



United States
Department of
Agriculture

Food Safety
and Inspection
Service

Washington, D.C.
20250

DEC 2 2008

Dr. Richard Arsenault
Director, Meat Programs Division
Canadian Food Inspection Agency
8 Colonnade Road
Ottawa, Ontario, KIA 0Y9

Dear Dr. Arsenault:

The Food Safety and Inspection Service (FSIS) conducted an on-site audit of Canada's meat, poultry, and egg products inspection system May 20 through June 25, 2008. Enclosed is a copy of the final audit report.

If you have any questions regarding the FSIS audit or need additional information, please contact me at telephone number (202) 690-5646, by facsimile at (202) 720-0676, or electronic mail at donald.smart@fsis.usda.gov.

Sincerely,

Donald Smart
Director
International Audit Staff
Office of International Affairs

Enclosure

cc:

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FINAL REPORT OF AN AUDIT CARRIED OUT IN CANADA
COVERING CANADA'S MEAT, POULTRY AND EGG
PRODUCTS INSPECTION SYSTEM

MAY 20 through JUNE 25, 2008

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

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ABBREVIATIONS AND SPECIAL TERMS USED IN THE REPORT

AVP	Associate Vice-President
CCA	Central Competent Authority (Canadian Food Inspection Agency)
CCP	Critical Control Point(s)
CFIA	Canadian Food Inspection Agency
CL	Critical Limit
CVS	Compliance Verification System
<i>E. coli</i>	<i>Escherichia coli</i>
FSIS	Food Safety and Inspection Service
<i>Lm</i>	<i>Listeria monocytogenes</i>
MOP	CFIA Manual of Procedures
NOID	Notice of Intent to Delist
PR/HACCP	Pathogen Reduction/Hazard Analysis and Critical Control Point
QMS	Quality Management System
RTE	Ready-to-Eat
RVO	Regional Veterinary Officer
<i>Salmonella</i>	<i>Salmonella</i> species
SPS	Sanitation Performance Standards
SSOP	Sanitation Standard Operating Procedures

1. INTRODUCTION

The audit took place in Canada from May 20 through June 25, 2008.

An opening meeting was held on May 20, 2008, in Ottawa, Canada, with the Central Competent Authority (CCA). At this meeting, the auditors confirmed the objective and scope of the audit and confirmed the itineraries of the auditors.

Each auditor was accompanied during the entire audit by representatives from the CCA, the Canadian Food Inspection Agency (CFIA), and/or the Area or the Regional Offices.

2. OBJECTIVE OF THE AUDIT

This audit was a routine audit with special emphases on *Escherichia coli* O157:H7 (*E. coli*) controls, humane handling and slaughter of livestock, and good commercial practices for poultry, and included three objectives. The first and main objective of the audit was to evaluate the performance of the CCA with respect to controls over the slaughter and processing establishments certified by the CCA as eligible to export meat, poultry, and egg products to the United States. The second objective was to review the establishments' programs and to conduct an on-site assessment of Canada's oversight of humane handling and slaughter of livestock and good commercial practices for poultry in the 17 slaughter establishments audited. The third objective was to review the establishment's programs and CFIA control measures for *E. coli* O157:H7 in the eight beef slaughter establishments audited.

In pursuit of the objectives, the following sites were visited: The headquarters office of the CCA, two Area Offices, two Regional Offices, three microbiology laboratories, one residue laboratory, two egg products establishments, and 23 slaughter and/or processing establishments.

Competent Authority Visits			Comments
Competent Authority	Headquarters	1	
	Area	2	Supervise Regional Offices
	Regional	2	Supervise Certified Establishments
Microbiology Laboratories		3	
Residue Laboratory		1	
Egg Products Establishments		2	
Equine Slaughter and Processing Establishment		1	
Meat Slaughter and Processing Establishments		12	
Poultry Slaughter and Processing Establishments		4	
Meat and/or Poultry Processing Establishments		6	

3. PROTOCOL

This on-site audit was conducted in four parts. One part involved visits with headquarters personnel to discuss oversight programs and practices, including enforcement activities. The second part involved interviews with CFIA inspection officials and a review of a selection of records in the country's inspection headquarters, area offices, regional offices and inspection offices located within individual establishments. The third part involved on-site visits to 25 establishments: Seventeen slaughter establishments, six meat and/or poultry processing establishments, and two egg products establishments. The fourth part involved visits to two private microbiology laboratories, one government microbiology laboratory and one government residue laboratory. All were conducting tests on product destined for export to the United States.

Program effectiveness determinations of Canada's inspection system focused on five areas of risk: (1) Sanitation controls, including the implementation and operation of Sanitation Standard Operating Procedures (SSOP) and Sanitation Performance Standards (SPS), (2) animal disease controls, (3) slaughter/processing controls, including the implementation and operation of Hazard Analysis and Critical Control Points (HACCP) systems and a testing program for generic *E. coli*, (4) residue controls, and (5) enforcement controls, including testing programs for *Salmonella* species (*Salmonella*). Canada's inspection system was assessed by evaluating these five risk areas.

During all on-site establishment visits, the auditors evaluated the nature, extent and degree to which findings impacted on food safety and public health. The auditors also assessed how inspection services were carried out by Canada and determined if establishment and inspection system controls were in place to ensure the production of meat, poultry, and egg products that are safe, unadulterated and properly labeled.

At the opening meeting, the auditors explained that Canada's inspection system would be audited against two standards: (1) CFIA laws, regulations, and other requirements and (2) any equivalence determinations made for Canada.

Equivalence determinations are those that have been made by FSIS for Canada under provisions of the Sanitary/Phytosanitary Agreement. The following equivalence determinations have been made for Canada:

- *Salmonella* Testing of Raw Product
 - Establishments select samples
 - Private laboratories analyze samples
- *Listeria monocytogenes (Lm)* Testing of Ready-to-Eat (RTE) Product
 - Establishments select samples
 - Private laboratories analyze samples
- Compositing of *E. coli* 0157:H7 samples prior to screening tests

- High Line Inspection System for Beef
- Canadian residue control program
- Generic *E. coli* testing for minor species
- MFLP-28 Bax[®] analytical method for *Lm* in RTE products
- MFLP-30 Bax[®] analytical method for *E. coli* O157:H7

4. LEGAL BASIS FOR THE AUDIT

The audit was undertaken under the specific provisions of United States laws and regulations, in particular:

- The Federal Meat Inspection Act (21 U.S.C. 601 et seq.)
- The Federal Meat Inspection Regulations (9 CFR Parts 301 to end), which include the PR/HACCP regulations
- The Poultry Products Inspection Act (21 U.S.C. 451 et seq.)
- The Poultry Products Inspection Regulations (9 CFR Part 381)
- The Egg Products Inspection Act (21 U.S.C. 1031 et seq.)
- The Egg Products Inspection Regulations (9 CFR Parts 590 and 592)

5. SUMMARY OF PREVIOUS AUDITS

Final audit reports are available on FSIS' website at the following address:
www.fsis.usda.gov/regulations_&_policies/foreign_audit_reports/index.asp

The last two comprehensive audits and one special audit of Canada's meat, poultry and egg products inspection system were conducted in April/May 2006, May/June 2007 and November 2007.

Summary of April/May 2006 Audit Findings

Government Oversight

- Significant deficiencies were noted in CFIA's oversight of private microbiology laboratories.
- There had been no direct contact between CFIA and the private laboratories giving instructions for a sample size of 325 grams for *Salmonella* testing of ready-to-eat products. Notification from CFIA of the increase to 325 grams went to the inspection force with instructions to inform the establishments, who were then to inform the private laboratories. CFIA did not followup with the private laboratories regarding the requirements of the *Salmonella* testing program.

- At one private laboratory, the quality assurance manager stated that not all methods used to test products for export had been validated in-house. Validation was in progress but not yet completed.

Sanitation Controls

- Eight of 21 establishments had deficiencies in the implementation of the SSOP, which resulted in both potential and direct product contamination.
- Nineteen of 21 establishments had deficiencies in the implementation of SPS.

Slaughter/Processing Controls

- Fifteen of 21 establishments had deficiencies in the implementation, corrective actions, verification and/or recordkeeping requirements of HACCP programs.
- In one establishment, no stand was available to perform the testing for generic *E. coli*, which made it difficult to collect the sample in a sanitary manner.
- Instead of collecting 325 grams of product for *Salmonella* testing, only 25 grams of product was being collected.

Enforcement Controls

- CFIA issued one Notice of Intent to Delist (NOID) for deficiencies in HACCP, SSOP, or SPS requirements. No establishments were delisted.
- In 20 of the 21 establishments audited, the CFIA was not enforcing some of the United States regulatory requirements, which are equivalent to Canadian requirements.

Summary of May/June 2007 Audit Findings

Government Oversight

- In one of the 24 establishments audited, there had been no visits from the CFIA inspection staff for a two-month period for the second shift.
- It appeared that not all inspectors had a complete understanding of the requirements of the Multi Commodity Activity Program (MCAP) task, and were not well trained in the performance of their inspection tasks.
- Four of the five Canadian microbiology laboratory methods listed in the Canadian Meat Hygiene Directive 2006-26 for analyses of RTE products were not determined to be equivalent by FSIS.
- Not all laboratories were analyzing a 325 gram test sample for *Salmonella* in RTE products. Some laboratories were using a 25 gram test sample.
- No methods, for the analysis of *Salmonella* in raw product, were determined to be equivalent by FSIS.

Sanitation Controls

- In 17 of the 24 establishments audited, the SSOP were not fully implemented. Some maintenance, corrective action and/or record-keeping requirements were not met. This resulted in both potential and direct product contamination.
- In 21 of the 24 establishments audited, SPS deficiencies were observed.

Slaughter/Processing Controls

- In one of the 24 establishments audited, deficiencies in the basic HACCP requirements were observed.
- In 14 of the 24 establishments audited, deficiencies in the implementation of the ongoing HACCP requirements were observed.
- In three of the 9 slaughter establishments audited, deficiencies were observed in the generic *E. coli* testing programs.

Enforcement Controls

- One establishment was delisted by the CFIA.
- Six NOIDs were issued by the CFIA.
- In 18 of 24 the establishments audited, some CFIA inspection requirements were not enforced.
- In one of the 9 slaughter establishments audited, the establishment did not receive its residue sampling schedule for FY 2006-2007.
- Two establishments that produced both single- and multiple-species ground products did not have species verification sampling scheduled for them by the CFIA.
- It appeared that some inspectors did not have a complete understanding of the requirements of the Multi Commodity Activity Program (MCAP) task, and were not well trained in the performance of their inspection tasks.
- Inspection personnel were not conducting hands-on pre-operational sanitation inspection verification or were not conducting it at the frequency required.

Summary of November 2007 Audit Findings

Sanitation Controls

- In one of the 7 establishments evaluated for SSOP implementation, the SSOP were not fully implemented.
- In three of the 7 establishments evaluated for SPS implementation, SPS deficiencies were observed.

Enforcement Controls

- One establishment was delisted by the CFIA.
- In four of the 10 establishments evaluated, some CFIA inspection requirements were not enforced.

6. MAIN FINDINGS

6.1 Government Oversight

The CFIA is the CCA for Canada's meat, poultry, and egg products inspection system. The CFIA has ultimate control over the production of food products derived from animals and eggs. Canada is divided into four areas of administration and field operations: The Atlantic, Ontario, Québec, and the West. The West Area has six Regional Offices. The remaining Areas each have four Regional Offices.

There has been one change in the organizational structure of the CFIA since the last routine audit of Canada's inspection system, conducted in May/June 2007. The CFIA was realigned to form a Policy and Programs Branch, which includes the product recall function. The Policy and Programs Branch is led by an Associate Vice-President (AVP) and is being realigned along three streams, each reporting to the AVP: (1) Policy is composed of three directorates, International Policy, Domestic Policy, and Strategic Policy; (2) Programs are composed of five directorates, Animal health, Plant Health, Consumer Protection, Agrifood and Meat and Seafood Safety, and the newly formed Program Modernization Office, and (3) Integration and Management is composed of two directorates, Business Planning and Transformation, and Business Service.

This realignment did not alter the structure of the command chain at the Area level. At the Area level, the Programs Director receives communications from headquarters and the Operations Director oversees the inspection operations in the establishments.

6.1.1 Ultimate Control and Supervision

The CFIA Regional Offices are responsible for oversight, control, and supervision of official inspection activities for domestic and United States-certified establishments. Inspection Managers are responsible for supervision and performance evaluations of the Veterinarians-in-charge (VIC) of establishments and complex processing supervisors (CS) and report directly to the regional director. The CS conducts Quality Management System (QMS) activities and is responsible for a set number of processing establishments and the direct supervision of processing specialist. Regional Veterinary Officers (RVO) are responsible for QMS activities in a set number of slaughter establishments and they normally report directly to the regional director. The VIC is responsible for inspection activities, QMS, and supervision of the food inspectors working in individual establishments. Food inspectors rotate through online and offline inspection responsibilities.

The periodic supervisory reviews in slaughter establishments are carried out by the RVO and in processing establishments by the CS. The reviews are now part of QMS, which is a part of the management controls integrated into the Compliance Verification System (CVS). The QMS evaluates the performance (delivery) of inspection by the CFIA personnel assigned to the establishments and identifies where the quality of the regulatory process can be improved. The CVS tasks are related to the evaluation of United States export requirements. CVS is a newly-implemented, electronic-based inspection system replacing the Multi Commodity Activity Program (MCAP).

6.1.2 Assignment of Competent, Qualified Inspectors

The CFIA Regional Offices are responsible for the hiring of new inspection personnel, staffing, and the assignment of inspection personnel for individual establishments.

The educational requirements for veterinarians are: A degree in veterinary medicine from an accredited college or, for veterinary graduates from non-accredited colleges, the veterinarians must pass a comprehensive examination overseen by the National Examining Board of the Canadian Veterinary Medical Association and receive a Certificate of Qualification.

The minimum educational standard for inspection positions is completion of post-secondary education specializing in relevant technical sciences or, for those that are current or former CFIA employees, an acceptable combination of education, training and/or experience. For new employees, the standard is completion of post-secondary education specializing in relevant technical sciences. CFIA Operations prefer a University graduate with specialization in a field related to the functions of the position.

Initial and on-going training programs are developed and structured through the CCA and delivered by national, area, or regional training personnel. All records of training as well as the need or position requirement for training is tracked through a software program called "People Soft".

All government employees, including CFIA employees, are required to have annual performance evaluations. Supervisors conduct scheduled QMS activities to evaluate the program effectiveness at all levels of inspection.

The CFIA has implemented CVS in all regulated establishments. This system assigns daily inspection verification tasks to the in-plant inspectors and supervisors. The training for implementation involves a four-day classroom training course in the design and use of the system followed by four to six weeks of in-plant mentoring. At the conclusion of the mentoring, an evaluation of the inspector's understanding and use of the CVS is performed. Remedial training is provided for inspectors that does not attain minimal capabilities in the use of the CVS. The requirements for successful performance of the tasks assigned by the CVS are stated in the manual of procedures.

6.1.3 Authority and Responsibility to Enforce the Laws

The authority of the CCA to enforce CFIA inspection laws are granted in the Meat Inspection Act, the Meat Inspection Regulations, and the Meat Hygiene Manual of Procedures. Although the CCA has the legal authority and the responsibility to enforce all applicable laws and regulations governing Canadian and third country requirements, some FSIS requirements were not enforced:

- One establishment was issued a NOID as a result of this audit.
- In 20 of the 25 establishments audited, some CFIA and/or FSIS requirements were not adequately enforced.
- In 17 of the 25 establishments audited, the establishment personnel did not implement the SSOP, evaluate the effectiveness of the SSOP, and/or have daily records sufficient to document the SSOP.
- In 15 of the 25 establishments audited, the establishment personnel did not maintain adequate records documenting some aspects of the HACCP plans.
- In 15 of the 25 establishments audited, the establishment personnel did not effectively implement either CFIA pre-requisite programs or other U.S. requirements, e.g., sanitation performance standards.

6.1.4 Adequate Administrative and Technical Support

The CFIA has adequate administrative and technical support to operate Canada's laboratory system. National Laboratory Operations in Ottawa provides oversight for the private and government laboratory systems. Government and private laboratories are accredited by the Standards Council of Canada (SCC) for ISO 17025 accreditation. Major accreditation audits are conducted every two years. A Memorandum of Understanding has been signed by the SCC and the CFIA, which outlines CFIA responsibilities to provide or approve audit team members, i.e., Technical Assessors for the SCC audit teams. Audit teams are comprised of CFIA and other technical audit experts. Laboratories participate in proficiency testing schemes organized by the CFIA and other programs organized by third-party providers.

Although the CFIA has adequate administrative and technical support to operate Canada's laboratory system, the following deficiency was identified:

- Some of the establishments required to submit the *Salmonella* verification testing samples were not following the security and chain-of-custody requirements described in the CFIA Meat Hygiene Manual of Procedures, Chapter 11, Section 11.7, Annex U, when submitting samples.

6.2 Headquarters Audit

The auditors conducted a review of inspection system documents at the CFIA Headquarters, two Area Offices, two Regional Offices and individual inspection offices. The records review included the following:

- Internal review reports
- Compliance Verification System reports
- Quality Management System reports
- Records documenting supervisory visits to establishments that are certified to export to the United States
- Inspection records
- Training records for inspection personnel
- New laws and implementation documents, such as regulations, notices, directives and guidelines
- Control of products from livestock with conditions such as tuberculosis, cysticercosis, etc., and of inedible and condemned materials
- Export product inspection and control, including export certificates
- Enforcement records, including examples of criminal prosecution

No concerns arose as a result of the examination of these documents.

7. ESTABLISHMENT AUDITS

The FSIS auditors visited a total of 25 establishments: Two egg products establishments, one equine slaughter and processing establishment, 12 meat slaughter and processing establishments, four poultry slaughter and processing establishments, and six meat and/or poultry processing establishments.

No establishments were delisted by the CFIA. One establishment received a NOID from the CFIA for HACCP, SSOP, and SPS deficiencies.

The specific deficiencies are noted on the attached individual establishment reports.

8. LABORATORY AUDITS

During laboratory audits, emphasis is placed on the application of procedures and standards that are equivalent to United States' requirements.

Residue laboratory audits focus on sample handling, sampling frequency, timely analysis, data reporting, analytical methodologies, tissue matrices, equipment operation and printouts, detection levels, recovery frequency, percent recoveries, intra-laboratory check samples, and quality-assurance programs, including standards books and corrective actions.

The following government residue laboratory was audited:

- CFIA residue laboratory, Center for Drug Residues, Saskatoon, SK

Microbiology laboratory audits focus on analyst qualifications, sample receipt, timely analysis, analytical methodologies, analytical controls, recording and reporting of results, and check sample programs. If private laboratories are used to test United States-eligible samples, the auditors evaluate compliance with the criteria established for the use of private laboratories under FSIS' PR/HACCP requirements.

The following two private microbiology laboratories and one CFIA microbiology laboratory were audited:

- CFIA Microbiology Laboratory of Veterinary Hygiene, St-Hyacinthe, QC
- Private microbiology laboratory, Certispec Food Laboratory, Dorval, QC
- Private microbiology laboratory, Integrated Explorations, Guelph, ON

No concerns arose as a result of these audits.

9. SANITATION CONTROLS

As stated earlier, the FSIS auditors focused on five areas of risk to assess Canada's meat poultry and egg products inspection system. The first of these risk areas that the FSIS auditors reviewed was Sanitation Controls.

Based on the on-site audits of establishments, and except as noted below, Canada's inspection system had controls in place for SSOP programs, all aspects of facility and equipment sanitation, the prevention of actual or potential instances of product cross-contamination, good personal hygiene practices, and good product handling and storage practices.

In addition, Canada's inspection system had controls in place for water potability records, back-siphonage prevention, separation of operations, temperature control, workspace, ventilation, ante-mortem facilities, welfare facilities, and outside premises.

9.1 Sanitation Standard Operating Procedures

Each establishment was evaluated to determine if the basic FSIS regulatory requirements for SSOP were met, according to the criteria employed in the United States' domestic inspection program. The SSOP in the 25 establishments audited were found to meet the basic FSIS regulatory requirements, with the following exceptions:

- In 7 of the 25 establishments audited, deficiencies were observed in the implementation of either the pre-operational or operational sanitation programs. For example:

- The anus and the distal portion of the large intestine of a hog carcass were dragging on an insanitary work platform prior to being dropped into the viscera inspection trays.
 - The employees eviscerating hog carcasses were wearing chain-link gloves which were not cleaned and could not be adequately cleaned and sanitized after contaminated viscera was handled.
 - Large pieces of fat and meat were attached to the surface of a continuously-moving, belted stainless steel evisceration table.
 - Condensate was observed dripping from a refrigeration supply line onto a hog carcass.
 - An employee was observed handling the outside of non-meat ingredient containers and then contacting edible product without first sanitizing his hands.
 - A shovel used to handle edible product was observed with product residue from a previous day's operations.
 - An employee's helmet and face shield were observed contacting packaging material which was then used to wrap edible product.
- In two of the 25 establishments audited, deficiencies in the maintenance and evaluation of the effectiveness of the SSOP were observed. For example:
 - The establishment personnel did not document the annual evaluation of the SSOP.
 - The cleaning procedures documents did not state the frequency at which the cleaning procedures would be performed.
 - Preventive measures were required to be documented only if the unsatisfactory condition is repeated on two consecutive occasions.
- In 11 of the 25 establishments audited, deficiencies in the documentation of SSOP implementation (including monitoring, SSOP maintenance and evaluation, or SSOP corrective actions and preventive measures) were observed. For example:
 - The establishment did not have personnel training procedures for the reconditioning of veal carcasses that fall onto the slaughter room floor.
 - Preventive measures for pre-operational and operational SSOP findings were not recorded for each occurrence.
 - The establishment personnel were not verifying cleaning procedures.
 - The daily operational sanitation procedures described in the SSOP did not match what was listed on the daily monitoring forms.

9.2 Sanitation Performance Standards

Each establishment was evaluated to determine if the basic FSIS regulatory requirements for SPS were met, according to the criteria employed in the United States' domestic inspection program. The SPS in the 25 establishments audited were found to meet the basic FSIS regulatory requirements, with the following exceptions:

- Seven establishments were identified with construction or maintenance deficiencies. For example:
 - The rubber gasket on a product storage freezer door was damaged and frost accumulation was present on some of the overhead structures in the freezer.
 - The floors in carcass coolers and in one area of a grinding room were damaged and rough.
 - One of the loading docks had refuse and debris present under the hydraulic floor plate.
 - Scrap metal was stored near a building in a manner that made it a potential harborage for pests.
 - Plastic wheeled carts used in the pack-off room had rough and damaged surfaces which made them difficult to clean and sanitize.
 - The aisle between the dry ingredients storage shelves in a dry storage area was filled with pallets and packaging materials which interfered with the ability to perform inspection.
 - Expandable foam insulation was located on a wall/beam junction above the entrance into a carcass drip cooler.

- Six establishments were identified with condensation or ventilation deficiencies. For example:
 - Water was observed dripping from an overhead platform onto the floor of an area transited by production employees.
 - Frozen beads of condensate were observed between rails containing carcasses.
 - Condensate was observed under two cooling unit drip pans, several carcass rails, and overhead structures in carcass chilling rooms.
 - Condensate was observed under over-product structures in a processing room.
 - Water was accumulating and beading under over-product structures at the final carcass wash.
 - Condensate was observed under the carcass rail and carcass rail flap above the entrance into the carcass drip cooler.

- Eight establishments were identified with sanitary operations deficiencies. For example:
 - An employee was observed cracking eggs rejected during candling on the edge of the candling hood before dropping them into the inedible container.
 - Bottles of sanitizer and lactic acid spray were stored in the meat reconditioning sink on the beef fabrication line and the knives in a scabbard at the veterinary disposition rail had blood and residue from previous use.
 - An establishment employee trimming carcasses at the contamination trim stand, located at the entrance to the cutting room, was wearing a cotton glove that could not be cleaned and sanitized when contaminated.
 - An establishment employee working on the carcass skinning line of the slaughter floor pushed a carcass into another carcass resulting in contact of the skinned and un-skinned portions of both carcasses.

- Establishment employees removing the hide from veal carcasses were grasping the hair side of the hide and then grasping the clean skinned side of the carcass without cleaning and sanitizing their mesh gloves.
 - The maintenance room, box make-up room and the packaging storage room were not organized to promote sanitary conditions.
 - Packaging material in the dry storage room was not protected from contamination and was not organized to provide sanitary conditions during storage.
 - Packaged frozen product in the frozen product freezer and the research and development cage was not stored and organized to provide sanitary conditions during storage.
 - The outside surfaces of an employee's work boots in the men's locker room were coated with residues of product from the previous day's production.
- Two establishments were identified with equipment and utensils deficiencies. For example:
 - In the egg-tray washing area, several egg trays that had exited the tray washer and were being stacked had egg residue and shell fragments on them.
 - The surface of a continuously-moving belted stainless steel evisceration table was not constructed to facilitate thorough cleaning and to ensure that product is not adulterated during use.
 - One establishment was identified with a dressing room/lavatory deficiency:
 - An accumulation of dust, litter, and debris was observed on the floor and under the lockers in the employee welfare areas.
 - One establishment was identified with a grounds/pest control deficiency:
 - Insects were observed in the product receiving dock. The overhead door to the receiving dock was not completely closed to exclude the entry of pests into the establishment.

10. ANIMAL DISEASE CONTROLS

The second of the five risk areas that the FSIS auditors reviewed was Animal Disease Controls. These controls include ensuring adequate animal identification, control over condemned and restricted product, implementation of the requirements for Bovine Spongiform Encephalopathy and specified risk materials, and procedures for sanitary handling of returned and reconditioned product.

No deficiencies were observed.

11. SLAUGHTER/PROCESSING CONTROLS

The third of the five risk areas that the FSIS auditor reviewed was Slaughter/Processing Controls. The controls include the following areas: Ante-mortem inspection procedures; ante-mortem disposition; humane handling and slaughter; post-mortem inspection procedures; post-mortem disposition; ingredients identification; control of restricted

ingredients; formulations; processing schedules; equipment and records; and processing controls of cured, dried, and cooked products.

The controls also include the implementation of HACCP systems in all establishments and the implementation of generic *E. coli* testing programs in slaughter establishments.

11.1 Humane Handling and Slaughter

Thirteen of the 25 establishments audited were livestock-slaughter establishments and were required to meet FSIS regulatory requirements for humane handling and slaughter. These 13 establishments were evaluated according to the criteria employed in the United States' domestic inspection program. The following deficiency was observed:

- In one establishment, the voltage of the electric prods used by establishment employees moving the animals along the single file chute to the stunner exceeded the 50 volt maximum allowed by regulations.

Four of the 25 establishments audited were poultry-slaughter establishments and were required to meet FSIS regulatory requirements for good commercial practices for poultry. These four establishments were evaluated according to the criteria employed in the United States' domestic inspection program.

No deficiencies were observed.

11.2 HACCP Implementation

All establishments approved to export meat and poultry products to the United States are required to have developed and adequately implemented HACCP programs. Each of these programs was evaluated according to the criteria employed in the United States' domestic inspection program.

The HACCP programs were reviewed during the on-site audits of the 23 establishments required to have HACCP programs. The two egg products establishments audited were not required to have developed and adequately implemented HACCP programs.

All 23 establishments audited had developed and adequately implemented HACCP programs, with the following exceptions:

- In two of the 23 establishments, the establishments did not list either a food safety hazard or a critical control point (CCP) or a critical limit (CL) or a procedure in the HACCP plans. For example:
 - The number of sample units to be measured for some CCPs were not described in an establishment's HACCP plan or in the monitoring procedures.
 - There was no CCP for monitoring of the product for zero-tolerance for the presence of feces, ingesta, or milk. There was insufficient supporting documentation to justify the establishment's decision not to have a Zero-Tolerance CCP for this product.

- In one of the 23 establishments, the verification and validation process procedures for a CL in the HACCP plan were insufficient. For example:
 - (A) The product process step for cooling of product was not listed as a CCP, although insufficient documentation was available to support the decision not to have cooling as a CCP. (B) The CL for a CCP, sauce holding, did not include a time limit and did not adequately describe which CL applied to which types of sauce (e.g., high-acid sauce or low-acid sauce).
 - There was insufficient documentation to support the decision to place some RTE products in the Alternative 2 category described in 9 CFR 430.

- In two of the 23 establishments, either the HACCP plans had not been reassessed according to regulatory requirements or the adequacy of the reassessment was deficient. For example:
 - In the HACCP plan for slaughter, the CL, for a CCP did not adequately address the process step.
 - One establishment did not follow its written procedures for annual reassessment of its HACCP plan.

- In 14 of the 23 establishments, the records associated with the HACCP plans and/or monitoring of the CCPs and CLs were deficient. For example:
 - A process monitor was not entering the observed data on the record as it was prescribed on the monitoring form.
 - No entry had been recorded for one of the required hourly monitoring checks.
 - The monitoring form for a CCP had a CL range for water pressure that did not match the one written in the HACCP plan.
 - The monitoring form for a CCP did not have an area to record the process start time when the CL required that a temperature be attained within a two-hour time limit.
 - The monitoring forms for two CCPs had multiple entries on multiple days when the monitoring was not conducted within the time frame stated in the HACCP plan.
 - An establishment's documentation for not having a CCP for zero-tolerance for the presence of fecal, ingesta, and milk on offal (cheek meat, tongues, tongue trim, hearts, and livers) in the HACCP plan, did not adequately support the decision made concerning control of the hazard.
 - The monitoring procedure for a CCP for product cooking, in the establishment's written HACCP plan, did not contain sufficient detail to determine which type of product was to be monitored by the procedures described in the document and which monitoring forms would be used.
 - An establishment did not identify the cause of a deviation and did not describe implementation of preventive measures to be taken as a result of a deviation from a CL.
 - The CL for zero-tolerance for fecal, milk and ingesta, recorded on monitoring records for a CCP, was not clearly identified and was not linked to the main-line results and the back-line results.

- Preventive measures for deviations from a CL were evaluated one time per week during the weekly evaluation process by an establishment, and not for each occurrence.
- Preshipment review records were initialed but were not signed.
- An establishment was not conducting the monitoring activities for a CCP, for the cooling of cooked roast beef as described in the HACCP plan and the monitoring procedure.
- An establishment employee recording the results for a CL for CCP, did not initial the entry at the time the specific event occurred

11.3 Testing for Generic *E. coli*

Canada has adopted the FSIS regulatory requirements for testing for generic *E. coli*.

Seventeen of the establishments audited were required to meet the basic FSIS regulatory requirements for testing for generic *E. coli* and were evaluated according to the criteria employed in the United States' domestic inspection program.

Testing for generic *E. coli* was properly conducted in the 17 slaughter establishments audited.

11.4 Testing of Ready-to-Eat Products

Canada has adopted the FSIS regulatory requirements for testing of RTE products, with the exception of the following equivalent measures:

- Establishments select samples
- Private laboratories analyze samples

Eight of the 25 establishments audited were producing RTE products for export to the United States. The following deficiency was observed:

- In one establishment, the supporting documentation reviewed did not support the use of the Alternative 2B testing program.

12. RESIDUE CONTROLS

The fourth of the five risk areas that the FSIS auditors reviewed was Residue Controls. These controls include sample handling and frequency, timely analysis, data reporting, tissue matrices for analysis, equipment operation and printouts, minimum detection levels, recovery frequency, percent recoveries, and corrective actions.

One CFIA government residue laboratory was reviewed during this audit.

- CFIA Saskatoon Meat Residues Laboratory in Saskatoon, SK

No deficiencies were observed.

13. ENFORCEMENT CONTROLS

The fifth of the five risk areas that the FSIS auditors reviewed was Enforcement Controls. These controls include the enforcement of inspection requirements and the testing program for *Salmonella*.

13.1 Daily Inspection in Establishments

Daily inspection was being conducted in all establishments audited.

13.2 Testing for *Salmonella* in Raw Product

Fifteen of the 17 slaughter establishments audited were required to meet the basic FSIS regulatory requirements for *Salmonella* testing and were evaluated according to the criteria employed in the United States' domestic inspection program.

Canada has adopted the FSIS requirements for testing for *Salmonella*, with the exception of the following equivalent measures:

- Establishments select samples
- Private laboratories analyze samples

Testing for *Salmonella* was properly conducted in the 14 slaughter establishments.

13.3 Species Verification

Species verification was conducted in all applicable establishments.

13.4 Periodic Supervisory Reviews

The periodic supervisory reviews are to be implemented as part of the QMS and performed quarterly in the eligible establishments. The QMS documentation of the periodic supervisory reviews was available only in very few establishments due to either the recent implementation or the continuing training in this process.

13.5 Inspection System Controls

The CCA had controls in place for ante-mortem and post-mortem inspection procedures and dispositions; restricted product and inspection samples; disposition of dead, dying, diseased or disabled animals; shipment security, including shipment between establishments; and prevention of commingling of product intended for export to the United States with product intended for the domestic market. Inspection system controls were not adequately in place for some inspection requirements. For example:

- One establishment received a NOID for deficiencies in implementation and documentation of SSOP; deficiencies in the design, validation and implementation of the HACCP plan; and deficiencies in SPS.
- Some CFIA and/or FSIS requirements were not enforced in 20 of the 25 establishments audited.

In addition, controls were in place for the importation of only eligible livestock from other countries, i.e., only livestock from eligible third countries and certified establishments within those countries, and the importation of only eligible meat products from other countries for further processing.

Lastly, adequate controls were found to be in place for security items, shipment security, and products entering the establishments from outside sources.

14. CLOSING MEETING

A closing meeting was held on June 25, 2008, with the CCA. At this meeting, the primary findings and conclusions were presented by the audit team.

The CCA understood and accepted the findings.

Don Carlson, DVM

Timothy King, DVM

Audit Team

Jay D. Belladonna for Don Carlson DVM
Jay D. Belladonna for Tim King DVM

15. ATTACHMENTS

Individual Foreign Establishment Audit Forms
Foreign Country Response to Draft Final Audit Report

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Maple Leaf Meats Incorporated 6355 Richmond Avenue Brandon R7A 7A3	2. AUDIT DATE 06/18/08	3. ESTABLISHMENT NO. 7	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Timothy King, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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

60. Observation of the Establishment

Date: 06/18/08 Est #: 7 (Maple Leaf Meats Incorporated [S/P]) (Brandon, Canada)

10. During operational sanitation inspection, on the loin pack off line an employees helmet and face shield was observed contacting packaging material which was then used to wrap edible product. The establishment personnel took immediate corrective action. [Regulatory reference(s): Canadian Meat Inspection Regulation (MIR) 30.1(1)(a)]

22/51. The establishment's documentation for not having a Critical Control Point (CCP) for the presence of fecal, ingesta, and milk ("zero tolerance") on offal (cheek meat, tongues, tongue trim, hearts, and livers) in the HACCP plan, did not adequately support the decision made concerning control of the hazard. [MIR 30.1(1)(a)]

39. A) During the operational sanitation inspection, water was observed dripping from pipes and overhead structures at two locations in the carcass cooler. No carcasses were present at the time of the observation. B) In the offal separation area the valve handles for the equipment sterilizers were worn and rusted, presenting the potential for cross contamination of product. The establishment personnel took immediate corrective action in both instances. [MIR 30.1(1)(a); MIR 34(1.1); MIR 34(2.1)]

61. NAME OF AUDITOR

Timothy King, DVM

62. AUDITOR SIGNATURE AND DATE



7/2/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Maple Leaf Poultry/A Member of Maple Leaf Foods 2619 - 91 Avenue Edmonton, AB T6P 1S3	2. AUDIT DATE 06/11/08	3. ESTABLISHMENT NO. 7F	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Timothy King, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Date: 06/11/08 Est #: 7F (Maple Leaf Poultry/A Member of Maple Leaf Foods [S/P]) (Edmonton, Canada)

10. During operational sanitation inspection in the cut up room before operations had started, a shovel used to handle edible product was observed with product residue from a previous day's operation on it. The establishment personnel took immediate corrective action. [Regulatory reference(s): Canadian Meat Inspection Regulation (MIR) 30.1(1)(a); MIR 34(2.1)(b); MIR 34(2.1)(f)]

19/51. In the Hazard Analysis Critical Control Point (HACCP) plan for slaughter the Critical Limit (CL), for Critical Control Point (CCP) 7B, did not adequately address the process step. [MIR 30.1(1)(a)]

22/51. These deficiencies were observed in the HACCP monitoring records: A) The monitoring form for CCP 7B had a CL range for water pressure that did not match the one written in the HACCP plan. B) The monitoring form for CCP 3B did not have an area to record the process start time when the CL required that a temperature be attained within a two hour time limit. C) The monitoring forms for CCP 5B and CCP 9B had multiple entries on multiple days when the monitoring was not conducted within the time frame stated in the HACCP plan. [MIR 30.1(1)(a)]

39/51. A) In the raw product cut up room, a walkway above a product conveyor had an opening (approximately one-half inch high) between the toe kick panels and the floor plates that could result in cross contamination when employees walked above the conveyor. B) In the product staging cooler, several loose ceiling panels were observed. [MIR 30.1(1)(a); MIR 34(2.2)]

41/51. In the carcass air chill chamber, frozen beads of condensate were observed between the rails of carcasses. [MIR 28(1)(g); MIR 37]

61. NAME OF AUDITOR

Timothy King, DVM

62. AUDITOR SIGNATURE AND DATE

Timothy King 7/2/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Elevages Perigord (1993) Incorporated 228 rue Principale St-Louis-de-Gonzague, Quebec J0S 1T0	2. AUDIT DATE 05/26/2008	3. ESTABLISHMENT NO. 37	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Slaughter/Processing, Date: 05/26/08 Est #: 37 (Elevages Perigord (1993) Incorporated [S/P] (St-Louis-de-Gonzague, Canada)

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

61. NAME OF AUDITOR

Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 05/26/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Lakeside Feeders Partnership North East 1/2, South West, Section 19; Township 19, Region 14, West 4 Brooks, AB T1R 1C6	2. AUDIT DATE 06/02/08	3. ESTABLISHMENT NO. 38	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Timothy King, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Date: 06/02/08 Est #: 38 (Lakeside Feeders Partnership [S/P]) (Brooks, Canada)

39. During the operational sanitation inspection, the following was observed: the rubber gasket on the product storage freezer door was damaged and frost accumulation was present on some of the overhead structures in the freezer, the floors in the carcass coolers and in one area of the grinding room were damaged and rough, one of the loading docks had refuse and debris present under the hydraulic floor plate, and scrap metal was stored near the building in a manner that made it a potential harborage for pests. The establishment management either took or scheduled corrective actions for all these deficiencies. [Regulatory reference(s): Canadian Meat Inspection Regulations (MIR) 30.1(1)(a); MIR 34(2); 34(2.1); MIR 34(2.2)]

46. During operational sanitation inspection, the following was observed: bottles of sanitizer and lactic acid spray were stored in the meat reconditioning sink on the cow fabrication line and the knives in a scabbard at the veterinary disposition rail had blood and residue from previous use present on them (no disposition rail outs had been performed yet that day). Establishment management or inspection personnel initiated corrective actions. [MIR 30.1(1)(a); MIR 34(2); MIR 34(2.1); MIR 34(2.2)]

61. NAME OF AUDITOR
Timothy King, DVM

62. AUDITOR SIGNATURE AND DATE

Timothy King 7/2/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Cargill Canada 165 Dunlop Drive Guelph, Ontario N1L 1P4	2. AUDIT DATE 06/13,16/2008	3. ESTABLISHMENT NO. 51	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Slaughter/Processing, Date: 06/13,16/2008 Est #: 51 (Cargill Canada [S/P/CS]) (Guelph, Canada)

- 13/51 Preventive measures for pre-operational and operational SSOP findings were not recorded for each occurrence. Preventive measures were described in the SSOP procedures as a general procedure, but were not evaluated for effectiveness. Repeated deficiencies were recorded for the same equipment for the first two weeks of April 2008 in the packaging room and the AMR, marrow bone and trim line room.
[Regulatory reference: Canadian Food Safety Enhancement Program (FSEP) Manual chapter 2, section 4.8.5]

The establishment was not verifying cleaning procedures. A third party contractor was conducting monitoring of cleaning procedures, but their process was not verified by the establishment.
[Meat Inspection Regulations (MIR) arts. 34.1, 34.2, 34.2.1 and FSEP Manual, Chapter 2, section E.1.1.]

61. NAME OF AUDITOR
Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 06/16/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Richelieu Meat Inc. 595 Rue Royale, Massueville, Quebec J0G 1K0	2. AUDIT DATE 06/04/2008	3. ESTABLISHMENT NO. 76	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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

60. Observation of the Establishment Slaughter/Cutting/Deboning, Date: 06/04/2008 Est #: 76 (Richelieu Meat Inc. []) (Massueville, Canada)
- 13/51 Preventive measures for pre-operational and operational SSOP findings were evaluated as a group for each day and not for each occurrence.
[Regulatory references: Canadian Meat Inspection Regulations (MIR) 30.1 and Food Safety Enhancement Program (FSEP) Manual, Chapter 2, section 4.8.3]
- 22/51 Preshipment review records were initialed but were not signed.
[Meat Hygiene Manual of Procedures (MOP) Chapter 11, USA section, Annex S]
- 41/51 Water was accumulating and beading under over-product structures at the final carcass wash.
[MIR art. 37 and 51]
- 46/51 Packaging material in the dry storage room was not protected from contamination and was not organized to promote and provide sanitary conditions during storage. The floor wall junctions behind packaging material were not cleaned and free of debris, e.g., dirt, grease, miscellaneous paper, cardboard, cleaning equipment and other unidentifiable material. [MIR art. 34.1 (1.1)]

61. NAME OF AUDITOR
Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 06/04/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Volaille Giannone Incorporated/Giannone Poultry In 2320 Principle St-Cuthbert, Quebec J0K 2C0	2. AUDIT DATE 05/29/2008	3. ESTABLISHMENT NO. 89	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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

60. Observation of the Establishment Slaughter/Processing Date: 05/29/2008 Est #: 89 (Volaille Giannone Incorporated/Giannone Poultry In [S/P]) (St-Cuthbert, Canada)

- 11/51 The establishment did not document the annual evaluation of their SSOP.
[Regulatory references: Canadian Meat Inspection Regulations (MIR) art. 29 (12), 30.1 and Food Safety Enhancement Program (FSEP) Manual chapter 2, section 5 (2)]
- 21/51 The establishment did not follow their written procedures for annual reassessment of their HACCP plan.
[MIR art. 29 (12), 30:1 and FSEP Manual chapter 2, section 5 (2)].
- 22/51 The establishment did not identify the cause of a deviation and implementation of preventive measures as a result of a deviation from the critical limit for CCP B11. Critical Control Point CCPB11 is the processing step where the temperatures of whole birds exiting the whole bird air chiller are monitored.
[FSEP Manual chapter 2, section 4.8.5]

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Cargill Limited 472 Avenue & Highway 2A North High River, AB T1V 1P4	2. AUDIT DATE 06/04/08	3. ESTABLISHMENT NO. 93	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Timothy King, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

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

61. NAME OF AUDITOR
Timothy King, DVM

62. AUDITOR SIGNATURE AND DATE
Timothy King 7/2/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Ecolait Limitee 1591 Chemin Ste-Claire La Plaine, Quebec J7M 1M2	2. AUDIT DATE 06/02/2008	3. ESTABLISHMENT NO. 96	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Slaughter/Cutting/Deboning Date: 06/02/2008 Est #: 96 (Ecolait Limitee []) (La Plaine, Canada)

13/51 Preventive measures for pre-operational and operational SSOP findings were evaluated one time per week during the weekly evaluation process by the establishment and not for each occurrence.

[Regulatory references: Canadian Meat Inspection Regulations (MIR) 30.1 and Food Safety Enhancement Program (FSEP) Manual, Chapter 2, section 4.8.3]

22/51 Preventive measures for deviations from a critical limit were evaluated one time per week during the weekly evaluation process by the establishment and not for each occurrence.

[Meat Hygiene Manual of Procedures (MOP) Chapter 11, USA section, Annex S]

Preshipment records were initialed but were not signed.

[MOP Chapter 11, USA section, Annex S]

46/51 An establishment employee trimming carcasses at the contamination trim stand, located at the entrance to the cutting room, was wearing a cotton glove that could not be cleaned and sanitized when contaminated.

[MIR art. 34.1 (1.1)]

46 An establishment employee working on the carcass skinning line of the slaughter floor pushed a carcass into another carcass providing contact of the skinned and un-skinned portion of both carcasses. The establishment, under CFIA supervision, took immediate and appropriate corrective action.

[MIR art. 34.1 (1.1)]

Establishment employees removing the hide from veal carcasses were grasping the hair side of the hide and then grasping the clean skinned side of the carcass without cleaning and sanitizing their mesh glove. There were no provisions for adequately cleaning and sanitizing the glove. The establishment, under CFIA supervision, took immediate and appropriate corrective action.

[MIR art. 34.1 (1.1)]

61. NAME OF AUDITOR

Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 06/02/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Tri-Pet Holdings Incorporated 70 Glen Scarlett Road Toronto, Ontario M6N 1P4	2. AUDIT DATE 06/17/2008	3. ESTABLISHMENT NO. 99	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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

60. Observation of the Establishment

Slaughter/Processing, Date: 06/17/2008 Est #: 99 (Tri-Pet Holdings Incorporated []) (Toronto, Canada)

- 10/51 Large pieces of fat and meat were attached to the surface of a continuously moving stainless steel belted evisceration table. The fat and meat pieces were observed after the cleaning and sanitation cycle. CFIA inspection officials initiated immediate and appropriate corrective action. Edible product was not saved after the deficiency was identified. [Regulatory reference: Canadian Meat Inspection Regulations (MIR) art. 56]
- 45/51 The surface of a continuously moving stainless steel belted evisceration table was not constructed to facilitate thorough cleaning and to ensure product is not adulterated during use. Stainless steel bars, positioned every 8 to 10 inches and spanning the width of the table were not secured tight to the table. There were gaps between the bars and the table which trapped meat and fat particles. These particles were not removed during the continuous cleaning and sanitizing process.
[MIR art. 56 and Food Safety Enhancement Program (FSEP) Manual chapter 2, section 2.7.2.10]

61. NAME OF AUDITOR

Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 06/17/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Supraliment S.E.C., Olymel. 25 Est, Route 125 St-Esprit de Montcalm, Quebec J0K 2L0	2. AUDIT DATE 05/30/2008	3. ESTABLISHMENT NO. 129	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Slaughter/Cutting/Deboning, Date: 05/30/2008, Est #: 129 (Supraliment S.E.C., Olymel. [S/P/CS]) (St-Esprit de Montcalm, Canada)

- 10/51 The anus and the distal portion of the large intestine were dragging on an insanitary work platform prior to being dropped into the viscera inspection trays. The employees eviscerating hog carcasses were wearing chain-link gloves which were not cleaned and could not be adequately cleaned and sanitized after contaminated viscera was handled. The establishment, under CFIA supervision, took immediate and appropriate corrective action. All affected viscera were down graded to inedible product. [Regulatory reference: Canadian Meat Inspection Regulations (MIR) art. 56]
- 13/51 Preventive measures for pre-operational and operational SSOP findings were not recorded for each occurrence. Preventive measures were described in the establishment's monthly monitoring records. [Food Safety Enhancement Program (FSEP) Manual chapter 2, section 4.8.5]
- 22/51 The critical limit for zero tolerance for fecal, milk and ingesta, recorded on monitoring records for CCP 2B, were not clearly identified and were not linked to the main line results and the back line results. [FSEP Manual chapter 2, section 4.8.5]
- 41 Condensate was observed under two cooling unit drip pans, several carcass rails and over-head structures in carcass chilling rooms number 5 and 6. The establishment, under CFIA supervision, took immediate and appropriate corrective action. No product was affected. [MIR art. 37]

61. NAME OF AUDITOR

Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 05/30/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Otter Valley Foods Incorporated 95 Spruce Street Tillsonburg, Ontario N4G 4C5	2. AUDIT DATE 06/12/2008	3. ESTABLISHMENT NO. 219	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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

60. Observation of the Establishment

Processing, No RTE, Date: 06/12/2008 Est #: 219 (Otter Valley Foods Incorporated []), (Tillsonburg, Canada)

13/51 Preventive measures were not documented in monitoring records for pre-operational and operational sanitation deficiencies.

[Regulatory reference: Canadian Food Safety Enhancement Program (FSEP) Manual chapter 2, section 4.8.5]

46/51 Packaged frozen product stored in the frozen product freezer and the research and development cage was not stored and organized to promote and provide sanitary conditions during storage.

[Meat Inspection Regulations (MIR) art. 34.1 (1.1)]

The lids of sour cream containers stored in the frozen product freezer were not sealed and the contents were exposed to an insanitary environment.

[MIR art. 34.1 (1.1)]

Liquid ingredient containers stored in the dry storage room were contaminated on the tops and sides with residues of the contents of the container.

[MIR art. 34.1 (1.1)]

The outside surfaces of employee's boots in the men's and women's locker rooms were coated with residues of product from the previous day's production. This area is a common area for employees that work in raw, cooked and finished product areas.

[MIR art. 34.1 (1.1)]

61. NAME OF AUDITOR

Don Carlson, DYM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DYM 06/12/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Olymel S.E.C./Olymel L.P. 7550-40th Avenue Red Deer T4N 6R7	2. AUDIT DATE 06/09/08	3. ESTABLISHMENT NO. 270A	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Timothy King, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Date: 06/09/08 Est #: 270A (Olymel S.E.C./Olymel L.P. [S/P]) (Red Deer, Canada)

15/51. During the review of the Hazard Analysis Critical Control Point (HACCP) plan for offal production no Critical Control Point (CCP) for monitoring of the product for the presence of feces, ingesta, or milk (Zero Tolerance) was included and there was insufficient supporting documentation to justify the establishment decision not to have a Zero Tolerance CCP for this product. [Regulatory reference(s): Canadian Meat Inspection Regulations (MIR) 30.1(1)(a)]

22/51. The pre-shipment review form for the Slaughter HACCP plan CCP#2, carcass temperature, did not include the full signature of the person verifying that the record was complete, all critical limits had been met, or all corrective actions associated with a deviation from a critical limit had been performed. [MIR 30.1(1)(a)]

52. During the operational sanitation inspection, it was observed that no meter was visible to determine the voltage of the electric prods used by establishment employees moving the animals along the single file chute to the stunner. When establishment maintenance personnel were summoned and tested the voltage of the prods it exceeded the fifty volt maximum allowed by regulation. The CFIA inspection personnel and establishment management took immediate control and corrective actions. [Canadian MIR 62(1)]

61. NAME OF AUDITOR

Timothy King, DVM

62. AUDITOR SIGNATURE AND DATE

Timothy King 7/2/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Maple Leaf Meats Incorporated 2525 Avenue Francis-Hughes Laval, Quebec H7S 2H7	2. AUDIT DATE 06/05/2008	3. ESTABLISHMENT NO. 271B	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Further Processing Date: 06/05/2008 Est #: 271B (Maple Leaf Meats Incorporated [PI]) (Laval, Canada)

13/51 A contract company, retained by the establishment, was conducting monitoring of the application of cleaning procedures for the establishment. The establishment's quality control personnel were not verifying the contracting company's monitoring procedures.

[Regulatory references: Canadian Meat Inspection Regulations (MIR) arts. 34.1, 34.2, 34.2.1 and Food Safety Enhancement Program (FSEP) Manual, Chapter 2, section E.1.1.]

22/51 The establishment was not conducting the monitoring activities for CCP 5B for the cooling of cooked roast beef as described in the HACCP plan and the monitoring procedure. When the product was moved from the blast chilling room to the refrigerated cold room, the recording of the CCP time-temperature requirement on the monitoring records was not as described in the written procedures.

[MIR art. 30.1 and FSEP Manual, Chapter 2, section 4.8.2]

61. NAME OF AUDITOR

Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 06/05/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION 9020-2516 Quebec Incorporated Volalles Marvid Poultry 5671 Boulevard Industriel Montreal Nord, Quebec H1G 3Z9	2. AUDIT DATE 06/03/2008	3. ESTABLISHMENT NO. 274	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment Slaughter/Processing, Date: 06/03/2008 Est. #: 274 (9020-2516 Quebec Incorporated [S/P]) (Montreal Nord, Canada)

- 13/51 Preventive measures for pre-operational and operational SSOP findings were not identified in establishment records.
[Regulatory references: Canadian Meat Inspection Regulations (MIR) 30.1 and Food Safety Enhancement Program (FSEP) Manual, Chapter 2, section 4.8.3]
- 22/51 Preshipment review records were initialed but were not signed.
[Meat Hygiene Manual of Procedures (MOP) Chapter 11, USA section, Annex S]
- Calibration records were available, but the establishment did not have a written calibration procedure for the thermometers used to measure the critical limit for CCP B7.
[MIR 29.12 and FSEP Manual, Chapter 2, section C.1.2]
- 41 Condensate was observed under over-product structures in the processing room. Areas of condensation were located over product contact surfaces, product containers and employee walk ways.
[MIR art. 37]
- 46/51 The maintenance room, box make-up room and the packaging storage room was not organized to promoted sanitary conditions. The floor wall junctions behind packaging material were not cleaned and free of debris, e.g., dirt, grease, miscellaneous paper, cardboard, metal scraps and other unidentifiable material. The floor of the maintenance room, box make-up room and the packaging storage room were not cleaned and free of debris, dirt, grease, paper, cardboard and other unidentifiable material.
[MIR art. 34.1]

61. NAME OF AUDITOR

Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 06/03/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Inovata Foods 12803 - 149 Street Edmonton T5L 2J7	2. AUDIT DATE 06/10/08	3. ESTABLISHMENT NO. 302	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Carlson/King		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Date: 06/10/08 Est #: 302 (Inovata Foods [P]) (Edmonton, Canada)

10/22. During operational sanitation inspection, an employee was observed handling the outside of non-meat ingredient containers and then contacting edible product without first sanitizing his hands. CFIA inspection personnel took control actions and establishment management initiated immediate corrective actions. [Regulatory reference(s): Canadian Meat Inspection Regulation (MIR) 30.1(1)(a); MIR 34(2.1)(f)]

11/51. During review of the Sanitation Standard Operating Procedures (SSOP) it was observed that: A) The cleaning procedures documents did not state the frequency at which the cleaning procedures would be performed. B) Preventive measures were required to be documented only if the unsatisfactory condition repeated on two consecutive occasions. [MIR 30.1(1)(a); MIR 34(2.1)(b)]

13/51. During review of operational sanitation records, it was observed that the daily operational sanitation procedures described in the SSOP did not match what was listed on the daily monitoring forms. [MIR 34(2); MIR 34(2.1)(f)]

21/51. During review of the Hazard Analysis Critical Control Point (HACCP) plan, it was observed that: A) The product process step for cooling of product was not listed as a Critical Control Point (CCP) and insufficient documentation was available to support the decision not to have cooling as a CCP. B) The Critical Limits for CCP 2B (sauce holding) did not include a time limit and did not adequately describe which critical limits applied to which types of sauce (e.g. high acid sauce or low acid sauce). C) There was insufficient documentation to support the decision to place the RTE products in the Alternative 2 category described in 9 CFR 430. [MIR 30.1(1)(a)]

22. During the review of the current day's monitoring records for CCP 3P (metal detection), it was observed that no entry had been recorded for one of the required hourly monitoring checks. CFIA inspection personnel took immediate control action. [MIR 30.1(1)(a)]

39/51. A) Plastic wheeled carts used in the pack off room had rough, damaged surfaces made them difficult to clean and sanitize. The floor in the pack off room was also cracked, rough, and worn in multiple areas. The establishment management scheduled these items for replacement or repair. B) In the dry storage area, the aisle between the dry ingredients storage shelves was filled with pallets and packaging materials which interfered with the ability to perform inspection. [MIR 30.1(1)(a); MIR 34(2.1)(f)]

44/51. An accumulation of dust, litter, and debris was observed on the floor and under the lockers in the employee welfare areas during the operational sanitation inspection. [MIR 34(2.1)(f)]

58. Inspection officials of Canada issued to establishment management a Notice of Intent to Delist (NOID) if the deficiencies identified during this audit are not corrected within 30 days from the time of issuance.

61. NAME OF AUDITOR

Carlson/King

62. AUDITOR SIGNATURE AND DATE

[Handwritten Signature] 7/2/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Cappola Food Incorporated 25 Lepage Court Toronto, Ontario M3J 3M3	2. AUDIT DATE 06/20/2008	3. ESTABLISHMENT NO. 327	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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

60. Observation of the Establishment

Further Processing, Date: 06/20/2008 Est #: 327 (Cappola Food Incorporated []) (Toronto, Canada)

- 22/51 The establishment was not conducting monitoring activities for CCP F2, the cooling of cooked pork, as described in the HACCP plan and the monitoring procedure. The product was to be cooled from 49°C to 4°C within 20 hours prior to packaging. Monitoring records documented the critical limit for some processes exceeded the 20 hour requirement at packaging. Time and temperature continuous recording records indicated that the process was under control, but this was not described as the official record for the measurement of the critical limit for CCP F2
[Regulatory references: Canadian Meat Inspection Regulations (MIR) art. 30.1 and Food Safety Enhancement Program (FSEP) Manual, Chapter 2, section 4.8.2]
- 46/51 The outside surfaces of employee's work boots in the men's locker room were coated with residues of product from the previous day's production. One boot had raw meat residue in the cleats of the bottom of the boot. This area is a locker room for employees that work in the cooked and fermented ready-to-eat production areas.
[CFIA MIR art. 34.1 (1.1)]

61. NAME OF AUDITOR

Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 06/20/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Santa Maria Foods Corporation 353 Humberline Drive Toronto, Ontario M9W 5X3	2. AUDIT DATE 06/19/2008	3. ESTABLISHMENT NO. 340	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Further Processing, Date: 06/19/2008 Est #: 340 (Santa Maria Foods Corporation [P]) (Toronto, Canada)

- 13/51 Preventive measures were not documented in the monitoring records for pre-operational sanitation deficiencies.
[Regulatory reference: Canadian Food Safety Enhancement Program (FSEP) Manual chapter 2, section 4.8.5]
- 22/51 On-site and records verification was not conducted as described in the establishment's HACCP plan for the critical limit for water activity, CCP 3B.
[FSEP Manual chapter 2, section 4.8.5]

Preshipment review records were initialed but were not signed.
[Meat Hygiene Manual of Procedures (MOP) Chapter 11, USA section, Annex S]

61. NAME OF AUDITOR

Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 06/19/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION XL Foods Incorporated 5101 - 11th Street South East Calgary, AB T2H 1M7	2. AUDIT DATE 05/30/08	3. ESTABLISHMENT NO. 401	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Timothy King, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Date: 05/30/08 Est #: 401 (XL Foods Incorporated [S/P]) (Calgary, Canada)

10/51. A) During pre-operational sanitation inspection, the following were observed: a piece of duct tape was wrapped around the hose of the hock sterilizer, a tuft of hair on the support for the carcass skinning rail, blood and residue on the tension adjustment knob for the employee safety wire, and surplus pipes filled with blood and dirt on the floor near the hide puller. Establishment management initiated immediate corrective actions. B) During review of the establishment Sanitation Standard Operating Procedures (SSOP) monitoring records, it was observed that the contracted cleaning service's supervisor had not documented an onsite verification of the sanitary conditions during the first quarter of calendar year 2008 as required in the Sanitation SOP plan. [Regulatory reference(s): Canadian Meat Inspection Regulation (MIR) 30.1(1)(a); MIR 34(2.1)(b)]

22/51. During review of the monitoring record for the slaughter Critical Control Point #1 (Age determination), it was observed that the process monitor was not entering the observed data on the record as it was prescribed on the monitoring form (e.g. the word cows was entered in the field prescribed for the carcass number or the time the monitoring was performed). [MIR 30.1(1)(a)]

61. NAME OF AUDITOR
 Timothy King, DVM

62. AUDITOR SIGNATURE AND DATE

Timothy King 7/2/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Atlantic Beef Products 95 Train Station Road Albany, Prince Edward Island COB 1A0	2. AUDIT DATE 06/10/2008	3. ESTABLISHMENT NO. 443	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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

60. Observation of the Establishment

Slaughter/Processing, Date: 06/10/2008 Est #: 443 (Atlantic Beef Products [S]) (Albany, Canada)

- 15/51 The number of sample units to be measured for CCP 2, 3, and 4 were not described in the establishment's HACCP plan or the monitoring procedures.
[Regulatory reference: Canadian Food Safety Enhancement Program (FSEP) Manual chapter 2, section 4.8.5]
- 22/51 The establishment employee recording the results for the critical limit for CCP 8, did not initial the entry at the time the specific event occurred.
[FSEP Manual chapter 2, section 4.8.5]
- 39/51 Expandable foam insulation was located on a wall/beam junction above the entrance into the carcass drip cooler. The insulation was not covered.
[Meat Inspection Regulations (MIR) art. 34.1 and FSEP Manual, Chapter 2, Section 2.2.1]
- 41 Condensate was observed on the carcass rail and carcass rail flap above the entrance into the carcass drip cooler.
[MIR art. 37 and 51]

61. NAME OF AUDITOR
Don Carlson, DYM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DYM 06/10/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Abattoir St-Germain Incorporated 195 rue Messier St-Germain, Quebec J0C 1K0	2. AUDIT DATE 05/27/2008	3. ESTABLISHMENT NO. 454	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Don Carlson, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Slaughter, Date: 05/27/2008 Est #: 454 (Abattoir St-Germain Incorporated [S]) (St-Germain, Canada)

13/51 The establishment did not have personnel training procedures for the reconditioning of veal carcasses that had fallen onto the slaughter room floor. [Regulatory references: Canadian Meat Inspection Regulations (MIR) art. 29 (12), 57 and Meat Hygiene Manual of Procedures (MOP) 4.7.4 (8)]

61. NAME OF AUDITOR

Don Carlson, DVM

62. AUDITOR SIGNATURE AND DATE

Don Carlson, DVM 05/27/2008

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Britco Pork, Inc. 22940 Fraser Highway Langley, BC V2Z 2T9	2. AUDIT DATE 05/27/08	3. ESTABLISHMENT NO. 513	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Carlson/King		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

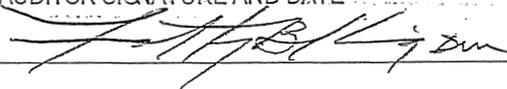
Date: 05/27/08 Est #: 513 (Britco Pork, Inc. [S/P]) (Langley, Canada)

10/51. A) During operational sanitation inspection in cooler #4, condensate was observed dripping from a refrigeration supply line onto a carcass hanging below it. Establishment management implemented immediate corrective action. B) During operational sanitation inspection in cooler #3, a carcass fell from the rail onto the cooler floor. The carcass was controlled according to the establishment's dropped product SOP but the employee who picked up the carcass failed to sanitize his gloves before touching other carcasses in the cooler. CFIA inspection personnel initiated a control action on the affected carcasses. [Regulatory reference(s): Canadian Meat Inspection Regulation (MIR) 30.1(1)(a)]

61. NAME OF AUDITOR

Carlson/King

62. AUDITOR SIGNATURE AND DATE

 7/2/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Les Aliments Tiffany Gate Foods Incorporated 195 Steinway Boulevard Toronto M9W 6H6	2. AUDIT DATE 06/20/08	3. ESTABLISHMENT NO. 600	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Timothy King, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Date: 06/20/08 Est #: 600 (Les Aliments Tiffany Gate Foods Incorporated [P]) (Toronto, Canada)

12. The Sanitation Standard Operating Procedures corrective actions did not include documented preventive measures when a deviation was observed. This finding had been noted on a Corrective Action Report issued by the CFIA inspector but no response from the establishment had been documented. [Regulatory reference(s): Canadian Meat Inspection Regulation (MIR)30.1(1)(a)]

22/51. The monitoring procedure for Critical Control Point (CCP) 5b, product cooking, in the establishment's HACCP plan did not contain sufficient detail to determine which type of product was to be monitored by the procedures described in the document and which monitoring forms would be used. [MIR 30.1(1)(a)]

39. During the operational sanitation inspection, water was observed leaking through a wall in the non-meat food ingredients storage room, dust and debris was observed on the floor and on cartons in the packaging storage area, and the air lock/seal for trucks at the receiving dock did not close tightly enough to prevent the entrance of pests into the establishment. [MIR 30.1(1)(a); MIR 34(1.1); MIR 34(2.1)]

61. NAME OF AUDITOR
Timothy King, DVM

62. AUDITOR SIGNATURE AND DATE

Timothy King DVM 7/2/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION MFI Food Canada Ltd; dba Inovatech Egg Products 70 Irene Street Winnipeg, MB R3T 4E1	2. AUDIT DATE 06/17/08	3. ESTABLISHMENT NO. E22	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Timothy King, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT

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

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

60. Observation of the Establishment

Date: 06/17/08 Est #: E22 (MFI Food Canada Ltd; dba Inovatech Egg Products [PJ] (Winnipeg, Canada)

36. During the review of records for instrument calibration, the establishment program stated that the thermometer for the egg whites dryer would be calibrated semi-annually, the records for these thermometers documented that the calibration had only been performed once a year for the two previous years. [Regulatory reference(s): Canadian Processed Egg Regulations CRC 290 Part II, sec. 6(2)(c)]

39. A) During Sanitation Inspection, an overhead door in the finished product loading area was not sealed sufficiently to exclude the entry of insects or rodents into the establishment. B) The concrete curbing in the pail washing room had one corner that was broken and deteriorated. Establishment management and CFIA personnel took immediate corrective actions. [CRC 290 Part II, sec. 7(2)(a); Part II, sec. 7(2)(d); Part II, sec. 8(14)]

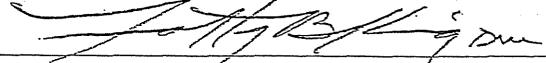
45. During Sanitation Inspection, in the egg tray washing area several egg trays that had exited the tray washer and were being stacked for reuse had egg residue and shell fragments on them. CFIA personnel took immediate control action. [CRC 290 Part II, sec. 8(2)]

46. During Sanitation Inspection, an employee at the egg scanner/candler was observed breaking rejected eggs on the side of the edible egg conveyor creating the potential for cross contamination. [CRC 290 Part II, sec. 8(2)]

61. NAME OF AUDITOR

Timothy King, DVM

62. AUDITOR SIGNATURE AND DATE

 7/2/08

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Vanderpol's Eggs Ltd 3911 Mount Lehman Road Abbotsford, BC V4X 2N1	2. AUDIT DATE 05/28/08	3. ESTABLISHMENT NO. E66VANDERPOLSE	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Timothy King, DVM		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
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10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
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Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
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Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	X
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	
24. Labeling - Net Weights		52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic E. coli Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	Part G - Other Regulatory Oversight Requirements	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment

Date: 05/28/08 Est #: E66VANDERPOLSEGGSLTD (Vanderpol's Eggs Ltd [P]) (Abbotsford, Canada)

38. During the sanitary operations inspection, insects were observed in the product receiving dock and the overhead door to the receiving dock was not completely closed to exclude the entry of pests into the establishment. The establishment management took immediate corrective actions. [Regulatory reference(s): Canadian Processed Egg Regulations, CRC 290 Part II, sec. 7(2)(d); Part II, sec. 8(14)]

41. In the pail filling/packaging room, water was observed dripping from an overhead platform onto the floor of an area transited by production employees. Immediate corrective action was taken by establishment management. [CRC 290 Part II, sec. 6(2)(b)(iii); Part II, sec. 8(2)]

46. A) During sanitary operations inspection, an employee was observed cracking eggs rejected during candling on the edge of the candling hood before dropping them into the inedible container, creating an insanitary condition that could cross contaminate edible product. The establishment management took immediate corrective actions. B) The employee closing the filled pails of egg products was using a plastic mallet that was stored on top of the scale readout panel and handled in a manner that could lead to cross contamination of product. [CRC 290 Part II, sec. 6(2)(b)(iii); Part II, sec. 8(2)]

61. NAME OF AUDITOR

Timothy King, DVM

62. AUDITOR SIGNATURE AND DATE

Timothy King DVM 7/2/08



Canadian Food Inspection Agency Agence canadienne
d'inspection des aliments

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K1A 0Y9

NOV 06 2008

Mr. Donald Smart
Director, International Audit Staff
Office of International Affairs – FSIS
1299 Farnam Street, Suite 300
Omaha, NE 68102

**SUBJECT: Response to Draft Final Report of an audit carried out in Canada
From May 20 to June 25, 2008**

Dear Mr. Smart:

Thank you for your letter of September 8, 2008 to Dr. F. Moulin, Acting Director, Meat Programs Division (MPD), Canadian Food Inspection Agency (CFIA), the accompanying copy of the Draft Final Report of an audit carried out in Canada during the period of May 20 to June 25, 2008 and the opportunity to provide comments on the report.

Foreign audit reports are welcomed as an additional source of information for the CFIA to assess the performance of Canada's meat inspection system and to contribute to our objective for continuous improvement.

With respect to the one establishment which received a "30 Day Notice of Intent to Delist" (NOID), you have acknowledged receipt of our letter of verification that corrective actions had been taken within the prescribed time frame. The action plan was accepted by FSIS and no further action was requested.

There were appropriate follow-up actions to the specific establishment deficiencies identified by the reports. They were corrected either immediately or are being corrected through the implementation of action plans. HACCP-related deficiencies have been addressed based on the revisions made to the FSEP manual, the survey on CVS-task delivery in establishments, and the implementation of the Group IV HACCP System Reassessment and Design tasks of the CVS.

CFIA officials present during the on-site audit and during the exit meeting did not challenge any of the individual observations made by the USDA/FSIS auditors.

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Canada

Therefore there is agreement with the content of the FSIS Country Audit Summary for Canada. There were no issues identified with the interpretations of CFIA policy as described by the report.

Should you wish to further discuss the above, please do not hesitate to contact me at (613) 221-1448 or at Richard.arsenault@inspection.gc.ca.

Yours sincerely,

A handwritten signature in dark ink, appearing to read 'R. Arsenault', is written over a faint horizontal line.

Richard Arsenault
Director
Meat Programs Division