

**Noncompliance Report , Establishment Number(s): M51205 + P51205 + V51205 (Durant, OK)**  
**Inspection Record Date Range: 01/01/2022 – 12/31/2022**

Est Nbr	Est Name	Non Comp ID	NR Nbr	Date	Non Comp Date	Task	Task Name	Regs	Description
M51205 +P51205 +V51205	BrucePac	37A7ED81-CDE1-4B10-9002-6BBEBE775FB5	AKZ5807012810N-1	8-Jan-22	10-Jan-22	01C01	Operational SSOP Record Review	416.16(a)	<p>At approximately 12:10 hours on Friday January 7th, 2022 I was observing operational sanitation procedures in the raw/fresh area on X-Ray 2 when I observed that maintenance personnel was removing a blade from the topping saw. I asked the maintenance personnel if the blade was broken and he said yes, it was damaged because of a jam up of beef that got stuck going through the saw. I observed maintenance replace the broken blade with a new blade and employees inspecting the product for foreign material before the X-Ray line resumed operations. Today, January 8th, 2022 when I was observing the operational sanitation records I noticed that there were no corrective or preventive actions recorded for the incident on January 7th, 2022 when the topping saw blade was broken/damaged and had been removed. 416.16(a) states that "each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the sanitation SOP's and any corrective actions taken." 416.15(b) states that "corrective actions include procedures to ensure appropriate disposition of product(s) that may be contaminated, restore sanitary conditions, and prevent the recurrence of direct contamination or adulteration of product(s), including appropriate reevaluation and modification of the sanitation SOP's and the procedures specified therein or appropriate improvements in the execution of the sanitation SOP's or procedures specified therein" (when necessary). In the establishment's Foreign Material Control program it states that (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) informed (b)(6) (Acting Quality Manager) of the issuance of this Noncompliance Record and also discussed the issue with (b)(6) (Corporate Quality Assurance Manager).</p>

M51205 +P5120 5+V512 05	BrucePa c	D2910E7E- ECFC- 474C- 807C- 3F2548633 2EA	AKZ470701 0614N-1	14-Jan- 22	14-Jan-22	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	At approximately 0610 hours I was performing a scheduled pre-operational sanitation inspection activity in the Ready to Eat area when I observed the following deficiencies :When I entered the Line 1 spiral freezer I observed several chicken pieces on the floor and on the product belt. When I entered the upstairs of the spiral freezer I noticed a piece of blue plastic on the belt that looked like it may have come from a glove. I also observed a piece chicken on the belt and sprocket at the freezer exit after I had the pans and covers removed, as well as chicken on the floor and on the framework.On the underside of the metal detector belt there were chicken particles and on the back side of the hopper there was an accumulation of chicken residue as well as the underside of the shaker at the back of the freezer.All of these deficiencies were shown to (b)(6) (Sanitation Manager) and (b)(6) (Sanitation Supervisor). I rejected the Line 1 spiral freezer with U.S. Rejected/Retained tag #B-45090606 at 0635 hours. After verification of corrective actions had been implemented the RTE area was released to production at 0710 hours.
M51205 +P5120 5+V512 05	BrucePa c	7DC2C3E8 -CAD3- 4095- A4E0- FE6293E4 A3EF	AKZ121301 2022N-1	22-Jan- 22	22-Jan-22	01C02	Operational SSOP Review and Observation	416.13(b), 430.4(a), 430.4(b)(2)	At approximately 12:45 hours I was in the Ready to Eat area observing sanitary conditions when I was informed that the Q.A. Tech would be performing non-product contact environmental Listeria sampling. I asked if I could observe the procedure and the first swab was conducted on a face shield in which only one side of the shield was swabbed. I asked the monitor why only one side was swabbed and he said because he only had to swab a four by four surface area. I informed him that a twelve by twelve surface area was supposed to be swabbed and he said I can swab a bigger area if you want me to. I observed the monitor perform two more swabs and he did swab a bigger surface area but it was not a twelve by twelve area.In the establishment's SSOP program under "Swab Testing Methods" it states that (b)(4)



									(b)(4) (b)(4). I informed (b)(6) (Interim Quality Manager) that a Noncompliance Record would be issued because the monitoring procedure was not conducted according to the Listeria Control Program that is referenced in the SSOP program.
M51205 +P5120 5+V512 05	BrucePa c	3B9018F0- 57F8-4728- B70B- 833166140 D56	AKZ350801 4931N-1	31-Jan- 22	31-Jan-22	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	At approximately 0620 hours while conducting a scheduled pre-operational sanitation inspection task I observed the following deficiencies on these product and non-product contact surfaces :On the belt on the inside of the third, fourth and fifth level of the #2 spiral freezer in the RTE area I observed multiple pieces of chicken, as well as on the framework under the belt. Also on the floor of the freezer I observed a piece of beef approximately two inches long and one inch in width. After observing corrective actions the RTE area was released to production at 0651 hours. No U.S. Rejected/Retained tag was used as corrective actions were verified when they were implemented.In the raw/fresh area on Line 2, I observed a buildup of chicken/meat residue on the belt roller and framework of the pro-grill and two tears on the edge of the belt. The deficiencies were addressed during my presence so no U.S. Rejected/Retained tags were used. All of these deficiencies were shown to (b)(6) (Sanitation Manager) and (b)(6) (Q.A. Lead) and they were informed of the issuance of this Noncompliance Record. The tears in the belt will be addressed independently on the maintenance schedule. The raw/fresh area was released to production at 0713 hours.
M51205 +P5120 5+V512 05	BrucePa c	479DDD64 -3FB5- 4E92- AAB5- 091EE0FE B661	AKZ420802 1906N-1	6-Feb-22	6-Feb-22	01B02	Pre-Op SSOP Review and Observation	416.13(a)	While performing Verification of Pre-Operation Sanitation after Sanitation and QA release and before start of operations I, (b)(6) CSI observed the following noncompliance: On February 6, 2022, at approximately 0620 hours both x-ray machines, flattener belts, transfer belts, and dicers there were pieces of meat and meat fat adhered to multiple belts, framework, and catch

								<p>pan, all product contact surfaces. Meat is dumped from combos then moves through the trimming belts and x-ray machines. Meat then moves through the compressing belts and the slicing machine, so the belts, catch pans and framework are all product contact surfaces. The multiple pieces of meat and meat fat ranging in approximate diameter from of an inch to of an inch and were too numerous to count. (b)(6) QA Lead and (b)(6) Sanitation Supervisor were verbally notified and shown the noncompliance. Mr. (b)(6) took immediate corrective actions and had the affected areas washed and sanitized. This noncompliance is a failure of the Establishment to comply with its written SSOP dated 01/25/21, page 1 of 7, II Pre-Operational Sanitation, The goal is to clean, sanitize, and inspect equipment (equipment includes utensils) and the facility according to pre-operational sanitation procedures prior to the start of operations to prevent insanitary conditions and the adulteration of product. This is also a failure of the Est. to comply with 416.13(a), of 9 CFR.</p>
M51205 +P5120 5+V512 05	BrucePa c	26B9A16D- E58E- 482C- 9BFA- 29033A086 F79	AKZ231002 0707N-1	7-Feb-22	7-Feb-22	01D01	SPS Verification	<p>416.3(a), 416.3(b), 416.4(b)</p> <p>At approximately 0630 hours I was performing a scheduled pre-operational sanitation inspection task in the microwave room when I discovered the following noncompliance :When I first began inspecting the microwave oven that is located in the room I noticed that it only has one door in the center that will open to the inside which makes it difficult to inspect thoroughly. I could only get a good view of the floor in which I noticed there was several pieces of dried chicken. There are also three drop down louvers at one end that deters or hampers the inspection of the machine, the sanitation Manager had to get a long pinch stick to hold up the louvers and remove two pieces of tape/plastic that was stuck to them.I informed (b)(6) (Sanitation Manger) and (b)(6) (Q.A. Lead) of the deficiencies and the issuance of this Noncompliance Record. The chicken that was seen in the bottom of the microwave was removed during my presence as was the tape/plastic that was stuck</p>



									to the louvers, so no U.S. Rejected/Retained tag was used.
M51205 +P5120 5+V512 05	BrucePa c	DEE4084B -4527- 47B7- 908B- E0D7E203 ED39	AKZ270802 1619N-1	19-Feb- 22	19-Feb-22	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	At approximately 0615 hours I was performing a scheduled pre-operational sanitation inspection task in the raw/fresh meat area when I discovered these deficiencies on product and non-product contact surfaces :On the #1 X-Ray Line I observed chicken residue on the framework on the dumper and on the floor around the dumper as well in the drain basket.On the inside of the infeed auger on Line #1 I observed two pieces of chicken and residue left in the bottom of the auger on Line #2. On Line #3 after the (b)(4) was taken apart I observed a piece of chicken about one half inch in diameter inside a straight pipe and one piece inside the belly of the machine. When I had the faceplate removed there was rust inside the internal fittings around the outer part of the auger and outer fittings and parts.All of the deficiencies were shown to (b)(6) (Sanitation Manager) and (b)(6) (Q.A. Supervisor) and they were verbally informed of the issuance of this Noncompliance Record. No U.S. Rejected/Retained tags were used as all of these deficiencies were addressed during my presence. After verification of corrective actions had been implemented the raw/fresh area was released to production at 0648 hours.
M51205 +P5120 5+V512 05	BrucePa c	1AF4578C- 0514- 4D2B- 8A7F- 7ADBC006 7217	AKZ080802 1622N-1	22-Feb- 22	22-Feb-22	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	At approximately 0615 hours while performing a scheduled pre-operational sanitation inspection task I observed the following deficiencies in the RTE area :On the triangle on the incline belt from the bagger there were multiple areas of breaded chicken crumbs which spanned areas as much as a one by one foot. On the incline belt from the dumper to the scales there were several small pieces of chicken ranging from one eighth to one quarter of an inch in size. There were also two white product tubs that had specs of residue inside them.On the (b)(4) incline belt there were three pieces of chicken ranging from one eighth to one quarter inch in size and on the top of the scales I noticed a one inch piece of chicken wedged between the shaker plate and the scale bucket. I informed (b)(6) (Q.A.

									Supervisor) and (b)(6) (Sanitation Supervisor) of the deficiencies and they were addressed and corrective actions verified during my presence so no U.S. Rejected/Retained tags were used. The RTE area was released to production at approximately 0740 hours.
M51205 +P5120 5+V512 05	BrucePa c	C3679BD5 -E32D- 4B43- A6F1- BAC8EA42 02AB	AKZ101802 1323N-1	23-Feb- 22	23-Feb-22	03G02	Fully Cooked-Not Shelf Stable HACCP	417.2(c)(5), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.5(b)	At approximately 1650 hours I was in the Ready to Eat area when I observed that Line one was down and establishment employees were cleaning the shaker belts. I asked the Line Supervisor why the Line was down and I was told there had been a low cook temperature. I spoke with (b)(6) (Q.A. Supervisor) and was informed that two HACCP deviations had occurred (one at the start of the shift and the one that had just occurred) and that corrective actions had been taken to divert the product either to recook or dispose of (eight pounds were disposed of) and the Line was cleaned after removing the affected product. I asked if the cause of the deviation had been identified and if any preventive measures had been implemented and was told that yes they did all corrective actions according to the program. Again, I asked what the cause of the deviation was and was told "we got a low temperature." I showed the regulations to establishment management and explained that the cause of the deviation has to be identified and further preventive measures must be implemented to prevent recurrence of the deviation prior to resuming production to comply with all four parts of 417.3. I informed establishment management that I would be rejecting Line one until the cause of the deviations could be identified and actions could be implemented to prevent recurrence. I took a regulatory control action and rejected the Line with U.S. Rejected/Retained tag #B-45090607 and informed management that it would be released when all four parts of 417.3 were met. At approximately 1730 hours I released the control action after establishment had determined that the cause of the first deviation was that the steam was not set right and needed to be adjusted. The cause of the second deviation was determined to be that



									there were too many thick pieces of chicken on the Line which prevented uneven cook flow, so less chicken was dumped on the belt and as a preventive measure the oven belt was slowed down to allow product more exposure time in the oven.No product that is injurious to health entered commerce as immediate corrective actions were taken at the moment the deviation occurred and further preventive measures were incorporated. The affected product was disposed of.
M51205 +P5120 5+V512 05	BrucePa c	573DC376- 2B9C- 4D62- BD46- 7AFB6A29 ACE1	AKZ230702 1326N-1	26-Feb- 22	26-Feb-22	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	At approximately 0645 hours I was performing a scheduled pre-operational sanitation inspection task in the raw/fresh area when I observed the following deficiencies on these food contact and non-food contact surfaces :On the small grinder parts there was some chicken residue inside a pipe and inside the air connector to the grinder valve and on the air hose. There was also chicken residue on the support bars inside the product contact surface of the grinder auger.When I was inspecting the (b)(4) machine I observed chicken residue inside the auger hopper on the support bars and chicken in the bottom of the elevator dumper lift. On the framework of the (b)(4) I observed chicken residue on the tomahawk bars underneath.I showed the deficiencies to (b)(6) (Supervisor) and (b)(6) (Q.A. Lead) and verbally informed them of the issuance of this Noncompliance Record. No U.S. Rejected/Retained tags were used because all of these deficiencies were addressed during my presence. After verification of corrective actions had been implemented the raw/fresh area was released to production at 0720 hours.
M51205 +P5120 5+V512 05	BrucePa c	F0C43451- 2B9E- 4FEB- 8398- 94678628A 7A6	AKZ311203 4803N-1	3-Mar-22	3-Mar-22	01D01	SPS Verification	416.2(b)(1), 416.2(b)(2), 416.4(b)	At approximately 1228 hours I was in the raw/fresh area observing sanitary conditions when I noticed a white pipe on the north wall that had steam and water coming out of it. It also had two spaces that look like they were cut into with zip ties holding them together.After further observance I noticed a drop cord just above the (b)(4) on X-Ray one that was corroded with dust, and a drop cord at the front of the dumper and above the X-Ray machine on Line 2 that was dusty. I noticed some drop cords

								<p>that were dusty behind tumbler one and two and some in the middle of the floor hanging from the ceiling that were tied up that had dust on them. I also noticed a grey hose behind tumbler 2 that had mold on it that spanned approximately four feet or so and some dusty safety glasses that were hanging on a cord from the white beam in the center of the room near the Grind Line. In the establishment's master sanitation schedule it states (b)(4)</p> <p>(b)(4) I verbally informed (b)(6) of the noncompliance and the issuance of this Noncompliance Record. No product or product contact surfaces were seen contaminated/adulterated therefore no U.S. Rejected/Retained tags were used.</p>
M51205 +P5120 5+V512 05	BrucePa c	2ACAEF48 -CC79- 4EB2- B902- 7CA5B6FF 6B8E	AKZ211803 5520N-1	20-Mar- 22	20-Mar-22	03G02	Fully Cooked-Not Shelf Stable HACCP	<p>417.5(a)(3)</p> <p>In the establishment's Fully Cooked Not Shelf Stable HACCP Plan on page one under monitoring procedures/frequencies it states that (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) At approximately 1800 hours I was in the Ready to Eat area observing a Quality Assurance Tech performing the monitoring procedure. I observed the employee take (b)(4) temperatures from product exiting the oven onto the first belt. The employee took (b)(4) temperatures as the product came through the oven, I asked him when he was going to take a temperature at the transfer belt and he said that he doesn't take any temperatures from that belt, he is only supposed to take temperatures from the oven exit belt. I spoke with (b)(6) (Q.A. Supervisor) and asked her if this was the procedure for the HACCP</p>



									<p>monitoring. She said that the SOP temperatures (b)(4) and the HACCP (b)(4) (b)(4) I told her that the employee had told me that he only has been taking SOP temperatures at the oven exit belt. Ms. (b)(6) said he had been trained to take the HACCP temperatures also but at the designated location (b)(4) (b)(4) No U.S. Rejected/Retained tags were used as no product was seen adulterated/contaminated and all of the SOP temperatures were well above the critical limit. However, the HACCP monitoring procedure was not being followed per the establishment's HACCP plan.</p>
M51205 +P5120 5+V512 05	BrucePa c	C0F81610- D47B- 4D07- ABEB- E2F12CDF 31B1	AKZ240804 5813N-1	9-Apr-22	13-Apr-22	01D01	SPS Verification	416.4(b), 416.5(a)	<p>At approximately 1300 hours I was performing an operational sanitation review and observation task in the Ready to Eat area. I was walking toward the (b)(4) area when I noticed a tablet setting on the edge of a concrete pillar on the wall. I saw that the tablet was registered to one of the Quality Assurance Techs. There is a stainless steel table that is designated for the Q.A. Techs to set their tools on during production. The tablet is used to enter data into the (b)(4) recordkeeping application. For instance, after the Quality Assurance Tech performs monitoring procedures such as product temperatures, metal detector checks, product specs and net weights the results are entered into the tablet into the recordkeeping application. In the establishment's GMP's for the Brucepac 4 plant, it states that "any time any tools touch the ground, team members must take that tool to the sanitation area to be cleaned and sanitized and the team member must also change their gloves and sanitize before returning to work." I informed (b)(6) (Q.A. Lead) of the observation and discussed the issue with (b)(6) (b)(6) (Q.A. Manager) and informed them of the issuance of this Noncompliance Record. No U.S. Rejected/Retained tag was used as no product was seen contaminated/adulterated by this incident. The Quality Assurance Tech was instructed to clean and</p>

									sanitize the tablet and change and sanitize gloves before returning to work.
M51205 +P5120 5+V512 05	BrucePa c	CFDD6A81 -4B2E- 456E- BCAC- E157CB59 B8E8	AKZ260804 3215N-1	15-Apr- 22	15-Apr-22	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	At approximately 0615 hours I was performing a review and observation activity of a pre-operational sanitation inspection task in the Ready to Eat area when I observed the following deficiencies :On the Line one spiral freezer there were two pieces of chicken (approximately one to one half inch) on the support bar above the infeed belt. On the Line Two motor for the (b)(4) I observed four pieces of chicken ranging from one eighth of an inch to one inch and on the inside belt of the spiral Two freezer there were three pieces of chicken of the approximate same size. Chicken was also observed on the framework of the spiral Two freezer above the belt. All of the deficiencies were shown to (b)(6) (Q.A. Lead) and (b)(6) (Sanitation Supervisor) and I informed them that I was rejecting the Spiral Two freezer with U.S. Rejected/Retained tag #B-45090516. A product containing a Soy allergen was produced on Line Two yesterday and a non-allergen product will be produced on this Line today.As I continued to inspect the Spiral Three freezer, I observed a numerous amount of chicken ranging from one half to one inch in size as well as particles of product in the hopper and chute at the back of the freezer exit. There was also chicken residue on the weigh plate and an excessive amount of carton/box dust on the box roller.At approximately 0700 hours after corrective actions had been verified the control action was lifted and the Line Two freezer was released to production. All of the deficiencies that were observed on Line One and Three were addressed during my presence.
M51205 +P5120 5+V512 05	BrucePa c	B9034C59- 1879- 4A9D- 99C3- 25D114BE 766B	AKZ342304 1520N-1	20-Apr- 22	20-Apr-22	01D01	SPS Verification	416.4(a), 416.5(a)	On 4-20-2022 while performing a routine Operational SSOP PHIS task I, CSI (b)(6) observed the following SPS noncompliance.At 2230hrs in the Fresh Department I observed an employee pick a piece of broken pallet off the floor near X-Ray Line 2 and dispose of it in an empty combo. The employee then proceeded to grab a stainless steel vat labeled edible, located under the X-Ray 2. The employee did not sanitize his hands



									<p>or put on gloves prior to handling a food contact surface. This instance created an insanitary condition and cross contaminated a food contact surface. Quality Assurance(QA) Technician (b)(6) was shown the noncompliance. QA Technician (b)(6) implemented immediate corrective actions in my presence and restored sanitary conditions in the area. QA Supervisor (b)(6) was informed of the noncompliance and verbally notified that a noncompliance record would be issued.</p>
M51205 +P5120 5+V512 05	BrucePa c	9C11B76C -220A- 433F- 8C2F- C6371E5D 7258	AKZ490004 0926N-1	25-Apr- 22	25-Apr-22	01D01	SPS Verification	416.4(a)	<p>On 4-25-2022 while performing a routine PHIS Operational SSOP task I, CSI (b)(6) observed the following noncompliance. At 2245hrs while monitoring conditions in the Fresh Meat Receival room I observed an employee transferring product from one combo to another with a metal shovel. When the employee was finished with the shovel, he placed the shovel on a stainless steel table within the room. Upon further observation I found residue from old stickers and rust spots on said table. A dead fly and several batteries were also observed on the table. This instance created and insanitary condition and cross contaminated a food contact surface. Quality Assurance (QA) Lead (b)(6) was shown the noncompliance and verbally notified that a noncompliance record(NR) would be issued. QA Lead (b)(6) performed immediate corrective action in my presence, so no US Reject tag was necessary. 2nd Shift Manager (b)(6) and Production Supervisor (b)(6) were also verbally informed of the noncompliance and that a NR would be issued.</p>
M51205 +P5120 5+V512 05	BrucePa c	6A7C0564- ABC9- 4345- 92C1- B56F1C07 D8D8	AKZ140005 0604N-1	2-May-22	2-May-22	03G02	Fully Cooked-Not Shelf Stable HACCP	417.3(a)(2), 417.4(a)(2)( ii)	<p>On 5-2-2022 while verifying preventative measure records for HACCP deviations I, CSI (b)(6) observed the following noncompliance at 1800hrs. The establishments critical limit for chicken at CCP#1 is (b)(4). At 0850hrs a deviation occurred as the establishment recorded a temperature of (b)(4). The establishments HACCP plan under Corrective Actions for CCP#1 states in part, (b)(4)</p>

								<p>(b)(4) The last acceptable check was recorded at 0845hrs. I found the establishment did not place the product on hold after exiting the IQF. The establishments HACCP Deviation record stated that the IQF product was not placed on hold due to the Shaker Belt being down at 0845hrs and that product was diverted however, CCP#1 records did not show that product was removed from the line at 0845hrs. The establishment failed to implement corrective actions as set forth in the HACCP plan. The establishments HACCP Plan under Corrective actions states that</p> <p>(b)(4)</p> <p>(b)(4) Through a records review on (b)(4) the establishments computer data entry system, it was found the establishment failed to perform a direct observation of corrective actions. I notified Plant Manager Miguel Vasquez and Quality Assurance (QA) Lead (b)(6) of the noncompliance and that a noncompliance record would be issued. QA Lead (b)(6) placed the affected container(960lbs) of Cooked Charbroiled Diced Chicken Breast on hold within the establishments computer system. At this time, it was not feasible to place a USDA Retain Tag on the container due to location and circumstance.</p>
M51205 +P5120 5+V512 05	BrucePa c	8750F2D0- 2AAE- 4FEF- BDE4- 6141F4C4 02E9	AKZ201405 1002N-1	2-May-22	2-May-22	03G02	Fully Cooked-Not Shelf Stable HACCP	<p>417.3(a)(2), 417.3(c), 417.5(b), 417.5(d)</p> <p>Today, May 2nd, 2022 during the routine performance of a fully cooked HACCP task on oven three I observed the following :There was a HACCP deviation of (b)(4) degrees F. that was recorded at 0717 hours and after that, there was another HACCP deviation of (b)(4) degrees F. that was recorded at 0850 hours. I began looking for any documentation that I could review as to what immediate corrective actions and preventive measures were taken in regards to the product, the production process and what caused the deviations. I was not able to find where it was documented either on paper or in (b)(4) which is the official data entry computer system for entering HACCP and SSOP deviation/deficiency results.I informed Ms. (b)(6) (Q.A. Manager) that a</p>



									Noncompliance Record would be issued because all of the regulatory requirements of 417.3 had not been met. I explained that when a deviation from a critical limit occurs it is the responsibility of establishment management to ensure that all appropriate corrective actions are taken and documented to ensure that no product that is injurious to health or otherwise adulterated, as a result of the deviation enters commerce, and all actions are to be documented at the time the event occurs.
M51205 +P5120 5+V512 05	BrucePa c	2CCDE8B8 -56EA- 4AD1- 9947- 4BE524DC A423	AKZ520705 1404N-1	4-May-22	4-May-22	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	At approximately 0635 hours, I was performing a scheduled pre-operational sanitation inspection task in the raw/fresh area when I observed the following deficiencies on product and non-product contact surfaces: On oven one I observed two pieces of chicken approximately one to two inches in size inside the pro-grill doors and meat residue in the cracks of the transfer belt. There was multiple chicken residue and pieces underneath the steam hood on all four steamers and the steam box of oven two. On Line one there was one piece of meat on the oven window on the cook side, and the oven belt had what looked like ingredients clumped together on the belt. Underneath the Line below the drip pans there was a big stretch of what appeared to be mold and grease caked on the pan and support drain bars. On the support bars on the oven two transfer belt there were multiple specks and residue from the previous production run. On oven three there were several pieces on the maintenance stand and residue on the steam valve. On the infeed to Line one there was several pieces of chicken residue inside two of the product pipes, on the Line 2 infeed there were several pieces of chicken on the transfer belt and on the underneath of the rack. On the number three infeed there was several pieces of chicken on the lip of the auger rack/bars. I informed (b)(6) (Sanitation Manager) and (b)(6) (Q.A. Lead) of all of these deficiencies and informed them of the issuance of this Noncompliance Record. After verification of corrective actions had been implemented the area

									was released to production at 0721 hours. All of these deficiencies were addressed in my presence so no U.S. Rejected/Retained tags were used.
M51205 +P5120 5+V512 05	BrucePa c	E467AE09- E5F9- 4066- 94B6- 533FE953 ABCF	AKZ080705 0823N-1	23-May- 22	23-May- 22	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	At approximately 0615 hours I was performing a scheduled pre-operational sanitation inspection task in the RTE area when I discovered the following deficiencies :In the floor of the #2 spiral freezer there was some chicken chunks on the bottom of the floor. Inside the #3 spiral just inside the freezer entrance I noticed a piece of metal lodged into the side of the cabinet underneath the belt. On the back of the spiral exit at the top underneath the rollers from the exit chute there were three to four pieces of chicken still clinging to the belt. And, on the spiral hopper after the exit chute there was a small piece of blue plastic (approximately 3/16 inch in size).All of these issues were shown to (b)(6) (Supervisor) and (b)(6) (Q.A. Manager). All of these deficiencies were addressed during my presence and no product was affected so no U.S. Rejected/Retained tags were used. Maintenance was called to retrieve the metal piece that was found inside spiral #3 and it was determined that it came from the front of the entrance to the spiral and came loose during sanitation. The piece was intact and did not show any signs of chipping or breakage. All of the other deficiencies were recleaned and sanitized. The RTE area was released to production at 0705 hours.
M51205 +P5120 5+V512 05	BrucePa c	FA520C6D -07C0- 4D35- 9C46- 6FE336297 7D8	AKZ302005 3023N-1	23-May- 22	23-May- 22	01D01	SPS Verification	416.4(a)	On 5-23-2022 while performing a routine SPS task I, CSI (b)(6) observed the following noncompliance.At 1845hrs, near the exit of the IQF on Line 1, I observed a stainless steel shovel resting against the freezer. The scoop end of the shovel was placed directly on top of the foot stand leading into the freezer and the handle was leaning against the freezer itself. The shovel is a food contact surface. This instance creates an insanitary condition of a food contact surface. 2nd Shift Production Supervisor (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. At 1850hrs Supervisor (b)(6) performed immediate



									corrective action in my presence. 2nd Shift Quality Assurance Supervisor (b)(6) was also verbally notified a noncompliance record would be issued. No product was observed to be affected at this time.
M51205 +P5120 5+V512 05	BrucePa c	CC11F8F7 -97E4- 4294-9043- 7A594FF0 2740	AKZ530605 4431N-1	31-May- 22	31-May- 22	01D01	SPS Verification	416.2(a)	Today May 31st, 2022 I observed four flies on yellow and black drop cords while performing pre-operational sanitation inspection at 0620 hours in the Raw/Fresh area. This afternoon at approximately 1435 hours I observed four flies on yellow and black drop cords and one fly on the side of the (b)(4) machine in the Raw/Fresh area. The flies that were observed during pre-operational sanitation inspection were shown to (b)(6) (Q.A. lead) and (b)(6) (Sanitation Supervisor) and were killed and disposed of. The flies that were observed in the same area this afternoon were shown to (b)(6) (Production Supervisor) and were killed and disposed of. The (b)(4) machine was not in use but it was sanitized after the fly was killed as was the drop cords. No product or product contact surfaces were seen adulterated/contaminated therefore no U.S. Rejected/Retained tags were used.
M51205 +P5120 5+V512 05	BrucePa c	456D329F- 123B- 4A19- 8F22- 6572CDE2 180F	AKZ122306 0524N-1	24-Jun- 22	24-Jun-22	01D01	SPS Verification	416.2(a), 416.4(a)	On 6-24-2022 while performing a routine Operational SSOP task I, CSI (b)(6) observed the following SPS noncompliance. At approximately 1820hrs I observed several flies in the dry storage cooler. A dead fly was observed in a stainless steel roll around vat and a dead fly was also observed in a grey lugger. Both the vat and the lugger are food contact surfaces. Quality Assurance(QA) personnel was shown the flies and the contaminated food contact surfaces. QA performed immediate corrective actions. 2nd Shift Plant Manager Miguel Vazquez and QA Supervisor (b)(6) were verbally informed of the noncompliance and that a noncompliance record would be issued. No product was observed to be affected at this time.
M51205 +P5120	BrucePa c	6C6FCC48 -B706- 4F12-	AKZ011607 0322N-1	22-Jul-22	22-Jul-22	01D01	SPS Verification	416.4(a)	On 7-22-2022 while performing a routine Operational SSOP task I, CSI (b)(6) observed the following noncompliance. At 1008hrs

5+V51205		8DEB-3D0C0F5C41FC							<p>near the grinding area on Fresh Side I observed a stainless-steel fork laying on the floor of an elevated stand. The stainless steel fork is a food contact surface. This instance creates an insanitary condition of a food contact surface. Fresh Side Supervisor (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. Supervisor (b)(6) performed immediate corrective action in my presence. At 1017hrs near X-ray Line 2 combo dumper on the Fresh Side I observed a stainless-steel fork resting in a utensil stand. The points of the fork were wedged underneath the combo dumper motor housing. After removing the fork from the stand, I observed rust transfer on the points of the fork. This instance creates an insanitary condition of a food contact surface. QA Tech (b)(6) was shown the noncompliance. QA (b)(6) performed immediate corrective action in my presence. QA Manager (b)(6) and QA Supervisor (b)(6) were verbally notified of the noncompliance and that a noncompliance record would be issued. No product was observed to be affected at this time.</p>
M51205+P51205+V51205	BrucePac	61DA1BD2-25AA-4573-A99C-20EDAD536523	AKZ0107083701N-1	1-Aug-22	1-Aug-22	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	<p>At approximately 0610 hours I was performing a scheduled pre-operational sanitation review and observation task in the raw area when I observed the following :On the wide end of the number one auger of the Grind Line there was residual amounts of product on the product contact surfaces of the support bars. On the number two auger of the Grind Line at the bottom of the inside of the auger underneath the blade and rotary cup clumps of product were present. Also on the seams on the inside of the auger there was residual chicken product in different places. On the metal detector belt there was chicken residue on the underneath of the belt and on the support bars. I informed (b)(6) (Q.A. Supervisor) and (b)(6) (Sanitation Supervisor) of the deficiencies and rejected the area with U.S. Rejected/Retained tag #B-45090517. After the equipment had been re-inspected and corrective actions had been implemented I released</p>



									the area to production at 0740 hours. I verbally informed (b)(6) (Q.A. Supervisor) and (b)(6) (Sanitation Supervisor) of the issuance of this Noncompliance Record.
M51205 +P5120 5+V512 05	BrucePa c	9A497AD9- EA72- 43A4- 94D2- D5BB242D 0D73	AKZ471108 1503N-1	3-Aug-22	3-Aug-22	03G02	Fully Cooked-Not Shelf Stable HACCP	417.2(c)(4), 417.2(c)(5), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.5(b)	At approximately 1120 hours I was in the Ready to Eat area performing a Fully Cooked Not Shelf Stable HACCP task. I was observing the Q.A. tech on Line one performing the monitoring procedure for the CCP lethality temperatures when the Tech picked up a piece of product and stuck the probe in it but the highest temperature achieved was (b)(4) degrees F. The Q.A. Tech kept trying to probe the product and finally took the thermometer out of the product and broke the piece of chicken into as if to see if it was raw. I informed the Tech that the Line had to be stopped and corrective actions had to be implemented. At my insistence the Line was stopped and Q.A. Lead, (b)(6) was notified. After the Line was stopped and management was notified, I retained approximately four hundred pounds of product from the oven exit to the freezer entrance with U.S. Rejected/Retained tag #B-45090518. I observed corrective actions of removing the product from the Line and disposing of it into inedible containers on the sanitation dock. There was also approximately twenty five cases of finished product that was held to be re-tumbled/recooked and all affected surfaces were cleaned before before operations resumed. The cause of the deviation was identified as an oven temperature variation in which the temperature controller was auto tuned on the oven by production to address the temperature variation. When the Line resumed operations the subsequent temperatures ranged from (b)(4) degrees F. thereby bringing the CCP back under control.
M51205 +P5120 5+V512 05	BrucePa c	A1BEFA4F -C621- 4E71- A310- A6E945B1 7F51	AKZ072308 4509N-1	9-Aug-22	9-Aug-22	01D01	SPS Verification	416.2(d)	On this day 8-9-2022 while monitoring the conditions throughout the Raw area I, CSI (b)(6) observed the following noncompliance. I observed heavily beaded condensation directly over X-Ray Line 2. The condensation spanned approximately 15 by 8. This instance creates an insanitary condition and a point for cross

									contamination. I took regulatory control of the X-Ray Line by instructing the X-ray lead to stop the line at 2125hrs. QA Technician (b)(6) was called to the line, shown the noncompliance, and verbally notified that a noncompliance record would be issued. 2nd Shift QA Supervisor (b)(6) was also notified that a noncompliance record would be issued. The establishment performed immediate corrective actions in my presence. After verifying corrective actions, I released the line back to production at 2145hrs. No product or product contact surfaces were observed to be affected at this time.
M51205 +P5120 5+V512 05	BrucePa c	04E3DD89 -F281- 40CD- 8414- 2A5260E9 B93B	AKZ412108 1716N-1	16-Aug- 22	16-Aug-22	01D01	SPS Verification	416.4(a)	On 8-16-2022 while performing a routine SPS task I, CSI (b)(6) observed the following noncompliance. At 1825hrs in the Fresh Room, near the allergen table in the spice area, I observed a stainless steel shovel laying on the floor. The shovel is a food contact surface. This instance creates an insanitary condition of a food contact surface. 2nd Shift QA Tech (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. At 1830hrs QA (b)(6) performed immediate corrective action in my presence. 2nd Shift Quality Assurance Supervisor (b)(6) was also verbally notified a noncompliance record would be issued. No product was observed to be affected at this time. See Noncompliance Record #s AKZ0116070322N-1 and AKZ3020053023N-1, associated for similar noncompliance.
M51205 +P5120 5+V512 05	BrucePa c	A9821A3F- 36D4- 4482- 9DDA- 758BFDA8 1DF9	AKZ280008 1819N-1	18-Aug- 22	18-Aug-22	01D01	SPS Verification	416.4(a)	On 8-18-2022 while performing a routine Operational task I, CSI (b)(6) observed the following noncompliance. At 2315hrs in the Cook Room, at the exit of Spiral 3 near the wall, I observed a stainless steel shovel laying on a green pallet which is a nonfood contact surface. The shovel is a food contact surface. This instance creates an insanitary condition of a food contact surface. 2nd Shift QA Lead (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. At 2320hrs QA (b)(6) performed immediate corrective



									<p>action in my presence. 2nd Shift Supervisor (b)(6) was also notified of the noncompliance and that a noncompliance record would be issued. No product was observed to be affected at this time. See Noncompliance Record #s AKZ0116070322N-1, AKZ3020053023N-1, and AKZ4121081716N-1, associated for similar noncompliance.</p>
M51205 +P5120 5+V512 05	BrucePa c	ECE6770E -A4F8- 4858- 98D3- FE8671FF 6191	AKZ050709 1420N-1	20-Sep- 22	20-Sep-22	01B02	Pre-Op SSOP Review and Observation	416.14	<p>At approximately 0610 hours during the performance of a scheduled pre-operational sanitation review and observation task I observed the following :In the ready to eat area while inspecting the Line one spiral freezer I observed chicken residue all along the support bar on the spiral belt underneath the sieve which is a product contact zone. There was also some chicken residue on the belt links underneath the belt. I informed (b)(6) (Supervisor) of the noncompliance and rejected the spiral freezer with U.S. Rejected/Retained tag B28725940. During inspection of the Line three spiral freezer I observed chicken crumbs on the exit chute of the spiral belt and two pieces of chicken on the support bar. I also observed two pieces of metal links from the freezer belt that were stuck to the magnet. After verifying all deficiencies had been addressed sufficiently by recleaning and sanitizing, and observing maintenance personnel inspected the Line 3 belt, I released the area at approximately 0700 hours.</p>
M51205 +P5120 5+V512 05	BrucePa c	20AF3D4B -F669- 45C0- AAF5- 67F52EAB C839	AKZ392310 4506N-1	6-Oct-22	6-Oct-22	01D01	SPS Verification	416.2(d)	<p>On 10-6-2022 while performing a routine Operational SSOP task I, CSI (b)(6) observed the following SPS noncompliance. At approximately 2100hrs I observed heavily beaded condensation dripping in the oven room. The condensation spread approximately 20 feet by 20 feet from the exit end of Oven Line 1 across to Oven Line 2 and spanning back to the (b)(4). Although the condensation was not directly over exposed product, employee aprons, gloves, and frocks could be cross contaminated. QA Lead (b)(6) and QA Tech (b)(6) were shown the noncompliance and verbally notified that a noncompliance record would be issued. The establishment performed immediate corrective</p>

									action. No product or product contact surfaces were observed to be affected at this time.
M51205 +P5120 5+V512 05	BrucePa c	86F6AA36- CA8D- 4118- B2A5- 3AC4F648 7745	AKZ512310 0119N-1	19-Oct- 22	19-Oct-22	01D01	SPS Verification	416.2(d)	<p>On 10-19-2022 while performing a routine SPS task I, CSI (b)(6) observed the following noncompliance. At approximately 2200hrs I observed heavily beaded condensation dripping in the oven room. The condensation spread approximately 20 feet by 20 feet from the exit end of Oven Line 1 across to Oven Line 2 and spanning back to the (b)(4). The condensation was also directly above the oven exit where product is post lethality exposed. No product was on the line at this time. I informed 2nd Shift Supervisor (b)(6) of the noncompliance and I took regulatory control of Oven Line 1 by halting any product from being placed on the belt. As I never left the area, no U.S. Reject tag was warranted. QA Lead (b)(6) and Supervisor (b)(6) were shown the noncompliance and verbally notified that a noncompliance record would be issued. 2nd Shift Production Manager (b)(6) was also verbally informed that a noncompliance record would be issued. No product or product contact surfaces were observed to be affected at this time. At 2215hrs the establishment elected to halt production on Oven Line 1 for the remainder of the shift. Manager (b)(6) stated that the establishment would continue to run the exhaust fan on Oven Line 2 to prevent the recurrence of noncompliance. See NR# AKZ3923104506N-1 associated for similar noncompliance.</p>
M51205 +P5120 5+V512 05	BrucePa c	F0AAF845- B490- 4C75- B3D0- 38C8F3BF F656	AKZ580610 0128N-1	28-Oct- 22	28-Oct-22	01B02	Pre-Op SSOP Review and Observation	416.13(c)	<p>On Friday October 28, 2022, at 0607 hours, I, CSI (b)(6) conducted pre-op at Brucepac on the RTE. While conducting pre-op, I observed the exit chute on line 1 was dirty. Half of the entrance of the chute was covered in chicken debris. It was as if the that part of the chute was not even sprayed with water. I notified (b)(6) Supervisor. He observed the debris and had a sanitation employee reclean the chute. While (b)(6) was instructing an employee to reclean the chute, I notified (b)(6) QA Supervisor, of the noncompliance. I told (b)(6) that I would be writing a NR. This</p>



								<p>was approximately 0615 hours. I continued pre-op in other areas while they recleaned the chute. At 0630 hours, I re-examined the chute and there was still residue on the chute. I showed this to (b)(6) and he recleaned it himself. I released the area at 0636 hours. This was a noncompliance of 9 CFR 416.13(c): Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOPs.</p>
M51205 +P5120 5+V512 05	BrucePa c	A2C5C140 -07F8- 4EA7- 95EB- 8B0500618 B66	AKZ500011 4502N-1	1-Nov-22	1-Nov-22	03G02	Fully Cooked-Not Shelf Stable HACCP	<p>417.5(a)(1)</p> <p>On 11-1-2022 while performing an Operational SSOP task I, CSI (b)(6) observed the following noncompliance. At 2215hrs on the Fresh Meat side of the establishment, I observed a lot of fresh poultry product being held in the old receiving dock in grey totes. According to the thermostat on the wall, the room was 43°F at 2215hrs and was set to 45°F. The establishments Storage Program under the fresh meat section states in part, (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) After reviewing the Fresh Meat Cooler log on (b)(4) Cooler 1 and 2 temperatures were recorded for 11-1-2022. QA and Production personnel stated that the Receiving Dock was not recorded on a data logger and was not put into (b)(4) QA Tech (b)(6) (b)(6) took a temp of the product, and it was (b)(4) QA (b)(6) took an ambient temperature of the room with a calibrated thermometer at 2240hrs and it was (b)(4) The establishment failed to follow the Storage Program as written by not documenting the temperature of the room in which fresh poultry was being stored, and the room being above the temperature stated in the program. 2nd Shift QA Supervisor (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. 2nd Shift Production Manager (b)(6) was also verbally notified that a noncompliance record would be issued. Mr. (b)(6) stated that the product</p>

									would be moved back into the cooler. No product was observed to be affected at this time.
M51205 +P5120 5+V512 05	BrucePa c	C7A6CF24 -14C7- 4941- B4EC- C2D5BE26 AC43	AKZ370712 3316N-1	16-Dec- 22	16-Dec-22	01B02	Pre-Op SSOP Review and Observation	416.13(a)	At approximately 0625 hours I was in the RTE area performing a scheduled review and observation activity of a Pre-Operational Sanitation inspection task when I observed the following product contact deficiencies:At the end of oven one inside the product drop box from the metal detector there was maintenance grease that was spewing from a gear box on top of it. In oven two there were several pieces of chicken left on the lip of the spiral and inside oven three there was a host of chicken debris and pieces on the support bar of the chain lift belt.On the (b)(4) I observed chicken residue underneath the lip of the shaker guide on the shaker table all the way across the guide and the belt below the shaker also had a few specs of residue. I observed multiple pieces of chicken on the Triangle belt and chicken residue in the crevices of the Lips of the shaker guides.I showed (b)(6) (Sanitation Supervisor) the deficiencies and informed him of the issuance of this Noncompliance Record. All of these deficiencies were addressed during my presence, so no U.S. Rejected/Retained tags were used. After implementation and verification of corrective actions the area was released to production at 0720 hours.
M51205 +P5120 5+V512 05	BrucePa c	7A56425E- 1D65- 4DFB- 96AF- 93AAB4A4 850C	AKZ361812 5428N-1	28-Dec- 22	28-Dec-22	01D01	SPS Verification	416.4(a)	On 12-28-2022 while performing a routine Operational Sanitation task I, CSI (b)(6) observed the following noncompliances.At 1716hrs on the Fresh Side I observed a stainless-steel roll around tote under x-ray 2 being used to collect the poultry juice from the combo. The juice is collected in the tote and placed back into the product that has finished the x-ray process. The tote being used to collect the juice was labeled inedible. At 1718hrs I stopped an employee from taking the juice to the product exiting the x-ray process. A stainless-steel bucket was also observed inside the inedible tote. I took regulatory control of the tote, juice, and bucket with US Reject Tag#B-45269473. X-ray Lead (b)(6) and QA Technician (b)(6) were shown the noncompliance. At 1730hrs QA (b)(6) brought



									<p>the tote, juices, and shovel to the sanitation area to be recleaned and sanitized. I remove the US reject Tag at this time. At 1738hrs near the Grind Line on Fresh Side I observed 3 stainless-steel buckets and one stainless-steel shovel being stored in a stainless-steel roll around tote labeled inedible. A hose to a pump that is used to pump solution from one container to another was observed on the floor near the grind line as well. QA (b)(6) was shown the noncompliance and took immediate corrective action by having the above mentioned brought to sanitation to have it recleaned and sanitized. 2nd Shift QA Supervisor (b)(6) was also notified that a noncompliance record would be issued. No product was observed to be affected at this time.</p>
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**Noncompliance Report , Establishment Number(s): M51205 + P51205 + V51205 (Durant, OK)**  
**Inspection Record Date Range: 01/01/2023 – 08/31/2023**

Est Nbr	Est Name	Non Comp ID	NR Nbr	Date	Non Comp Date	Task	Task Name	Regs	Description
M51205+ P51205+ V51205	BrucePa c	C102B551- 9EB7- 43E8- 910D- 88D0EA74 7FB6	AKZ0121010909 N-1	9-Jan-23	9-Jan-23	01D01	SPS Verification	416.4(a), 416.4(b)	On 1-9-2023 while performing an Operational SSOP task I, CSI (b)(6) observed the following SPS noncompliances in the Fresh Area. At 1935hrs I observed a stainless-steel long handled fork under the hopper for the tumblers. The handle of the fork was on the floor. Stainless-steels forks are considered a food contact surface. I took regulatory control by placing US Reject Tag#B38096087 on the fork. QA Technician (b)(6) was shown the noncompliance and verbally notified that a noncompliance record (NR) would be issued. I removed the US Reject tag at 2010hrs after verifying corrective actions. At 1945hrs in the Spice Area I observed a stainless-steel pair of scissors laying on the floor. I also observed the entirety of the floor to be covered in a mix of white and red colored seasonings. Upon further observation I found southwest seasoning boxes to be opened and some of the seasoning on the floor. The southwest seasoning contains soy. I took regulatory control of the Spice Area by taping off the area with US Reject Tag#B38096086. QA Technician (b)(6) was shown the noncompliance and verbally notified that the noncompliance would be added to the NR. The establishment performed corrective action and I removed US Reject Tag#B38096086 at 2015hrs. No product was observed to be affected at this time. 2nd Shift QA Supervisor (b)(6) and 2nd Shift Manager (b)(6) were verbally notified of the noncompliance and that the NR would be issued.
M51205+ P51205+ V51205	BrucePa c	836CB584- 678B- 4BC1- 80C0- 10C4F85A 381A	AKZ1123021002 N-1	2-Feb-23	2-Feb-23	01D01	SPS Verification	416.2(b)(1), 416.2(b)(3)	On this day 2-2-2023 while performing a routine PHIS Operational SSOP task I, CSI (b)(6) observed the following SPS noncompliance. At 2215hrs while monitoring the conditions in the Receiving Dock, I observed the temporary plastic wall to have several holes



									<p>in multiple areas. The temporary wall is being used to block the bay doors that lead outside while the new dock is being built. The bay doors were observed to be fully opened. Due to the negative air pressure, air was blowing directly from outside into the receiving dock. Although no product or ingredients were in the room at the time, this area is sometimes used to stage spices or ingredients establishment structures, rooms, and compartments must be of sound construction, to allow for storage of product in a manner that does not result in the creation of insanitary conditions. At 2230hrs I notified 2nd Shift QA Supervisor (b)(6) (b)(6) that a noncompliance record would be issued. 2nd Shift Production Manager (b)(6) (b)(6) was also verbally notified that a noncompliance record would be issued.</p>
M51205+ P51205+ V51205	BrucePa c	F05595C4- E145-4051- 9129- EF9B0D56 2F56	AKZ0812024015 N-1	15-Feb-23	15-Feb-23	01B02	Pre-Op SSOP Review and Observatio n	416.13(c)	<p>On Wednesday February 15, 2023 at 0610 hours, I, CSI (b)(6) conducted pre-op at Brucepac on the RTE side. While conducting pre-op at Triangle 1, I observed debris on 6 of the 8 tubs. I also observed approximately 3 whole chicken pieces and debris under the machine. I notified (b)(6) Supervisor. He observed the debris and had a sanitation employee reclean the area and the tubs were taken to the back to be recleaned. While (b)(6) (b)(6) was instructing an employee to reclean the area, I notified (b)(6) QA Tech Lead, of the noncompliance. I told (b)(6) (b)(6) that I would be writing a NR. This was approximately 0615 hours. I rechecked the area and then I released the area at 0625 hours. This was a noncompliance of 9 CFR 416.13(c): Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOPs.</p>
M51205+ P51205+ V51205	BrucePa c	C36C1AF7 -9C1E- 4A24- 9DB4-	AKZ3810021422 N-1	22-Feb-23	22-Feb-23	01B02	Pre-Op SSOP Review and	416.13(c)	<p>On February 22, 2023, at approximately 0620 hours, I, CSI (b)(6) was conducting pre-operational inspection. While inspecting the (b)(4) number 1, I observed about 2 handfuls of chicken pieces in the drip</p>

		8E3175B61 B85					Observation		pan and pieces on the floor under the oven. I showed this to (b)(6) QA Tech Lead. She notified (b)(6) Sanitation Supervisor, who had a couple of employees clean the pan and the floor underneath it. Once the area was recleaned, I reinspected the oven and released the ovens at approximately 0630 hours. I did notify (b)(6) that I would be writing an NR for the oven. This was a noncompliance of 9 CFR 416.13(c): Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOPs.
M51205+ P51205+ V51205	BrucePac	5FD36BFD -A658- 4612-96B2- 9EBAC884 798F	AKZ1721055704 N-1	4-May-23	4-May-23	01C02	Operational SSOP Review and Observation	416.13(c)	On May 4th, while performing a routine Operational Sanitation PHIS task I, CSI (b)(6) observed the following noncompliance. At 1836hrs while monitoring the activities in the Tumbler Room I observed a grey tote with raw chicken strips staged to be tumbled. I observed an unknown blue substance present on the chicken and the liner inside of the grey tote. QA Lead (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. At 1840hrs, I took regulatory control by placing US Retain tag #B45-090615 on the grey tote containing 1844lbs of raw chicken strips, product #B21CC4300, Batch 9-1. The product was slice and x-rayed on 1st shift. Upon further observation, I found a similar substance present on the underside of a tote lid sitting on top of a blue colored pallet. After discussion with establishment personnel, it was determined that this was the likely source of the contamination. Production Supervisor (b)(6) and QA Supervisor (b)(6) were also verbally notified of the noncompliance and that a noncompliance record would be issued.
M51205+ P51205+ V51205	BrucePac	7ED9DDB D-5EFF- 41DF- B8EA-	AKZ5207053004 N-2	4-May-23	4-May-23	01B02	Pre-Op SSOP Review and	416.13(c)	On Thursday, May 4, 2023, at approximately 0615 hours I observed the following noncompliance while performing a Routine Pre-operational SSOP verification procedure after the plants pre-operational monitoring



		64FA6FD0 F2B0					Observation		<p>inspection and prior to the start of operations on the Cooked/RTE side:Product residue from the previous days production was observed in the form of chicken debris on the blade guide fingers on the discharge side of the (b)(4) slicer for Oven one (1). Mr. (b)(6) was shown the noncompliance and verbally informed of the forthcoming NR. I also observed product residue that appeared to be particles of chicken too numerous to count affecting the product contact surface of a metal product chute approximately three (3) inches wide by ten (10) inches long immediately following the lift belt on top of Triangle # 1. Mr. (b)(6) was shown this as well and verbally informed that this would be added the noncompliance. Because immediate corrective actions were implemented and sanitary conditions were restored in each instance mentioned, I elected not to use a U.S. Rejected Tag at this time. No product was affected as a result of these findings. The aforementioned deficiencies display a failure of the company to comply with 9CFR 416.13(c) as well as the plants Sanitation Standard Operating Procedures, which states in section II. Pre-operational Sanitation:(b)(4) sanitize and inspect equipment (equipment includes utensils) and the facility according to the pre-operational sanitation procedures prior to the start of operations to prevent insanitary conditions and the adulteration of product.</p>
M51205+ P51205+ V51205	BrucePac	FEBE3DF0 -40DB- 46A6- 8C39- 379181578 F8E	AKZ1922053811 N-1	11-May-23	11-May-23	01D01	SPS Verification	416.2(d), 416.4(a)	<p>On 5-11-2023 while performing an Operational SSOP Review and Observation task I, CSI (b)(6) observed the following noncompliance.At 2020hrs on the Cook Side of the establishment, I observed condensation drip from the ceiling down into the stainless steel hopper located at the Spiral Freezer Exit on Oven Line 3. The hopper is a food contact surface. No product was being ran at this time. I immediately notified the production line lead and the QA tech that I was taking regulatory</p>

									control of the area. Production Supervisor (b)(6) was shown the noncompliance and notified that a noncompliance record would be issued. The establishment performed immediate corrective actions in my presence. After verifying corrective actions I released the area back to production at 2107hrs. No product was affected at this time. 2nd Shift QA Supervisor (b)(6) and 2nd Shift Production Manager (b)(6) were also shown the noncompliance and notified that noncompliance record would be issued. Since I never left the area, no US Retain tag was necessary.
M51205+ P51205+ V51205	BrucePa c	32D095C6- C68B- 4509- 8EE6- 79C3B993 8F6B	AKZ4906054130 N-1	29-May-23	30-May-23	01B02	Pre-Op SSOP Review and Observatio n	416.13(a)	At approximately 0615 hours I was performing a review and observation activity of a scheduled pre-operational sanitation inspection task when I observed the following deficiencies: On the inside product contact surface of the brine chiller tank to the number one tumbler I discovered a residue buildup behind the product flow pipe. On the support frame of the number two X-Ray Line there was also a buildup of chicken residue. On the catch pan underneath the number one X-Ray there was a zip tie that was left by maintenance personnel and one on the floor. When I was inspecting the number two tumbler maintenance personnel had also left two screwdrivers on the catwalk. All of these deficiencies were shown to (b)(6) (Sanitation Manager) and corrected during my presence so no U.S. Rejected/Retained tags were used. The Raw area was released to production at 0640 hours.
M51205+ P51205+ V51205	BrucePa c	009F6DAD -E77B- 4026- AE87- 47B279320 0C5	AKZ4601070507 N-1	6-Jul-23	6-Jul-23	01D01	SPS Verification	416.2(a), 416.4(a)	On 7-6-2023 while inspecting the Line 3 Spiral Line I, CSI (b)(6) observed the following noncompliance. I observed a live fly on the white Teflon walls located at the exit end of the metal detector belt at the back of Spiral 3. I killed the fly to prevent it from flying off. QA Lead (b)(6) and Cook Side Supervisor (b)(6) were shown the noncompliance



									and verbally notified that a noncompliance record would be issued. The establishment implemented corrective actions in my presence and as such no US Reject tag was warranted.No product was observed to be affected at this time.
M51205+ P51205+ V51205	BrucePa c	AC625061- C82D- 4A57- BB74- 7105312F9 A11	AKZ1707073924 N-1	24-Jul-23	24-Jul-23	01B02	Pre-Op SSOP Review and Observatio n	416.13(a), 416.2(a)	At approximately 0615 hours I was performing a review and observation activity of a scheduled pre-operational sanitation inspection task in the raw/fresh processing area when I observed these deficiencies on product and non-product contact surfaces:On Line two inside the fresh meat auger there was chicken residue underneath the support bar. On the belt rollers to the oven there was dried chicken and fat that ranged from one eighth to one half inch in size. On the oven transfer belt to the RTE room I observed a piece of chicken fat that was approximately one inch long and one eighth inch wide.On Line four I observed a fly inside the fresh meat auger and inside the (b)(4) underneath the screw auger was multiple pieces of chicken residue. On the rollers and support bars of the oven belt there was some dried chicken and fat residue.I informed (b)(6) (Supervisor) of the deficiencies and rejected the area with U.S. Rejected/Retained tag #B-39138566 and informed him of the issuance of this Noncompliance Record.After all the deficiencies had been addressed and verification of corrective actions had been complete, I released the area to production at 0645 hors. No product was seen contaminated/adulterated by these deficiencies.
M51205+ P51205+ V51205	BrucePa c	F5069301- 1448-46A3- B867- 8C9F02B5 BF87	AKZ4623071826 N-1	26-Jul-23	26-Jul-23	03G02	Fully Cooked- Not Shelf Stable HACCP	417.5(a)(1) )	On 7-26-2023 while performing an Operational SSOP Review and Observation task I,CSI (b)(6) observed the following noncompliance;At 2130hrs in Cooler 2 on Fresh Side, I observed a box of Beef Fajita Marinade seasoning staged directly over a pallet of garlic chicken thigh seasoning on the

								<p>racks. The Beef Fajita Marinade has the allergens soy and wheat while the garlic seasoning has only soy. Storing unlike allergens above another allergen creates a point for allergen crosscontamination. I showed 2nd Shift Supervisor (b)(6) the noncompliance. Supervisor (b)(6) performed immediate corrective action by arranging the ingredients in a manner that prevented allergen cross contamination. No leaks or rips were observed in the box of Beef Fajita Marinade. The establishments Allergen Program, under the Raw Materials section, states in part, (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The establishment failed to follow the program as written. The establishment maintains a photo record of the spices stored in Cooler 2 and Cooler 3. A photo is taken at the end of each night and sent to management. A photo was taken of the spice rack in Cooler 2 on 7-25-2023 and the box of Beef Fajita Marinade was observed in the photo. The establishment utilizes a (b)(4) with in-plant labels for allergens by placing a (b)(4) label on all allergens and lists each allergen that is present in the product/ingredient on the (b)(4) label. The (b)(4) label was not visible in the photo taken and sent on 7-25-2023. This instance represents insufficient records being maintained by the establishment to prevent unlike allergens from being stored above each other. 2nd Shift Manager (b)(6) 2nd Shift QA Supervisor (b)(6) and 2nd Shift QA Lead (b)(6) were also informed of the noncompliance. To prevent recurrence of the noncompliance, Shift Manager (b)(6) stated that he would have a discussion with the dry storage warehouse about removing spices from the cooler that are not being used, have a retraining with his team members on allergen storage, and also discuss changing (b)(4)</p>
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									label used for product/ingredients containing soy/wheat.No product or ingredients were observed to be affected at this time.See MOI AKZ0022013504I issued for similar occurrence.
M51205+ P51205+ V51205	BrucePa c	2CBD6597- EB3E- 447E- 98DF- D7925BE5 9EC3	AKZ2322080514 N-1	14-Aug-23	14-Aug-23	01D01	SPS Verification	416.2(d)	<p>On 8-14-2023 while performing an Operational SSOP task I, CSI (b)(6) observed the following SPS noncompliance.</p> <p>At 1755hrs on the Fresh Meat Side of the establishment, I observed heavily beaded condensation above the hopper for Tumbler 1. The condensation spanned approximately 4 feet by 4 feet. The hopper was full of fresh poultry at this time.</p> <p>Fresh Side Supervisor (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. Supervisor (b)(6) performed immediate corrective action in my presence. No product or product contact surfaces were observed to be affected at this time.</p>

**Noncompliance Report, Establishment Number(s): M51205+P51205+V51205 (Durant, OK)**

**Inspection Date Range: 09/01/2023 – 09/30/2023**

Establishment Number	Establishment Name	Non Compliance ID	NR Number	NR Inspection Date	Non Compliance Date	Task Code	Task Name	Reg Number(s)	NR Description
M51205+P51205+V51205	BrucePac	0B078810-C626-46F6-8298-E8F7E2BB84B4	AKZ0507093608N-1	9/8/2023	9/8/2023	01B02	Pre-Op SSOP Review and Observation	416.13(a)	<p>At approximately 0615 hours I was conducting a review and observation activity of a scheduled pre-operational sanitation task when I observed the following deficiencies in the RTE area:</p> <p>While inspecting the (b)(4) machine, I observed a large area of chicken residue left on the inside product contact surface of the cone underneath the buckets on the shaker. On the top of the transfer from the incline belt to the shaker I observed some overspray, and on the incline belt from the bagger to the metal detector there was a piece of breadding.</p> <p>During my inspection of the (b)(4) machine, I also observed some breadding and several pieces of chicken on the transfer belt from the bagger to the metal detector.</p> <p>All of these deficiencies were shown to (b)(6) (Sanitation Foreman) and he was informed of the issuance of this Noncompliance Report.</p> <p>No product was seen contaminated/adulterated by these deficiencies and no U.S. Rejected/Retained tags were used as all of the deficiencies were addressed during my presence. The RTE area was released to production at 0635 hours.</p>
M51205+P51205+V51205	BrucePac	E833009C-47EC-455D-BCE2-6625C12FA75C	AKZ5919091014N-1	9/14/2023	9/14/2023	01D01	SPS Verification	416.2(d)	<p>On 9-14-2023 while monitoring the conditions throughout the establishment I, CSI (b)(6) observed the following noncompliance.</p> <p>At 1640hrs on the fresh side, I observed heavily beaded condensation in the following areas:</p> <p>A 4 foot by 4 foot area in the spice area near the refrigeration unit, a 10 foot by 10 foot area in the Grind area near the auger, and a 3 foot area above</p>



									<p>the Hopper Dump for Tumbler 2. Condensation in the Grind Area dripped into 3 stainless steel roll around totes.</p> <p>The above mentioned areas are a point for product and product contact cross contamination. Production Supervisor (b)(6) and QA Lead (b)(6) were verbally notified of the noncompliance and that a noncompliance would be issued. The establishment performed immediate corrective action in my presence.</p>
M51205+ P51205+ V51205	BrucePac	C8CB89DA- 2986-4CE0- 81F6- 681E0EDE7 6BE	AKZ47170940 21N-1	9/21/2023	9/21/2023	01D01	SPS Verificati on	416.2(d)	<p>On 9-21-2023 while performing an Operational SSOP task I, CSI (b)(6) observed the following SPS noncompliance.</p> <p>At 1545hrs, in the Line 1 Oven Room, I observed heavily beaded condensation located on the ceiling directly above the oven exit. The condensation spanned approximately 1 foot by 1 foot. This instance creates a point for cross contamination of post lethality exposed product and product contact surfaces.</p> <p>2nd Shift QA Lead (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. 2nd Shift Supervisor (b)(6) was also notified that a noncompliance record would be issued. The establishment performed immediate corrective actions in my presence. No product or product contact surfaces were observed to be affected at this time.</p>

Noncompliance Report , Establishment Number(s): M51205+P51205+V51205 (Durant, OK)  
Inspection Record Date Range: 09/29/2023 – 09/30/2024

Est. Number	Est. Name	Non Compliance ID	NR Number	NR Inspection Date	Non Compliance Date	Task Code	Task Name	Regulation Number(s)	NR Description
M51205+ P51205+ V51205	BrucePac	50ABBCA2-3248-4FB8-B86B-D055C54B53C1	AKZ4714101418N-1	10/18/2023	10/18/2023	03G02	Fully Cooked-Not Shelf Stable HACCP	318.2(d)	<p>On October 18th, 2023 I was informed that a load of three hundred ninety cases of Fully Cooked Shredded White Meat Chicken was being returned to BrucePac from Establishment (b)(4) Texas.</p> <p>I spoke with (b)(6) (Q.A. Manager) about the returned product, and I explained that I was not on site at BrucePac because I was at another establishment involved in export duties. I had explained that after I completed the export duty, I would be on site at BrucePac a little later to remove the USDA seal that had been placed on the truck by the USDA Inspector from Establishment (b)(4)</p> <p>Before I finished my export duties, (b)(6) (Q.A. Manager) called me and said that the USDA seal had been removed by someone at BrucePac and the product had already been unloaded. I explained that the seal could only be removed by a USDA employee.</p> <p>When I arrived at BrucePac I verified the product was in fact the three hundred ninety cases that had been returned from Establishment (b)(4) by reviewing the bill of lading and the shipping Log as well as the product and code dates.</p> <p>I informed plant management that I would be retaining the product and explained that a subsequent MOI would be issued and sent to the district office. This Noncompliance Report informs establishment management that when a violation of a regulatory action occurs, several regulatory actions will be taken in regard to the violation.</p>
M51205+ P51205+ V51205	BrucePac	B55E1277-26B9-4409-8CD7-9311FF5D2C97	AKZ0609102026N-1	10/26/2023	10/26/2023	01D01	SPS Verification	416.2(d)	<p>At approximately 0830 hours I was performing a scheduled Sanitation Performance Standard task in the fresh area. When I came through the double door into the fresh area, I noticed heavy beaded condensation on the ceiling above and just in front of the tote</p>



									<p>dumper on Line one. The condensation spanned approximately five feet wide by eight feet long. I also observed heavily beaded condensation on an approximate area of about ten feet wide by twenty feet long on the ceiling above the grind Line. (the grind Line is not in use today). I informed (b)(6) (b)(6) (Q.A. Supervisor) of the condensation who was in the area at the time of the observation. Immediate corrective actions were taken to reduce and/or eliminate the condensation issue by notifying maintenance personnel to hang plastic, dedication an employee to wipe down the condensation and by taping/tagging out the grind Line to prevent thru traffic.</p> <p>No product or product contact surfaces were seen contaminated/adulterated therefore no U.S. Rejected/Retained tags were used. management personnel were notified of the issuance of this Noncompliance Record.</p>
M51205+ P51205+ V51205	BrucePac	E440EAF5- 6456-4CB5- 82C0- B3721F77474 5	AKZ5806110209N-1	11/9/2023	11/9/2023	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.2(d), 416.4(a), 416.4(b)	<p>At approximately 0610 hours I was performing a review and observation activity of a scheduled pre-operational sanitation inspection task when I observed the following deficiencies on these product and non-product contact surfaces:</p> <p>On the grind Line on the inside of the pre-grinder I observed a piece of meat (approximately one by one inch) stuck inside the auger, and on the inside of the post-grinder there were multiple slivers of product left inside the auger.</p> <p>I noticed a big clump of product wedged in between the electrical box and the side of the mixer and there was dried product residue underneath some of the support bars on the mixer.</p> <p>When I was inspecting the auger to the (b)(4) machine I observed meat residue on the inside stuck underneath the support screws inside the auger and there was also meat residue present on the</p>

									<p>underneath of several of the support bars.</p> <p>I also observed beaded condensation on the ceiling just above the (b)(4) auger.</p> <p>All of these deficiencies were shown to (b)(6) (Sanitation Manager) and (b)(6) (Sanitation Supervisor) and were addressed in my presence so no U.S. Rejected/Retained tags were used.</p> <p>After corrective actions had been incorporated, I released the area to production at 0645 hours.</p>
M51205+ P51205+ V51205	BrucePac	994B6642-1BF4-41E2-9290-F33CCF0E46AF	AKZ5823123412N-1	12/12/2023	12/12/2023	01D01	SPS Verification	416.2(d)	<p>On this day 12-12-2023 while monitoring the conditions throughout the Oven Room I, CSI (b)(6) (b)(6) observed the following noncompliance.</p> <p>At 2225hrs I observed excessive amounts of steam throughout the Oven Room. Heavily beaded condensation was observed at the exit end of Oven Line 2. At the oven exit over Line 2, there is an opening where product is exposed and uncovered. At this point in the process, the product is considered post lethality exposed and as such this instance creates an insanitary condition and a point for product contamination. I informed the QA Tech to halt product from entering the oven to prevent any possible contamination. The establishment halted production on Line 1 and performed immediate corrective action in my presence. Production resumed at 2235hrs after corrective actions.</p> <p>As I never left the area, no US Retain Tag was necessary. I verbally informed 2nd Shift Supervisor (b)(6) and 2nd Shift QA Supervisor (b)(6) that a noncompliance record would be issued. No product or product contact surfaces were observed to be affected at this time.</p>
M51205+ P51205+ V51205	BrucePac	A6182669-EC5F-46DF-9C2D-	AKZ0411124421N-1	12/21/2023	12/21/2023	03G02	Fully Cooked-Not Shelf	417.2(c)(4)	<p>At approximately 10:30 a.m. I was observing Quality Assurance personnel performing a HACCP monitoring procedure on Oven one, when I noticed that the monitor only probed product from one part of the</p>



		6F088A6978F4					Stable HACCP		<p>Line. I asked why product on the other side of the Line had not been probed and was told "because I can't reach it".</p> <p>I informed (b)(6) (Q.A. Supervisor) and (b)(6) (Q.A. Manager) of the inconsistency. After discussing the incident with management personnel, and after I reviewed the HACCP plan it was discovered that the HACCP plan does not address the frequency at which the monitoring procedure is to be performed. The HACCP plan only states that (b)(4)</p> <p>(b)(4)</p> <p>I reviewed the 417.2 HACCP regulation with (b)(6) (Q.A. Manager) which states that "the HACCP plan must include the frequency that will be used to monitor each of the critical control points to ensure compliance with the critical limits".</p>
M51205+ P51205+ V51205	BrucePac	FCB123E5-E6EB-4E96-8C0F-236E056E1865	AKZ2616013225N-1	1/24/2024	1/24/2024	01D01	SPS Verification	416.2(d)	<p>On 1-24-2024 while performing a Operational SSOP task I, CSI (b)(6) observed the following SPS noncompliance.</p> <p>At 1800hrs in the (b)(4) room, I observed heavily beaded condensation spanning the entirety of the drip pan on the refrigeration unit. Employees were directly under the condensation putting together boxes. I informed QA Tech (b)(6) and the Line Lead (b)(6) of the noncompliance. The employees cleared the area. I took regulatory control of the area with US Reject Tag #090619 at 1805hrs.</p> <p>QA Supervisor (b)(6) and Production Supervisor (b)(6) were shown the noncompliance and verbally notified that a noncompliance record would be issued. The establishment performed corrective actions and I removed US Reject Tag #090619 at 0130hrs.</p> <p>No product or product contact surfaces were observed to be affected at this time.</p>

M51205+ P51205+ V51205	BrucePac	21396991- 1038-4C10- BEA9- EEB32F16153 7	AKZ1007020002N-1	2/2/2024	2/2/2024	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	<p>At approximately 0615 hours I was performing a review and observation activity of a scheduled pre-operational sanitation inspection task in the fresh/raw area when I observed the following deficiencies:</p> <p>On the nonproduct contact surface of the X-Ray infeed belt I observed chicken residue on the support bar underneath the belt, and on the belt, there was some overspray of product residue. On the inside product contact surface of the topping saw there were two pieces of chicken meat approximately one inch by one inch in size wrapped around the support bar where the chicken passes through on the belt.</p> <p>When I progressed to the infeed to the ovens there was already a tote of product setting in the dumper ready to be dumped into the hopper. I informed (b)(6) (Sanitation Foreman) and (b)(6) (Sanitation Supervisor) that the product had to be removed from the floor before I could inspect any of the infeed machinery. The tote of product was removed from the floor, and I continued with the pre-operational sanitation inspection procedures.</p> <p>No product was seen adulterated/contaminated, and all of these deficiencies were addressed during my presence, therefore no U.S. Rejected/Retained tags were used. The fresh/raw area was released to production at 0645 hours.</p>
M51205+ P51205+ V51205	BrucePac	692B00C4- 6FF2-4188- 8E7A- 9DEDE8FCB40 3	AKZ1307025606N-1	2/6/2024	2/6/2024	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(b)	<p>At approximately 0610 hours I was performing a review and observation activity of a scheduled pre-operational sanitation inspection task when I observed the following deficiencies:</p> <p>On the Line 2 spiral chute and support bar of the shaker I observed some overspray, and on the belt to the freezer there were several small pieces of chicken residue. On the exit chute on Line 4 spiral there was a piece of chicken approximately one eighth inch in size.</p> <p>When I was inspecting the Gia in the packaging area, I</p>



									<p>observed quite a bit of chicken pieces ranging anywhere from one eighth inches in size to one half inch in size on the exit chute of the scale machine.</p> <p>All of the deficiencies were identified and shown to (b)(6) (Sanitation Supervisor) and I informed management of the issuance of this Noncompliance Record.</p> <p>No product was seen adulterated/contaminated by these deficiencies therefore no U.S. Rejected/Retained tags were used.</p> <p>After all of these deficiencies were addressed during my presence the area was released to production at 0700 hours.</p>
M51205+ P51205+ V51205	BrucePac	9AA05C4D- CCCC-4A9F- 9790- 6C627F646A9 0	AKZ2522023421N-1	2/21/2024	2/21/2024	01D01	SPS Verification	416.4(a)	<p>On 2-21-2024 while performing an Operational SSOP task I, CSI (b)(6) observed the following noncompliance.</p> <p>At 2125hrs on the Cook Side of the establishment, I observed a white lugger and a stainless steel scraper laying on the floor of the catwalk at the exit end of the spiral freezer on Line 1. White Luggers are used to hold post lethality exposed product and the stainless steel scraper is used to clear product off of the line in the spiral freezers. Both are considered food contact surfaces.</p> <p>I informed QA Lead (b)(6) of the noncompliance and verbally notified him that a noncompliance record would be issued. QA (b)(6) performed immediate corrective actions in my presence.</p> <p>QA Supervisor (b)(6) and Production Manager (b)(6) were both verbally notified that a noncompliance record would be issued. No product was observed to be affected at this time.</p>
M51205+ P51205+ V51205	BrucePac	742163DE- 92AA-4EBE- 8AD2-	AKZ4907033201N-2	3/1/2024	3/1/2024	01B02	Pre-Op SSOP Review and	416.13(a), 416.4(b)	<p>At approximately 0620 hours I was performing a review and observation activity of a scheduled pre-operational sanitation inspection task when I observed</p>

		7E86BDCC4847					Observation		<p>the following deficiencies in the Ready to Eat area:</p> <p>On Line one at the (b)(4) entrance on the support bar there was a splatter of chicken residue across the length of the bar. On the inside product contact surface of the freezer belt was several pieces of chicken approximately one eighth to one fourth inch in size. On the inside of the packaging hopper at the back of Line one I observed several splatters of chicken residue.</p> <p>Inside the Line two freezer I observed multiple pieces of chicken on the freezer floor and three pieces of metal approximately one inch in length by one half inch wide.</p> <p>On the (b)(4) in the packaging area, I observed two pieces of chicken underneath the platform on top of the bagger machine. There was a piece of chicken one inch in length and one fourth inch in width on the shaker belt .</p> <p>All of these deficiencies were addressed during my presence, so no U.S. Rejected/Retained tags were used. The metal pieces were shown to Maintenance, and it was determined that the metal was a fin that came from the evaporator coil which is part of the housing unit inside the spiral freezer.</p> <p>No product was seen adulterated/contaminated from these deficiencies. After corrective actions had been implemented, I released the area to production at approximately 0720 hours.</p>
M51205+ P51205+ V51205	BrucePac	A3762904-BA56-4F7C-8DC9-8BB4C68A317F	AKZ4907033201N-1	3/1/2024	3/1/2024	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(b)	<p>At approximately 0620 hours I was performing a review and observation activity of a scheduled pre-operational sanitation inspection task when I observed the following deficiencies:</p> <p>On Line one on the (b)(4) entrance on the support bar there was a splatter of chicken residue across the length of the bar. On the inside product contact</p>

									<p>surface of the freezer belt was several pieces of chicken approximately one eighth to one fourth inch in size. On the inside of the hopper at the back of Line one I observed several splatters of chicken residue.</p> <p>Inside the Line two freezer I observed multiple pieces of chicken on the freezer floor and three pieces of metal approximately one inch in length by one half inch wide.</p> <p>On the (b)(4) I observed two pieces of chicken underneath the platform on top of the bagger machine. There was a piece of chicken one inch in length and one fourth inch in width on the shaker belt</p> <p>All of these deficiencies were addressed during my presence, so no U.S. Rejected/Retained tags were used. The metal pieces were shown to Maintenance, and it was determined that the metal came from the</p>
M51205+ P51205+ V51205	BrucePac	9FB7B159- FC33-46A5- 84FD- C6F27BEF79A F	AKZ5122035212N-1	3/12/2024	3/12/2024	01D01	SPS Verification	416.2(d)	<p>On 3-12-2024 while performing an Operational SSOP task I, CSI (b)(6) observed the following noncompliance.</p> <p>At 2050hrs while in the Oven Room I observed heavily beaded condensation on the ceiling above the exit end of Oven Line 2. The product exiting the oven is post lethality exposed and as such, this instance creates a point for product cross contamination. I took regulatory control by instructing an Equipment Operator to stop the line.</p> <p>QA Supervisor (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. The establishment performed immediate corrective actions in my presence, so no US Reject tag was placed.</p> <p>I released regulatory control of Oven Line 2 at 2110hrs after the establishment corrective actions were</p>



									completed. No product was observed to be affected at this time.
M51205+ P51205+ V51205	BrucePac	0B04842C- 4999-4F26- 8F19- 72AF22027B8 7	AKZ5906032322N-1	3/22/2024	3/22/2024	01B02	Pre-Op SSOP Review and Observatio n	416.13(a), 416.4(a), 416.4(b)	<p>At approximately 0615 hours I was performing a review and observation activity of a scheduled pre-operational sanitation inspection task in the RTE area when I observed the following deficiencies:</p> <p>AS I was inspecting the Oven one freezer, I noticed that the rails inside the freezer had chicken residue all the way down from the front of the freezer to the back of the freezer. I informed (b)(6) and showed him the condition of the rails and rejected the freezer with U.S. Rejected/Retained tag #B39138325.</p> <p>On the Line four spiral freezer exit chute I discovered several pieces of chicken ranging from one eighth to one quarter of an inch in size. On the movable roller curtain at the end of Line four there were also chicken splatters and residue.</p> <p>At 0635 I went back over to finish inspecting the Line one four and observed a metal spatula that was setting on a transfer belt that had chicken residue on the end of it. At 0645 after re-inspecting the Line one freezer and after corrective actions had been implemented the Rejected/Retained tag was removed and the RT area was released to production.</p>
M51205+ P51205+ V51205	BrucePac	B3F16AFC- DB2A-4381- 880D- 3AFD96A3484 3	AKZ1923045129N-1	4/29/2024	4/29/2024	01D01	SPS Verification	416.2(a)	<p>On 4/29/2024 while performing a routine Operational SSOP Review and Observation task I, CSI (b)(6) (b)(6) observed the following SPS noncompliance.</p> <p>At 2110hrs, I observed several small grey bugs on the white plastic cover of a 2000lb combo of chicken breast staged in Cooler 1. Two of the bugs were alive and moving on the plastic cover. Quality Assurance Lead (b)(6) was shown the noncompliance and took immediate corrective action by removing the cover and discarding it. The interior cover of the combo was inspected, no bugs were observed, and no product was observed to be affected.</p>

									<p>At 2117hrs, I observed 2 dead bugs on top of a 55gallon drum of Canola Oil. QA Lead (b)(6) was shown the noncompliance and took immediate corrective action by having the drum cleaned and sanitized. '</p> <p>Quality Assurance Supervisor (b)(6) was informed of the noncompliances and verbally notified that a noncompliance record would be issued.</p>
M51205+ P51205+ V51205	BrucePac	9D2CBE4E- D642-4FA3- 9902- E96EB6F772F 1	AKZ2821051216N-1	5/16/2024	5/16/2024	01D01	SPS Verification	416.2(d)	<p>On 5-16-2024 while performing an Operational SSOP task I, CSI (b)(6) observed the following noncompliance.</p> <p>At 1934hrs I observed heavily beaded condensation on the underside of the drain pan and drain pipe of the refrigeration unit in the Spice Room. The condensation was observed to be dripping onto a sealed box of spices. No spices were observed to be affected at this time.</p> <p>QA Lead (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. Lead (b)(6) performed immediate corrective action in my presence. The spice within the sealed box was removed and placed in a new container, the condensation was wiped, and all ingredients were removed from under the refrigeration unit.</p> <p>QA Supervisor (b)(6) was also verbally notified of the noncompliance and that a noncompliance record would be issued. No product was observed to be affected at this time.</p>
M51205+ P51205+ V51205	BrucePac	D26DEA14- 8E5C-4D45- A10D- 634D81F9F1F 5	AKZ3316065704N-1	6/4/2024	6/4/2024	01D01	SPS Verification	416.2(d)	<p>On 1-4-2024 while performing an Operational SSOP task I, CSI (b)(6) observed the following noncompliance.</p> <p>At 1005hrs I observed heavily beaded condensation on the ceiling in the (b)(4) Packaging room. The condensation spanned approximately 1'x 6' and was located directly over the (b)(4) Scale System, (b)(4)</p>

									<p>Shaker, and a portion of the (b)(4) Incline Belt. All the above surfaces are food contact surfaces. Although no product was being ran at this time due to employees being on break, this instance creates an insanitary condition and a point for product cross contamination. Furthermore, product ran on this equipment is post lethality exposed.</p> <p>QA Supervisor (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. Supervisor (b)(6) performed immediate corrective action in my presence. I released the area back to production at 1014hrs after verifying corrective actions. QA Manager (b)(6) was also verbally notified of the noncompliance and that a noncompliance record would be issued.</p> <p>No product was observed to be affected at this time.</p>
M51205+ P51205+ V51205	BrucePac	3B55D45D- 84A2-4A61- AD11- A7089B33DF2 3	AKZ3022070915N-1	7/15/2024	7/15/2024	01D01	SPS Verification	416.2(d)	<p>On 7-15-2024 while performing an Operational Sanitation Inspection I, CSI (b)(6) observed the following SPS noncompliance.</p> <p>At 2131hrs I observed heavily beaded condensation on the sprinkler head located near the spiral freezer exit shaker belt on Spiral Freezer Line 2. Although the condensation was not above product or product contact surfaces, this instance creates a point for cross contamination.</p> <p>QA Lead (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. Lead (b)(6) implemented immediate corrective action in my presence by having the condensation removed. 2nd Shift Production Manager (b)(6) was also verbally notified of the noncompliance and that a noncompliance record would be issued.</p> <p>No product or product contact surfaces were observed to be affected.</p>



M51205+ P51205+ V51205	BrucePac	7C0C4BC0- FE91-4A16- B07C- 581171A03DB 7	AKZ2622073019N-1	7/19/2024	7/19/2024	01D01	SPS Verification	416.2(d)	<p>On 7-19-2024 while performing an Operational SSOP Task I, CSI (b)(6) observed the following SPS noncompliance.</p> <p>In the Cook Room, at 1745hrs, I observed condensation over Line 1. The condensation spanned approximately 10'x25' going from the exit of the spiral freezer to the hopper and bagger for Line 1. Although no product was observed to be affected, this instance creates a point for cross contamination. I took regulatory control and had the establishment stop Line 1 at 1745hrs. After the line was stopped, I observed condensation on the refrigeration unit on the ceiling near the (b)(4) Slicer on Line 1 as well.</p> <p>2nd Shift Quality Assurance Supervisor (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. The establishment immediately implement corrective actions in my presence. Regulatory control was released at 2030hrs.</p> <p>2nd Shift Production Manager (b)(6) was also shown the noncompliance and verbally notified that a noncompliance record would be issued.</p> <p>See Noncompliance Record #AKZ3022070915N-1 linked and associated for similar noncompliance.</p>
M51205+ P51205+ V51205	BrucePac	38569280- C239-4B74- 9B3D- 27E1482D674 2	AKZ0107075129N-1	7/29/2024	7/29/2024	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	<p>At approximately 0610 I was performing a review and observation activity of a pre-operational sanitation inspection task in the Raw/Fresh area when I observed the following deficiencies:</p> <p>On the auger to Line #2 infeed there was a buildup of chicken residue underneath the lip inside the auger and on the guard plate inside the auger, as well as a one-inch piece of chicken left on the auger blade.</p> <p>On the #1 X-Ray Line on the return belt there were multiple pieces of chicken residue ranging anywhere from one eighth of an inch in size to one quarter of an</p>

									<p>inch.</p> <p>On the metal detector belt on the Grind Line, I found residual chicken residue on the support bars.</p> <p>I informed (b)(6) (Sanitation Foreman) of the issuance of this Noncompliance Record. All of these deficiencies were addressed during my presence, so no U.S. Rejected/Retained tags were used. At 0650 hours the Raw/Fresh area was released to production.</p>
M51205+ P51205+ V51205	BrucePac	53394FC3- 0272-4E3A- 8CA0- 451C6B66CBB C	AKZ4611080113N-1	8/13/2024	8/13/2024	01D01	SPS Verification	416.2(a)	<p>At approximately 11:20 a.m. I was in the raw receiving area when I observed twenty totes of chicken that had been unloaded setting on the dock. I noticed on top of ten of the twenty totes there was one fly on top of the blue plastic of each tote. I looked around the area to see if there were any more flies present and observed one live fly crawling on the floor.</p> <p>I informed the Q.A. Tech in the area of the fly situation, and also informed (b)(6) (Service Support Manager) and suggested the area outside the dock be monitored.</p> <p>No product or product contact surfaces were seen adulterated/contaminated by this incident, therefore no U.S. Rejected/Retained tags were used.</p>
M51205+ P51205+ V51205	BrucePac	E786ACE3- 7BCF-49C6- 92E9- 0F9F11881E6 4	AKZ5322084522N-1	8/22/2024	8/22/2024	01D01	SPS Verification	416.2(d)	<p>On 8-22-2024 while performing an Operational SSOP task I, CSI (b)(6) observed the following noncompliance.</p> <p>At 2100hrs while in the Oven Room, I observed heavily beaded condensation on the ceiling directly above the exit end of Oven Line 2. The product exiting the oven is post lethality exposed and as such, this instance creates a point for product cross contamination. I took regulatory control by instructing an Equipment Operator to stop the line at 2105hrs.</p> <p>QA Lead (b)(6) was shown the noncompliance and verbally notified that a noncompliance record would be issued. The</p>

									<p>establishment performed immediate corrective actions in my presence, so no US Reject tag was placed.</p> <p>I released regulatory control of Oven Line 2 at 2110hrs after the establishment corrective actions were completed. No product was observed to be affected at this time. Production Manager (b)(6) and QA Supervisor (b)(6) were also notified that a noncompliance record would be issued.</p>
M51205+ P51205+ V51205	BrucePac	33994571- 96CC-484F- A690- 70280D350D3 C	AKZ4607084328N-1	8/28/2024	8/28/2024	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(a), 416.4(b)	<p>At approximately 0615 hours I was performing a review and observation activity of a scheduled pre-operational sanitation inspection task when I observed the following deficiencies on these product and non-product contact surfaces:</p> <p>While I was inspecting the Grind Line in the Raw/Fresh area I observed a half to a full cup of meat in the bottom (roller end) of the meat block conveyor, and also in the top roller end of the conveyor there was meat residue and on the product contact surface area of the belt itself as it was being turned, I observed more meat residue.</p> <p>When I was inspecting the parts for the Grinder, I observed a huge amount of product left inside one of the parts to the machine. Inside the (b)(4) Grinder/Blender there was visible meat scraps in the bottom and residue that was stuck to the sides of the machine. Underneath the metal detector on the conveyor, I observed a meat and fat residue when I felt of the underneath of the metal detector. There was a metal pitchfork which is used to pull and break up meat that had meat on it from top to bottom.</p> <p>There were also numerous non-product contact surfaces such as rails, guards and support bars that had meat and/or fat residue that had to be removed. All of these deficiencies were addressed in my presence therefore no U.S. Rejected/Retained tags were used. After corrective actions had been</p>



									implemented, the area was released to production at 0720 hours.
M51205+ P51205+ V51205	BrucePac	5CAA339C-033B-45AD-A370-7705A13D3B7E	AKZ0309091713N-1	9/13/2024	9/13/2024	01B02	Pre-Op SSOP Review and Observation	416.13(c), 416.4(a), 416.4(b)	<p>At approximately 0630 hours I was performing a review and observation activity of a scheduled pre-operational sanitation inspection task in the Raw/Fresh area when I observed the following deficiencies on product and non-product contact surfaces.</p> <p>On the (b)(6) flattener belts on X-Ray one and two I observed chicken residue/pieces intertwined in some of the links on both belts.</p> <p>On the inside of the auger to the (b)(4) on Line four I observed a tablespoon of chicken residue, and on the catwalk ladder to the small grinder on the Grind Line there was chicken clumps all along the support rails of the ladder. On the inside of the Blender on the Grind Line I observed chicken residue all along the outer support bar on the inside of the blender. On the meat block conveyor there were two pieces of meat (beef) underneath the bottom of the conveyor belt. Underneath the catwalk to the metal detector conveyor there was chicken hanging from the cracks on the catwalk and on the metal detector conveyor on the belt rollers were residual pieces of chicken.</p> <p>All of the deficiencies were shown to (b)(6) and (b)(6) (Sanitation Supervisors) and (b)(6) (Sanitation Manager) and they were informed of the issuance of this Noncompliance Record. After corrective actions had been implemented the area was released to production at 0736 hours. No U.S. Rejected/Retained tags were used as all of these deficiencies were addressed during my presence and no product was seen contaminated/adulterated.</p>
M51205+ P51205+ V51205	BrucePac	9D71B67F-97F8-484C-BA1C-E438592D4CD3	AKZ2107090726N-1	9/26/2024	9/26/2024	01B02	Pre-Op SSOP Review and Observation	416.13(a), 416.4(b)	At approximately 0615 hours I was performing a review and observation activity of a pre-operational sanitation inspection task when I observed the following deficiencies on product and non-product contact surfaces in the packaging area:

									<p>On the outfeed incline belt from the product chute on the (b)(4) there were small pieces of chicken residue. While I was inspecting the scale I observed product residue on multiple scale buckets and on the frame of the (b)(4) I informed the Lead that I was rejecting the area until the machine had been cleaned properly.</p> <p>At approximately 0640 hours I re-inspected the machine and found that there were still several pieces of product on some of the buckets and framework.</p> <p>After corrective actions had been implemented, I released the area at 0655 hours. No Rejected/Retained tags were used as all of these deficiencies were addressed during my presence and no product was seen adulterated/contaminated by these deficiencies.</p>
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