



United States
Department of
Agriculture

Food Safety
and Inspection
Service

Washington, D.C.
20250

SEP 11 2003

Dr. Mervyn Baker, Director
Food of Animal Origin Division
Canadian Food Inspection Agency
59 Camelot Drive
Nepean, Ontario K 1A0Y9
Canada

Dear Dr. Baker:

Enclosed is a copy of the final report of the Food Safety and Inspection Service (FSIS) audit of Canada's meat and poultry inspection system conducted from October 15, 2002 through November 15, 2002. Comments by Canada on the draft final audit report have been included as Attachment "G" in the final audit report. FSIS also wishes to apologize for the delay in transmitting this report.

If you have any questions or need additional information, please contact me. My telephone number is 202-720-3781, my email address is sally.stratmoen@fsis.usda.gov, and my fax number is 202-690-4040.

Sincerely,

for Sally Stratmoen, Acting Director
International Equivalence Staff
Office of International Affairs

Enclosure

cc: John Masswohl, First Secretary, Agric., Embassy of Canada
Gary C. Groves, Minister-Counselor, FAS, U.S. Embassy, Ottawa
Robert Hoff, Area Officer, FAS
Linda Swacina, Deputy Administrator, FSIS
Karen Stuck, Assistant Administrator, Office of International Affairs, FSIS
Amy Winton, State Department
Dave Young, FAS
Donald Smart, Director, Review Staff, FSIS
Clark Danford, Acting Director, IEPS, OIA
Sally Stratmoen, Acting Director, IES OIA
Richard F. Brown, IES, OIA
Steve McDermott, IES, OIA
Country File (FY 2003 Canada #1 Audit)

FINAL

JUN - 4 2003

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

OCTOBER 15 THROUGH NOVEMBER 15, 2002

Food Safety and Inspection Service
United States Department of Agriculture

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ABBREVIATIONS AND SPECIAL TERMS USED IN THE REPORT

CCA	Central Competent Authority - Canadian Food Inspection Agency (CFIA)
FSIS	Food Safety and Inspection Service
PR/HACCP	Pathogen Reduction/Hazard Analysis and Critical Control Point Systems
SSOP's	Sanitation Standard Operating Procedures
<i>E. coli</i>	<i>Escherichia coli</i>
<i>Salmonella</i>	<i>Salmonella</i> species

1. INTRODUCTION

The audit took place in Canada from October 15 through November 15, 2002.

An opening meeting was held on October 15, 2002 in Ottawa, Ontario with the Central Competent Authority (CCA), the Canadian Food Inspection Agency (CFIA). At this meeting, the auditor confirmed the objective and scope of the audit, the auditor's itinerary, and requested additional information needed to complete the audit of Canada's meat and poultry inspection system.

The auditor was accompanied during the entire audit by representatives from CFIA and/or representatives from the regional and local inspection offices.

2. OBJECTIVE OF THE AUDIT

This was a routine annual audit. The 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 and poultry products to the United States.

In pursuit of the objective, the following sites were visited: the headquarters of CFIA, one regional inspection office, two laboratories performing analytical testing on United States-destined product, three meat slaughter establishments, six poultry slaughter establishments, three meat processing establishments and two poultry processing establishments.

CFIA Visits	Central	1
	Regional	1
Laboratories		2
Meat Slaughter Establishments		3
Meat Processing Establishments		3
Poultry Slaughter Establishments		6
Poultry Processing Establishments		2

3. PROTOCOL

This on-site audit was conducted in four parts. One part involved visits with CFIA officials to discuss oversight programs and practices, including enforcement activities. The second part involved an audit of a selection of records in the country's inspection headquarters and in one regional office. The third part involved on-site visits to 14

establishments: nine slaughter establishments and five processing establishments. The fourth part involved visits to one government and one private laboratory. The SGS Laboratory was conducting analyses of field samples for the presence of generic *Escherichia coli* (*E. coli*), *Salmonella* species (*Salmonella*), and *Listeria monocytogenes*. The CFIA Laboratory (Carling) was conducting analyses of field samples for *E. coli* and of non-meat field samples for Canada's national residue control program.

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's), (2) animal disease controls, (3) slaughter/processing controls, including the implementation and operation of HACCP programs and a testing program for generic *E. coli*, (4) residue controls, and (5) enforcement controls, including a testing program for *Salmonella*. Canada's inspection system was assessed by evaluating these five risk areas.

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

In the opening meeting, the auditor explained that Canada's meat and poultry inspection system would be audited against two standards: (1) FSIS regulatory requirements and (2) an equivalence determination that has been made for Canada. FSIS requirements include, among other things, daily inspection in all certified establishments, monthly supervisory visits to certified establishments, humane handling and slaughter of animals, ante-mortem inspection of animals and post-mortem inspection of carcasses and parts, the handling and disposal of inedible and condemned materials, sanitation of facilities and equipment, residue testing, species verification, and requirements for HACCP and SSOP's, and testing for generic *E. coli* and *Salmonella*.

Equivalence determinations are those that have been made by FSIS for Canada under provisions of the Sanitary/Phytosanitary Agreement. Currently, one equivalence determination has been made in regard to *Salmonella* testing: the establishment personnel take the samples and private laboratories analyze the samples.

There are several issues currently under consideration for equivalence determination. These include pre-shipment reviews, monthly supervisory visits, and analytical methods 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.) and the Federal Meat Inspection Regulations (9 CFR Parts 301 to end), which include the Pathogen Reduction/HACCP regulations.
- The Poultry Products Inspection Act (21 U.S.C. 451 et seq.) and the Poultry Products Inspection Regulations (9 CFR Part 381).

5. SUMMARY OF PREVIOUS AUDITS

Final audit reports are available on FSIS' website at www.fsis.usda.gov/ofotsc.

The following deficiency, which was observed during the audit of the Canadian meat inspection system conducted in April 2000, was found to have been corrected by the time of the audit in June 2001:

- The HACCP plans had no CCP in one audited establishment.

The following deficiencies were identified during the FSIS audits of Canada's inspection system conducted both in April 2000 and in June 2001 (these were repeat findings)

- Reduced supervisory reviews were observed in one province.
- Poor sanitary dressing and sanitizing procedures were observed in several establishments.

During the most recent audit of Canada, conducted by FSIS in June 2001, the following additional deficiencies were found:

- The CFIA performed reduced numbers of supervisory reviews, four per year in Alberta and British Columbia, and one to three per year in slaughter establishments in Quebec.
- The carcass selection for testing for *E. coli* and *Salmonella* was not random in two establishments.
- The zero tolerance policy for fecal contamination was not defined in two establishments; the critical limits allowed fecal contamination of carcasses.
- The detector for proper closure of glass containers was malfunctioning in one establishment.
- No denaturing of carcasses was performed in four establishments.
- The employee at the bird salvage station in one establishment did not sanitize her knife during the operation.
- Several sanitary deficiencies, such as condensation, were observed.

6. MAIN FINDINGS

6.1 Government Oversight

Canada is divided into four areas of administration and field operations. Each area is divided into several Regions, with local offices as needed. The personnel in these area and regional offices supervise and oversee all field inspection personnel and in-plant functions.

In the CFIA headquarters in Ottawa, in order to gather more information on oversight, interviews were conducted with the officials responsible for:

- Field operations and inspection services,
- Poultry operations,
- Residues,
- Bovine spongiform encephalopathy,
- Export programs and U. S. Regulations, and
- Enforcement and compliance.

In the CFIA Regional office in Vancouver, British Columbia, interviews were conducted with the officials responsible for:

- Regional operations,
- Monthly supervisor visits,
- Prerequisite programs and monthly supervisor visits, and
- Enforcement.

6.1.1 CCA Control Systems

An official of the CCA on the Ottawa Headquarters Staff, the supervisor of the Area Supervisors, oversees the maintenance of eligibility to export to any other country. His Area Supervisors have the authority, under Canadian regulations, to enforce the necessary requirements to export to a country. His duties also include initiating investigations into failure on the part of an establishment to meet the standards of the importing country and to delist those who fail in this requirement.

6.1.2 Ultimate Control and Supervision

Control in an establishment is accomplished by the Veterinarian-in-Charge (in a slaughter establishment) and by the Inspector-in-Charge (in a processing establishments). These officials are supervised by other officials from the respective Regional Offices and Area Offices. The central control and supervision is in the Headquarters Office in Ottawa. Permits to export to another country are granted or withdrawn by this office.

6.1.3 Assignment of Competent, Qualified Inspectors

Ensuring adequate training to inspectors before assignment to a position is the responsibility of the headquarters staff; the training is carried out by the local supervisor in the establishment. There are trainers in the field of export requirements, and in-plant staff involved with export duties receive the necessary special training. It is also the responsibility of the supervisor to see that all establishments are adequately staffed with trained and competent inspectors.

6.1.4 Authority and Responsibility to Enforce the Laws

CFIA has the authority and responsibility to enforce U.S. requirements. Each establishment has copies of the pertinent CFIA and U.S. rules and regulations.

6.1.5 Adequate Administrative and Technical Support

CFIA has adequate administrative and technical support in the central and regional offices and in the field to operate and support its inspection system, including experts, specialists and adequate facilities.

6.2 Headquarters Audit

The auditor conducted a review of inspection system documents at headquarters in Ottawa and at a regional office in Vancouver. These records reviews focused primarily on food safety hazards and included the following:

- Internal review reports,
- Supervisory visits to establishments that were certified to export to the United States,
- Training records for inspectors and laboratory personnel,
- New laws and implementation documents such as regulations, notices, directives and guidelines,
- Sampling and laboratory analyses for residues,
- Sanitation, slaughter and processing inspection procedures and standards,
- 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, consumer complaints, recalls, seizure and control of noncompliant product, and withholding, suspending, or withdrawing inspection services from or delisting an establishment that is certified to export product to the United States.

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

7. ESTABLISHMENT AUDITS

The FSIS auditor visited a total of fourteen establishments, of which nine were slaughter establishments and five were processing establishments. Fifteen establishments were

originally scheduled for audit; one closed permanently before the scheduled audit date. Two of the establishments were delisted by Canada. Est. 411 was delisted because of poor sanitary conditions in the processing department. Est. 38 was delisted because of fecal contamination of carcasses during the dressing procedure.

Two establishments received “Notices of Intent to Delist” from the Canadian officials. Est. 173 was given a Notice of Intent to Delist because of poor sanitary conditions and inadequate pest control. Est. 92 was given a Notice of Intent to Delist because of poor sanitation and inadequate HACCP implementation. These two establishments may retain their certification for export to the United States provided that they correct all deficiencies noted during the audit within 30 days of the date the establishment was audited.

Specific deficiencies are noted in the attached individual Establishment Audit Checklists.

8. RESIDUE AND MICROBIOLOGY LABORATORY AUDITS

During the laboratory audits, emphasis was 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.

Microbiology laboratory audits focus on analyst qualifications, sample receipt, timely analysis, analytical methodologies, analytical controls, recording and reporting of results, and check samples. If private laboratories are used to analyze samples from products produced for export to the United States, the auditor evaluates compliance with the criteria established for the use of private laboratories under the FSIS Pathogen Reduction/HACCP requirements.

The following laboratories were audited:

1. SGS Laboratory, Vancouver, British Columbia. This is a private laboratory that does microbiological testing for CFIA. There was one deficiency:
 - The method of analysis for generic *E. coli* in this laboratory was a modified version of an AOAC method that had not been submitted to FSIS for an equivalence determination.
2. CFIA Food Laboratory (Carling), Ottawa, Ontario. This is a government laboratory that does microbiological and residue testing, although no testing for residues in meat was performed in this laboratory.

No concerns arose from the audit of this laboratory.

9. SANITATION CONTROLS

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

Based on the on-site audits of the 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.

Except as noted below, Canada's inspection system also had controls in place for water potability records, chlorination procedures, back-siphonage prevention, separation of operations, temperature control, work space, ventilation, ante-mortem facilities, welfare facilities, and outside premises.

9.1 SSOP's

Each establishment was evaluated to determine if the basic FSIS regulatory requirements for SSOP's were met, according to the criteria employed in the United States domestic inspection program. The SSOP's in all the establishments audited were found to meet the basic FSIS regulatory requirements. The following deficiencies regarding SSOP implementation were noted:

- No preventive measures were recorded in the daily pre-operational sanitation documentation in three establishments; no preventive measures were recorded either in the daily pre-operational or in the daily operational sanitation documentation in ten establishments.
- In one establishment, repetitive pre-operational deficiencies were not adequately addressed.
- In one establishment, operational sanitation documentation was incomplete.
- In one establishment, the descriptions of cleaning procedures were incomplete.
- Documentation of corrective actions in the daily operational sanitation records was inadequate in one establishment.

9.2 Sanitation

The following sanitation deficiencies were noted (further details may be found in the individual Foreign Establishment Audit Checklists, which are attached to this report):

Sanitary Operations

- In four establishments, condensation was falling from overhead structures that were not cleaned and sanitized daily onto exposed product and/or production equipment.
- In one establishment, overspray was falling onto exposed carcasses in a cooler from overhead structures that were not cleaned and sanitized daily.

- In the boning room in one establishment, heavily beaded condensation was observed directly above exposed-product handlers.
- In the ready-to-eat department in one establishment, condensation drip pans drained directly onto the floor.
- In one establishment, the water in all the sterilizers was below the required temperature. No corrective actions were taken.
- In one establishment, baked pizza dough crusts were stored under insanitary conditions.
- In one establishment, the closing ring of a tomato-paste drum was placed on the floor and subsequently allowed to contact exposed product.
- In one establishment, liquid was dripping onto a layer of plastic covering product in a combo bin in a cooler.
- In two establishments, floor hoses were in contact with production equipment.
- In one establishment, dropped-meat reconditioning stations were not identified.
- Very poor housekeeping was found in two establishments.

Equipment

- In three establishments, butchering equipment (a carcass-splitting saw, a brisket saw, and a dehorning clipper) was not cleaned and sanitized between carcasses.
- There was common contact between carcass necks and the splitting saw drain hose in one establishment.
- The viscera trays in one establishment were not cleaned before being used again.
- The viscera conveyor was not cleaned adequately in one establishment.
- There were no splashguards at the evisceration station in one establishment; water was splashing onto employees.
- In four establishments, product-contact equipment was observed with old product residues and some also with rust.

Personal Hygiene

- In one establishment, handlers failed to wash their hands after handling inedible-product containers before handling edible-product.
- In one establishment, an employee was using floor-cleaning equipment and then putting ice onto exposed product without washing his hands.
- At the evisceration tables in two establishments, table boots were stored in contact with floor boots.
- In one establishment, workers' aprons were not cleaned adequately before breaks.

Hand-Washing Facilities

- Blocked and plugged hand-wash basins were found at an inspection station and in the cut-up department of one establishment.
- There was no hot water at the hand wash sink in one establishment.

Product Handling and Storage

- In one establishment, assembled product boxes were on the floor and touching a wall.
- In one establishment, exposed product was stored directly below shipping boxes of vacuum-packing bags.
- In one establishment, cartoned product was stored directly on the floor in the freezer.
- In one establishment, exposed product was stored in the freezer.
- In two establishments, cartons prepared for use were not stored in a sanitary manner.
- In one establishment, broken glass was found on finished cartons in the storage area.

Pest Control

- In two establishments, mice had been caught and corrective actions taken as a result were not documented adequately.

10. ANIMAL DISEASE CONTROLS

The second of the five risk areas that the FSIS auditor reviewed was Animal Disease Controls. These controls include ensuring adequate animal identification, humane handling and humane slaughter, control over condemned and restricted product, and procedures for sanitary handling of returned and reconditioned products. The auditor determined that Canada's inspection system had adequate controls in place. No deficiencies were noted.

There had been no outbreaks of animal diseases with public health significance since the last FSIS audit.

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 dispositions, post-mortem inspection procedures, post-mortem dispositions, ingredients identification, control of restricted ingredients, formulations, processing schedules, equipment and records, and processing controls of cured, dried, and cooked products. The following deficiency was noted:

- In one establishment, tendons were harvested before final inspection of the carcass and were not available in case a carcass was condemned.

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

11.1 Humane Handling and Slaughter

No deficiencies were observed.

11.2 HACCP Implementation

All establishments approved to export meat 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 14 establishments. Serious deficiencies with basic HACCP requirements were identified in eight establishments and relatively minor deficiencies in three more. The deficiencies regarding basic HACCP requirements were the following:

- The hazard analyses were incomplete in six establishments: there was no record of hazards considered and rejected, or of the justification for their rejection.
- Some critical limits specified in the written HACCP plans, including zero tolerance for visible contamination with feces, ingesta, and milk, were inappropriate in two establishments, so that the zero-tolerance policy was not adequately enforced. This was a repeat deficiency from the FSIS audit in June 2001. In one of these, fifteen carcasses were observed after skinning: all had visible fecal contamination in the perineal area; a further ten carcasses were examined after the steam vacuuming, and four of these still had visible fecal material in the same area. In the other, according to the written plan, findings of up to 5% visible contamination with feces or ingesta were considered acceptable.
- The description of corrective actions, to be taken in response to deviations from critical limits, was inadequate in one establishment.
- Preventive measures were not included in the written corrective actions specified in response to deviations from critical limits in five establishments.
- The monitoring frequency specified for Critical Limits was inappropriate in one establishment.

The ongoing HACCP requirements were adequately implemented in eleven of the establishments audited. In the other three establishments, the following HACCP implementation deficiencies were identified:

- The documentation of corrective actions taken in response to deviations from critical limits was inadequate in two establishments.
- The documentation of preventive measures was not included in the written corrective actions taken in response to deviations from critical limits in three establishments.

11.3 Testing for Generic *E. coli*

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

Nine of the fourteen 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. The testing for generic *E. coli* was properly conducted in all nine slaughter establishments.

11.4 Testing for *Listeria monocytogenes*

None of the 14 establishments audited were producing ready-to-eat products for export to the United States, so testing for *Listeria monocytogenes* was not required.

12. RESIDUE CONTROLS

The fourth of the five risk areas that the FSIS auditor 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. The CFIA Food Laboratory (Carling) in Ottawa, Ontario, a government laboratory, was audited. No deficiencies were noted. No meat samples were analyzed in this laboratory for residues.

Canada's National Residue Testing Plan for 2002 was being followed and was on schedule.

13. ENFORCEMENT CONTROLS

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

13.1 Daily Inspection in Establishments

Inspection was being conducted daily in all slaughter and processing establishments.

13.2 Testing for *Salmonella* species

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

- Establishment personnel take the samples under the supervision of CFIA personnel and the samples are analyzed in private laboratories.

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

Testing for *Salmonella* was properly conducted in eight of the nine establishments. The following deficiency was noted:

- In one establishment, part of the population was not included in the sample selection process.

13.3 Species Verification

Species verification was being conducted as required, with the following exception:

- In one establishment, in which both veal and pork were processed, species verification was not performed on finished product.

13.4 Monthly Reviews

During this audit it was found that, in all establishments visited, monthly supervisory reviews of certified establishments were being performed and documented as required.

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.

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

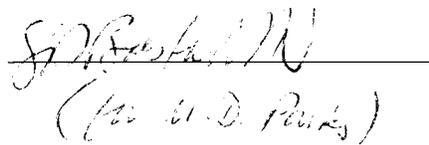
Lastly, adequate controls were found to be in place for security items, shipment security, and products entering the establishments from outside sources.

14. CLOSING MEETING

A closing meeting was held on November 15, 2002 in Ottawa, Ontario with CCA. At this meeting, the primary findings from the audit were presented by the auditor.

The CCA understood and accepted the findings.

Dr. M. Douglas Parks
International Audit Staff Officer


(for M. D. Parks)

15. ATTACHMENTS

Foreign Country Laboratory Review Reports

Foreign Establishment Audit Checklists

Foreign Country comments to the Draft Final Audit Report

REVIEW DATE
 12 Nov., 2002

NAME OF FOREIGN LABORATORY
 Ottawa Food Laboratory

Att. A-1a

FOREIGN COUNTRY LABORATORY REVIEW

FOREIGN GOV'T AGENCY Canadian Food Inspection Agency	CITY & COUNTRY Ottawa, Ontario, Canada	ADDRESS OF LABORATORY Bldg. 22, Central Experimental Farm
NAME OF REVIEWER Dr. M. Douglas Parks	NAME OF FOREIGN OFFICIAL Eli Neidert, Manager, National Chemical Residue Program	

Residue Code/Name		Ecol																		
SAMPLING PROCEDURES	REVIEW ITEMS	ITEM #	EVALUATION CODE																	
	Sample Handling	01		A																
	Sampling Frequency	02		A																
	Timely Analyses	03		A																
	Compositing Procedure	04		A																
	Interpret Comp Data	05		A																
Data Reporting	06	A																		
ANALYTICAL PROCEDURES	Acceptable Method	07	A																	
	Correct Tissue(s)	08	A																	
	Equipment Operation	09	A																	
	Instrument Printouts	10	O																	
QUALITY ASSURANCE PROCEDURES	Minimum Detection Levels	11	O																	
	Recovery Frequency	12	O																	
	Percent Recovery	13	O																	
	Check Sample Frequency	14	O																	
	All analyst w/Check Samples	15	O																	
	Corrective Actions	16	O																	
	International Check Samples	17	O																	
REVIEW PROCEDURES	Corrected Prior Deficiencies	18	O																	
OTHER REVIEW		19	EVAL. CODE																	
		20	EVAL. CODE																	

SIGNATURE OF REVIEWER	DATE
-----------------------	------

FOREIGN COUNTRY LABORATORY REVIEW

(Comment Sheet)

REVIEW DATE

12 Nov., 2002

NAME OF FOREIGN LABORATORY

Ottawa Food Laboratory

A-16

FOREIGN GOV'T AGENCY

Canadian Food Inspection Agency

CITY & COUNTRY

Ottawa, Ontario, Canada

ADDRESS OF LABORATORY

Bldg. 22, Central Experimental Farm

NAME OF REVIEWER

Dr. M. Douglas Parks

NAME OF FOREIGN OFFICIAL

Eli Neidert, Manager, National Chemical Residue Program

RESIDUE

ITEM

COMMENTS

Note: Residue testing was also part of this laboratory's operations, but none were performed on meat samples.

A-2a

7 Nov., 2002

SGS Laboratory

FOREIGN COUNTRY LABORATORY REVIEW

FOREIGN GOV'T AGENCY
 Canadian Food Inspection Agency

CITY & COUNTRY
 Vancouver, British Columbia,
 Canada

ADDRESS OF LABORATORY
 50-655 W. Kent Ave. N.

NAME OF REVIEWER
 Dr. M. Douglas Parks

NAME OF FOREIGN OFFICIAL
 Dr. Joseph Beres

Residue Code/Name		Item #	Ecol	List	Stap	Sal													
SAMPLING PROCEDURES	REVIEW ITEMS	ITEM #	EVALUATION CODE																
	Sample Handling	01		A	A	A	A												
	Sampling Frequency	02		A	A	A	A												
	Timely Analyses	03		A	A	A	A												
	Compositing Procedure	04		A	A	A	A												
	Interpret Comp Data	05		A	A	A	A												
	Data Reporting	06	A	A	A	A													
ANALYTICAL PROCEDURES	Acceptable Method	07	C	A	A	A													
	Correct Tissue(s)	08	A	A	A	A													
	Equipment Operation	09	A	A	A	A													
	Instrument Printouts	10	O	O	O	O													
QUALITY ASSURANCE PROCEDURES	Minimum Detection Levels	11	O	O	O	O													
	Recovery Frequency	12	O	O	O	O													
	Percent Recovery	13	O	O	O	O													
	Check Sample Frequency	14	O	O	O	O													
	All analyst w/Check Samples	15	O	O	O	O													
	Corrective Actions	16	O	O	O	O													
	International Check Samples	17	O	O	O	O													
REVIEW PROCEDURES	Corrected Prior Deficiencies	18	O	O	O	O													
OTHER REVIEW		19																	
		20																	

SIGNATURE OF REVIEWER

DATE

FOREIGN COUNTRY LABORATORY REVIEW <i>(Comment Sheet)</i>		REVIEW DATE 7 Nov., 2002	NAME OF FOREIGN LABORATORY SGS Laboratory	<i>A-2b</i>
FOREIGN GOV'T AGENCY Canadian Food Inspection Agency		CITY & COUNTRY Vancouver, British Columbia, Canada	ADDRESS OF LABORATORY 50-655 W. Kent Ave. N.	
NAME OF REVIEWER Dr. M. Douglas Parks		NAME OF FOREIGN OFFICIAL Dr. Joseph Beres		

RESIDUE	ITEM	COMMENTS
<i>E. coli</i>	07	The method of analysis for generic <i>E. coli</i> in this laboratory was a modified version of an AOAC method that had not been submitted to OIA for an equivalence determination.

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Lakeside Feeders Ltd P O Box 1868 Brooks, Alberta	2. AUDIT DATE Nov 4, 2002	3. ESTABLISHMENT NO. 38	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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 .	X	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	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	
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

B-16

Est 38

13 No preventive measures were recorded in the daily pre-operational sanitation documentation

14/51 The zero-tolerance policy for visible contamination with feces was not adequately enforced. Fifteen carcasses were observed after skinning; all had visible fecal contamination in the perineal area. A further ten carcasses were examined after the steam vacuuming, and four of these still had visible fecal material in the same area.

15 The monitoring frequency specified for the CCP "SL1" was inappropriate.

46 (A) Cartoned product was stored directly on the floor in the freezer. (B) Exposed product was stored in the freezer. (C) overspray was falling onto exposed carcasses in a cooler from overhead structures that were not cleaned and sanitized daily. (D) Several meat wash stations were not identified. (E) In the box preparation room, unprotected boxes were stacked against the wall. (F) The carcass-splitting saw was not properly cleaned and sanitized between uses. (G) At the evisceration tables in two establishments, table boots were stored in contact with floor boots.

Note: following consultation with the Office of International Affairs in Washington, D.C., this establishment was removed from the list of establishments certified as eligible to export to the USA on November 14, 2003.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Atrahan Transformation, Inc. 800 Chemin des Acadiens Yamachiche, Quebec	2. AUDIT DATE Oct.21,2002	3. ESTABLISHMENT NO. 80	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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.	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	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/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

B-26

Est 80

13 No preventive measures were recorded in the daily pre-operational or operational sanitation documentation

15 Preventive measures were not included in the corrective actions specified in response to deviations from critical limits.

46 (A) Condensation was falling onto exposed carcasses in the "hot box" cooler. (B) The brisket saw was not reliably cleaned and sanitized between carcasses. (C) The viscera conveyor was not cleaned adequately. (D) Exposed product was stored directly below shipping boxes of vacuum-packing bags. (E) A floor hose was in contact with a liver skinning machine while it was in operation.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Hayter's Turkey Products Inc. R R #2 Dashwood, Ontario	2. AUDIT DATE Oct 24, 2002	3. ESTABLISHMENT NO. 85	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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	
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

B-36

Est. 85

10/46 Rust and product residues from previous days' production were observed on the feet of a scale used for exposed product and sitting on an exposed product work surface.

13 No preventive measures were recorded either in the daily pre-operational or in the daily operational sanitation documentation.

22 Preventive measures were not included in the corrective actions specified in response to deviations from critical limits.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Lilydale Co-operative Ltd 7727 127 Ave Edmonton, Alberta	2. AUDIT DATE Oct 31, 2002	3. ESTABLISHMENT NO. 92	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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.	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	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

B-4b

Est 92

10 (A) the descriptions of cleaning procedures were incomplete. (B) Repetitive pre-operational deficiencies were not adequately addressed. (C) Operational sanitation documentation was incomplete.

13 No preventive measures were recorded either in the daily pre-operational or in the daily operational sanitation documentation.

15 (A) The hazard analysis was incomplete: there was no record of hazards considered and rejected, or of the justification for their rejection. (B) The critical limits specified in the written HACCP plan for zero tolerance for visible contamination with feces, ingesta, and milk, were inappropriate.

46 (A) All the sterilizers were below the required temperature. No corrective actions were taken. (B) General housekeeping throughout the establishment was very poor: dust, dirt, broken pallet pieces, and debris were found in many areas. (C) Liquid was dripping onto a layer of plastic covering product in a combo bin in a cooler. (D) Employee aprons were not cleaned adequately before breaks and were stored on the rack for re-use. (E) Employees were observed to handle inedible-product containers and then handle edible-product, without washing their hands in between.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Lilydale Co-operative Ltd 31894 Marshall Road R R #5 Abbotsford, B C	2. AUDIT DATE Nov 5, 2002	3. ESTABLISHMENT NO. 92C	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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.	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	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

B-5b

Est 92C

10/46 (A) Condensation drip pans drained directly onto the floor in the ready-to-eat department. (B) Scales used for weighing exposed product had residues from previous days' use. (C) There were no splash guards at the evisceration station; water was splashing onto employees. (D) The moving visera trays were not cleaned before being used again. (E) The veterinarian's hand wash sink was blocked with a soap container. (F) The drain in a hand wash sink in the cut-up department was plugged. (G) Assembled product boxes were on the floor and touching a wall.

13 No preventive measures were recorded either in the daily pre-operational or in the daily operational sanitation documentation.

15 The hazard analysis was incomplete: there was no record of hazards considered and rejected, or of the justification for their rejection.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION McCain Foods Ltd Madawaska County New Brunswick	2. AUDIT DATE Oct 17, 2002	3. ESTABLISHMENT NO. 173	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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 SSOPs have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	X
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.	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	X
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.	X	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

B-6b

Est 173

10/46 (A) Condensation was falling from overhead structures that were not cleaned and sanitized daily onto production equipment and into open boxes ready for use. (B) Equipment was being washed in the hand wash sink.

13 No preventive measures were recorded in the daily pre-operational sanitation documentation.

15 The documentation of preventive measures was not included in the written corrective actions taken in response to deviations from critical limits.

20 The description of corrective actions, to be taken in response to deviations from critical limits, was inadequate.

38 A mouse had been caught in the electrical room, and corrective actions taken as a result were not documented adequately.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Eastern Protein Foods Ltd 30 Chipman Drive Kentville, Nova Scotia	2. AUDIT DATE Oct 18, 2002	3. ESTABLISHMENT NO. 203	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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.		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

B-7b

Est 203

13 No preventive measures were recorded in the daily pre-operational or operational sanitation documentation.

15 The critical limits specified in the written HACCP plan for zero tolerance for visible contamination with feces and ingesta, and milk, were inappropriate. According to the written plan, findings of up to 5% visible contamination with feces or ingesta were acceptable.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Mondiv Food Products Inc Boisbriand, Quebec	2. AUDIT DATE Oct 22, 2002	3. ESTABLISHMENT NO. 251	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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	46
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

B-8b

Est 251

- 13 No preventive measures were recorded in the daily pre-operational sanitation documentation.
- 46 The closing ring of a tomato-paste drum was placed on the floor and subsequently allowed to contact exposed product.

61. NAME OF AUDITOR
Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Viandes Export Inc 10039 Ave Rome Montreal-Nord, Quebec	2. AUDIT DATE Oct 23, 2002	3. ESTABLISHMENT NO. 309	4. NAME OF COUNTRY Canada
5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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	X
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.	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	
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	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

B-96

Est 309

10/46 Heavily-beaded condensation was observed directly above exposed-product handlers In the boning room.

13 (A) No preventive measures were recorded either in the daily pre-operational or in the daily operational sanitation documentation. (B) Documentation of corrective actions in the daily operational sanitation records was inadequate.

15 (A) Preventive measures were not included in the written corrective actions specified in response to deviations from critical limits. (B) The documentation of preventive measures was not included in the written corrective actions taken in response to deviations from critical limits.

34 No species verification was performed on finished products in this establishment, although both veal and pork were processed.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION XL Foods Inc. 5101 – 11th Street South East Calgary, Alberta	2. AUDIT DATE Nov 1, 2002	3. ESTABLISHMENT NO. 401	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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.	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	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	X
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

B-106

Est 401

10/46 (A) There was dripping condensate in the cooler above carcass rails. (B) There was common contact between carcass necks and the splitting saw drain hose. (C) At the evisceration tables in two establishments, table boots were stored in contact with floor boots. (D) The dehorning clipper was not cleaned and sanitized between carcasses.

13 No preventive measures were recorded, either in the daily pre-operational or in the daily operational sanitation documentation in ten establishments.

15 The hazard analysis was incomplete: there was no record of hazards considered and rejected, or of the justification for their rejection.

55 Leg tendons were harvested before final inspection of the carcass and were not available in case a carcass was condemned.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION R.F.G. Canada Inc. 50A Claireport Crescent Toronto, Ontario	2. AUDIT DATE Oct. 28, 2002	3. ESTABLISHMENT NO. 411	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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	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/Park 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

B-116

Est 411

13 No preventive measures were recorded either in the daily pre-operational or in the daily operational sanitation documentation.

15 In the written HACCP plan, preventive measures were not included in the corrective actions specified in response to deviations from critical limits.

46 (A) Baked pizza dough blanks were stored under insanitary conditions in the dry storage area, exposed to an overhead loft. (B) The baking trays were in very poor condition with residues on them. (C) The canvas flaps of the oven were stained with residues. (D) A storage rack with exposed dough blanks was stored against the wall. (E) Tempering of meat was done in the production area with exposed product present. (F) A floor hose was stored in contact with product equipment, ready for use. (G) Very poor housekeeping had been maintained in the freezer: there were considerable amounts of dirt and debris. (H) Boxes were being assembled in the exposed product production areas. (I) The production area was very congested.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Superior Poultry Processors Ltd Coquitlam, B C	2. AUDIT DATE Nov 6, 2002	3. ESTABLISHMENT NO. 545	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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	X
19. Verification and validation of HACCP plan.		47. Employee Hygiene	X
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

B-126

Est 545

10/46 (A) Condensation was dripping onto exposed product in the production cooler. (B) Uncovered boxes of packaging material were being stored on the dock. (C) broken glass was found on finished cartons in the storage area

15 The hazard analysis was incomplete: there was no record of hazards considered and rejected, or of the justification for their rejection.

.47 An employee was using floor-cleaning equipment and then putting ice onto exposed product without first washing his hands.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION 9076-4549 Quebec Inc. 61, Rue Notre-Dame, Route 138 Berthierville, Quebec	2. AUDIT DATE	3. ESTABLISHMENT NO. 603	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		6. TYPE OF AUDIT <input 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

B-136

Est 603

Note: This establishment was originally scheduled to be included in the audit, but it was closed permanently before the scheduled audit date.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Grand River Poultry Farm Ltd 334 Grand River Street North Paris, Ontario	2. AUDIT DATE Oct 25, 2002	3. ESTABLISHMENT NO. 612	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.		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.		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		
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		X			

60. Observation of the Establishment

B-14b

Est 612

13 No preventive measures were recorded either in the daily pre-operational or in the daily operational sanitation documentation

15 (A) The hazard analysis was incomplete: there was no record of hazards considered and rejected, or of the justification for their rejection. (B) Preventive measures were not included in the written corrective actions specified in response to deviations from critical limits.

22 The documentation of preventive measures was not included in the written corrective actions taken in response to deviations from critical limits.

32 Part of the population was not included in the sample selection process.

This establishment was not operating on the day of the audit due to construction.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Keewatin Meat and Fish Ltd P O Box 329 Rankin Inlet, Nunavut	2. AUDIT DATE Oct 30, 2002	3. ESTABLISHMENT NO. 619	4. NAME OF COUNTRY Canada
	5. NAME OF AUDITOR(S) Dr. M. Douglas Parks		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.	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	
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	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

B-156

Est 619

10/46 (A) There was no hot water at the hand wash sink. (B) Some exposed product drying racks had residues from previous days' operations.

13 No preventive measures were recorded either in the daily pre-operational or in the daily operational sanitation documentation.

15 The hazard analysis was incomplete: there was no record of hazards considered and rejected, or of the justification for their rejection.

61. NAME OF AUDITOR

Dr. M. Douglas Parks

62. AUDITOR SIGNATURE AND DATE



Canadian Food Inspection Agency Agence canadienne
d'inspection des aliments

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K1A 0Y9

Tel: (613) 221-7003
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MAY 26 2003

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Chief, Equivalence Section
International Policy Staff
Office of Policy, Program Development
and Evaluation
United States Department of Agriculture
Food Safety and Inspection Service
Washington, D.C. 20250

Dear Ms Stratmoen:

SUBJECT: Audit of Canadian Meat Inspection System

This is further to your letter of March 20, 2003 providing us with a copy of the draft final audit report for the on-site audit of the Canadian meat and poultry inspection system conducted by the FSIS between October 15 and November 15, 2003.

As per routine procedures, an inspection report is produced immediately following the inspection of establishments. The content of the report is discussed among inspection officials and afterwards is presented to the operator of the establishment with a request to take appropriate corrective/preventive measures. On behalf of the CFIA, I can confirm that the appropriate corrective action has been taken to address shortcomings identified in establishments during the visit. Enclosed, as requested, are follow-up reports that describe the corrective and preventive actions taken in the two establishments that were given a 30-day notice.

For establishments revisited, CFIA supervisors were requested to pay special attention to repetitive deficiencies and for all establishments to verify that sanitation programs and HACCP plans are complete and effective. This action has been taken to address FSIS observations that indicated a need for improvement in the implementation of sanitation and HACCP requirements.

In order to facilitate compliance, we have re-examined the applicable sections of our Manual of Procedures and Food Safety Enhancement Program. Amendments have been made to help all concerned better understand the requirements. Canadian sanitation requirements have already been recognized as equivalent to FSIS requirements. We have, nevertheless, brought more emphasis on the need to implement preventive measures in addition to corrective measures in the procedures.

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Regarding HACCP systems, Canada has chosen to implement the HACCP principles using a comprehensive system referred to as the "Food Safety Enhancement Program". This program in addition to using HACCP principles, as per CODEX guidelines, is built on auditable prerequisite programs aimed at ensuring that the work environment is suitable for food production. These programs include premises, transportation, equipment, personnel, sanitation (SSOP) and pest control and recalls.

The Food Safety Enhancement Program (FSEP) Manual, Volume IV clearly indicates that the auditor, before closing a Corrective Action Request (CAR), must be satisfied that the corrective actions have been implemented and are effective. Obviously, if a condition repeats, the corrective action is not effective and a subsequent CAR would not be closed unless a preventive action is implemented. The FSEP Manual states:

"All CARs will be subjected to follow-up by the auditor/responsible inspector. He/she will review all written corrective actions submitted by the company to determine if they are acceptable.

After the "Date for completion of corrective action", the auditor / responsible inspector will perform a follow-up visit at the establishment to ensure that the corrective actions have been completed as described and are effective. Follow-up visits will be performed during the subsequent audits or sooner if required.

Note:

the follow-up visit by the auditor/responsible inspector for a major non-conformity must be performed as soon as possible after the "Date for completion of corrective action" identified in Part B of the CAR form (see Section 6.3.3).

When the auditor/responsible inspector is satisfied that the corrective action is completed and effective, the CAR will be closed."

In addition, the training material is again placing emphasis on that aspect. All this material was and is still available for FSIS auditors to review. However, in light of the comments made, the CFIA decided to modify the CAR form to even further clarify the necessity for preventative measures to be included. (copy attached)

CFIA has also re-examined its inspection requirements regarding the zero tolerance for contamination of meat products during dressing. Canadian requirements prescribe that "all carcasses and parts presented for post mortem inspection should be cleaned and free from dressing defects". Operators are responsible for ensuring that this requirement is met and inspection staff are responsible for monitoring the situation. In response to concerns raised, this aspect has been emphasized as it relates to contamination with faecal material, ingesta or milk to facilitate its definition in establishments HACCP systems.

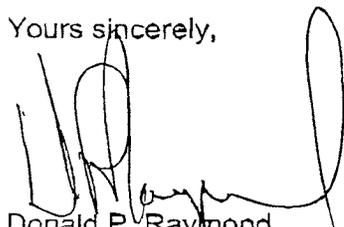
The analytical methodology used by Canada for *E.coli* O157:H7 is currently under review. All required information is being provided to permit the evaluation (under an equivalence exercise already initiated) of the sensitivity of the methods officially approved by the CFIA for such testing. Regarding the testing for generic *E. coli*, we believe that this was simply a misunderstanding. It is clear that all laboratories have to use an AOAC approved method. We do not intend to present alternative methods at this time. The laboratory in question has been contacted to ensure that all are clear on this matter.

Regarding species verification, the CFIA conducts a monitoring program each year that requires sampling in establishments that manufacture products for which the species of origin cannot be readily identified (e.g., comminuted products). Sampling is conducted randomly, which means that not all establishments are selected for monitoring on an annual basis. Establishments manufacturing products such as cuts readily identifiable are not targeted by the Canadian monitoring species verification program. In establishments visited the program was delivered as planned.

Please rest assured that the CFIA is committed to ensure that all applicable FSIS requirements are met by Canadian establishments eligible to export to the USA. CFIA corrective and preventive actions described above do address the issues raised during the audit.

Should you wish to further discuss the actions taken by the CFIA, please do not hesitate to contact this office.

Yours sincerely,

A handwritten signature in black ink, appearing to read 'Donald P. Raymond', with a large, stylized flourish extending to the right.

Donald P. Raymond
Acting Director
Food of Animal Origin Division

Enclosure