leg Processor #9. The equipment was rewashed with potable water and returned to service by approximately 0021 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) and 9 CFR 416.13(c).
5309	P6137A	NJN190601 0519N-1	01/19/2012	01C02	Operational SSOP Review and Observation	C	On January 19, 2012, at approximately 0245 hrs I was in the packaging department verifying operational sanitary conditions when I observed the following non compliance: the two white belts of the tray conveyor on (b) (4) line had a dry orange pasty material on them from the previous day's production. The white belts are a direct product contact surface. The orange pasty material on the belts was a residue from the (b) (4) rub which contains ingredients that the establishment has identified as an allergen. I notified (b) (6) and (b) (6) of the non compliance. I did not initiate regulatory control of the unit since the establishment initiated immediate corrective actions to restore sanitary conditions. There was no product involved.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN2009010619N-1	01/19/2012	01B02	Pre-Op SSOP Review and Observation	C	I was performing pre operational sanitation inspection at the start of operations in the Fillet department at 0650 hours after the QC technicians had performed their pre operational sanitation inspection and released the area for production when I noted the following noncompliance: One of the bearings on singulagtor # 3 had a black oily substance with an oil like texture seeping out from under the bearing mount, and there was an excessive amount of grease on the gears and the gear shaft on the underside of the singulator belt. The singulator belt is a direct product contact surface. I applied USDA Reject tag # B39415993 to singulator # 3 at 0650 hours and informed Mr. (b) (6) of the noncompliance. After corrective actions to restore sanitary conditions were implemented the unit was released at 0630 hours on 1/20/12 the following morning.
5308	M6137	BXL5721014218N-1	01/18/2012	01C02	Operational SSOP Review and Observation	C	At approximately 1920 hours, while walking thru the (b) (4) Room area, I observed (b) (6) picking up from the floor a pile of approximately 25 pounds of tenders and placing them on a brown lid. He then, took the product to the reprocessing sink. I stood by to verify proper reprocessing procedure as described on the establishment's SSOP program. The employee working on the reprocessing sink grabbed with both hands approximately fifteen tenders. He held the product under the running chlorinated water for a few seconds and then, placed the "reconditioned" product into a brown tub right next to the reprocessing station. He continued to reprocess the rest of the tenders using the same procedure until he was done. There was no ice added to the product at any time. When the employee was ready to return the product back to production without waiting 5 minutes for Quality Control reinspection; I immediately, prevented him from returning the product back to the production line. I notified (b) (6) of the noncompliance. Quality Control had the employee to recondition the tenders one piece at the time and place them into a clean container. Product was released after it was reprocessed properly. The establishment's SSOP procedure for proper reconditioning of product states under PROCEDURES: "(b) (4) (b) (4)". This scenario represents the establishment's failure to properly implement his reprocessing procedure.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5723010 918N-1	01/18/2012	01C02	Operational SSOP Review and Observation	C	<p>On 01/18/2011 at approximately 2015 hours while monitoring temperatures in Plant #2 cooler, I observed the following. The overhead refrigeration unit on the Packaging side of the cooler was apparently in the defrost cycle as fluids were spraying from the unit onto 4 covered stainless tanks and four pallets of brown product tubs. There was also condensing fluids dripping from the ceiling directly in front of the unit. A tub of boneless skinless breasts was uncovered so I attached U.S. Retained Tag #B31407411 to it. I contacted (b) (6) and discussed my concerns. The boneless skinless breasts approximately 60 pounds were condemned by production and placed in a gray inedible barrel. A refrigeration mechanic was called. He said it was the normal defrost cycle that lasts about 45 minutes. The tanks were moved and the plastic protective covers were replaced. The covers on the brown product tubs were covered with numerous black specks of (UFM) in addition to the fluids spraying from the refrigeration unit. The lids on approximately 25 brown product tubs were replaced. As the refrigeration unit was still spraying a small amount of fluid and with the cooler near capacity plastic sheets were used to cover the affected pallets. I returned later and the defrost cycle was apparently over restoring sanitary conditions by approximately 2100 hours. My findings indicated a noncompliance with 9 CFR 416.2(d) and 9 CFR 416.4(d).</p>
5309	P6137A	NJN121601 5918N-1	01/17/2012	03J02	Slaughter HACCP	C	<p>While reviewing the establishment's hazard analysis for the paws production I observed the following non-compliance. The establishment determines (b) (4)</p> <p>The justification for this determination is (b) (4)</p> <p>" In the establishment's hazard determination they state a (b) (4) " which is CCP1-B (b) (4) and CCP2-BC (b) (4) these measures are applied to the carcass after the paws are removed. The establishment also states (b) (4) . The establishment determines (b) (4)</p> <p>" The establishment's own determination shows the potential of fecal to be on the paw prior to the picking/scalding step. Fecal material is a known vehicle for pathogens. The establishment was not able to provide any records to support the decision made in their hazard analysis that the hazard identified at live receiving was reduced to an acceptable level or eliminated as required by 9 CFR 417.3. The establishment does not have any written corrective actions in response to a deviation from a critical limit or measures to prevent reoccurrence. The establishment has no CCP in place for the paws production.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE091901 3017N-1	01/17/2012	03J02	Slaughter HACCP	C	<p>At 1200 hours on January 17, 2012, while reviewing the establishment's hazard analysis for slaughter, I observed the following noncompliance: At Step 13 "Venting" and Step 14 "Eviscerator" in the Hazard Analysis, the plant recognizes the potential food safety hazard of (b) (4), and determines it as reasonably likely to occur because, (b) (4). The necks are still attached to the carcass during these steps, but are removed prior to the CCP put in place to control the biological food safety hazard associated with fecal material. There is no CCP in place to address necks, nor is there any supporting documentation or justification proffered in the hazard analysis to demonstrate that necks would not be exposed to the food safety hazard determined to be reasonably likely to occur at these two steps in the evisceration process. That the establishment identified a food safety hazard that was determined to be reasonably likely to occur in their hazard analysis, but failed to implement measures to control the hazard represents noncompliance with 9 CFR 417.2 (b) (1). (b) (6) was notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above. On January 11, 2012, NR No. HYE5816010611N documents a similar noncompliance where the establishment failed to effectively address a hazard reasonably likely to occur in their hazard analysis.</p>
5308	M6137	BXL2014010 516N-1	01/16/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>While monitoring the Establishments' Preoperational Sanitation Procedures, I observed a noncompliance with regulations 9CFR 416.4(a) and 416.13 (c). At approximately 0506 hours while inspecting shell and tubes in Plant #1, I inspected inside the chiller water tube and I found a chunk of compressed feathers and fat measuring approximately 5" long and 1" wide, I informed (b) (6) of the noncompliance. The tube was cleaned and released at approximately 0509 hours. At approximately 0525 hours, I inspected a pipe that transfers Livers to the Giblets Chiller and I found red residue inside the pipe, I informed (b) (6) and (b) (6) of the noncompliance. The pipe was cleaned and released at approximately 0540 hours. At approximately 0550 hours, I inspected a pipe that transfers Gizzards to the Giblets Chiller and I found a thick layer of light brown residue, I informed (b) (6) and (b) (6) of the noncompliance. The pipe was cleaned and released at approximately 0626 hours. This is a repetitive noncompliance.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3105012 617N-1	01/16/2012	06D02	Other Inspection Requirements	C	<p>On 01/17/2012 at approximately 0135 hours while monitoring Establishment Facilities in Plant #1 Line #1 (b) (4) after a scheduled break, I observed the following. There appeared to an excessive number of missing viscera. I reviewed the shift (b) (4) - NO VISCERA Monitoring Log and found a Quality Control entry (13) made at 2330 hours. I conducted a no viscera check and found 30 no viscera at approximately 0139 hours. As the limit at (b) (4) BPM is (b) (6) no viscera, I contacted (b) (6) who called (b) (6). A Quality Control recheck failed with 22 no viscera at 0143 hours so the line was slowed to 126 BPM. Repairs were apparently made during the lunch break however a recheck by Quality Control failed again at 0402 hours at 126 BPM with 17 no viscera. The limit at 126 BPM is 11 no viscera. Quality Control rechecks at 0642 and 0647 hours brought the process back into compliance. My findings indicated a noncompliance with 9 CFR 381.76(a).</p>
5333	P7632	HYE420401 1816N-1	01/16/2012	01B02	Pre-Op SSOP Review and Observation	C	<p>While performing the monthly Dry Inspection, CIP/Pre-Operational Sanitation Review and Observation in Area 1, I observed the following noncompliance: At the bottom of the B line scalding there was one pipe corroded with rust that had flaked off onto the bottom of the scalding. I took regulatory control of the B line scalding with the application of U.S. Retain tag B39415949. I informed (b) (6) at 2020 hours of the noncompliance. Mr. (b) (6) proffered corrective actions that the pipe would be scrubbed clean of all rust and that the B line scalding would be rewashed and free of all rust. With the corrective actions completed I reinspected the scalding and found it free of all rust and released the scalding for B line at approximately 2105 hours.</p>
5308	M6137	BXL2318012 013N-1	01/13/2012	03J04	Poultry Zero Tolerance Verification	C	<p>While performing Pre-Chill Finished Product Standard check, I observed noncompliance with the following regulatory requirements of regulation 9 CFR 381.65 (e) and 417.2 (c)(4). At approximately 1050 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination inside the bird under the right leaf fat area. The fecal material was a smear measuring approximately 2" long and 3/4" wide, brownish green in color and pasty in texture. This exceed the limit of Zero Tolerance for the process to be in control. I informed (b) (6) and (b) (6) of the noncompliance, the protocol for fecal failure was implemented. Quality Control performed a Recheck at approximately 1108 hours and it passed. This is a violation of the critical limits of CCP-2B (b) (4) of the Plant's HACCP plan for slaughter.</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5705013 412N-1	01/11/2012	01C02	Operational SSOP Review and Observation	C	On 01/12/2012 at approximately 0038 hours while monitoring Establishment Facilities in Plant #2, I observed the following. The ice being collected from the ice machine had numerous black (UFM) specks to approximately 1/4". I contacted (b) (6) who contacted refrigeration maintenance personnel. The tank being filled was replaced after the black specks appeared to stop coming out of the dispenser shoot. I observed the ice in use at several stations and found no visible UFM. The ice was condemned and the tank was rinsed with potable water per company procedure restoring sanitary conditions by approximately 0046 hours. (b) (6) was informed. My findings indicated a noncompliance with 9 CFR 416.2(g).
5309	P6137A	NJN440501 4511N-1	01/11/2012	01C02	Operational SSOP Review and Observation	C	I was in the evisceration department at approximately 0225 hours when I noted the following noncompliance; I observed one of the spray nozzles positioned on the oil gland removal machine for "A" line was overspraying water from the carcasses onto and into the ice bin hopper and ice conveyor/chute that delivers ice into the foot chiller. The ice hopper/ chute is a direct product contact surface because it delivers ice into the foot chiller to aid in the chilling of the poultry feet. I informed Mr. (b) (6) and (b) (6) of the noncompliance. After the establishment restored sanitary conditions the ice hopper and conveyer were released. No product was involved.
5333	P7632	HYE581601 0611N-1	01/11/2012	03J02	Slaughter HACCP	C	At 1400 hours on January 11, 2012, while reviewing the establishment's hazard analysis for slaughter, I observed the following noncompliance: At Step 13 "Venting" and Step 14 "Eviscerator" in the Hazard Analysis, the plant recognizes the potential food safety hazard of (b) (4), and determined it to be reasonably likely to occur because, (b) (4). There are no statements or supporting documentation for such statements in the establishment's HACCP Plan that giblets would not be exposed to the food safety hazard determined to be reasonably likely to occur at these two steps in the evisceration process. There is no CCP in place for giblets. That the establishment identified a food safety hazard that was determined to be reasonably likely to occur in their hazard analysis, but failed to implement measures to control the hazard represents noncompliance with 9 CFR 417.2 (b) (1). (b) (6) was notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE520201 0210N-1	01/10/2012	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0020 hours while performing the SSOP verification task in the second processing department (bag line), I observed the following non compliance; during the start of the bag line, baskets were being brought in from the degree cooler which had fat particles, frozen blood from who knows what previous days production, and a part of a gizzard in it which I observed employees using these baskets to put bagged product onto. The establishment failed to meet its SSOP, section 2-5 Packaging - step #7 which states; "(b) (4) " I informed (b) (6) of the forthcoming non compliance record. 9CFR 416.4 (b) Sanitary Operations states; " Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product."</p>
5308	M6137	BXL2600012 711N-1	01/09/2012	03J02	Slaughter HACCP	C	<p>On 01/09/2012 at approximately 2100 hours while monitoring the Establishments' Hazard Analysis-Slaughter and supporting documents, I observed the following. The HACCP Monitoring Log-CCP-7B (b) (4) Plant #1 for 01/06/2012 showed that at 1808 hours the antimicrobial rinse concentration was .89%. The Log lists the acceptable range as (b) (4) Under 'Comments' it stated that (b) (4) The previous documented check was .30% at 1722 hours and a documented recheck at 1822 hours was .55%. A review of the establishments' Hazard Analysis for Plant #1 under step 28 (b) (4) and identifies only one supporting document, Supplement #2. Supplement #2 is FSIS Dir 7120.1 Safe and Suitable Ingredients Used in the Production of Meat, Poultry, and Egg Products which under Antimicrobial (b) (4) and states "(b) (4) "The Establishments' Supplement #10 (b) (4) ' under 'Purpose' states "(b) (4) " Under 'corrective action' list actions to be taken if the concentration falls below (b) (4) but does not list actions to be taken when the FDA limit of .8% is exceeded.. I discussed the issue with (b) (6) . My findings indicated a noncompliance with 9 CFR 417.3(b), 9 CFR 417.3(b)(1),(2),(3),(4) and 9 CFR 417.2(c)(3).</p>

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3905015 110N-1	01/09/2012	03J04	Poultry Zero Tolerance Verification	C	On 01/10/2012 at approximately 0227 hours while conducting a Zero Tolerance fecal check on Line (b) (4) in plant #2, I observed the following. After (b) (6) randomly selected a 10 bird sample, I observed one bird with visible fecal contamination. The fecal material was approximately 3/8" by 1/4" in size and was located on the left side kidney area. There was also several small smears approximately 1/16" to 1/4" in size on the right side of the carcass under the fat flap. The fecal material was greenish brown to white in color and pasty in texture. This exceeded the limit of Zero Tolerance for the process to be in control. I showed (b) (6) my findings. He implemented the protocol for fecal failure. The recheck passed at 0250 hours. My findings indicated a noncompliance with 9 CFR 417.2(c)(4), 9 CFR 381.65(e), and the critical limit of CCP-2B (b) (4) of the Plants HACCP Plan for Slaughter.
5333	P7632	HYE261301 5309N-1	01/09/2012	01C02	Operational SSOP Review and Observation	C	At 1010 hours on January 9, 2012, Inspector (b) (7)(C) observed water overflowing from the overhead drip pan under the Giblet Shackle Wash Cabinet and above the kick out wheel at his inspection station (#4) on Evisceration Line #1. He notified the plant of his suspicions that the situation could lead to potential product contamination. Getting no response and the water continuing to fall onto the wheel, Inspector (b) (7)(C) requested the presence of offline inspection personnel. Upon arrival at Station 4, Line 1, at 1017 hours, I immediately observed three steady streams of water overflowing the drip pan and one of them was flowing directly on the nonproduct contact surfaces of the Station #4 kick-out wheel. The water then flowed to the bottom side of the wheel and dripped onto the product and the product contact surfaces of the product shackles on Line One. Regulatory control of Evisceration Line One was taken with the application of US Reject Tag #B38 494940 and (b) (6) was notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above. At 1027 hours regulatory control was released with the acceptance of effective corrective actions to restore sanitary conditions and appropriate disposition of product as well as the proffered preventive measure that production would turn down the water in the cabinet and monitor it until maintenance could identify and eliminate the cause of the overflow.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5333	P7632	HYE501101 1509N-1	01/09/2012	01C02	Operational SSOP Review and Observation	C	At 0908 hours on January 9, 2012, while performing a post chill finished products inspection procedure at the exit end of the North Chiller, I observed that the catch-screen placed beneath the inclined feeder belt to the rehang table was overflowing with carcasses and there were already more than twenty-two carcasses on the floor. Regulatory control of the product was taken with the application of US Retained Tag #B38 494934 and (b) (6) was notified of the forthcoming documentation of the failure to comply with the regulatory requirements cited above. At 0917 hours regulatory control was relinquished with the acceptance of effective corrective actions to include the restoration of sanitary conditions, the appropriate disposition of product, and the proposed preventive measure that management personnel undergo further training to keep bins and other tools in place to achieve a more effective response when product backs up at the rehang area.
5333	P7632	HYE320701 1409N-1	01/08/2012	04A06	Poultry Finished Product Standards	C	I was conducting the verification procedure for Poultry Finished Product Standard on the Off line at approximately 0434 hours when I observed the following non compliance: Three carcasses out of the ten bird check were contaminated with ingesta. All three carcasses had ingesta around the breast, neck area. I immediately stopped the line and applied US Retained tag #B40193565 and showed my findings to (b) (6) and (b) (6) and informed them of the non compliance. Regulatory control of the OFF-line was relinquished at approximately 0443 after sanitary conditions were restored and a recheck was performed in my presence by (b) (6) and found his recheck to be acceptable. Plants Reprocess/Salvage procedure in part A- 1, states in part, (b) (4)).
5308	M6137	BXL4519011 406N-1	01/06/2012	04A06	Poultry Finished Product Standards	C	While monitoring the establishments' reprocessing procedure on Line 9 in Plant #2, I observed a noncompliance with the following regulatory requirements of regulation 9 CFR 381.84. At approximately 1614 hours, I randomly removed a 10 bird sample for my reprocessing test, I found four out of nine birds split tails in the sample that contained Airsacculitis exudates. This is an automatic failure. I immediately took regulatory control action by stopping the line. I informed (b) (6) of the noncompliance, she immediately took action by retaining the product into a tank. I placed a U.S. Retained Tag # B31407471 on the tank. At approximately 1626 hours I performed a retest and it passed. The retained product was reworked and released at approximately 1710 hours. This is a repetitive noncompliance.

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4605013 006N-1	01/05/2012	04A06	Poultry Finished Product Standards	C	On 01/06/2012 at approximately 0115 hours while monitoring the Establishments' Reprocessing Line ^{(b) (6)} in Plant #1, I observed the following. After randomly selecting a 10 bird sample, I found two of the birds with split tails that still contained airsacculitis exudates. The establishment marks birds by splitting the tail when directed by IPP to identify that for whatever reason a bird needs to be vacuumed. I showed (b) (6) my findings. As it was near break time, I informed (b) (6) that I would be performing the recheck. He acknowledged, so I selected a second 10 bird sample of only split tail birds and found two more birds with Aisracculitis Exudates. By 0117 the line was stopped for company break. After break an extra person was assigned to vacuum birds. Product was tanked until the affected birds were collected for rework. The reworked birds were later released by Quality Control. QC personnel performed a recheck on the line which passed at 0139 hours. My findings indicated a noncompliance with 9 CFR 381.84.
5308	M6137	BXL5405012 006N-1	01/05/2012	01C02	Operational SSOP Review and Observation	C	On 01/06/2011 at approximately 0130 hours while monitoring the Establishments' Operational Sanitation Procedures in Plant #1, I observed the following. During the Establishments break, a mechanic was repairing the peeler assembly on the gizzard processing table located between lines 1 & 2. There was a cardboard parts box and various tools on top of the perforated portion of the table where gizzards collect. There were gizzards on the table in various stages of washing and peeling. The repairs were finished just as production started. I contacted (b) (6) and discussed the issue. I contacted the SSOP and asked for the shifts SSOP Equipment Breakdown Log. There were no entries on the log. I showed the log to (b) (6). A review of the SSOP Section II-Operational Sanitation under 'Implementation- Daily Procedure' states that (b) (4). (b) (4). The Equipment Breakdown Procedure dated Nov 15,2010 updated Nov 4, 2011 under 'Purpose' states that (b) (4). (b) (4). Under "Scope" it states that (b) (4). (b) (4). A review of the file of SSOP-Equipment Breakdown Logs for the past several weeks showed that there were no logs filed for the AM shift. My findings indicated a noncompliance with 9 CFR 416.4(d), 9 CFR 416.13(b), 9 CFR 416.15(a), and 9 CFR 416.16(a).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2517010 204N-1	01/04/2012	01D01	SPS Verification	C	While monitoring the establishment's AQL procedure at the giblet chiller exit, plant 1, I observed a noncompliance with the following regulatory requirements of 9 CFR 381.65(a) and 416.4(a). At approximately 1410 hours, I found a piece of intestine measuring approximately 2" long inside of a brown tub half full with hearts. This piece of intestine had visible fecal material leaking from both sides and coming in contact with the product. The fecal material was dark brown in color, pasty in texture with a very strong odor. I informed (b) (6) of the noncompliance, she immediately condemned the product by placing it in a gray inedible barrel. Brown tub was washed.
5308	M6137	BXL5105013 205N-1	01/04/2012	01B02	Pre-Op SSOP Review and Observation	C	On 01/05/2011 at approximately 0012 hours while monitoring the Establishments' Preoperational Sanitation Procedures, I observed the following. In Packaging Area #1 there were numerous pieces of fat and tissue on a brown product belt associated with line (b) (4). A section of the belt approximately 20 feet long had tissue to 2" with a large number of pieces attached to the metal pins used to attached the two ends. The inside surfaces of the same belt were covered with black (UFM) specks along the entire length and width of the belt. The product contact surfaces of the belt were rinsed with potable water and returned to service. The nonproduct contact surfaces will be cleaned with the next scheduled chlorine application. Using Establishment procedures sanitary condition were restored by approximately 0017 hours. At approximately 0025 hours in the (b) (4) Deboning Room along Line #1, there was a small conveyor belt and associated stainless steel brackets that was covered with fat and product from the previous days production to approximately 1". The belt was rinsed with potable water and returned to service. There were numerous white product cones also along Line #1 with large pieces of fat to 3" on the internal surfaces and several cones had smaller pieces of tissue stuck to the rough worn exterior product contact surfaces. The fat was removed and sanitary conditions were restored using Establishment procedures by approximately 0032 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), and 9 CFR 416.13(c).

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2318010 103N-1	01/03/2012	04A06	Poultry Finished Product Standards	C	While monitoring the establishments' reprocessing procedure on Line 2 ⁰⁹ in Plant #2, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.84. At approximately 1409 hours, I randomly removed a 10 bird sample for my reprocessing test. I found two out of seven birds with split tails in the sample that contained <i>Airsacculitis</i> exudates. I performed a recheck at approximately 1413 hours, in which one of the ten birds contained <i>Airsacculitis</i> exudates. I immediately took regulatory control action by stopping the line and informed (b) (6) and (b) (6) of my findings, they then began to retain the product and slowed the line. I performed another recheck at approximately 1425 hours and two out of ten birds contained <i>Airsacculitis</i> exudates. At approximately 1428 hours I performed another recheck and it passed bringing the process back in to compliance. The retained product was reworked and released by Quality Control at approximately 1536 hours. This is a repetitive noncompliance.
5308	M6137	BXL4123012 403N-1	01/03/2012	01D01	SPS Verification	C	On 01/03/2012 at approximately 2000 hours while monitoring temperatures in the Plant #1 cooler, I observed the following. The center refrigeration unit on the Plant #1 side of the cooler was apparently in the defrost cycle as fluids were dripping from the unit onto a pallet of salvage part tubs. There were also fluids dripping from the ceiling and piping directly in front of the unit, and droplets were spraying from the fan assembly. There were droplets of fluid covering most of the surface area of the plastic sheets covering 10 tanks directly in front of the unit. As there was no production I did not hang USDA retained tags but instead contacted (b) (6) who had the affected tanks with product moved. The refrigeration unit returned to normal operation so the spraying and dripping stopped. The lids on the salvaged parts tubs were changed along with the plastic sheets on the tanks. A mechanic arrived but made no adjustments or repairs as the unit was back in normal operation. Sanitary conditions were restored by approximately 2020 hours. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(d).
5308	M6137	BXL2813010 602N-1	01/02/2012	03J04	Poultry Zero Tolerance Verification	C	At approximately 900 hours, while performing a Finish product Standard check on line 2 of Plant 1, I found a zero tolerance noncompliance. After randomly removing 10 birds from line 2 in plant 1, I found one out of ten birds contaminated with feces. This failure reflected a violation of the CCP2B, (b) (4) of the Plant's HACCP Plan for slaughter. The fecal material was located on the bird's right wing, midjoint area. It was dark brownish color and pasty in texture, measuring approximately 1/8" in diameter. I immediately notified management of the noncompliance. The zero tolerance protocol was implemented by the establishment, bringing the process back in control.