United States Department of Agriculture

Food Safety and
Inspection Service

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

May 1, 2024

Dr. Hyun Kyung Kim
Director
International Cooperation Division
Ministry of Food & Drug Safety
Sejong Government Complex
#94 Dahsom 2 ro
Sejong City
Republic of Korea

Dear Dr. Kim,

The United States Department of Agriculture (USDA), Food Safety and Inspection Service (FSIS) conducted an onsite verification audit of the Republic of Korea's poultry and pork inspection system October 30–November 30, 2023. Enclosed is a copy of the final audit report. The comments received from the Government of the Republic of Korea are included as an attachment to the report.

Sincerely,

MARGARET BURNS RATH

Digitally signed by MARGARET BURNS RATH
Date: 2024.05.01 15:16:28 -04'00'

Margaret Burns Rath, JD, MPH
Acting International Coordination Executive
Office of International Coordination

Enclosure

FINAL REPORT OF AN AUDIT CONDUCTED OF

THE REPUBLIC OF KOREA

OCTOBER 30–NOVEMBER 30, 2023

EVALUATING THE FOOD SAFETY SYSTEM GOVERNING

PROCESSED POULTRY AND PROCESSED PORK PRODUCTS

INTENDED FOR EXPORT TO THE UNITED STATES OF AMERICA

April 25, 2024

Food Safety and Inspection Service
U.S. Department of Agriculture

Executive Summary

This report describes the outcome of an onsite equivalence verification and an initial equivalence determination audit of the Republic of Korea conducted by the U.S. Department of Agriculture's Food Safety and Inspection Service (FSIS) October 30–November 30, 2023. The first audit objective was to verify whether the Republic of Korea's food safety inspection system governing processed poultry remains equivalent to that of the United States, with the ability to export processed poultry products that are safe, wholesome, unadulterated, and properly labeled. The second audit objective was to verify whether the Republic of Korea's food safety inspection system governing processed pork is being implemented as documented in the Self-Reporting Tool. The Republic of Korea currently is eligible to export Thermally Processed - Commercially Sterile (TPCS) and Fully Cooked - Not Shelf Stable (FC-NSS) poultry products to the United States and has requested eligibility to export TPCS and FC-NSS pork products to the United States.

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

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

GOVERNMENT OVERSIGHT (e.g., ORGANIZATION AND ADMINISTRATION)

- Under certain provisions of the Republic of Korea's Livestock Products Sanitary Control Act, retesting of violative samples is allowed. The Ministry of Food and Drug Safety (MFDS), the Central Competent Authority with oversight of official laboratories, has not provided written procedures to prohibit retesting of official microbiological samples with unacceptable test results or to ensure that products that are retested are ineligible for export to the United States.

An exit meeting was held November 30, 2023, by videoconference with representatives from MFDS and the Animal and Plant Quarantine Agency (APQA). During the exit meeting, MFDS and APQA committed to address the preliminary findings as presented. FSIS will evaluate the adequacy of MFDS and APQA documentation of proposed corrective actions once received and determine whether the information provided satisfies FSIS' equivalence requirements.

TABLE OF CONTENTS

I. INTRODUCTION

The Food Safety and Inspection Service (FSIS) of the U.S. Department of Agriculture (USDA) conducted an onsite audit of the Republic of Korea's food safety inspection system October 30–November 30, 2023. The audit began with an entrance meeting held October 30, 2023, in Seoul, Republic of Korea, to discuss the audit objective, scope, and methodology. The participants included inspection officials from the Ministry of Food and Drug Safety (MFDS), the Animal and Plant Quarantine Agency (APQA), and representatives from the USDA's Foreign Agriculture Service (FAS). APQA, an agency under the Ministry of Agriculture, Food, and Rural Affairs (MAFRA), is the Central Competent Authority (CCA) for meat and poultry slaughter, and MFDS is the CCA for meat and poultry processing operations. The FSIS auditors were accompanied by representatives from MFDS, APQA, and FAS throughout the entire audit. The audit concluded with an exit meeting conducted remotely via videoconference November 30, 2023.

II. AUDIT OBJECTIVE, SCOPE, AND METHODOLOGY

This was a two-part audit which encompassed a routine ongoing verification audit for raw and processed poultry products and an initial equivalence verification audit for processed pork products. The first audit objective was to verify whether the Republic of Korea's food safety inspection system governing processed poultry remains equivalent to that of the United States, with the ability to export processed poultry products that are safe, wholesome, unadulterated, and properly labeled. The second audit objective was to verify whether the Republic of Korea's food safety inspection system governing processed pork is being implemented as documented in the Self-Reporting Tool (SRT). Currently, the Republic of Korea is eligible to export the following categories of products to the United States:

Process Category	Product Category	Eligible Products[1]
Thermally Processed - Commercially Sterile	Thermally Processed, Commercially Sterile (TPCS)	Chicken and Duck - All Products Eligible
Fully Cooked - Not Shelf Stable	Ready-to-Eat (RTE) Fully-Cooked Poultry	Chicken and Duck - All Products Eligible
Fully Cooked - Not Shelf Stable	RTE Poultry Fully-Cooked Without Subsequent Exposure to the Environment	Chicken and Duck - All Products Eligible

The USDA's Animal and Plant Health Inspection Service (APHIS) recognizes the Republic of Korea as affected with highly pathogenic avian influenza and exotic Newcastle disease. APHIS has declared poultry products imported from the Republic of Korea subject to highly pathogenic avian influenza and Newcastle disease requirements specified in Title 9 of the United States Code of Federal Regulations (9 CFR) 94.6.

[1] All source poultry used to produce products must originate from eligible countries and establishments certified to export to the United States.

Prior to the onsite equivalence verification audit, FSIS reviewed and analyzed the Republic of Korea's SRT responses and supporting documentation, including official chemical residue and microbiological sampling plans and results. During the audit, the FSIS auditors conducted interviews, reviewed records, and made observations to verify whether the Republic of Korea's food safety inspection system governing processed poultry and pork products is being implemented as documented in the country's SRT responses and supporting documentation.

FSIS applied a risk-based procedure that included an analysis of country performance within six equivalence components, product types and volumes, frequency of prior audit-related site visits, point-of-entry (POE) reinspection and testing results, specific oversight activities of government offices, and testing capacities of laboratories. The review process included an analysis of data collected by FSIS over a 3-year period, in addition to information obtained directly from APQA and MFDS through the SRT.

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

The FSIS auditors reviewed administrative functions at the CCA headquarters, three regional offices, and nine local inspection offices within the establishments. The FSIS auditors evaluated the implementation of control systems in place that ensure the national system of inspection, verification, and enforcement is being implemented as documented in the country's SRT responses and supporting documentation.

Currently, the Republic of Korea has seven certified establishments that produce and export processed poultry products to the United States. The FSIS auditors visited three poultry slaughter and three poultry processing establishments. These poultry slaughter establishments provide raw source materials to certified poultry processing establishments in the Republic of Korea for products intended for export to the United States. Prior to the onsite audit, MFDS provided FSIS with three additional establishments that have requested certification from MFDS once FSIS grants eligibility to export processed pork products to the United States. The FSIS auditors visited these three pork processing establishments as part of the initial equivalence determination process. These pork processing establishments will source their raw pork products from FSIS-regulated establishments in the United States or from certified slaughter establishments in other countries with eligibility to export raw pork products to the United States. For this reason, FSIS did not evaluate or audit the inspection of swine slaughter establishments in the Republic of Korea.

During the establishment visits, the FSIS auditors paid particular attention to the extent to which industry and government interacted to control hazards and prevent noncompliance that threatens food safety. The FSIS auditors assessed the ability of APQA and MFDS to provide oversight through supervisory reviews conducted in accordance with FSIS equivalence requirements for

foreign food safety inspection systems outlined in 9 CFR 381.196 (for poultry products) and 9 CFR 327.2 (for meat products).

The FSIS auditors also visited two government (one microbiological and one chemical residue) and one third-party (private) (microbiological) laboratories to verify that these laboratories can provide adequate technical support to the food safety inspection system.

Competent Authority Visits		#	Locations
Competent Authority	Central	1	• MFDS, Osong
	Regional Offices	3	• Daejeon Regional Office, Daejeon • Honam Regional Office, Gunsan • Daegu Regional Office, Daegu
Laboratories		3	• Gyeonggi-do Veterinary Laboratory Services, Suwon • Jollabuk-do Veterinary Laboratory, Jangsu • Société Générale de Surveillance (SGS) Korea Co., Ltd. (third-party), Uiwang
Poultry slaughter establishments		3	• Establishment K01404001, Harim Corporation, Iksan • Establishment K01413007, Charmfre Co., Ltd., Buan • Establishment M01318001, Maniker Co., Ltd., Cheonan
Poultry processing establishments		3	• Establishment GJA14001, Harim Corporation, Iksan • Establishment GJA17002, Charmfre Co., Ltd., Buan • Establishment SRA200001, Jungdawn Jayeonilga #A Co., Ltd., Paju
Pork processing establishments		3	• Lotte Wellfood Co., Ltd., Gimcheon • Dongwon F&B Jincheon Factory, Jincheon • CJ Cheiljedang Corporation Jincheon Blossom Campus, Jincheon

FSIS performed the audit to verify that the Republic of Korea's food safety inspection system meets requirements equivalent to those under the specific provisions of United States laws and regulations, in particular:

- The Poultry Products Inspection Act (21 United States Code (U.S.C.) Section 451 et seq.);
- The Poultry Products Inspection Regulations (9 CFR part 381);
- The Federal Meat Inspection Act (21 U.S.C. Section 601 et seq.); and
- The Meat Inspection Regulations (9 CFR Parts 301 to the end).

The audit standards applied during the review of the Republic of Korea's food safety inspection system for poultry and pork products included: (1) all applicable legislation originally determined by FSIS as equivalent as part of the initial review process and, (2) any subsequent equivalence determinations that have been made by FSIS under provisions of the World Trade Organization's Agreement on the Application of Sanitary and Phytosanitary Measures.

III. BACKGROUND

From June 1, 2020, to May 31, 2023, FSIS import inspectors performed 100 percent reinspection for labeling and certification on 1,307,433 pounds of TPCS poultry products and 4,922,404 pounds of Fully Cooked – Not Shelf Stable poultry products exported from the Republic of Korea to the United States. FSIS also performed reinspection on 187,257 pounds of TPCS poultry products and 688,314 pounds of Fully Cooked – Not Shelf Stable poultry products at POE for additional types of inspection, including physical examination and condition of container for TPCS products and testing for chemical residues and microbiological pathogens in RTE products (e.g., *Listeria monocytogenes* (*Lm*) and *Salmonella*), for which no products were rejected for issues related to public health.

Additionally, 41 pounds of RTE poultry products were refused entry for other issues not related to public health, including shipping damage, labeling, or other miscellaneous issues.

The previous audit conducted in 2022 identified the following findings:

Summary of Findings from the 2022 FSIS Audit of the Republic of Korea
Component 1: Government Oversight (e.g., Organization and Administration)
• MFDS, the CCA with oversight of official laboratories, has a provision that allows official samples with violative chemical residue test results to be retested and has not provided written procedures to ensure that products that are retested cannot be exported to the United States.
Component 2: Government Statutory Authority and Food Safety and Other Consumer Protection Regulations (e.g., Inspection System Operation, and Product Standards and Labeling)
• APQA, the CCA with oversight of slaughter establishments, has not provided adequate controls to ensure that chicken feet from corresponding condemned carcasses are excluded from being used in the production of chicken broth as an ingredient used in products intended for export to the United States.

During the current audit, the FSIS auditors verified that the corrective actions for the above findings reported in 2022 were implemented and effective in resolving the findings.

The most recent FSIS final audit reports for the Republic of Korea's food safety inspection system are available on the FSIS website at: www.fsis.usda.gov/foreign-audit-reports.

IV. COMPONENT ONE: GOVERNMENT OVERSIGHT (e.g., ORGANIZATION AND ADMINISTRATION)

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

The Republic of Korea's legal framework to administer and enforce regulatory requirements through MAFRA and MFDS inspection activities is based on the Livestock Products Sanitary Control Act (LPSC), the Food Sanitation Act, the Special Act on Imported Food Safety Control, the Act on Labeling and Advertising of Foods, the Act on Traceability Management of Livestock and Livestock Products, and the Prevention of Contagious Animal Disease Act (PCAD). In addition, the Republic of Korea has developed the Quarantine and Inspection Guidelines for the U.S. Export of Poultry Products (hereinafter referred as Guidelines). The Guidelines requirements ensure that laws, regulations, and policies are properly implemented and applied consistently at all certified establishments. The Guidelines provide instructions to inspection personnel for verification of establishments' prerequisite programs, HACCP systems, product formulation checks, microbiological and chemical residue sampling and testing, sanitary control procedures, and conducting ante-mortem and post-mortem inspections.

The Republic of Korea has provided SRT responses and supporting documentation indicating that processed pork products intended for export to the United States will be inspected and verified using the same procedures and organizational structures as poultry products currently eligible for export to the United States. The FSIS auditors verified that there had been no major changes to the organizational structure of the inspection system since the previous FSIS audit in 2022. The Republic of Korea's meat (processed pork) and poultry inspection system is organized by the national government and operates at the central, regional, district and local levels. At the central level, the Republic of Korea's meat and poultry inspection system is divided between MAFRA and MFDS. APQA, an agency within MAFRA, is the CCA responsible for conducting inspection activities in certified poultry slaughter establishments. APQA inspection personnel oversee the proper application of legislation, technical guidelines, and instructions for the implementation of poultry slaughter requirements and official controls at its regional, district, and local level offices. MFDS is the CCA responsible for conducting inspection activities in pork and poultry processing establishments. MFDS inspection personnel oversee the proper application of legislation, technical guidelines, and instructions for the implementation of pork and poultry processing requirements and official controls at its regional and local level offices.

At the regional level, APQA has two regional offices located in Honam and Jungb and one district office in Cheonan that oversee inspection activities at certified poultry slaughter establishments. MFDS has three regional offices located in Gwangju, Gyengin, and Seoul that oversee inspection activities at certified poultry processing establishments. In addition, MFDS has two regional offices located in Daejeon and Daegu to oversee inspection activities at three pork processing establishments that intend to export to the United States once an equivalence determination is finalized.

At the local level, APQA veterinarians' official title is Quarantine Officer (QOs). The QOs are responsible for conducting slaughter inspection and quarantine duties at certified poultry slaughter establishments. The QOs operate in accordance with the provisions of Article 30 of PCAD and Article 13 of LPSC. The QOs are supported by Assistant Inspectors (AIs) of the Livestock Health Control Association (LHCA) who conduct slaughter inspection activities in accordance with the provisions of Article 14 of LPSC. LHCA is a public institution established to efficiently execute duties related to poultry sanitation management and is responsible for the training and management of AIs. MFDS Inspection Officers (IOs) are veterinarians responsible

for conducting inspection activities in pork and poultry processing establishments. IOs operate in accordance with the provisions of Article 13 of LPSC.

The FSIS auditors reviewed the recruitment process and verified that all inspection personnel, including QOs, IOs, and AIs, are full time government-paid employees of the national or local government. The FSIS auditors reviewed government inspection personnel educational credentials and training records concerning good commercial practices (GCP) and animal welfare, ante-mortem inspection, post-mortem inspection, sanitation standard operating procedures (Sanitation SOP), HACCP, chemical residue and microbiological sampling methodology, heat treatment and process control, and import requirements specific to the United States. The FSIS auditors verified that APQA and MFDS have organized these ongoing training programs. There were no concerns noted with the training materials or the training records.

MFDS is responsible for notifying FSIS of establishments newly approved or delisted as establishments certified to export to the United States. The FSIS auditors reviewed MFDS' preliminary certification process for approval and certification of pork processing establishments that intend to export to the United States once an equivalence determination is finalized. The FSIS auditors confirmed that MFDS has the legal authority and responsibility to approve or reject an establishment request to be certified as eligible to export products to the United States based on the outcome of the record reviews and onsite inspection verification of compliance with FSIS import requirements.

MFDS and APQA have the legal authority and responsibility to ensure that adulterated or misbranded products are not exported to the United States. Article 33 of the LPSC provides regulatory definitions for adulterated and misbranded products that are consistent with FSIS requirements. At the regional and local inspection offices, the FSIS auditors verified that government inspection personnel have legal authority to recall, seize, and destroy hazardous poultry products in accordance with Article 36 of LPSC. The FSIS auditors also verified that each audited establishment had a written recall program as required by the Guidelines. In addition, the Guidelines instructs inspection personnel to verify establishment traceability programs prior to issuing export health certificates. The FSIS auditors reviewed recently issued export health certificates and confirmed that government inspection personnel adhere to inspection procedures outlined in Section 13 of the Guidelines. The FSIS auditors did not identify any concerns.

The FSIS auditors verified that APQA and MFDS have provided instructions to its inspection personnel to identify and document any noncompliance findings on a noncompliance record (NR). The FSIS auditors reviewed inspection-generated NRs and verified that government inspection personnel identified and documented noncompliance findings in NRs in accordance with requirements in the Guidelines. Government inspection personnel closed NRs after verifying the adequacy and effectiveness of the establishment's preventive measures and corrective actions addressing noncompliance findings. The FSIS auditors confirmed that there have not been any elevated enforcement actions associated with certified establishments since the previous FSIS audit in 2022.

The Korean Laboratory Accreditation Scheme (KOLAS) is the national accreditation body for laboratories that test official government verification samples of products intended for export to

the United States. MFDS has established the relevant laws and regulations to ensure that designated laboratories can maintain equivalence with international accreditation standards and operate under quality control standards consistent with the International Organization for Standardization (ISO)/International Electrotechnical Commission (IEC) Guide 17025 standards. The legal framework of laboratories is captured in the Testing and Inspection on Food and Drug Act (Laboratory Quality Assurance) and the Regulations on Evaluation of Testing and Inspection Agencies in the Food and Drug Industry. MFDS has the legal authority to designate and certify government and third-party (private) laboratories to perform analyses for official government verification sampling and testing programs in accordance with the standards, specifications, and testing methods set forth in the Korean Food Code. MFDS is also responsible for conducting annual audits of government and private laboratories against the standards laid out in the Guidelines. The FSIS auditors visited two government and one third-party (private) laboratory: Gyeonggi-do Veterinary Laboratory Services, Jollabuk-do Veterinary Laboratory, and Société Générale de Surveillance (SGS) Korea Co., Ltd. The Gyeonggi-do Veterinary Laboratory Service is a government laboratory conducting analyses of official microbiological verification samples on RTE poultry products. The Jollabuk-do Veterinary Laboratory is a government laboratory conducting chemical residue testing on official samples originating from certified poultry slaughter establishments. The SGS Korea Co., Ltd. is a private laboratory contracted by MFDS to conduct analyses of official microbiological verification samples on RTE pork products. These laboratories are accredited by KOLAS to ISO/IEC 17025 standards. The FSIS audit scope in each laboratory included review of sample receipt, timely analysis, analytical methodologies, analytical controls, analyst qualifications and trainings, proficiency testing, and recording and reporting of results. The FSIS auditors reviewed the most recent accreditation audits, the laboratories' staff training records, and the results of their proficiency testing. The FSIS auditors identified the following finding related to the microbiological laboratory oversight:

- Under certain provisions of the Republic of Korea's LPSC, retesting of violative samples is allowed. MFDS has not provided written procedures to prohibit retesting of official microbiological samples with unacceptable test results or to ensure that products that are retested are ineligible for export to the United States.

However, the FSIS auditors' review of inspection records indicated that no retesting occurred on products shipped to the United States since the previous FSIS audit in 2022.

FSIS onsite audit verification activities indicate that the Republic of Korea's food safety inspection system governing processed poultry and pork products has the organizational structure to provide ultimate control, supervision, and enforcement of regulatory requirements. The laboratory finding described above does not indicate an imminent threat to public health.

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

The second equivalence component the FSIS auditors reviewed was Government Statutory Authority and Food Safety and Other Consumer Protection Regulations. The system is to provide

for GCPs in poultry; ante-mortem inspection of birds; post-mortem inspection of every carcass and its parts; controls over condemned materials; controls over establishment construction, facilities, and equipment; at least once per shift inspection during processing operations; and periodic supervisory visits to official establishments.

The FSIS auditors confirmed that QOs perform ante-mortem inspection of live birds at the receiving and holding areas prior to slaughter at certified poultry slaughter establishments when carcasses and parts from these birds would serve as source material for further processing. The FSIS auditors assessed ante-mortem inspection through onsite record reviews, interviews, and observations of government inspection personnel performing these procedures in the poultry slaughter establishments that were audited. The FSIS auditors confirmed that QOs and AIs perform post-mortem inspection procedures in accordance with APQA's requirements. The FSIS auditors observed and verified that proper presentation, examination, and disposition of poultry carcasses and parts were being implemented during post-mortem inspection. The FSIS auditors verified through onsite observations and record reviews that each certified establishment audited had enough qualified in-plant government inspection personnel to provide inspection coverage during all slaughter operations, and at least once per production shift during processing operations when producing poultry products for export to the United States. The FSIS auditors verified that post-mortem inspection stations at the audited poultry slaughter establishments were equipped with appropriate lighting, receptacles for condemned carcasses and parts, hang back racks, and start/stop switches to stop the slaughter line. The FSIS auditors did not identify any concerns with the implementation of ante-mortem or post-mortem inspection procedures.

The FSIS auditors evaluated in-plant government inspection personnel verification of establishment sanitary dressing procedures in poultry slaughter establishments. The in-plant government inspection personnel verify the effectiveness of establishment's sanitary dressing by performing daily verification of finished products standards at pre-chill and post-chill stations and zero tolerance verification checks in accordance with APQA requirements. The FSIS auditors observed that in-plant government inspection personnel physically examine randomly selected birds to perform zero tolerance verification checks at the designated areas and prior to poultry carcasses entering the chiller. The results of the zero tolerance verification checks are documented in accordance with APQA requirements.

The FSIS auditors verified that the audited establishments have a system in place to distinguish between eligible poultry and pork products intended for export to the United States from products destined for other markets. This includes complete separation of the entire production process (e.g., receiving, processing, and storage) by time and space through labeling and a lot management system for product intended for export to the United States. The FSIS auditors verified that MFDS and APQA require that poultry products intended for export to the United States meet FSIS labeling requirements. The FSIS auditors noted that in-plant government inspection personnel perform ongoing labeling verification activities. The in-plant government inspection personnel routinely verify labeling requirements throughout production and, in particular, prior to issuing an export health certification.

The FSIS auditors verified that MFDS and APQA require certified establishments to separate and appropriately dispose of condemned or inedible poultry and pork products. This included

inspection verification of certified establishments' procedures to identify, separate, and dispose of condemned materials. The Guidelines require condemned materials to be placed in containers with distinctive markings and require the establishment to maintain appropriate records of disposed materials. The FSIS auditors confirmed that government inspection personnel conduct inspection verification activities at least once per production shift to verify proper collection, segregation, storage in designated containers, and disposal of condemned poultry in accordance with MFDS and APQA requirements.

The FSIS auditors verified through interviews and record reviews that MFDS and APQA conduct supervisory reviews twice a year at establishments eligible to export to the United States. The supervisory reviews are performed by QOs or IOs who are not responsible for performing inspection at the establishments. The supervisory reviews include assessment of the establishment's HACCP system including prerequisite programs, sampling procedures, sanitation, management of facilities, and GCPs.

APHIS-restricted products (raw poultry and raw pork) are not eligible for export to the United States. Currently, APHIS only allows TPCS (pork) and TPCS and FC-NSS (poultry) products as eligible for export to the United States from processing establishments certified by MFDS and listed as eligible in the FSIS Import/Export Library. Currently, there are three certified poultry slaughter establishments that provide raw source materials to four certified processing establishments in the Republic of Korea. The FSIS auditors verified that certified poultry processing establishments only receive raw poultry source materials from the Republic of Korea's certified slaughter establishments and that none of these processing establishments received raw poultry products from any other country. The audited pork processing establishments intending to become certified to export to the United States once an equivalence determination is finalized are importing raw meat from FSIS-regulated establishments in the United States for their source materials. During onsite visits to the establishments, the FSIS auditors verified that each audited establishment has a system in place to identify and segregate pork and poultry products destined for export to the United States from those that are destined for other markets, during all stages of production, storage, and shipment. The FSIS auditors verified that government inspection personnel review labels on boxes and individual packages as part of their export certification task to verify compliance with product labeling for export to the United States.

FSIS onsite audit verification activities indicate that MFDS and APQA continue to maintain the legal authority, a regulatory framework, and adequate verification procedures to ensure sufficient official regulatory control using statutory authority consistent with criteria established for this component.

VI. COMPONENT THREE: GOVERNMENT SANITATION

The third equivalence component the FSIS auditors reviewed was Government Sanitation. The FSIS auditors verified that the CCA requires each official establishment to develop, implement, and maintain written Sanitation SOPs to prevent direct product contamination or insanitary conditions, and to maintain requirements for sanitation performance standards (SPS) and sanitary dressing.

The FSIS auditors verified that MFDS and APQA require slaughter and processing establishments to develop, implement, and maintain written Sanitation SOPs, SPS, and implement sanitary dressing procedures to prevent direct product contamination or the creation of insanitary conditions consistent with FSIS requirements in 9 CFR part 416. The FSIS auditors verified that each audited establishment maintains a written sanitation program to include cleanliness of the food contact surfaces prior to the start of operations and to maintain sanitary conditions during operations to prevent product adulteration or creation of insanitary conditions. Each audited establishment's Sanitation SOPs included maintenance and improvement of sanitary conditions through ongoing evaluation of the establishment's hygienic practices. The FSIS auditors confirmed that QOs and IOs conduct daily verification of sanitation requirements in accordance with the Guidelines. Inspection verification activities consist of a combination of document review, observation, and hands-on inspection verification.

The FSIS auditors observed in-plant government inspection personnel conducting pre-operational sanitation verification in one of the audited establishments. The in-plant government inspection personnel's hands-on verification procedures began after the establishment personnel completed their pre-operational sanitation inspection and determined that the facility was ready for government pre-operational sanitation verification activities. The FSIS auditors assessed the ability of government inspection personnel to identify insanitary conditions and exercise regulatory enforcement controls to ensure proper implementation of sanitary requirements during pre-operation inspection. The FSIS auditors did not identify any concerns.

The FSIS auditors observed the in-plant government inspection personnel perform hands-on operational sanitation verification in all visited establishments. The FSIS auditors noted that the inspection verification activities included direct observation of the actual operations and review of the establishments' associated records. The FSIS auditors also examined inspection personnel's documentation of sanitation noncompliance records and verified that government inspection personnel took regulatory enforcement control actions sufficient to ensure that sanitary conditions were restored, and product was protected from contamination. The FSIS auditors' observations and record reviews of establishments' sanitation monitoring, verification, and corrective action records showed no systemic concerns. Similarly, the review of in-plant government inspection personnel records documenting inspection verification results and periodic supervisory reviews showed that inspection personnel were adequately verifying establishments' compliance with sanitation regulatory requirements.

The FSIS auditors evaluated in-plant government inspection personnel verification of establishment sanitary dressing procedures in certified poultry slaughter establishments. The in-plant government inspection personnel conduct daily verification of the establishment's sanitary dressing procedures including verification of zero tolerance for ingesta and fecal material. The Guidelines, Annex 13, Inspection Standards and Detailed Inspection Methods Used for Slaughtered Livestock and Its Meat, and Annex 14, Inspection Standards for the Fecal Contamination of Poultry Carcass, describe requirements for certified poultry slaughter establishments to develop, implement, and maintain written procedures to ensure proper application of sanitary dressing procedures and prevent carcasses with visible ingesta or fecal contamination from entering the chiller. The FSIS auditors' observations and record reviews of inspection verification activities regarding these requirements did not raise any concerns.

FSIS onsite audit verification activities indicate that the Republic of Korea's food safety inspection system governing processed poultry and pork products maintains sanitation programs that are consistent with criteria established for this component. The FSIS auditors identified isolated findings related to the inspection verification of sanitation requirements. These are noted in the individual establishment checklists provided in Appendix A of this report.

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

The fourth equivalence component the FSIS auditors reviewed was Government HACCP System. The food safety inspection system is to require that each official establishment develop, implement, and maintain a HACCP system.

MFDS and APQA require slaughter and processing establishments to develop, implement, and maintain a HACCP system consistent with FSIS requirements in 9 CFR part 417. The initial certification of an establishment that intends to export poultry and pork products to the United States is contingent upon the approval of a validated HACCP plan. Once an establishment is certified, it is subject to a yearly audit by APQA and MFDS. The Guidelines provide instructions to certified establishments on implementation of the HACCP requirements and provides procedures for the QOs and IOs for verification and enforcement of the HACCP requirements.

The FSIS auditors verified that audited establishments' HACCP programs include written hazard analysis; flow charts; supporting documentation for hazard analysis decisions and critical limits, monitoring, and verification activities for critical control points (CCP); documentation of validation and reassessments; and records supporting the implementation of the HACCP system. The FSIS auditors reviewed establishment records for monitoring, verification, corrective actions, and validation, as well as inspection daily verification records for all CCPs. The FSIS auditors verified that audited establishments took appropriate corrective actions in response to any critical limit deviations and in-plant government inspection personnel adequately documented and verified the effectiveness of the establishments' corrective actions.

In accordance with APQA requirements, certified poultry slaughter establishments are required to maintain a CCP to control fecal contamination and ensure that contaminated carcasses do not enter the chiller. The Guidelines outlines the APQA inspection requirements for verification of zero tolerance. The FSIS auditors did not identify any concerns regarding zero tolerance CCP monitoring or verification procedures.

In accordance with MFDS requirements, poultry processing establishments producing RTE products for export to the United States are required to maintain a zero tolerance for *Salmonella*, *Lm*, *Campylobacter jejuni*, *Campylobacter coli*, and *Yersinia enterocolitica* in RTE products intended for direct consumption without further processing or cooking. MFDS requires certified poultry processing establishments to address these microbiological food safety hazards in their HACCP plan. At the time of this audit, MFDS was revising its HACCP verification procedures concerning control of *Lm* in the post-lethality processing environment for RTE processed pork intended for export to the United States.

FSIS onsite audit verification activities indicate that the Republic of Korea's food safety inspection system governing processed poultry and pork products maintains HACCP systems that are consistent with criteria established for this component. The FSIS auditors identified isolated findings related to the inspection verification of HACCP record-keeping requirements. These are noted in the individual establishment checklists provided in Appendix A of this report.

VIII. COMPONENT FIVE: GOVERNMENT CHEMICAL RESIDUE TESTING PROGRAMS

The fifth equivalence component the FSIS auditors reviewed was Government Chemical Residue Testing Programs. The food safety inspection system is to present a chemical residue testing program, organized and administered by the national government, which includes random sampling of internal organs, fat, or muscle of carcasses for chemical residues identified by the exporting country's poultry inspection authorities or by FSIS as potential contaminants.

The Republic of Korea's National Residue Program (NRP) has been established pursuant to Article 16 of Enforcement Rule on the Livestock Products Sanitary Control Act, Article 6 of Testing and Inspection on Food and Drugs Act, and Article 23 of National Regulatory Law. The NRP is issued each year based on an evaluation of results from the previous year, taking into consideration many factors and making adjustments to the plan, including any changes to which substances will be targeted for testing (e.g., antibiotics, synthetic antimicrobials, hormones, pesticides and other drugs of veterinary interest). Other factors which may be considered as part of the annual evaluation include the frequency and nature of residue violations, established maximum residue levels (MRLs), drug withdrawal protocol failures, violations involving drug overdosing and drug resistance, and toxicity or lack of information on drug use. While MFDS is the key player in the planning and monitoring of the implementation of the NRP, APQA collaborates in determining the target compounds in meat and poultry products both at farms and slaughter establishments. APQA also engages in exploratory testing and providing technical training to the staff involved in executing the NRP. In addition to MFDS and APQA, the local governments also provide support for implementation of the NRP through residue testing of farm animals and meat and poultry products at local testing laboratories. The veterinary services branch of the local government is also responsible for animal health and sanitation on livestock farms and slaughter establishments, including sample collection for chemical residue testing. However, at poultry slaughter establishments certified to export to the United States, QOs collect and ship samples to the appropriate laboratory.

The NRP includes regulatory surveillance sampling of all livestock and poultry showing pathology or exhibiting signs of having been administered veterinary drugs or with visible injection sites. Samples consisting of kidneys and liver matrices are collected at the establishments by QOs for rapid qualitative testing for the presence of antibiotics. Animal species targeted as part of the NRP include cattle, pigs, sheep and goat, horse, and poultry, including chickens and ducks. The FSIS auditors reviewed documents pertaining to implementation of the NRP and conducted interviews with MFDS and APQA officials and confirmed implementation of testing in accordance with documentation submitted to FSIS annually for the NRP. The Republic of Korea sets MRL criteria in accordance with U.S. requirements or Codex guidelines. MRLs may also be based on results obtained from studies

conducted domestically. For example, MFDS conducts a risk assessment for the presence of lead, chromium and arsenic in livestock and poultry every 4-5 years, and these studies inform development of MRL criteria. The documents reviewed at each audited poultry slaughter establishment indicated that those establishments were being sampled by the QO in accordance with sample allocations in the NRP.

Positive results are reported to MFDS and APQA and traced back to the farm of origin, which is then subject to intensive testing in conjunction with measures to prohibit the farm from supplying live poultry to be slaughtered and processed for export to the United States. Document reviews and interviews conducted by the FSIS auditors indicates that MFDS and APQA follow procedures of the Guidelines, Annex 1, Methods for Sampling and Inspection of Residues in Meat, etc. and Measures per Inspection Result.

FSIS onsite audit verification activities indicate that the Republic of Korea's food safety inspection system is implementing its chemical residue sampling and testing as documented through their SRT submission. There have not been any POE violations related to this component since the previous FSIS audit in 2022.

IX. COMPONENT SIX: GOVERNMENT MICROBIOLOGICAL TESTING PROGRAMS

The sixth equivalence component the FSIS auditors reviewed was Government Microbiological Testing Programs. The food safety inspection system is to implement certain microbiological sampling and testing programs to verify that meat and poultry products prepared for export to the United States are safe and wholesome.

APQA's microbiological Monitoring Program for Exported Poultry Products requires poultry slaughter establishments certified to provide source material for use in production of RTE products intended for export to the United States to develop a sampling and testing program to monitor process control throughout the slaughter and dressing process (e.g., at pre-evisceration and post-chill locations). Establishments are to maintain this program in either a HACCP plan, Sanitation SOP, or other prerequisite program. The establishment sampling requirements for monitoring process control throughout the slaughter and dressing process through indicator organism testing are consistent with FSIS requirements in 9 CFR 381.65.

The FSIS auditors verified that the three audited poultry slaughter establishments have written procedures for pre-chill and post-chill sampling of poultry carcasses for indicator organism testing as per APQA requirements. The written procedures provided instructions for random selection of carcasses, aseptic sample collection techniques, sampling frequency, packaging, and delivery of samples to assigned laboratories. The FSIS auditors also observed sample collection by establishment personnel at the pre-chill and post-chill locations. The FSIS auditors review of establishments' monitoring and inspectors' verification records identified no concerns.

APQA requires official government verification sampling for *Salmonella*. The FSIS auditors verified through observations, interviews, and record reviews that in-plant government inspection personnel conduct official verification sampling for *Salmonella* in raw poultry

carcasses in accordance with the Guidelines. Official government verification sampling includes the daily collection of one poultry carcass sample until the sample set is completed, with a set consisting of 51 samples. The FSIS auditors observed QOs sample collection methodology, labeling, packaging, and shipping of sealed samples to the regional government laboratory with appropriate accompanying documentation. The FSIS auditors also confirmed that government inspection personnel were reviewing official test results for trend analysis and verifying the establishments' proper implementation of corrective measures when the establishments do not meet the established performance standards. The FSIS auditors' review of inspection records, including *Salmonella* testing results, identified no concerns.

Currently, the Republic of Korea is eligible to export TPCS and FC-NSS RTE poultry products to the United States. These are hermetically-sealed RTE poultry products that are not exposed to the post-lethality processing environment. The FSIS auditors verified that MFDS requires certified poultry processing establishments to meet *Lm* and *Salmonella* sampling and testing requirements for RTE poultry products destined for export to the United States. The FSIS auditors noted that in the audited pork processing establishments intending to become certified to export to the United States, the official government verification sampling for RTE products (e.g., *Lm* and *Salmonella*) has yet to be implemented. MFDS intends to implement official verification sampling of RTE products for *Salmonella* and *Lm* consistent with current sampling conducted for RTE poultry products eligible for export to the United States.

The Korean Food Code mandates zero tolerance of *Lm* and *Salmonella* in RTE products. The FSIS auditors verified that MFDS considers RTE products that test positive for *Lm* and *Salmonella*, and RTE products that come into contact with food contact surfaces that have tested positive for *Lm*, to be adulterated. Establishments are required to implement corrective actions in response to a *Lm* or *Salmonella* positive sample resulting from either an establishment monitoring test or official government verification test. The FSIS auditors interviewed government inspection personnel at the audited pork and poultry processing establishments to evaluate their level of knowledge regarding control of RTE regulatory requirements and official verification sampling.

The FSIS auditors reviewed IOs daily verification activities at audited poultry processing establishments. This included verification of the time and temperature records of heat-treatment and sterilization processes, traceability of products eligible for export to the United States, and retort calibration and maintenance records. The FSIS auditors noted that in the audited pork processing establishments, the official inspection verification of processing requirements for export of TPCS or RTE products to the United States has yet to be implemented. MFDS indicated that those establishments intending to become certified to export processed pork products to the United States will be required to comply with MFDS requirements as implemented for TPCS and RTE poultry products currently eligible for export to the United States. The FSIS auditors reviewed inspection verification records and laboratory testing results for TPCS and RTE poultry products exported to the United States and found no concerns.

FSIS onsite audit verification activities indicate that the Republic of Korea's poultry inspection system includes microbiological sampling and testing programs implemented as documented

through MFDS and APQA's SRT submissions. There have not been any POE violations related to this component since the previous FSIS audit in 2022.

X. CONCLUSIONS AND NEXT STEPS

A remote exit meeting was held November 30, 2023, with representatives from MFDS and APQA. At this meeting, the FSIS auditors presented the preliminary findings from the audit. An analysis of the findings within each component did not identify any deficiencies that represented an immediate threat to public health. The FSIS auditors identified the following preliminary finding:

GOVERNMENT OVERSIGHT (e.g., ORGANIZATION AND ADMINISTRATION)

- Under certain provisions of the Republic of Korea's LPSC, retesting of violative samples is allowed. MFDS has not provided written procedures to prohibit retesting of official microbiological samples with unacceptable test results or to ensure that products that are retested are ineligible for export to the United States.

During the exit meeting, MFDS and APQA committed to address the preliminary audit finding as presented. FSIS will evaluate the adequacy of MFDS and APQA documentation of proposed corrective actions once received and determine whether the information provided satisfies FSIS' equivalence requirements.

APPENDICES

Appendix A: Individual Foreign Establishment Audit Checklists

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Harim Corporation, Iksan	11/07/2023	K01404001	The Republic of Korea
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	OIEA International Audit Staff (IAS)		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		**Part E - Other Requirements**	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		**Part F - Inspection Requirements**	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Periodic Supervisory Reviews	
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic *E. coli* Testing		55. Post Mortem Inspection	
27. Written Procedures		**Part G - Other Regulatory Oversight Requirements**	
28. Sample Collection/Analysis		56. European Community Directives	O
29. Records		57.	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

Establishment Operations:	Poultry Slaughter
Prepared Products:	Raw Intact

60. Observation of the Establishment

There were no significant findings to report after consideration of the nature, degree, and extent of all observations.

61. AUDIT STAFF	62. DATE OF ESTABLISHMENT AUDIT
OIEA International Audit Staff (IAS)	11/07/2023

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Charmfre Co., Ltd., Buan	11/08/2023	K01413007	The Republic of Korea
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	OIEA International Audit Staff (IAS)		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	X
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Periodic Supervisory Reviews	
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57.	
58.	
59.	

Establishment Operations:	Poultry Slaughter
Prepared Products:	Raw Intact

60. Observation of the Establishment

39-Presence of rusted areas on the overhead structures in the production areas where exposed product was present. No direct product adulteration observed.
41-Presence of beaded condensate on the overhead structures above exposed product in the production area. No direct product adulteration observed.

61. AUDIT STAFF	62. DATE OF ESTABLISHMENT AUDIT
OIEA International Audit Staff (IAS)	11/08/2023

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Maniker Co., Ltd., Cheonan	11/13/2023	M01318001	The Republic of Korea
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	OIEA International Audit Staff (IAS)		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		**Part E - Other Requirements**	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		**Part F - Inspection Requirements**	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Periodic Supervisory Reviews	
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	
Part D - Sampling Generic *E. coli* Testing		55. Post Mortem Inspection	
27. Written Procedures		**Part G - Other Regulatory Oversight Requirements**	
28. Sample Collection/Analysis		56. European Community Directives	O
29. Records		57.	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions		59.	
31. Reassessment			
32. Written Assurance			

Establishment Operations:	Poultry Slaughter
Prepared Products:	Raw Intact

60. Observation of the Establishment

There were no significant findings to report after consideration of the nature, degree, and extent of all observations.

61. AUDIT STAFF	62. DATE OF ESTABLISHMENT AUDIT
OIEA International Audit Staff (IAS)	11/13/2023

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Harim Corporation, Iksan	11/07/2023	GJA14001	The Republic of Korea
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	OIEA International Audit Staff (IAS)		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Periodic Supervisory Reviews	
52. Humane Handling	O
53. Animal Identification	
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57.	
58.	
59.	

Establishment Operations:	Poultry Processing
Prepared Products:	Thermally Processed Commercially Sterile and Fully Cooked-Not Shelf Stable

60. Observation of the Establishment

39-Excessive use of silicone type materials to cover gaps or holes in the ceiling in the production area where exposed product was present.
39-Presence of silicon type materials on the ceiling of an ice making machine. Silicone was used to fill the space gaps between metal plates constructing the inside top surfaces of the ice making machine cabinet.
39-Presence of rusted areas on the ceiling over exposed products in the production areas.

61. AUDIT STAFF	62. DATE OF ESTABLISHMENT AUDIT
OIEA International Audit Staff (IAS)	11/07/2023

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Charmfre Co., Ltd., Buan	11/08/2023	GJA17002	The Republic of Korea
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	OIEA International Audit Staff (IAS)		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Periodic Supervisory Reviews	
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57.	
58.	
59.	

Establishment Operations:	Poultry Processing
Prepared Products:	Thermally Processed Commercially Sterile

60. Observation of the Establishment

There were no significant findings to report after consideration of the nature, degree, and extent of all observations.

61. AUDIT STAFF	62. DATE OF ESTABLISHMENT AUDIT
OIEA International Audit Staff (IAS)	11/08/2023

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Jungdawn Jayeonilga #A Co., Ltd., Paju	11/14/2023	SRA200001	The Republic of Korea
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	OIEA International Audit Staff (IAS)		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Periodic Supervisory Reviews	
52. Humane Handling	O
53. Animal Identification	
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57.	
58.	
59.	

Establishment Operations:	Poultry Processing
Prepared Products:	Thermally Processed Commercially Sterile

60. Observation of the Establishment

There were no significant findings to report after consideration of the nature, degree, and extent of all observations.

61. AUDIT STAFF	62. DATE OF ESTABLISHMENT AUDIT
OIEA International Audit Staff (IAS)	11/14/2023

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Lotte Wellfood Co., Ltd., Gimcheon	11/01/2023	N/A	The Republic of Korea
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	OIEA International Audit Staff (IAS)		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	X
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	X
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Periodic Supervisory Reviews	
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57.	
58.	
59.	

Establishment Operations:	Pork Processing
Prepared Products:	Thermally Processed Commercially Sterile and Fully Cooked-Not Shelf Stable

60. Observation of the Establishment

20-The establishment's written HACCP plan did not include measures to prevent recurrence as part of its corrective actions to be followed in response to a deviation from a critical limit.
22-The establishment’s HACCP plan did not include its return product procedures in its flowchart or resulting hazard analysis.
39-Presence of rusted areas, exposed insulation, loose silicone, and holes in the ceiling in the production areas where exposed product was present. No direct product adulteration observed.
47-Observed establishment employees leave production areas to use restroom facilities without removing or changing their working uniforms or hair nets prior to returning to the production areas.

61. AUDIT STAFF	62. DATE OF ESTABLISHMENT AUDIT
OIEA International Audit Staff (IAS)	11/01/2023

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Dongwon F&B Jincheon Factory, Jincheon	11/02/2023	N/A	The Republic of Korea
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	OIEA International Audit Staff (IAS)		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	X
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Periodic Supervisory Reviews	
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57.	
58.	
59.	

Establishment Operations:	Pork Processing
Prepared Products:	Thermally Processed Commercially Sterile and Fully Cooked-Not Shelf Stable

60. Observation of the Establishment

22-The establishment's HACCP verification records for review of records did not include the times or the results of verification activities.
22-The establishment’s HACCP system did not include its return product procedures in its flow chart or resulting hazard analysis.
39-Presence of space gaps among ceiling panels in multiple locations in the production areas where exposed product was present. No direct product adulteration observed.
41-Presence of beaded condensate on an overhead cooling unit above exposed product in the production area. No direct product adulteration observed.

61. AUDIT STAFF	62. DATE OF ESTABLISHMENT AUDIT
OIEA International Audit Staff (IAS)	11/02/2023

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
CJ Cheiljedang Corporation Jincheon Blossom Campus, Jincheon	11/03/2023	N/A	The Republic of Korea
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	OIEA International Audit Staff (IAS)		X ON-SITE AUDIT ☐ DOCUMENT AUDIT

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Periodic Supervisory Reviews	
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57.	
58.	
59.	

Establishment Operations:	Pork Processing
Prepared Products:	Thermally Processed Commercially Sterile

60. Observation of the Establishment

22-The establishment's HACCP verification records for review of records did not include the times or the results of verification activities.
22-The establishment's HACCP verification procedures did not include direct observation of monitoring procedures as part of its verification activities.
22-The establishment's HACCP monitoring records did not include the times of the monitoring activities.
22-The establishment’s HACCP system did not include its return product procedures in its flow chart or resulting hazard analysis.

61. AUDIT STAFF	62. DATE OF ESTABLISHMENT AUDIT
OIEA International Audit Staff (IAS)	11/03/2023

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

식품의약품안전처
Ministry of Food and Drug Safety

Imported Food Policy Division
187 Osongsaengmyeong2(i)-ro, Heungdeok-gu,
Cheongju-si, Chungcheongbuk-do, 28159
Republic of Korea
Tel: +82-43-719-2155 Fax: +82-43-719-2150

April 19, 2024

Michelle Catlin, PhD
International Coordination Executive
Office of International Coordination

Subject: Submission of documents elaborating corrective measures taken based on the outcome of an on-site equivalence verification audit of Korea by FSIS

Dear Dr. Michelle Catlin,

This letter is with regard to the FY24 Draft Final Audit Report on the Korea's pork and poultry inspection system which was conducted from October 30 to November 14, 2023.

After reviewing this report, Korea submits documents elaborating results of the corrective measures taken for deficiencies observed by FSIS.

Like we are currenlty exporting our poultry products to the U.S, I look forward to export our processed pork products to your country in the near future.

I appreciate your cooperation, and should you have further questions, please feel free to contact me.

Sincerely,

KANG MIN HO

Kang Min-ho
Director of the Imported Food Policy Division
Imported Food Safety Policy Bureau

Enclosure :
Results of the corrective measures taken based on the audit findings

Submissions of the Corrective Actions for the Results of the U.S. FSIS On-site Audit

☐ Corrective Actions by Government Oversight (Annex 1)

Findings	Corrective action
Under certain provisions of the Republic of Korea's LPSC, retesting of violative samples is allowed. MFDS has not provided written procedures to prohibit retesting of official microbiological samples with unacceptable test results or to ensure that products that are retested are ineligible for export to the United States	Revised the related export guideline (10.3.1. Notwithstanding Article 12-3(2) (Re-inspection of Livestock Products) of the Livestock Products Sanitary Control, the manager of the establishment for export should not ask for re-test of poulty meat or poultry products of which microbiological tests results are non-compliant, thereby excluding concerned poulty meat or poultry products from being used as raw materials of products for export.)

☐ Corrective Actions by Establishments (Annex 2)

※ Please refer to Annex 2 for more detailed contents of corrective measures

1. Establishment for poultry products

1-1. Charmfre Co., Ltd., Buan(K01413007): slaughterhouse

Findings	Corrective action
39-Presence of rusted areas on the overhead structures in the production areas where exposed product was present. No direct product adulteration observed.	Repaired ventilation in the ceiling of selecting/packaging room to prevent foreign materials from falling
41-Presence of beaded condensate on the overhead structures above exposed product in the production area. No direct product adulteration observed.	Revised procedures in the HACCP plan regarding the condensate removal procedure

1-2. Harim Corporation, Iksan (GJA14001): processing plant

Findings	Corrective action
39-Excessive use of silicone type materials to cover gaps or holes in the ceiling in the production area where exposed product was present	Removed silicone and got a finish
39-Presence of silicon type materials on the ceiling of an ice making machine. Silicone was used to fill the space gaps between metal plates constructing the inside top surfaces of the ice making machine cabinet.	Changed panels of in/out of an ice making machine
39-Presence of rusted areas on the ceiling over exposed products in the production areas.	Removed rusted areas and painted them

2. Establishment for pork products

2-1. Lotte Wellfood Co., Ltd., Gimcheon

Findings	Corrective action
20-The establishment's written HACCP plan did not include measures to prevent recurrence as part of its corrective actions to be followed in response to a deviation from a critical limit	Established measures to prevent recurrence in the HACCP plan
22-The establishment’s HACCP plan did not include its return product procedures in its flowchart or resulting hazard analysis.	Added procedures for return of products in the HACCP plan
39-Presence of rusted areas, exposed insulation, loose silicone, and holes in the ceiling in the production areas where exposed product was present. No direct product adulteration observed.	-Repaired ceilings -Revised the HACCP plan to check any damages of the ceiling and walls in the production areas
47-Observed establishment employees leave production areas to use restroom facilities without removing or changing their working uniforms or hair nets prior to returning to the production areas.	Revised the HACCP plan to remove/change working uniforms when using areas other than the production areas

2-2. Dongwon F&B Jincheon Factory, Jincheon

Findings	Corrective action
22-The establishment's HACCP verification records for review of records did not include the times or the results of verification activities.	Revised a format of the HACCP verification records to keep the times and results of the HACCP verification activities
22-The establishment's HACCP plan did not include its return product procedures in its flowchart or resulting hazard analysis.	Established management standard of product return in the HACCP plan (documentation of returning of released products to the establishment)
39-Presence of rusted areas, exposed insulation, loose silicone, and holes in the ceiling in the production areas where exposed product was present. No direct product adulteration observed.	Repaired holes and gaps in the ceiling as well as water leaks (selecting room, canned ham filling room, processing room of chilled ham etc.)
41-Presence of beaded condensate on an overhead cooling unit above exposed product in the production area. No direct product adulteration observed.	-Conducted a regular removal of condensate in the cooling unit -Banned loading of products under the cooling unit

2-3. CJ Cheiljedang Corporation Jincheon Blossom Campus, Jincheon

Findings	Corrective action
22-The establishment's HACCP verification records for review of records did not include the times or the results of verification activities.	Revised a format of the CCP monitoring records to keep daily verification activities
22-The establishment's HACCP verification procedures did not include direct observation of monitoring procedures as part of its verification activities.	Revised monitoring procedures to keep the results of daily verification activities
22-The establishment's HACCP monitoring records did not include the times of the monitoring activities.	Revised a format of the CCP monitoring records to keep the times of the monitoring activities
22-The establishment's HACCP system did not include its return product procedures in its flow chart or resulting hazard analysis.	Incorporated the return product procedures into the HACCP flow chart and hazard analysis table (investigate the cause and destroy)