

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, DC

FSIS DIRECTIVE	6500.1	2/1/17
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**NEW POULTRY INSPECTION SYSTEM: POST-MORTEM INSPECTION AND
VERIFICATION OF READY-TO-COOK REQUIREMENT**

CHAPTER I – GENERAL

I. PURPOSE

A. This directive provides instructions to inspection program personnel (IPP) on how to perform online and offline post-mortem inspection procedures at poultry slaughter establishments operating under the New Poultry Inspection System (NPIS) and how to verify that those establishments operating under the NPIS are producing ready-to-cook (RTC) poultry. This directive includes information previously issued in FSIS Notice 37-15, 38-15 and 39-15 and reflects askFSIS questions.

B. IPP are to continue to follow instructions on how to perform ante-mortem inspection procedures and verify Good Commercial Practices (GCP) according to instructions in [FSIS Directive 6100.3](#), *Ante-Mortem and Post-Mortem Poultry Inspection*.

KEY POINTS:

- *How to perform online and offline post-mortem inspection procedures at young chicken and turkey slaughter establishments operating under the New Poultry Inspection System (NPIS)*
- *How to perform verification procedures for Ready-to-Cook requirements at young chicken and turkey slaughter establishments operating under NPIS*
- *How to use new Public Health Information System (PHIS) tasks: Poultry NPIS Zero Tolerance Food Safety Verification task and Poultry Ready-to-Cook task. (Poultry Finished Product Standards and Poultry Zero Tolerance Verification tasks are not used in NPIS establishments).*
- *Instructions when carcass inspector finds fecal contamination or Septicemia or Toxemia (Sep/Tox) and the establishment's Critical Control Point (CCP) or other monitoring is located after or before the carcass inspector*
- *Clarifies regulatory citation for verifying pre-requisite program corrective actions is 9 CFR 417.5(a)(1); and adds that 9 CFR 381.83, 381.65(f) and 381.76(b)(6)(ii)(C) are cited each time the Poultry NPIS Zero Tolerance Food Safety Verification task is marked as "Inspection Completed" in PHIS.*

DISTRIBUTION: Electronic

OPI: OPPD

II. BACKGROUND

A. On August 21, 2014, FSIS published a final rule to modernize poultry slaughter inspection (see *Modernization of Poultry Slaughter Inspection*, [79 FR 49565](#)). The rule went into effect on October 20, 2014. The final rule established a new inspection system called NPIS for the inspection of young chickens, and all turkeys. NPIS is in addition to, not a replacement for, the current Streamlined Inspection System (SIS), New Line Speed Inspection System (NELS), New Turkey Inspection System (NTIS), or Traditional Inspection system. Establishments that slaughter classes of poultry other than young chickens and turkeys may request a waiver of slaughter regulations in accordance with the *Salmonella* Initiative Program (SIP) ([76 FR 41186](#) July 13, 2011) in order to operate under NPIS. The effective date of the new requirements is the date the establishment starts to operate under NPIS.

CHAPTER II - POST-MORTEM INSPECTION AND OFFLINE VERIFICATION UNDER NPIS

I. ONLINE AND OFFLINE CONSUMER SAFETY INSPECTOR DUTIES

A. One Consumer Safety Inspector (CSI) is assigned to perform online carcass inspection (CI) duties, and one CSI is assigned to offline verification inspection (VI) duties for each evisceration line. CSIs are to rotate equally between the VI and CI positions, and work together with the Public Health Veterinarians (PHVs) to ensure that poultry products leaving the slaughter line are safe and wholesome. Inspectors assigned to establishments operating under NPIS are trained to perform both CI and VI duties.

B. The CI duties include a continuous online inspection of each carcass at a fixed location before the chiller with a focus on food safety to determine whether each carcass is not adulterated. Online CSIs are presented with carcasses that have been sorted, trimmed, and reprocessed by establishment employees, and thus CSIs are to focus on identifying carcasses affected with food safety conditions.

C. The VI duties are to monitor and evaluate establishment process controls and verify that establishments follow good commercial practices (GCP). CSIs perform offline activities throughout the slaughter area and along the evisceration and picking lines to verify compliance with Sanitation Standard Operating Procedures (Sanitation SOPs), Sanitation Performance Standards (SPS), HACCP regulatory requirements, and GCPs.

D. The VI duties also include conducting verification checks of carcass samples collected just before the CI station to ensure that the establishment is effectively sorting carcasses and producing products that comply with the Agency's zero visible fecal tolerance and other performance standards.

II. ONLINE POST-MORTEM INSPECTION UNDER NPIS

A. The online CSI is stationed on the production line at a fixed point before the chiller and after the establishment has completed all sorting, trimming, and reprocessing activities as required by 9 CFR 381.76(b)(6)(ii)(A).

B. The online CSI is to visually inspect each carcass to determine whether the carcass is adulterated either because of a food safety condition or other condition such as generalized Inflammatory Process (IP) that warrants condemnation of the entire carcass. The CSI is to follow procedures listed below in paragraph D. of this section to condemn carcasses affected with condemnable conditions. If the CSI is unable to determine whether the entire carcass is condemnable, the CSI is to direct the establishment to hang back the carcass for PHV disposition.

C. If the online CSI identifies a carcass with food safety defects, i.e., a carcass contaminated with feces or with septicemia or toxemia (Sep/Tox), the CSI is to:

1. Stop the evisceration line and direct the establishment to hang back the affected carcass for condemnation or reprocessing as applicable;
2. Restart the line once the carcass is removed from the evisceration line;
3. Write a Noncompliance Record (NR) after rotating to the offline VI assignment if the establishment's CCP or other monitoring to prevent carcasses with food safety defects from entering the chiller is located before the CI station.
 - a. The CSI is to use the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task to document finding a Sep/Tox carcass or a carcass contaminated with fecal material.
 - b. If the CSI finds a Sep/Tox carcass she or he is to describe the carcass, state that the establishment is not preventing carcasses with septicemic and toxemic conditions from entering the chiller, and cite 9 CFR 381.76(b)(6)(ii)(C) and 381.83 on the NR.
 - c. If the CSI finds a carcass with visible fecal contamination she or he is to describe the fecal contamination, state that the establishment is not preventing carcasses with fecal material from entering the chiller, and cite 9 CFR 381.65(f) and 381.65(g) on the NR.
 - d. The CSI is to verify the establishment's corrective actions as described for offline verification in Chapter II. Section III. D. 6.
4. Do not write a NR if the establishment's CCP or other monitoring to prevent carcasses contaminated with food safety defects from entering the chiller is located after the CI station. Instead the PHV or designee is to notify the establishment management and perform applicable PHIS tasks based on where the establishment has incorporated its written procedures into its HACCP system to verify that:
 - a. The establishment has written procedures and is meeting the requirement to prevent fecal contamination and enteric pathogens throughout the slaughter process (9 CFR 381.65(g)) as described in [FSIS Directive 6420.5](#) *Verifying Poultry Slaughter Establishments Maintain Adequate Procedures for Preventing Contamination with Feces and Enteric Pathogens* and,
 - b. The establishment has written sorting procedures and its sorting activities, disposing of carcasses and parts are in control to meet 9 CFR 381.76(b)(6)(ii) requirements.
5. Instructions for recording the number of carcasses with fecal contamination by the online CSI on the FSIS Form 6000-36 are described in Chapter III Section V Forms Documentation.

D. If the online CSI identifies a carcass affected with non-food safety animal disease condition that warrants condemnation of the entire carcass, he or she is to stop the line and direct the establishment to hang back the carcass for condemnation. The CSI is to condemn carcasses that clearly exhibit condemnable conditions. Criteria for carcass condemnation are found in the following regulations and other criteria in this directive:

1. Tuberculosis (9 CFR 381.81);
2. Skin leukosis (9 CFR 381.82);

3. Air sacculitis (generalized) (9 CFR 381.84);
4. Inflammatory Process (generalized) (9 CFR 381.86);
5. Parasites (infestation or show lesions of infestation) (9 CFR 381.88);
6. Tumors that have spread (metastasized) or affected the carcass due to its size, position or nature (9 CFR 381.87) and keratoacanthoma tumors that have coalescing tumors (9 CFR 381.87);
7. Bruises (generalized) (9 CFR 381.89);
8. Cadavers (9 CFR 381.90);
9. Mutilation (excessive) 9 CFR 381.91(a);
10. Overscald (excessive) 9 CFR 381.92;
11. Turkey Osteomyelitis Complex (TOC) (if evidence of general systemic disturbance) 9 CFR 381.86; and
12. Certain other conditions, that if generalized to the extent that the carcass cannot be trimmed or salvaged, the entire carcass is to be condemned by the CSI.

E. The online CSI is to stop the line and direct the establishment to hang back any uneviscerated (not drawn) carcasses that are presented for inspection for PHV disposition. The PHV is to further evaluate whether the establishment is effectively sorting carcasses.

NOTE: If the online CSI identifies a dead-on-arrival (DOA) carcass (9 CFR 381.71(a)), the CSI is to stop the line and direct the establishment management to hang back the carcass for condemnation. The CSI is to restart the line after the carcass is removed from the line. The CSI is to notify the PHV or designee to verify that the establishment's controls for preventing DOAs from entering the establishment are effective. (See [FSIS Directive 6100.3.](#))

F. The online CSI is to record the number of non-food safety carcasses that the CSI condemns online but not the cause of condemnation, on the FSIS Form 6000-36 as described in Chapter III Section V. Forms Documentation.

G. Presentation: The online CSI is to notify the PHV or designee when the CSI believes that a carcass-by-carcass inspection cannot be adequately performed within the time available because of the manner in which the birds are being presented to the CSI, or because of factors that may indicate a loss of process control, such as persistent, unattended defects. The CSI is to be aware that proper presentation of carcasses under the NPIS is described in 9 CFR 381.76 (b)(6)(iii) and requires that:

1. Each carcass, except carcasses and parts identified as "major portions" under 9 CFR 381.170 (b) (22), must be held by a single shackle;
2. Both hocks (when available) of each carcass are held by the shackle;
3. The back side of the carcass must face toward the inspector; and
4. There must be minimal carcass swinging motion.

H. The online CSI is to notify the PHV or designee if the CSI observes persistent, unattended non-food safety trim and processing defects on carcasses.

1. Persistent trim and processing defects means the defect(s) on carcasses continue to occur repetitively; and
2. Unattended means the establishment has been given the opportunity to respond to persistent defects and has not effectively corrected the problem.
3. Follow instructions in Chapter IV of this directive to verify the Ready-to-Cook requirement.

III. OFFLINE VERIFICATION INSPECTION UNDER NPIS

A. The offline CSI conducts offline food safety related verification inspection activities to verify that an establishment complies with regulatory requirements in the HACCP system in accordance with [FSIS Directive 5000.1](#), *Verifying an Establishment's Food Safety System*. The HACCP system includes the HACCP Plans and Sanitation SOPs or other prerequisite programs.

B. The offline CSI is to verify that the establishment has developed written procedures to prevent carcasses with visible fecal contamination from entering the chiller and has incorporated them into its HACCP system and is to document any noncompliance. See [FSIS Directive 6420.5](#).

C. The offline CSI is to verify that the establishment has developed written procedures for preventing carcasses with Sep/Tox from entering the chiller and has incorporated the procedures into its HACCP system and is to document any noncompliance.

D. Verification of Food Safety: The offline CSI is to verify that food safety hazards, i.e., Sep/Tox carcasses (9 CFR 381.83) and carcasses with fecal contamination (9 CFR 381.65(f)), are prevented from entering the chiller by examining sets of 10 carcasses using the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task.

1. Each day, the offline CSI is to conduct eight 10 bird carcass checks (that is, a 10 bird check each hour) for each evisceration line for every shift. In large establishments with many eviscerating lines the PHV may schedule random times for each CSI.
2. The offline CSI is to conduct food safety checks by randomly selecting 10 carcasses just before the CI station and examining them offline to verify that the establishment's process produces product free of visible fecal and Sep/Tox contamination before the chiller.
3. The CSI is to examine each 10-bird sample set at the prechill offline VI station to identify feces according to the identification guidelines for feces (see Attachment 1) and is to identify Sep/Tox carcasses according to disposition criteria in 9 CFR 381.83. The CSI is to use the following inspection procedure to examine each carcass.
 - a. Outside back: While holding the carcass, with the back of the carcass toward the inspector and starting at the hock area, observe the hocks, back part of the legs, tail area, back of the carcass, and top side of the wings;
 - b. Outside Front. Turn the carcass and observe the bottom side of the wings, breast, and front part of the legs;

- c. Inside: Observe the inside surfaces of the carcass and the abdominal flaps and fat; and
 - d. Neck Flap Area: Observe the neck flap and the thoracic inlet area.
4. If the offline CSI performs the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task and does not observe fecal material or Sep/Tox contamination on any of the carcasses, she or he is to indicate compliance was verified with 9 CFR 381.76(b)(6)(ii)(C), 381.83 and 381.65(f) in PHIS and mark the task as "Inspection Completed" each time the task is performed.
 5. If the offline CSI detects food safety conditions on any of the 10 birds in a set, she or he is to notify the establishment of the noncompliance with 9 CFR 381.65(f) or with 9 CFR 381.83 and 381.76(b)(6)(ii)(C) and complete the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task by writing an NR. An NR is written regardless of where the establishment has located its CCP or other monitoring to meet these requirements.
 - a. If the CSI finds fecal material on one or more carcasses, she or he is to describe the fecal material and state on the NR that the establishment has failed to prevent carcasses with fecal material from entering the chiller and cite 9 CFR 381.65(f).
 - b. If the CSI finds signs of Sep/Tox in one or more carcasses, she or he is to describe the carcass and state on the NR that the establishment has failed to prevent Sep/Tox carcasses from entering the chiller and cite 9 CFR 381.83 and 9 CFR 381.76(b)(6)(ii)(C).
 - c. If the CSI finds fecal material on one or more carcasses and one or more Sep/Tox carcasses in the same 10-bird sample, she or he is to document a NR and cite 9 CFR 381.65(f), 381.83, and 381.76(b)(6)(ii)(C).
 6. After notifying the establishment of the noncompliance, the offline CSI is to verify that the establishment's corrective actions are effective.
 - a. If the establishment's written procedures are incorporated into its HACCP plan, then the CSI is to perform the PHIS Slaughter HACCP Verification task to verify that the corrective actions meet the requirements of 9 CFR 417.3(a).
 - b. If the establishment's written procedures are incorporated into its Sanitation SOP, then the CSI is to perform the PHIS Operational Sanitation SOP Review and Observation task to verify that the corrections meet the requirements of 9 CFR 416.15.
 - c. If the establishment's written procedures are incorporated into another prerequisite program, then the CSI is to perform the PHIS Slaughter HACCP Verification task to verify that the corrective actions meet the requirements of 9 CFR 417.5(a)(1).

E. The offline CSI is to condemn any Sep/Tox carcasses found on the 10 bird verification check and record the number condemned, but not the cause of condemnation, on the FSIS Form 6000-36 as described in Chapter III Section V Forms Documentation.

F. Verification of Non-food Safety Animal Disease: If the offline CSI observes carcasses affected with non-food safety animal disease conditions that warrant condemnation of the entire carcass during the performance of the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task, she or he is to follow the instructions below.

1. The CSI is to condemn the carcass and record the condemnation on the FSIS Form 6000-36 described in Chapter III Section V. Forms Documentation, The CSI is to retain the affected carcass for veterinary disposition if she or he has a question as to whether the entire carcass is condemnable.
2. If the CSI finds more than two carcasses in the 10 bird set with a disease condition warranting condemnation of the entire carcass, then the CSI is to write an NR and use the appropriate PHIS task according to the location in the establishment's HACCP system where the establishment has elected to include its sorting procedures (9 CFR 381.76(b)(6)(ii)(C)).
3. On the NR, the CSI is to describe observations of the disease condition warranting condemnation of the entire carcass, citing the appropriate regulation for the disease condition. The CSI is also to cite 9 CFR 381.76(b)(6)(ii)(A) and state that the establishment did not dispose of carcasses and parts exhibiting likely condemnable conditions before presenting carcasses to the online CSI, and that the sorting activities are not effective.

G. If the CSI observes persistent, unattended non-food safety trim or processing defects on carcasses during the performance of the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task, the CSI is to complete the task, orally notify the establishment management and the PHV that the products resulting from the establishment's slaughter operation may not meet the definition of RTC poultry in 9 CFR 381.1 and thus are not meeting the requirement in 9 CFR 381.76(b)(6)(ii)(D). The PHV is to further evaluate the situation to determine if the process is out of control and a NR should be written as described in Chapter IV Section II.D.3.

H. Offline CSIs are to use the PHIS task applicable to where the establishment's procedures and processes are incorporated into its HACCP system to verify the requirements listed below. Verification activities by the offline CSI include, but are not limited to, evaluating establishment records, observing establishment employees perform monitoring tasks according to written procedures or processes, and inspecting carcasses and parts to ensure that adulterated carcasses, parts, tissues, or exudates are removed and disposed of.

I. CSIs are to verify that the establishment is complying with the following requirements:

1. Conducts carcass with associated viscera sorting activities, disposes carcasses and parts exhibiting likely condemnable conditions and conducts appropriate trimming and reprocessing activities before carcasses are presented to the online CSI (9 CFR 381.76(b)(6)(ii)(A)). CSIs are to complete the applicable PHIS task by writing a NR if the offline CSI finds the establishment does not have written procedures or does not meet the criteria described in its sorting procedures and cite 9 CFR 381.76(b)(6)(ii);
2. Monitors carcasses after completion of all trimming, washing, or a combination of trimming and washing followed by chlorine (or other approved Offline Reprocessing (OFLR) antimicrobial rinse) to ensure that the OFLR effectively removes visible contamination from internal and external surfaces (9 CFR 381.91(b)(2)) before returning carcasses to the evisceration line for inspection by the online CSI. The establishment makes available reprocessed carcasses for CSIs to periodically select a representative sample to verify the effectiveness of the OFLR by inspecting the internal and external surfaces. This verification is in addition to the offline inspection of all parts described in number 5. below.
3. Returns carcasses or major portions (as defined in 9 CFR 381.170(b)(22)) back to the evisceration line before the CI station after completing OFLR and salvaging activities, as required by 9 CFR

381.76(b)(6)(ii)(B). CSIs are to be aware that under NPIS major portions are carcasses missing some parts or are from transversely cut carcasses with at least one wing and the breast in the front portion and at least one leg and back in the back portion for hanging on the line before the CI. If the establishment does not return such product to the evisceration line, then the offline CSI is to complete the applicable PHIS task by writing a NR, citing 9 CFR 381.76(b)(6)(ii)(B).

4. Has a written process in its HACCP system that ensures that all parts, (e.g. legs, wings, thighs, breasts, backs and quarters except major portions), are available for offline inspection by the CSI or PHV after reprocessing or salvage activities are completed (9 CFR 381.76(b)(6)(ii)(B)). The CSI or PHV is to visually inspect all parts presented in a single layer using mostly a hands free procedure. If the establishment does not have a process or does not follow the process to allow FSIS to inspect parts, then the CSI is to complete the applicable PHIS task by writing a NR, citing 9 CFR 381.76(b)(6)(ii)(B) and stating that such product will not receive the benefit of inspection.
5. Ensures that the corresponding viscera, feet, and necks are also identified and disposed of in accordance with 9 CFR 381.76(b)(6)(iii)(E) when the online CSI condemns a carcass. Individual viscera do not need to be identified if the establishment discards all viscera produced within the time period in which the carcass was condemned by the online CSI.
6. Establishments using approved Online Reprocessing (OLR) and OFLR have written procedures in their HACCP system to ensure visible contamination is removed from internal and external surfaces and applicable operating parameters are monitored (9 CFR 381.91(b)).

NOTE: CSIs are to follow the establishment's procedures to periodically verify as applicable that giblets, feet and necks are produced in a sanitary manner and meet regulatory definitions of "Ready-to-Cook poultry" and "Giblets" provided in 9 CFR 381.1 and in accordance with 9 CFR 381.76(b)(6)(ii)(D).

CHAPTER III - PHV RESPONSIBILITIES

I. CONDUCTING FOOD SAFETY INSPECTION UNDER NPIS

A. PHVs assigned to an establishment operating under NPIS are to assess the overall design and implementation of all establishment processes described in the HACCP system and process control procedures in accordance with [FSIS Directive 5000.1](#). Chapter III Part II or Part II Section III B. 6.

B. The PHV is to work together with the CSIs performing VI and CI to ensure that food safety defects or other conditions do not impair the CSI's ability to perform post-mortem inspection of each carcass. (See paragraph III below for instruction on verifying line speed.)

C. The PHV is to review NRs to evaluate when there may be a trend of noncompliances for not removing or properly disposing of carcasses exhibiting signs consistent with condemnable animal disease. This trend may indicate that the establishment is not maintaining process control in its sorting procedures (9 CFR 381.76(b)(6)(ii)). If the PHV finds that the NRs are repetitive with association (linkage), she or he is to follow the instructions in [FSIS Directive 5000.1](#).

D. In establishments that have located their CCP or other monitoring such as Sanitation SOPs or prerequisite programs to prevent food safety defects from entering the chiller after the online carcass inspection, a NR is not written by the online carcass inspector. Instead the PHV or designee is to perform appropriate PHIS HACCP and Sanitation SOP tasks to evaluate the overall effectiveness of the establishment's written procedures for preventing fecal and enteric pathogen contamination throughout the slaughter and dressing operations (9 CFR 381.65(f), 381.65(g), and 381.65(h)). If the PHV determines that

there is evidence that written procedures are not in control to prevent contamination, for example, the establishment is relying on reconditioning and reprocessing to remove contamination from product instead of preventing contamination, the PHV is to slow the line speed until the process is consistently in control (9 CFR 381.69(c)) and document as appropriate in an NR that written procedures are not being effectively applied. Also see Section III. Verification of Evisceration Line Speed.

E. The PHV is to evaluate and assess the situation when notified by the CSIs that persistent unattended non-food safety trim and processing defects are interfering with carcass inspection (9 CFR 381.69 (c)), or that the establishment's sorting process is not in control (9 CFR 381.76(b)(6)(ii)) to meet the RTC definition (9 CFR 381.1). The PHV is to evaluate the situation to determine whether the establishment is complying with those requirements. The evaluation is to involve:

1. Conducting or assigning directed PHIS Poultry RTC tasks to review establishment records documenting that products resulting from its slaughter operations are meeting the definition of RTC and taking samples;
2. Observing carcasses at the online CI station to determine whether the establishment's process is in control, or whether the presentation of the carcasses is affecting the CSI's ability to inspect carcass-by-carcass (9 CFR 381.76(b)(6)(iii)); and
3. If the PHV determines that the presence of persistent, unattended trim or processing defects indicate that the process is not in control or is interfering with carcass-by-carcass inspection, she or he is to follow instructions as described in Section III. Verification of Evisceration Line Speed and as needed consult with immediate supervisor.

F. The PHV or designee is to verify that the establishment meets facility requirements that are specific to NPIS (9 CFR 381.36 (f) and 381.76(b)(6)(i)) as often as necessary. The PHV or designee is to issue a NR documenting the noncompliance using the PHIS Other Inspection Requirements task if a requirement is not met and citing on the NR the specific applicable regulation.

II. AVIAN VISCERAL LEUKOSIS FLOCK CHECK FOR YOUNG CHICKEN ESTABLISHMENTS

A. In young chicken slaughter establishments the PHV is to verify that the establishment has provided a location at a point along the production line, after the carcasses are eviscerated, at which an inspector may safely and properly inspect the first 300 young chicken carcasses of each flock, together with the associated viscera, for the presence of avian visceral leukosis as required under 9 CFR 381.36(f)(3). The PHV is to verify that the leukosis inspection area meets the other facility requirements in 9 CFR 381.36(f)(3); i.e., that it has a minimum of 200 foot-candles of shadow-free lighting on the surface where the viscera are inspected. The PHV or designee is to inspect the first 300 carcasses of each flock together, with the viscera uniformly trailing or leading or otherwise identified with the corresponding carcass, to determine whether the flock is affected with leukosis. Young chicken establishments are required to notify the PHV or designee prior to the slaughter of each new flock (9 CFR 381.76(b)(6)(iv)).

B. If the PHV or designee finds any lesion compatible with leukosis on the carcass or the viscera, he or she is to instruct the establishment to hang back the carcass and viscera for veterinary disposition. If the disposition of leukosis is confirmed by the PHV, then the PHV is to designate the flock as positive. The PHV is to use professional judgment to expand the sample beyond 300 carcasses or to un-designate a positive flock if leukosis is detected in only one carcass or viscera.

C. If a flock is positive for leukosis, the PHV is to adjust inspection procedures to ensure the adequate inspection of each carcass and viscera and direct the establishment to adjust its processing operations as

needed to accommodate the adjusted inspection procedures. If leukosis is found record the number carcasses condemned but not the cause of condemnation on the FSIS Form 6000-36 as described in Chapter III Section V. Forms Documentation.

D. If the establishment fails to notify the PHV or designee of the start of a new flock, or if the establishment fails to provide the appropriate facilities for inspection of the 300 carcasses, then the PHV is to use the PHIS Other Inspection Requirements task to write an NR citing 9 CFR 381.76(b)(6)(iv) (on leukosis) or 381.36(f) (on facilities), as appropriate, and is to take a regulatory control action (9 CFR 500.2(a)(3)) at hanging to stop operations until the establishment demonstrates control of product slaughtered without leukosis inspection. The PHV or designee is to perform the 300 carcass leukosis check of the remaining lot and if negative no further action is taken. If leukosis is found then the establishment must dispose of carcasses slaughtered from the affected flock before the leukosis check and follow instruction in paragraph C. above for FSIS to continue to inspect the remainder of the flock. Consult with District Office as needed for further instruction.

III. VERIFICATION OF EVISCERATION LINE SPEED

A. The PHV is to verify that the establishment's line speed does not exceed the maximum speed of 140 birds per minute (bpm) authorized for young chickens (9 CFR 381.69(a)) or 55 bpm for turkeys (9 CFR 381.69(b)) as often as necessary to ensure that the online CSI can adequately perform a visual carcass-by-carcass inspection within the time available.

B. The PHV is to measure line speed using physical methods. The maximum allowed line speed is a whole number. Any line speed measurement resulting in a fraction is to be rounded up. If the maximum line speed is exceeded, the PHV is to write an NR using the PHIS Other Inspection Requirements task, citing 9 CFR 381.69, and slow the line to comply with 9 CFR 381.69. In establishments where line speed can't be determined by counting each carcass, the establishment is to establish a procedure that assures line speeds are not exceeding the maximum allowed. An example may be counting shackles in such a manner to support that the establishment's electronic counter is accurate.

C. The PHV is to assess presentation of birds to the online CSI and evaluate the health status of the flock or other factors that may indicate loss of process control, such as persistent unattended defects, to determine whether these factors are having any impact on the ability of IPP to perform the proper inspection procedures at a given line speed (9 CFR 381.69(c)). If in the judgment of the PHV a carcass-by-carcass inspection cannot be adequately performed, the PHV is to reduce the line speed to a speed at which the online CSI can perform the proper inspection procedures and at which process control can be restored. PHVs are to use the PHIS Other Inspection Requirements task to write an NR citing 9 CFR 381.69(c) and 381.76(b)(6)(iii).

NOTE: The CSI is not authorized to slow line speeds, but the online CSI is authorized to stop the line to have carcasses removed from the line that are contaminated with feces or Sep/Tox or carcasses warranting the condemnation of the entire carcass. The PHV is authorized to reduce line speed.

IV. POST-MORTEM DISPOSITIONS AND CORRELATION

A. The PHV plays a critical role in ensuring that the public health is protected by verifying that the establishment is effectively sorting. The PHV evaluates the results of the CSI's carcass verification checks and verifies that there is an appropriate disposition of affected carcasses and parts. The final responsibility for disposition determinations rests with the PHV. The PHV is to conduct a post-mortem examination of carcasses or parts that are held for their final examination. The PHV may seek diagnostic assistance from the pathology laboratory and consider the laboratory's report within the context of ante-

mortem and post-mortem findings.

B. During work unit meetings, the PHV is to meet with the inspection team as necessary to review pathology and regulatory requirements for addressing food safety conditions (Sep/Tox and fecal contamination) and non-food safety disease conditions warranting condemnation of the entire carcass.

C. The PHV may utilize the revised “The Entry Training for the PHV” modules on Post-mortem Inspection and Multi-species Dispositions, found at the following link, for correlating.

<http://www.fsis.usda.gov/wps/portal/fsis/topics/inspection/workforce-training/regional-on-site-training/public-health-veterinarian>;

D. The PHV is to verify that establishments slaughtering turkeys have trained employees to identify TOC lesions and determine whether the flock is positive. If the flock is positive then turkeys are salvaged to remove lesions affected with TOC.

E. If requested by establishment management, the PHV is to correlate with the establishment management on dispositions.

V. FORMS DOCUMENTATION

A. Under NPIS online and offline CSIs record the number of condemned carcasses, but not the cause on FSIS Form 6000-36 NPIS Lot Tally Sheet by entering a hash mark under columns “No. Condemned by FSIS”.

B. When an establishment has located its CCP or other monitoring control after the CI station to prevent carcasses contaminated feces from entering the chiller, the online CSI is to record any finding of fecal contamination on the FSIS Form 6000-36 by entering a hash mark under Special Survey codes found at bottom of the form.

C. Under the NPIS, IPP are to enter in PHIS the total head slaughtered and total head condemned by FSIS or disposed of by the establishment into PHIS Animal Disposition Reporting (ADR). IPP are not to report condemnation categories.

D. IPP are to enter the number of head condemned by the online and offline CSIs as recorded on FSIS Form 6000-36, NPIS Lot Tally Sheet, and the total head disposed by the establishment, and other slaughter data as recorded on FSIS Form 6510-7, Poultry Lot Information.

E. If requested by establishment management (9 CFR 381.103), the PHV or designee is to provide a copy of the current FSIS Form 9061-2, Poultry Condemnation Certificate which is generated in PHIS Animal Disposition Reporting (ADR). The form can be printed by clicking on the “Condemnation Certificate” printer icon.

F. The establishment and the PHV, or their designees, are to sign the form and retain a copy after establishment management signs the form. The copy is retained for the current fiscal year plus one additional fiscal year.

NOTE: The post-mortem “Total No. of Head Condemned/Disposed of.” category heading in Form 9061-2, Poultry Condemnation Certificate, reflects the NPIS. The number recorded under this heading reflects the total number of heads condemned by the inspector and the total number of heads disposed of by the establishment.

CHAPTER IV – VERIFICATION THAT ESTABLISHMENT IS PRODUCING READY-TO-COOK POULTRY

I. REQUIREMENTS

A. Establishments operating under the NPIS are required to maintain records documenting that the products resulting from their slaughter operations meet the definition of RTC poultry (9 CFR 381.76(b)(6)(ii)(D)). Establishments that operate under SIS, NELS or NTIS are required to continue to meet Finished Product Standards (FPS) regulations (9 CFR 381.76 (b)(3)(iv)).

B. Establishments operating under the NPIS may adopt any of the following criteria to determine whether they are producing RTC poultry:

1. Other Consumer Protection (OCP) standards developed for the Hazard Analysis of Critical Control Points-based Inspection Models Project (HIMP) pilot;
2. The parameters in the FPS regulations (9 CFR 381.76 (b)(3)(iv));
3. Alternative FPS procedures allowed under a SIP waiver; or
4. Other OCP performance standards or defect criteria as defined in a published study or a scientifically or statistically-based study that the establishment conducted itself to document they are meeting the RTC definition.

II. IPP RESPONSIBILITIES

A. IPP are to verify the RTC requirements using the routine and directed PHIS Poultry RTC task when the establishment starts to operate under NPIS. At that time, IPP will update the establishment profile to include the new PHIS Poultry Ready-to-Cook task and the PHIS Poultry NPIS Zero Tolerance Food Safety task and to disable the Poultry Finished Product Standards task and the Poultry Zero Tolerance Verification task.

B. Routine PHIS Poultry RTC task: When the task is scheduled, IPP are to verify that the establishment maintains records, as required under 9 CFR 381.76(b)(6)(ii)(D), to document that the products resulting from their slaughter operations meet the definition of RTC poultry in 9 CFR 381.1. IPP are to review the establishment's records to verify that the records contain, at a minimum, the information below.

1. Data to support that the establishment is producing RTC poultry. For example, an establishment may use statistical process control charts, HACCP records, or other documentation;
2. The points in the operation where the establishment monitors carcasses or other parts of poultry to determine whether they meet the RTC definition and records results of these monitoring activities. For example, an establishment may monitor and record the results at a pre-chill and a post-chill station;
3. The frequency with which the establishment conducts monitoring activities. The records should specify the sample set size and how often the establishment monitors carcasses per line per shift. For example, an establishment may conduct and document its monitoring activities at least every

two hours per line per shift at the pre-chill location and at least twice per shift per line at the post-chill location;

4. The definitions of the OCP non-conformances or processing and trim defects for which the establishment is monitoring. For example, the establishment may be monitoring carcasses for processing and trim non-conformances as specified in the FPS regulations; trim and processing defects used under its FPS SIP waiver; OCP defects established under the HIMP pilot; or another OCP standard defined in a published study or a scientifically or statistically-based study that the establishment conducted itself. If the establishment references a study, it should give a brief description of the study and have the supporting information on file;
5. The evaluation criteria that the establishment uses to determine whether the products resulting from its slaughter operation meet the RTC definition. For example, an establishment may follow the subgroup limits for non-conformances and defects in the FPS regulations, the limits established in its FPS SIP waiver, the trim and processing defect levels for the HIMP OCP performance standards, or other OCP evaluation criteria based on a published study or the establishment's scientifically or statistically-based study to determine the upper limits for non-conformances; and
6. The corrective actions that the establishment plans to take if the levels of defects and non-conformances exceed its evaluation criteria for RTC poultry.

C. Directed PHIS Poultry RTC task: IPP are not to perform a directed PHIS Poultry RTC task unless assigned by the PHV or Inspector-in-Charge (IIC) or designee.

1. If, during the performance of the PHIS Poultry Zero Tolerance Food Safety task, offline CSIs observe persistent, unattended trim or processing OCP defects that cause him or her to suspect that the establishment is not effectively sorting carcasses to meet the RTC definition, he or she is to notify the establishment and the PHV or IIC.
2. If, during the performance of the online carcass inspection, online CIs observe persistent, unattended OCP defects, he or she is to notify the PHV or IIC.
 - a. Persistent trim and processing defects means the defect(s) on carcasses continue to occur repetitively. Trim and processing defects that are persistent include observing numerous carcasses, either in a row or in clusters, which have obvious, severe or numerous problems that could affect the usability of the product. Examples of obvious or severe problems include sores and scabs on the skin that indicate deep tissue involvement with or without trimmable IP. A defect is persistent if, for example, IPP find multiple broken crops that may indicate loss of process control related to proper feed withdrawal or improper equipment alignment.
 - b. Unattended means the establishment has been given the opportunity to respond to persistent defects and has not effectively corrected the problem. Defects are unattended if the establishment fails to effectively address the problem even though it has had an opportunity to do so.

NOTE: Examples of non-food safety trim and processing defects. include: sores, breast blisters, bruises, trimmable tumors, trimmable synovitis or air sacculitis, compound fractures, scabs, dermatitis, salpingitis, nephritis, kidney removal where applicable, oil glands, lungs, intestines, cloaca, bursa of Fabricus, esophagus, crop, trachea, and feathers.

3. If the CI or VI informs the PHV or IIC that persistent unattended non-food safety trim and processing defects are interfering with carcass inspection, or that the establishment's sorting process is not in control to meet the RTC definition, the PHV or IIC is to evaluate the situation to determine whether an NR should be written. The evaluation is to involve, but not limited to:
 - a. Observing carcasses at the online CI inspection station to determine whether the establishment's process is in control, or whether the presentation of the carcasses is affecting the CI's ability to inspect carcass-by-carcass; or
 - b. Conducting or assigning a directed PHIS Poultry RTC task.
 - i. When performing the directed Poultry RTC task, IPP are to verify that the establishment's records contain the required information and are to examine and verify that products resulting from the establishment's slaughter operations are meeting the establishment's evaluation criteria.
 - ii. If IPP find a food safety defect while performing a Poultry RTC task, IPP are to perform an appropriate PHIS food safety task and take any necessary action.

III. DOCUMENTATION FOR RTC

A. IPP are to write a NR if the establishment does not have records to document that the products resulting from its slaughter operation meet the definition for RTC poultry, or if the records that the establishment has do not include the minimum information required in 9 CFR 381.76(b)(6)(ii)(D) and 9 CFR 381.1. IPP are to issue the NR using the PHIS Poultry RTC task and citing those regulations. The NR is to state that the establishment is unable to document that the products resulting from its slaughter operations meet the RTC definition.

B. IPP are to also issue an NR using the PHIS Poultry RTC task and citing 9 CFR 381.76(b)(6)(ii)(D) and 9 CFR 381.1 if they examine product as directed and find that:

1. The results exceed the criteria that the establishment uses to determine that the products resulting from its slaughter operation meet the RTC definition; or
2. The establishment did not take necessary corrective actions to restore process control when the evaluation criteria are exceeded.

C. If the PHV or IIC determines that the presentation of persistent unattended trim or processing defects indicates a loss of process control, and in turn affects the CI's ability to adequately conduct a carcass-by-carcass inspection, the PHV or IIC has the authority to direct the establishment to reduce the line speed (9 CFR 381.69 (c)). If the PHV or IIC directs the establishment to reduce the line speed, then he or she is to issue a NR using the PHIS Poultry RTC task and citing 9 CFR 381.69 (c), 9 CFR 381.1 and 381.76 (b)(6)(ii)(A).

D. IPP are to associate the NRs that are issued for the failure to meet the RTC definition and associated documentation requirements. IPP are to discuss with their supervisor and notify the District Office (DO) when establishment management is unwilling or unable to take necessary steps to re-establish control of its process necessary to meet RTC regulatory requirements.

E. The DO is to notify the establishment in writing that repeated noncompliances may lead to a regulatory control action (9 CFR 500.2) that would affect the entire production of the product in question because

product is economically adulterated or misbranded or was produced under conditions that preclude FSIS from determining that product is not adulterated or misbranded.

CHAPTER V - DATA ANALYSIS

The Office of Data Integration and Food Protection (ODIFP), in conjunction with Office of Policy and Program Development (OPPD), Policy Development Staff (PDS) will conduct a policy effectiveness analysis of this directive based on PHIS inspection data collected from establishments operating under NPIS.

CHAPTER VI - QUESTIONS

Refer questions regarding this directive to your supervisor. Follow up questions can be sent to the Policy Development Staff (PDS) through [askFSIS](#) or by telephone at 1-800-233-3935. When submitting a question, use the **Submit a Question** tab, and enter the following information in the fields provided:

Subject Field: Enter **Directive 6500.1**
Question Field: Enter question with as much detail as possible.
Product Field: Select General Inspection Policy from the drop-down menu.
Category Field: Select Slaughter-Poultry from the drop-down menu.
Policy Arena: Select Domestic (U.S.) only from the drop-down menu.

When all fields are complete, press **Continue** and at the next screen press **Finish Submitting Question**.

NOTE: Refer to [FSIS Directive 5620.1](#), *Using askFSIS*, for additional information on submitting questions.



Assistant Administrator
Office of Policy and Program Development

Attachment 1: Identification of Feces for Poultry

To determine whether an establishment is preventing poultry carcasses with visible fecal material from entering the chilling tank, as required by 9 CFR 381.65(f), inspection program personnel who examine carcasses must be able to properly identify feces.

Three factors—color, consistency, and composition—are essential in identifying fecal material on the inside or outside of poultry carcasses.

- The color of feces ranges from varying shades of yellow to green, brown, and white.
- The consistency of feces is characteristically semi-solid to a paste.
- The composition of feces may or may not include plant material.

Inspection program personnel are to take care to distinguish feces from ingesta.

- The color of ingesta varies with the diet.
- The consistency of ingesta is characteristically solid or granular; digestive fluids sometimes are present.
- The composition of ingesta is identifiable plant material.

(9 CFR 381.65(f) does not apply to ingesta. However, inspection program personnel who find ingesta during fecal contamination checks should notify establishment management to remove ingesta from affected carcass(es).)

**Attachment 2:
FSIS Form 6000-36, NPIS Lot Tally Sheet**

New Poultry Inspection System - -Lot Tally Sheet		Shift	Est. No.	Date Inspected		
Class Poultry <input type="checkbox"/> Young Chickens <input type="checkbox"/> Young Turkeys <input type="checkbox"/> Fryer-Roaster turkeys <input type="checkbox"/> Old Breeder Turkeys <input type="checkbox"/> Young Breeder Turkeys		Class of Poultry if establishment has waiver for NPIS <input type="checkbox"/> Light Fowl <input type="checkbox"/> Heavy Fowl <input type="checkbox"/> Ducks <input type="checkbox"/> Geese Capons <input type="checkbox"/> Other (Guineas, Squabs, Pigeons, etc.)				
	No. carcasses condemned by FSIS	No. carcasses condemned by FSIS	No. carcasses condemned by FSIS	No. carcasses condemned by FSIS	No. carcasses condemned by FSIS	Total CD
	5	10	15	20	25	-----
Lot No. _____						
Lot No. _____						
Lot No. _____						
Lot No. _____						
Lot No. _____						
Lot No. _____						
Lot No. _____						
Lot No. _____						
Lot No. _____						
Lot No. _____						
Lot No. _____						
Special Survey	Code: 75 Reprocessed birds	Total:				