

OPI: MPITS/SISPD

FINISHED PRODUCT STANDARDS PROGRAM FOR THE  
NEW LINE SPEED INSPECTION SYSTEM AND THE  
STREAMLINED INSPECTION SYSTEM

I. PURPOSE

This directive provides guidelines for applying the Finished Product Standards program for the New Line Speed and Streamlined Inspection Systems for poultry.

II. CANCELLATION

FSIS Notice 43-86.

III. (RESERVED)

IV. REFERENCES

Section 381.76 of MPI Regulations.

V. ABBREVIATIONS

The following will appear in their shortened forms in this directive:

FPS - Finished Product Standards  
IIC - Inspector in Charge  
NELS - New Line Speed Inspection System  
SIS - Streamlined Inspection System

VI. POLICY AND PROCEDURES

A. General.

1. Under NELS and SIS, USDA inspectors focus their attention on whole carcass disposition. Carcasses which are passed by the inspector are properly trimmed by establishment personnel and then subject to reinspection. Under NELS, reinspection is accomplished by (1) inspection personnel monitoring the establishment's slaughter quality control program which is designed to produce carcasses meeting the FPS program and (2) applying the FPS program. Under SIS, reinspection is accomplished by applying only the FPS program. Under SIS, reinspection is accomplished by applying only the FPS program.

2. Under both systems, the IIC or designee shall at least twice a day:

a. Review the establishment's application of the FPS program, and

b. Perform the required FPS tests.

3. The policy set forth in the Finished Product Standards Program for Poultry Inspection Systems guidelines for reduced frequency testing in establishments operating under NELIS remains in place.

B. Guidelines. The following guidelines have been developed to achieve consistent application of the prechill and postchill FPS program by establishment and inspection personnel:

1. Timeframes. An important part of the FPS program is the timeframe used to examine and record the results for the 10-bird subgroup sample. It has been determined that a trained, experienced person can perform and record the prechill FPS subgroup sample in 8 to 10 minutes. A postchill FPS subgroup sample should be completed in 5 to 7 minutes. The timeframes for both prechill and postchill FPS testing may be reduced if the person performing the test is assisted in recording the nonconformances. The postchill FPS subgroup sample timeframe should be followed whenever it is necessary to conduct the FPS test in order to release product retained for postchill rework.

2. Procedure for Observing Carcasses. A four-step procedure has been developed which will allow the FPS program to be uniformly applied in observation of critical parts of the carcass.

a. Outside Back. While holding the carcass, with the back of the carcass toward the observer and starting at the hock area, observe the hocks, back part of the legs, tail area, back of the carcass, and top side of the wings.

b. Outside Front. Turn the carcass and observe the bottom side of the wings, breast, and front part of the legs.

c. Inside. Observe the inside surfaces of the carcass and the abdominal flaps and fat.

d. Neck Flap Area. Observe the neck flap and the thoracic inlet area.

3. Correlation. As a group, the IIC, the FSIS monitoring personnel, and the establishment monitoring personnel should conduct one prechill and one postchill FPS correlation test at least twice weekly. The purpose of this exercise is for the IIC to ensure that all establishment and inspection personnel applying the standard do so correctly and uniformly.

Establishments experiencing difficulty in passing the FPS should determine the cause of the problems, correct and control their manufacturing process, and increase the frequency of the FPS tests until the problem is eliminated. In these situations, the IIC shall increase the frequency of correlation between establishment and inspection monitoring personnel.

W. S. Horne  
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