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| U.S. Department of Agriculture Food Safety and Inspection Service GOOD COMMERCIAL PRACTICES CORRELATION VISIT REPORT | 1. CASE NUMBER: XKC5611062604CP Alameda DO# 05-19-GCP010 | |
| | 2. EST. NUMBER: P8289 | 3. EST. ID: 5361 |

4a. ESTABLISHMENT NAME:
 Reichardt Duck Farm, Inc.

4b. ESTABLISHMENT ADDRESS/ P.O. BOX
 3770 Middle Two Rock Road

4c. CITY, STATE, ZIP CODE
 Petaluma, California 94952-4625

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| 5a. NAME OF DVMS (b) (6) | 5b. NAME OF PHV (b) (6) | 5c. NAME OF IIC (b) (6) |
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| 6. DATE(S) OF VISIT (MM/DD/YY) FROM: 6/3/2019 TO: 6/3/2019 | 7. CIRCUIT VISITED (4-digit no.) 0531 | 8. PLANT SIZE <input type="checkbox"/> Large <input checked="" type="checkbox"/> Small <input type="checkbox"/> Very Small |
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| 9. SPECIES SLAUGHTERED <input checked="" type="checkbox"/> Duck <input type="checkbox"/> Other | 10a. LINE SPEED: (b) (4) 10b. NUMBER OF LINES: 1 |
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11. STUNNING USED:
☒ YES ☐ NO

STUNNING METHOD: ☐ Controlled Atmosphere Stunning
☒ Electric Stunning

12. REASON FOR VISIT

☐ District Office Direction

☒ Routine Visit

☐ Repetitive Non-Compliance

☐ Data-Driven Visit

☐ Suspicion of Violations

☐ Special Correlation/Other

13. SYSTEMATIC APPROACH USED?

☒ Yes ☐ No ☐ IMPLEMENTATION NOT ASSESSED PER THIS DATE

IF YES, CHECK ITEMS BELOW THAT HAVE BEEN IMPLEMENTED; NUMBERS CORRESPOND TO THE THREE STEPS OF THE SYSTEMATIC APPROACH

- ☒ 1. Assessing under what circumstances poultry may experience excitement, discomfort, or accidental injury while being handled in connection with slaughter.
- ☒ 2. Taking steps to minimize the possibility of such excitement, discomfort, and accidental injury.
- ☒ 3. Evaluating periodically how poultry are being handled and slaughtered to ensure
- (a) that excitement, discomfort, or accidental injury is being minimized;
 - (b) that poultry are slaughtered in a manner that results in thorough bleeding of the poultry carcass; and
 - (c) that breathing has stopped before scalding.

14. RECOMMENDATIONS

☒ No Action

15. FINDINGS / Narrative Report:

Correlation:

USDA: (b) (6)

Establishment: (b) (6)

Correlation with IPP was conducted separately and included pre-assessment findings, as well as reviews of 9 CFR 381.65(b) and FSIS Directive 6110.1.

Pre-Visit Data Review:

PHIS data was reviewed from June 3, 2018 to June 2, 2019. This is a small duck slaughter and processing establishment that operates one shift, five (5) days per week.

No Noncompliance Records for Good Commercial Practices (GCP) or Memorandum of Interview records were issued during the above interval.

Systematic Approach:

The Establishment has a training PowerPoint presentation that designates their animal welfare, handling and slaughter procedures. The plant does not perform internal audits or keep GCP monitoring records.

Recommendation:

No Action: The establishment's live animal handling and slaughter met the requirements of the Poultry Products Inspection Act and 9 CFR 381.65(b).

Findings/Narrative Report:

(b) (6) accompanied me during the plant visit. We observed unloading of two trailer loads of ducks into the holding area, employees moving ducks into the shackling facilities and employees hanging ducks into shackles on the slaughter line. I observed facilities structures, equipment, and live duck handling procedures/techniques.

All facilities and equipment for the slaughter plant appear to be in good working order to prevent injury of live ducks prior to them being stunned. I observed that all employees who handled the live ducks used appropriate handling techniques to minimize excitement and/or injury to the ducks.

During my observation, I found that all ducks were properly stunned, were appropriately cut, and adequately bled out by the time they reached the scald tank. I observed no ducks breathing when they entered the scalding tank.

EXIT MEETING: Attending the meeting were (b) (6)

The establishment complied with 9 CFR 365(b) during my visit; no ducks entered the scalders still breathing, and all ducks were bled out prior to entering the scalders.

We briefly discussed practices the establishment has in place for keeping ducks cool during hot weather when the ducks are in the holding area prior to the shackle line. The establishment has water hoses to mist the area and keep the ducks comfortable. We discussed how the shackler employee monitors the holding chute next to the line to prevent birds from stacking up there. In addition, we discussed how employees stop the kill line when an employee finds a duck that has not expired after bleeding out, to prevent the duck from entering the scalders while still breathing.

When no other questions or concerns were raised, the meeting was adjourned.

Respectfully,

(b) (6)

(b) (6)

(b) (6)

USDA Food Safety and Inspection Service – Office of Field Operations

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| U.S. Department of Agriculture Food Safety and Inspection Service GOOD COMMERCIAL PRACTICES CORRELATION VISIT REPORT | | 1. CASE NUMBER: NCO1316060621CP ALAMEDA DO # 05-19-GCP011 | |
| 2. EST. NUMBER: M27389+P27389 | | 3. EST. ID: 9259 | |

4a. ESTABLISHMENT NAME:
 Pitman Farms

4b. ESTABLISHMENT ADDRESS/ P.O. BOX
 1078 North Avenue

4c. CITY, STATE, ZIP CODE
 Sanger, California 93657

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| 5a. NAME OF DVMS (b) (6) | 5b. NAME OF PHV (b) (6) (night shift) | 5c. NAME OF IIC (b) (6) (day shift) |
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| 6. DATE(S) OF VISIT (MM/DD/YY) FROM: 6/11/2019 TO: 6/11/2019 | 7. CIRCUIT VISITED (4-digit no.) 0502 | 8. PLANT SIZE <input checked="" type="checkbox"/> Large <input type="checkbox"/> Small <input type="checkbox"/> Very Small |
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| 9. SPECIES SLAUGHTERED <input checked="" type="checkbox"/> Chicken <input checked="" type="checkbox"/> Duck <input type="checkbox"/> Goose <input type="checkbox"/> Turkey <input type="checkbox"/> Other | 10a. LINE SPEED: (b) (4) 10b. NUMBER OF LINES: 1 |
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11. STUNNING USED:
☒ YES ☐ NO

STUNNING METHOD: ☒ Controlled Atmosphere Stunning
 ☐ Electric Stunning

12. REASON FOR VISIT

- ☐ District Office Direction
 - ☒ Routine Visit
 - ☐ Repetitive Non-Compliance
 - ☐ Data-Driven Visit
 - ☐ Suspicion of Violations
 - ☐ Special Correlation/Other
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13. SYSTEMATIC APPROACH USED?

- ☐ Yes ☒ No ☐ IMPLEMENTATION NOT ASSESSED PER THIS DATE

IF YES, CHECK ITEMS BELOW THAT HAVE BEEN IMPLEMENTED; NUMBERS CORRESPOND TO THE THREE STEPS OF THE SYSTEMATIC APPROACH

- ☐ 1. Assessing under what circumstances poultry may experience excitement, discomfort, or accidental injury while being handled in connection with slaughter.
 - ☐ 2. Taking steps to minimize the possibility of such excitement, discomfort, and accidental injury.
 - ☐ 3. Evaluating periodically how poultry are being handled and slaughtered to ensure
 - (a) that excitement, discomfort, or accidental injury is being minimized;
 - (b) that poultry are slaughtered in a manner that results in thorough bleeding of the poultry carcass; and
 - (c) that breathing has stopped before scalding.
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14. RECOMMENDATIONS

- ☒ No Action
 - ☐ NR by IIC
 - ☐ NOIE
 - ☐ Suspension/Withdrawal
 - ☐ Other
 - ☐ Letter of Concern
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15. FINDINGS / Narrative Report:

Correlation:

USDA:

Day shift: (b) (6); Night shift: (b) (6)

Correlation:

USDA: Day shift: (b) (6); Night shift: (b) (6) Establishment:

Establishment: Day Shift: Stacey Easterling, Plant Manager; (b) (6)

(b) (6)

Correlation with IPP was conducted separately and included pre-assessment findings, as well as reviews of 9 CFR 381.65(b) and FSIS Directive 6110.1.

Pre-Visit Data Review:

PHIS data was reviewed from June 11, 2018 to June 10, 2019. Est. P27389 is a large multi-species poultry slaughter/processing facility. The plant slaughters chickens, turkeys, ducks and occasionally geese.

No Noncompliance Records for Good Commercial Practices (GCP) were documented in PHIS for the above interval.

The following non-regulatory GCP concerns were discussed with establishment management and documented as Memorandum of Information (MOI) in PHIS:

June 22, 2018, PHIS # NCO4602064322G: Two live ducks loose from cage module, employee replaced ducks into cages after FSIS inspector notified them.

June 25, 2018, PHIS # NCO5605065025G: One live duck loose from cage module, employee replaced duck into cage after FSIS inspector notified them.

July 11, 2018, PHIS # NCO5722071811G: Loose chicken under truck, employee caught chicken and placed back into cage when notified.

September 20, 2018, PHIS # NCO4217092220G: SPHV found a green cage unit with chickens on the floor at the CO2 stunning unit and notified establishment management. Two birds were dead, one was injured, remaining chickens were unharmed. Management stated that the green unit was in poor condition and damaged further by CO2 machinery.

December 18, 2018, PHIS # NCO0409121118G: SPHV observed a total of 8 young chickens with swollen and red-to-purple swollen heads exit the scalding without a bleeding cut at the neck.

January 2, 2019, PHIS # NCO1214014602G: CSI observed two damaged cage modules with chickens, and found 3 dead chickens inside one of the modules. Two of the chickens had been injured between the cage and framework of the module.

May 7, 2019, PHIS # NCO1012050507G: On April 24 and 25, 2019, the SPHV was informed that CO2 delivery was delayed, and the establishment management proceeded to use the backup electric stunner instead of CO2. The SPHV observed repeated instances of post-stunner conscious birds ineffectively cut and wounded by the automatic knife. The SPHV also observed several birds hung by one leg only, which caused improper positioning for the stunner and automatic knife. The establishment added backup cutters at the bleeding lane during this period after the SPHV observations.

Systematic Approach:

No, the establishment does not operate within the guidelines for a systematic approach as outlined in Federal Register Notice Docket No. 04-037N, *Treatment of Live Poultry Before Slaughter*. The establishment has generalized written statements for bird handling and bird slaughter but have had some difficulties implementing GCP procedures, noticing when there is a problem, and implementing changes to correct or improve practices. This will be re-assessed at the next DVMS GCP verification visit.

Recommendation:

No Action: The establishment's live animal handling and slaughter met the requirements of the Poultry Products Inspection Act and 9 CFR 381.65(b).

Findings/Narrative Report:

(b) (6) accompanied me during the night shift visit, and (b) (6) accompanied me during the day shift. I observed facilities structures, equipment, live bird holding and handling, stunning, hanging and slaughter procedures.

All facilities and equipment for the slaughter plant appear to be in good working order to prevent injury of live birds prior to them being stunned. I observed that all employees who handled CO2-stunned ducks and chickens used appropriate hanging techniques to minimize injury to the birds. During my observations, I found that all birds were properly stunned, were appropriately cut, and adequately bled out by the time they reached the scald tank. I observed no birds breathing when they entered the scald tank.

EXIT MEETING: Attending the day shift meeting were (b) (6)

(b) (6)

The establishment complied with 9 CFR 365(b) during my visit; no birds entered the scald tank still breathing, and all birds were bled out prior to entering the scald tank.

We discussed some of my observations during each shift. On the night shift, I observed that as the cage modules of ducks were propelled to the CO2 unit, occasionally a module would strike the module in front of it roughly. This could lead to bruises and injuries. The establishment assured us that they would adjust it. During the day shift, we observed two trucks of chicken modules parked in areas where the birds in the rear modules of each truck were exposed to direct sun exposure when the employees went on a break at the module staging location. These birds were panting and restless. Management employees could not find the truck drivers, but one truck was brought forward so all the cages were under the cooling fan setup.

I recommended that establishment employees be mindful of situations such as sun exposure, especially during hot weather. I also recommended that employees keep the guides to the neck straighteners at the automatic knife machines and the pre-scald head-puller devices clean and prevent buildup of feathers and clotted blood.

When no other questions or concerns were raised, the meeting was adjourned.

Respectfully,

(b) (6)

(b) (6)

(b) (6)

(b) (6)

USDA Food Safety and Inspection Service – Office of Field Operations

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| U.S. Department of Agriculture Food Safety and Inspection Service GOOD COMMERCIAL PRACTICES CORRELATION VISIT REPORT | 1. CASE NUMBER: JDD1516064421CP ALAMEDA DO # 05-19-GCP012 | |
| | 2. EST. NUMBER: M18909 + P157 | 3. EST. ID: 5112 |

4a. ESTABLISHMENT NAME:
Foster Farms

4b. ESTABLISHMENT ADDRESS/ P.O. BOX
500 F Street

4c. CITY, STATE, ZIP CODE
Turlock, California 95380

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| 5a. NAME OF DVMS (b) (6) | 5b. NAME OF PHV (b) (6) day shift | 5c. NAME OF IIC (b) (6), night shift |
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| 6. DATE(S) OF VISIT (MM/DD/YY) FROM: 6/12/2019 TO: 6/12/2019 | 7. CIRCUIT VISITED (4-digit no.) 0508 | 8. PLANT SIZE <input checked="" type="checkbox"/> Large <input type="checkbox"/> Small <input type="checkbox"/> Very Small |
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| 9. SPECIES SLAUGHTERED <input checked="" type="checkbox"/> Turkey <input type="checkbox"/> Other | 10a. LINE SPEED: (b) (4) 10b. NUMBER OF LINES: 1 |
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11. STUNNING USED:
☒ YES ☐ NO

STUNNING METHOD: ☐ Controlled Atmosphere Stunning
 ☒ Electric Stunning

12. REASON FOR VISIT

☐ District Office Direction

☒ Routine Visit

☐ Repetitive Non-Compliance

☐ Data-Driven Visit

☐ Suspicion of Violations

☐ Special Correlation/Other

13. SYSTEMATIC APPROACH USED?

☒ Yes ☐ No ☐ IMPLEMENTATION NOT ASSESSED PER THIS DATE

IF YES, CHECK ITEMS BELOW THAT HAVE BEEN IMPLEMENTED; NUMBERS CORRESPOND TO THE THREE STEPS OF THE SYSTEMATIC APPROACH

- ☒ 1. Assessing under what circumstances poultry may experience excitement, discomfort, or accidental injury while being handled in connection with slaughter.
- ☐ 2. Taking steps to minimize the possibility of such excitement, discomfort, and accidental injury.
- ☐ 3. Evaluating periodically how poultry are being handled and slaughtered to ensure
(a) that excitement, discomfort, or accidental injury is being minimized;
(b) that poultry are slaughtered in a manner that results in thorough bleeding of the poultry carcass; and
(c) that breathing has stopped before scalding.

14. RECOMMENDATIONS

- ☐ No Action
- ☐ NR by IIC
- ☐ NOIE
- ☐ Suspension/Withdrawal
- ☒ Other MOI - Heat stress in birds
- ☐ Letter of Concern

15. FINDINGS / Narrative Report:

Correlation:

USDA: Day shift: (b) (6); Night shift: (b) (6)

Establishment: Day Shift: David Alverson, Plant Manager; (b) (6)

Correlation with IPP was conducted separately and included pre-assessment findings, as well as reviews of 9 CFR 381.65(b) and FSIS Directive 6110.1.

Pre-Visit Data Review:

PHIS data was reviewed from June 12, 2018 to June 11, 2019. Est. M18909/P157 Foster Farms is a large turkey slaughter/processing facility.

No Noncompliance Records for Good Commercial Practices (GCP) were issued during the above interval. The following non-regulatory GCP concerns were discussed with establishment management and documented as Memorandum of Information (MOI) in PHIS:

January 7, 2019, PHIS #JDD5319013508G: SPHV observed a conscious turkey without a neck cut enter the scalding, and condemned the turkey as a cadaver after scalding and further processing.

January 14, 2019, PHIS #JDD2716011414G: SPHV observed one conscious turkey with a shallow neck cut enter the scalding and reappear as a cadaver. The SPHV also observed another cadaver that was hung back at the USDA inspection station that had a very shallow neck cut.

Systematic Approach:

The Establishment has a systematic approach plan in place that assesses under what circumstances poultry may experience excitement, discomfort and accidental injury as recommended in Federal Register Notice Docket #04-037N, Treatment of Live Poultry Before Slaughter.

Recommendation:

Other: GCP MOI concerning birds overheating in the live holding shed prior to slaughter on the night shift.

The establishment's turkey slaughter met the requirements of the Poultry Products Inspection Act and regulation 9 CFR 381.65(b).

Findings/Narrative Report:

During my day shift visit I observed unloading and shackling of turkeys at the live hang barn. I observed turkeys proceeding through the electric stunning trough, to the automatic knife and backup cutter, and the pre-scald area. I observed facilities structures, equipment, and live turkey handling procedures. All facilities and equipment for the slaughter plant appear to be in good working order to prevent injury of live turkeys prior to them being stunned. I observed that all employees who handled the live turkeys used appropriate handling techniques to minimize excitement and/or injury to the turkeys. I observed that all turkeys were properly stunned, were appropriately cut, and adequately bled out by the time they reached the scald tank. I observed no turkeys breathing when they entered the scalders.

When inspecting the live holding shed during the night shift, I noted that the turkeys in the holding shed exhibited open-mouthed breathing and increased respiratory rate (panting), standing and restlessness. Very few birds were resting on their keel. The thermometer in the holding shed registered 95 degrees at approximately 10:30 pm. On the night shift at the automatic knife and backup cutter location, I observed eight heavy toms that were shackled by one leg. These missed the automatic knife but the backup cutter was able to cut them for bleeding out prior to scalding.

EXIT MEETING: Attending the meeting were (b) (6) Mr. Alverson and (b) (6).

The establishment complied with 9 CFR 365(b) during my visit; no turkeys entered the scalders still breathing, and all turkeys were bled out prior to entering the scalders.

We discussed practices the establishment has in place for keeping the turkeys cool during hot weather in the holding shed. Mr. Alverson will have the Foster Farms corporate veterinarians evaluate the shed so they can recommend improvements.

When no other questions or concerns were raised, the meeting was adjourned.

Respectfully,

(b) (6) (b) (6)

(b) (6)

(b) (6)

USDA Food Safety and Inspection Service – Office of Field Operations

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| U.S. Department of Agriculture Food Safety and Inspection Service GOOD COMMERCIAL PRACTICES CORRELATION VISIT REPORT | | 1. CASE NUMBER: NRF5017072026CP ALAMEDA DO #05-19-GCP013 | |
| 2. EST. NUMBER: P9030 | | 3. EST. ID: 5383 | |

4a. ESTABLISHMENT NAME:
 New American Poultry

4b. ESTABLISHMENT ADDRESS/ P.O. BOX
 8612 Younger Creek Drive

4c. CITY, STATE, ZIP CODE
 Sacramento, California 95828

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| 5a. NAME OF DVMS (b) (6) | 5b. NAME OF PHV N/A | 5c. NAME OF IIC (b) (6) |
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| 6. DATE(S) OF VISIT (MM/DD/YY) FROM: 7/12/2019 TO: 7/12/2019 | 7. CIRCUIT VISITED (4-digit no.) 0517 | 8. PLANT SIZE <input type="checkbox"/> Large <input checked="" type="checkbox"/> Small <input type="checkbox"/> Very Small |
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| 9. SPECIES SLAUGHTERED <input checked="" type="checkbox"/> Chicken <input type="checkbox"/> Pigeon <input type="checkbox"/> Other | 10a. LINE SPEED: (b) (4) 10b. NUMBER OF LINES: 1 |
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11. STUNNING USED:
☒ YES ☐ NO

STUNNING METHOD: ☐ Controlled Atmosphere Stunning
☒ Electric Stunning

12. REASON FOR VISIT

☐ District Office Direction

☒ Routine Visit

☐ Repetitive Non-Compliance

☐ Data-Driven Visit

☐ Suspicion of Violations

☐ Special Correlation/Other

13. SYSTEMATIC APPROACH USED?

☒ Yes ☐ No ☐ IMPLEMENTATION NOT ASSESSED PER THIS DATE

IF YES, CHECK ITEMS BELOW THAT HAVE BEEN IMPLEMENTED; NUMBERS CORRESPOND TO THE THREE STEPS OF THE SYSTEMATIC APPROACH

- ☐ 1. Assessing under what circumstances poultry may experience excitement, discomfort, or accidental injury while being handled in connection with slaughter.
- ☒ 2. Taking steps to minimize the possibility of such excitement, discomfort, and accidental injury.
- ☐ 3. Evaluating periodically how poultry are being handled and slaughtered to ensure
(a) that excitement, discomfort, or accidental injury is being minimized;
(b) that poultry are slaughtered in a manner that results in thorough bleeding of the poultry carcass; and
(c) that breathing has stopped before scalding.

14. RECOMMENDATIONS

- ☒ No Action
- ☐ NR by IIC
- ☐ NOIE
- ☐ Suspension/Withdrawal
- ☐ Other
- ☐ Letter of Concern

15. FINDINGS / Narrative Report:

Correlation:

(b) (6)

Plant Manager: Ken Cheung

Correlation with IPP was conducted separately and included pre-assessment findings, as well as reviews of 9 CFR 381.65(b) and FSIS Directive 6110.1.

Pre-Visit Data Review:

PHIS data was reviewed from July 12, 2018 to July 11, 2019. Est. P9030 is a small poultry slaughter/processing facility. The plant slaughters young chickens and squabs.

One noncompliance record (NR) was issued for noncompliance with 9 CFR 381.65(b) during the above interval: October 11, 2018, #NRF3814100412N-1; the FSIS inspector found 4 squab carcasses that were bright red, indicating cadaver birds that had not thoroughly bled out before entering the scalding.

Systematic Approach:

The establishment handles and slaughters poultry in a systematic manner. A written plan was not evaluated during this visit.

Recommendation:

No Action: The establishment's live animal handling and slaughter met the requirements of the Poultry Products Inspection Act and 9 CFR 381.65(b).

Findings/Narrative Report:

(b) (6) observed facilities structures, equipment, live bird holding and handling, stunning, hanging and slaughter procedures. The young chickens are staged outside the building in the early morning out of the direct sunlight. Employees maneuver the cage modules with a forklift, and stack the modules inside the hanging bay out of the sun. (b) (6) observed that the inside of the hanging bay had two fans to cool off the space, but these were pointed at the employees hanging birds. The roosters in the cage modules stacked inside were starting to exhibit rapid, open-mouth breathing and restlessness. Employees unload the cages and directly hang the birds in the shackles. All employees handled the chickens gently. No loose birds were observed in the building or on the grounds.

Birds are stunned with an electric stunner immersion bath. Out of approximately 500 birds, one was observed to be un-stunned. The birds are cut by hand, individually, and bleed out along the shackle line prior to scalding. All birds had stopped breathing, and were bled out by the time these entered the scalding. No cadaver birds were observed, and no live birds were found in the DOA barrels.

EXIT MEETING: (b) (6) met with Mr. Cheung to discuss the Good Commercial Practices visit. The establishment complied with 9 CFR 365(b) during the visit; no birds entered the scalding still breathing, and all birds were bled out prior to entering the scalding.

Mr. Cheung accompanied (b) (6) to the hanging bay where the birds were staged before cage unloading and shackling, to observe the birds that were exhibiting signs of heat stress. (b) (6) recommended that employees monitor the cages for bird panting and restlessness, and Mr. Cheung adjusted the industrial fans to provide better airflow inside the building.

No further discussion was held.

Respectfully,

(b) (6) (b) (6)

(b) (6)

(b) (6)

USDA Food Safety and Inspection Service – Office of Field Operations

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| U.S. Department of Agriculture Food Safety and Inspection Service GOOD COMMERCIAL PRACTICES CORRELATION VISIT REPORT | 1. CASE NUMBER: VYF2213103901CP Alameda DO #05-19-GCP014 | |
| | 2. EST. NUMBER: P2882 | 3. EST. ID: 5204 |

4a. ESTABLISHMENT NAME:
 Perdue Foods LLC

4b. ESTABLISHMENT ADDRESS/ P.O. BOX
 2700 Lakeville Highway

4c. CITY, STATE, ZIP CODE
 Petaluma, California 94955

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| 5a. NAME OF DVMS (b) (6) | 5b. NAME OF PHV (b) (6) | 5c. NAME OF IIC (b) (6) |
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| 6. DATE(S) OF VISIT (MM/DD/YY) FROM: 9/25/2019 TO: 9/25/2019 | 7. CIRCUIT VISITED (4-digit no.) 0531 | 8. PLANT SIZE <input type="checkbox"/> Large <input checked="" type="checkbox"/> Small <input type="checkbox"/> Very Small |
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| 9. SPECIES SLAUGHTERED <input checked="" type="checkbox"/> Chicken <input type="checkbox"/> Other | 10a. LINE SPEED: (b) (4) 10b. NUMBER OF LINES: 1 |
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11. STUNNING USED:
☒ YES ☐ NO

STUNNING METHOD: ☐ Controlled Atmosphere Stunning
☒ Electric Stunning

12. REASON FOR VISIT

- ☐ District Office Direction
- ☒ Routine Visit
- ☐ Repetitive Non-Compliance
- ☐ Data-Driven Visit
- ☐ Suspicion of Violations
- ☐ Special Correlation/Other

13. SYSTEMATIC APPROACH USED?

☒ Yes ☐ No ☐ IMPLEMENTATION NOT ASSESSED PER THIS DATE

IF YES, CHECK ITEMS BELOW THAT HAVE BEEN IMPLEMENTED; NUMBERS CORRESPOND TO THE THREE STEPS OF THE SYSTEMATIC APPROACH

- ☒ 1. Assessing under what circumstances poultry may experience excitement, discomfort, or accidental injury while being handled in connection with slaughter.
- ☒ 2. Taking steps to minimize the possibility of such excitement, discomfort, and accidental injury.
- ☒ 3. Evaluating periodically how poultry are being handled and slaughtered to ensure
- (a) that excitement, discomfort, or accidental injury is being minimized;
 - (b) that poultry are slaughtered in a manner that results in thorough bleeding of the poultry carcass; and
 - (c) that breathing has stopped before scalding.

14. RECOMMENDATIONS

- ☒ No Action
- ☐ NR by IIC
- ☐ NOIE
- ☐ Suspension/Withdrawal
- ☐ Other
- ☐ Letter of Concern

15. FINDINGS / Narrative Report:

Correlation:

(b) (6)

[REDACTED]

[REDACTED]

[REDACTED]

[REDACTED]

Correlation with IPP was conducted separately and included pre-assessment findings, as well as reviews of 9 CFR 381.65(b) and FSIS Directive 6110.1.

Pre-Visit Data Review:

PHIS data was reviewed from September 25, 2018 to September 24, 2019. This is a small poultry slaughter and processing establishment that operates on one shift, usually five days per week. There have been no Good Commercial Practices (GCP) Noncompliance Records or non-regulatory concerns MOIs in PHIS during the above interval.

Systematic Approach:

The Establishment has a written systematic approach in place that assesses under what circumstances poultry may experience excitement, discomfort and accidental injury as recommended in Federal Register Notice Docket #04- 037N, Treatment of Live Poultry Before Slaughter, and implements the systematic approach.

Recommendation:

No Action: The establishment's live animal handling met the requirements of the Poultry Products Inspection Act and 9 CFR 381.65(b).

Findings/Narrative Report:

(b) (6) and (b) (6) accompanied (b) (6) during the walk-through of the holding shed for live chickens, forklift placement of baskets onto loading conveyor, live hang, post-stun, post-auto knife and pre-scald. (b) (6) observed cooling measures, equipment, and live-bird handling and slaughter.

All facilities and equipment are in good working order to prevent injury of live birds prior to them being stunned. (b) (6) observed that all employees who handled live birds used appropriate handling techniques to minimize excitement and/or injury to the birds.

(b) (6) observed that all birds were properly stunned, were appropriately cut, and had been properly bled out by the time they reached the scald tank. No birds were breathing when they entered the scald tank.

EXIT MEETING: Attending the meeting were (b) (6). The establishment complied with 9 CFR 365(b) during the visit; no birds entered the scald tank still breathing, and all birds were bled out prior to entering the scald tank.

(b) (6) briefly discussed the rate of broken wings observed at the pre-scald location, and (b) (6) indicated that the establishment routinely monitors for broken wings at the post-stun location.

(b) (6) gently suggested that the establishment archive some of their older records in the bird welfare plan binder.

The establishment handles and slaughters young chickens in compliance with GCP recommendations and 9 CFR 365(b). No further items were discussed, and the meeting was adjourned.

Respectfully,

(b) (6)
(b) (6)

(b) (6)

(b) (6)

USDA Food Safety and Inspection Service – Office of Field Operations

| | | | |
|---|--|---|---------------------|
| U.S. Department of Agriculture Food Safety and Inspection Service GOOD COMMERCIAL PRACTICES CORRELATION VISIT REPORT | | 1. CASE NUMBER: TBA2412120305CP Alameda DO# 05-20-GCP001 | |
| | | 2. EST. NUMBER: P9332 | 3. EST. ID: 5400 |
| | | | |
| 4a. ESTABLISHMENT NAME: Diestel Turkey Ranch | | | |
| 4b. ESTABLISHMENT ADDRESS/ P.O. BOX 22200 Lyons Bald Mountain Road | | | |
| 4c. CITY, STATE, ZIP CODE Sonora, California 95370 | | | |
| 5a. NAME OF DVMS (b) (6) | 5b. NAME OF PHV (b) (6) | 5c. NAME OF IIC same | |
| 6. DATE(S) OF VISIT (MM/DD/YY) FROM: 11/14/2019 TO: 11/14/2019 | 7. CIRCUIT VISITED (4-digit no.) 0508 | 8. PLANT SIZE <input type="checkbox"/> Large <input checked="" type="checkbox"/> Small <input type="checkbox"/> Very Small | |
| 9. SPECIES SLAUGHTERED <input checked="" type="checkbox"/> Turkey <input type="checkbox"/> Other | | 10a. LINE SPEED: (b) (4) 10b. NUMBER OF LINES: 1 | |
| 11. STUNNING USED: <input checked="" type="checkbox"/> YES <input type="checkbox"/> NO STUNNING METHOD: <input type="checkbox"/> Controlled Atmosphere Stunning <input checked="" type="checkbox"/> Electric Stunning | | | |
| 12. REASON FOR VISIT <input type="checkbox"/> District Office Direction <input checked="" type="checkbox"/> Routine Visit <input type="checkbox"/> Repetitive Non-Compliance <input type="checkbox"/> Data-Driven Visit <input type="checkbox"/> Suspicion of Violations <input type="checkbox"/> Special Correlation/Other | | | |

13. SYSTEMATIC APPROACH USED?

☒ Yes ☐ No ☐ IMPLEMENTATION NOT ASSESSED PER THIS DATE

IF YES, CHECK ITEMS BELOW THAT HAVE BEEN IMPLEMENTED; NUMBERS CORRESPOND TO THE THREE STEPS OF THE SYSTEMATIC APPROACH

- ☒ 1. Assessing under what circumstances poultry may experience excitement, discomfort, or accidental injury while being handled in connection with slaughter.
- ☒ 2. Taking steps to minimize the possibility of such excitement, discomfort, and accidental injury.
- ☒ 3. Evaluating periodically how poultry are being handled and slaughtered to ensure
- (a) that excitement, discomfort, or accidental injury is being minimized;
 - (b) that poultry are slaughtered in a manner that results in thorough bleeding of the poultry carcass; and
 - (c) that breathing has stopped before scalding.

14. RECOMMENDATIONS

- ☒ No Action
- ☐ NR by IIC
- ☐ NOIE
- ☐ Suspension/Withdrawal
- ☐ Other
- ☐ Letter of Concern

15. FINDINGS / Narrative Report:

Correlated With:

(b) (6)

[REDACTED]

[REDACTED]

[REDACTED]

Summary of Data Assessment Prior to Visit:

Est. P9332 is a HACCP-small turkey slaughter/processing facility. PHIS slaughter data and NR/MOI summary reports for the period November 14, 2018 to November 13, 2019 were reviewed. No Poultry GCP MOI or NR issuances were found in PHIS during this interval.

Systematic Approach Comments:

The establishment has a systematic approach in place that assesses under what circumstances poultry may experience excitement, discomfort and accidental injury, minimizes the possibility of such excitement, discomfort and accidental injury, and periodically evaluates and improves their handling and slaughter methods, as addressed in Federal Register Docket #04-037N "Treatment of Live Poultry Before Slaughter".

Summary of Reason(s) for Recommendation: No Action

The establishment complied with 9 CFR 381.65(b) during this visit. The handling of live turkeys and turkey slaughter operations were performed in accordance with Good Commercial Practices.

Findings/Narrative Report:

(b) (6) and (b) (6) accompanied (b) (6) during the walk-thru of the shackling shed for live turkeys and live shackling, post-stun, post-auto knife, bleed line, pre-scald and post-scald. (b) (6) observed weather measures, equipment, and live-bird handling and slaughter.

All facilities and equipment were in good working order to prevent injury of live turkeys prior to them being stunned. (b) (6) observed that all employees who handled live turkeys used appropriate handling techniques to minimize excitement and/or injury to the birds.

(b) (6) observed approximately 100 turkeys on the live hang line. All turkeys were properly stunned. Occasionally, a large turkey would enter the automatic knife by the wing first, cutting the wing before the bird was cut at the throat. The back-up cutter was attentive and applied an additional cut on these birds. All turkeys had been properly bled out by the time they reached the scald tank. No turkeys were breathing when they entered the scald.

EXIT MEETING: Attending the meeting were (b) (6) and (b) (6).

The establishment complied with 9 CFR 365(b) during the visit; no turkeys entered the scald still breathing, and all turkeys were bled out prior to entering the scald.

The management discussed the issue of the occasional turkey going through the automatic knife by the leading wing first. (b) (6) is going to investigate this and adjust the guide bars and knife level if necessary.

(b) (6) suggested that the establishment archive some of the older records in the turkey handling plan binder.

The establishment handles and slaughters young turkeys in compliance with GCP recommendations and 9 CFR 365(b). No further items were discussed, and the meeting was adjourned.

Respectfully,

(b) (6) (b) (6)

(b) (6)

(b) (6)

USDA Food Safety and Inspection Service – Office of Field Operations



United States Department of Agriculture

Food Safety and
Inspection
Service

1400
Independence
Avenue, SW.
Washington,
D.C. 20250

From: (b) (6)
Date: 9/23/2019
Subject: Good Commercial Practices/Rehang Station
Meeting Date: 9/23/2019
Meeting Time: 11:00 AM
Establishment: P325 - Tyson Foods, Inc.
Reason Code:
Other Reason Code:
Comments:

On 9/23, 2019 at approximately 1037 hours while performing a GCP Task, I observed three birds in the Line 1 condemn barrel without neck cuts at Line 1 Rehang Station. All three birds had intact neck epidermis. One of the three birds had a laceration that penetrated the top of the skull. At this time, (b) (6) were shown the findings. It was reasonable to assume that all three of these birds had not been properly bled and had entered the scalding still breathing. (b) (6) immediately investigated the incident and determined the root cause to be a maladjusted cut blade, and the late arrival of the back up cutter to the line from break.

9 CFR 381.65(b) 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 breathing has stopped prior to scalding".

The Establishment is reminded that NRs for noncompliance and MOIs related with 9 CFR 381.65(b) when finalized are posted for public review on the FSIS website, and the information contained within the NRs and MOIs for GCPs can be FOIA requested by individuals from the general public. The Establishment is also reminded that they are responsible for providing their own MOI responses through PHIS.

Copies of this Memorandum of Interview will be distributed to the Establishment, inspection file, and the District Veterinary Medical Specialist per FSIS directive 6100.3. The issue will be discussed at the next weekly meeting.

(b) (6)

On March 15, 2019 at approximately 2005 hours while performing a routine PHIS Poultry Good Commercial Practices task (b) (6) observed the following noncompliance.

At the entrance of the stunning equipment there were two dead birds lying on the ground in a puddle of blood with both their legs ripped off. I proceeded to inform a (b) (6) (b) (6) was in the area. I showed him the dead birds and asked him to call the Live hang supervisor and management to find out what happened to these birds. As we were examining the birds, overhead on the west picking line a live bird was caught by its neck between the support bar and belly beam with both legs ripped off and its intestines hanging out. The bird instantaneously fell to the ground and (b) (6). (b) (6) immediately euthanized the bird by performing cervical dislocation. At this time, I then looked back up at the picking line and a bird was entering the stunner with both feet and its neck hung in a shackle loop. (b) (6) immediately ran over to stop the line to remove the bird's neck from the shackle loop. (b) (6) and (b) (6) came to the area and observed the birds. At this time, there were no more birds hung on the line.

Failure to implement procedures for preventing accidental injury and/or death inconsistent with 9CFR 381.65(b) in regards to birds presented for slaughter, resulted in a GCP failure, and birds died by means other than slaughter. FSIS encourages establishments to develop and implement a systematic approach to ensure poultry presented for slaughter are treated in a manner that minimizes excitement, discomfort, and accidental injury. The initial component of the approach is to assess the areas where problems may occur. The second component asks that establishments determine if their facilities are designed and maintained to prevent excitement, discomfort, and accidental injury to poultry the entire time that live poultry are held in connection with slaughter. Finally, establishments should periodically evaluate their handling methods to ensure that their employees are treating animals in a manner that minimizes injury, excitement and discomfort prior to slaughter and that their methods ensure all poultry are slaughtered in accordance with 9 CFR 381.65 (b).

The establishment was notified that the USDA expects the establishment to employ handling methods consistent with Good Commercial Practices. Plant Management is asked to consider these USDA concerns and prevent future occurrences.

Copies of this noncompliance will be distributed to the establishment, inspection file and District Veterinary Medical Specialist per FSIS Directive 6100.3. The establishment is also reminded that NRs and MOIs documented for GCP issues can be FOIA requested and made available for viewing by FSIS.

Documented by (b) (6)



United States Department of Agriculture

Food Safety and
Inspection
Service

1400
Independence
Avenue, SW.
Washington,
D.C. 20250

From: (b) (6)
Date: 9/3/2019
Subject: Good Commercial Practices/Live Hang
Meeting Date: 9/3/2019
Meeting Time: 8:00 AM
Establishment: P325 - Tyson Foods, Inc.
Reason Code:
Other Reason Code:
Comments:

On Wednesday, 8/28/2019, approximately 0700 hours, while observing conditions in the Live Hang and Picker Room areas after an extended power outage (approximately 1 hour and 22 minutes since the outage began) (b) (6) observed live birds hanging on the kill line, closest to the entry door, past the first window in an area where employees are typically stationed to remove birds from the line that are considered ineligible for slaughter and to ensure birds eligible for slaughter are presented properly. (b) (6) also observed birds on the line entering into the stunner and past the stunner. (b) (6) verbally notified (b) (6) (b) (6), and proceeded to show him the findings. (b) (6) asked (b) (6), why the birds had not been removed from the line given the amount of time operations had not been active. (b) (6) stated that they couldn't remove the birds due to the leg bar holding them in place on the line. (b) (6) asked (b) (6) if he could euthanize the birds at that time. She replied she would not give him instructions but would notify her immediate supervisor of the issue. (b) (6) also observed birds hanging on the live hang line submerged in water inside the stunner. The stunner was filled to the capacity with water that was overflowing onto the floor below. (b) (6) verbally notified (b) (6) of the situation with the birds in the stunner and that she was going to notify (b) (6) (b) (6), of her findings in order for him to make determinations of the next step regarding the issue.

(b) (6), was notified at approximately 0717 hours by (b) (6) regarding the findings at Live Hang/Stunners by (b) (6) proceeded to Live Hang/Picker Rooms, and upon arriving at 0720 hours, (b) (6) observed approximately 25-30 birds that were hung on shackles in the stunner. The stunner had been dropped (b) (6) could see at the exit to the stunner that several birds had had their necks cut. Upon entering through the "Entrance Door" to Live Hang there were birds hanging from shackles that had been euthanized, extending from the exit of live hang to the entrance to the stunner guide bars. There were no birds hanging on shackles in the Live Hang Room.

Based on the observations made by (b) (6) and supported by (b) (6) when he entered the Picking Room and Live Hang Departments, it is reasonable to assume that the birds observed had drowned between the onset of the power outage and USDA's arrival. In addition, the Establishment failed to lower the stunner or remove the birds from the stunner area when the power outage occurred, and the line stopped. This resulted in the birds drowning in the stunner. In addition, it is reasonable to assume that the birds that were still hanging on the line(s) had not been removed from the line or humanely euthanized until the establishment was approached by USDA. These actions are unacceptable and incongruent with the expectations of Good Commercial Practices.

(b) (6) inquired as to the Corrective Actions that (b) (6) would pursue. (b) (6) (b) (6) said that he would remove all dead birds in the Stunner, remove their heads and place them in a condemn barrel. He would do the same for the birds that were on the kill



line before the entrance into the stunner, but would have to wait for the power to be restored to remove the birds situated in the leg bar apparatus. (b) (6) explained that they would not start live hang operations until he had received confirmation from the Establishment that the source of power was back to normal (b) (6) explained to (b) (6) that if the power were to shut down again that he needed to follow the Establishments procedures for birds in the stunner and live hang in the event of an extended line stoppage. (b) (6) explained that there was a ten minute time limit for the birds to be in the stunner at a standstill, and after that the stunner had to be dropped, drained, and the birds removed and humanely euthanized. (b) (6) explained to (b) (6) that it was unacceptable to let the birds drown and/or hang in place for extended period of time alive. (b) (6) acknowledged these issues. (b) (6) stated that the reason no one was there to attend to the situation was a Tornado Warning Practice called by the Establishment and he had removed all team members including himself. He stated that he expected that the power would be restored within a short period of time.

The establishment is reminded in addition to the regulations found in 9CFR 381.65(b), it is also a violation of the Poultry Products Inspection Act (PPIA) 21 USC 458 (a)(1) if birds hung on the slaughter line are allowed to die by means inconsistent with good commercial practices, such as drowning. Establishments should develop and implement measures to ensure poultry presented for slaughter are treated in a manner that minimizes excitement, discomfort, and accidental injury. Establishments should assess the areas where handling problems may occur. Establishment's should determine if their facilities are designed and maintained to prevent excitement, discomfort, and accidental injury to poultry the entire time that live poultry are held in connection with slaughter. Establishment's should periodically evaluate their handling methods to ensure that their employees are treating animals in a manner that minimizes injury, excitement and discomfort prior to slaughter and that their methods ensure all poultry are slaughtered in accordance with 9 CFR381.65 (b). Establishment's should consider the implanting these measures during emergency weather drills when birds will be left in the kill process indefinitely.

USDA is requesting the establishment provided corrective actions and preventive measures in regards to this identified failure to support Good Commercial Practices. The establishment is also being notified further failures to operate within the expectations of Good Commercial Practices can result in further enforcement action.

A copy of this MOI will be provided to the FLS, DVMS and Dallas District Office for further review. The establishment is reminded that copies of NRs and MOIs related to Good Commercial Practices can be released through FOIA request to the general public.

(b) (6) P325