

**Beef
Quality
Assurance
Standard**

Processor Standard



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Table of Contents

1 Introduction

2 Scheme Regulations

3 Processor Requirements

4 Appendices

4.1 Reference Information

4.2 DAF Animal Transport Inspection Report Form

4.3 Meat Plant SOPs

4.4 Final Product Testing

Note: The Processor needs to be fully aware of the requirements of the Producer Standard.

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I Introduction

Introduction

This section contains important general information for Processors and forms part of the overall requirements of the Standard. It is crucial that Processors take sufficient time to read and fully understand this section of the Standard (Introduction, all sub-sections).

The relevant Processor requirements are described in this Standard for Processors (i.e. Section 1, Introduction; Section 2, Scheme Regulations; Section 3, Processor Requirements and Section 4, Appendices).

However, the Processor also needs to understand fully the Producer requirements as set out in the Bord Bia Beef Quality Assurance Standard for Producers a copy of which is included with this standard.

CONTENTS

- 1.1 Background and Objectives
- 1.2 Terms, Requirements Categories and Application of Non-Compliances
- 1.3 Formal Training
- 1.4 Definitions
- 1.5 Normative References for the Standard
- 1.6 Cautionary Notes

1.1

BACKGROUND AND OBJECTIVES

- a) The Bord Bia Beef Quality Assurance Scheme is based on this integrated Processor Standard and on the Producer Standard. It involves the Beef Processor working in partnership with the Producer to ensure best practice in beef production and processing.
- b) Beef produced and processed in accordance with the requirements laid down in the Standards (Producer and Processor) is described as Quality Assured Beef. No other implication can be taken from this term (see also definitions below).
- c) Other standards that are deemed to be equivalent to this standard may be acceptable subject to formal approval by Bord Bia.

- d) The Beef Quality Assurance Standard was developed by an expert group representing Bord Bia, Teagasc, the Food Safety Authority of Ireland, the Beef industry (Producers and Processors), Industry Advisors and the Department of Agriculture and Food. It replaces the previous revision (Revision 02) issued in 1995.
- e) The full onus of responsibility for compliance with the requirements of this Processor Standard is on Processors participating in the Scheme and not on Bord Bia or its auditors or any other third party. Compliance is monitored through independent audit.
- f) The requirements detailed in this Standard do not and are not intended to replace any statutory obligations of the industry.

TERMS, REQUIREMENTS CATEGORIES AND APPLICATION OF NON-COMPLIANCES

1.2

1.2.1

*Explanation of terms
"Must", "Should",
"Critical and
Categories 1-3"*

Mandatory Requirements are indicated in the text with the term "must". Non-mandatory requirements are indicated in the text with the term "should".

The requirements and their meaning and significance (and compliance with these requirements as determined by audit or other means) are detailed here:

- **Critical:** where a breach of the requirements may constitute a grave and immediate food safety risk. These requirements are indicated in the text in **bold underlined** typeface and the word "Critical" appears in bold underlined text in parentheses at the end of the sentence or paragraph as follows **(Critical)**.
- **Category 1:** where the requirements deal with core best practices. These requirements are indicated in the text in **bold** typeface and the word "Category 1" appears in bold text in parentheses at the end of the sentence or paragraph as follows **(Category 1)**.
- **Category 2:** all the mandatory requirements not Critical or Category 1 are Category 2 and appear in the text in normal typeface.
- **Category 3:** These are recommendations for best practice and are indicated in the text in *italic* typeface. While not mandatory, they are expected to be adopted unless evidence exists that the requirement(s) need not be adopted. This evidence will be examined on a case-by-case basis during audits.

1.2.2
Application of
Non-Compliances
(as determined by
independent audits)

First Time Auditees

Critical or Category 1 Non-Compliances:

Failure to comply with a Critical or Category 1 requirement as determined by audit automatically excludes first time auditees from certification under the Scheme.

Category 2 Non-Compliances:

Where there are more than 15 category 2 non-compliances the auditee will be deemed to have a Category 1 non-compliance (see above) and will be automatically excluded from certification under the Scheme.

Where there are 15 or less Category 2 non-compliances, the auditee must then give a signed commitment to the Auditor to have the necessary corrective/preventive action put in place within the time-scale specified (maximum period 3 months). Written evidence that the corrective/preventive action has been/is being put in place must be available before certification is granted.

Depending on the nature of the non-compliance and the corresponding response, an on-site verification of the corrective/preventive action may be required.

Category 3 Non-Compliances:

Failure to comply with applicable recommendations as determined by audit will be noted in the audit report and corrective/preventive actions must be implemented before the next full audit.

Existing Members

Critical Non-Compliance:

Failure to comply with a critical requirement, as determined by audit, obliges the Processor to immediately cease to market Beef as 'Quality Assured' under the Scheme. The auditor will immediately advise the Certification body (or Bord Bia) of the situation. The Processor's Membership will be automatically "Suspended" pending a review of the situation and a formal decision regarding membership.

Category 1 Non-Compliance:

Failure to comply with a Category 1 requirement, as determined by audit, obliges the Processor to initiate immediate corrective/preventive action. The Auditor will specify the nature of the non-compliance and the corresponding time-scale for completion (up to a maximum of one month). Membership status will be "Under Review" during this one-month period.

The Processor must give a signed commitment to the Auditor to have the problem resolved within the time-scale specified (maximum one month from date of audit).

Depending on the nature of the non-compliance and the corresponding response, an on-site verification of the corrective/preventive action may be required. On confirmation that effective corrective/preventive action has been put in place, certification will be renewed.

Failure to provide satisfactory evidence within the specified time-scale will result in cancellation of membership, removal from the BQAS register/database and withdrawal of the certificate.

Category 2 Non-Compliances:

Where there are more than 15 category 2 non-compliances the auditee will be deemed to have a Category 1 non-compliance (see above).

Where there are 15 or less Category 2 non-compliances, the auditee must then give a signed commitment to the Auditor to have the necessary corrective/preventive action put in place within the time-scale specified (maximum period 3 months). Written evidence that the corrective/preventative action has been/is being put in place must be provided before certification can be renewed.

Depending on the nature of the non-compliance and the corresponding response, an on-site verification of the corrective/preventive action may be required.

Failure to provide satisfactory evidence within the specified time-scale will result in cancellation of membership, removal from the BQAS register/database and withdrawal of the certificate.

Category 3 Non-Compliances:

Failure to comply with applicable recommendations as determined by audit will be noted in the audit report and corrective/preventive actions must be implemented before the next full audit.

1.3

FORMAL TRAINING

The term "formal training" is used to indicate the requirement that the training was received from a national or public body or from a Bord Bia approved organisation/individual and that a certificate is available.

1.4

DEFINITIONS

BQAS: the Bord Bia Beef Quality Assurance Scheme.

BQAS Register/Database: the register / database of the current certified members indicating the membership status.

Bord Bia: the Irish Food Board.

Certification Body: the body / agency to which the Quality Assurance Board has devolved responsibility / authority for all certification decisions regarding membership of the scheme.

DAF is taken to mean the Department of Agriculture and Food.

FSAI is taken to mean the Food Safety Authority of Ireland.

Member: a Producer or Processor that is certified under the BQAS and is shown on the BQAS register / database.

Membership Certification Period: Processors: this will be 18 months from the date of issue of the Membership Certificate or until the next audit.

Membership Certification Types:

- **Certified:** the status (as indicated on the BQAS register / database) that is given where there is compliance (as defined in Introduction sub-section 1.2).
- **Under Review:** the status (as indicated in the BQAS register / database) of the Processor where category 1 non-compliance(s) or appeal(s) exist (as defined in Introduction sub-section 1.2).
- **Suspended:** the status (as indicated on the BQAS register / database) of the membership of the Processor where a critical non-compliance has been identified. In this situation, beef cannot be marketed under the Scheme pending a formal decision of the Certification Body.

Processor Standard: the requirements as set out in Sections 1-4 in this document (Processor Standard) which detail current best practices for the processing of beef.

Scheme: the Beef Quality Assurance Scheme consists of three elements:

- The Producer Standard,
- The Processor Standard,
- The process for ensuring that the requirements as set out in the Standards are met (through auditing, certification, etc.) and that the relevant details are published.

Producer: a beef Producer with a valid Herd Number.

Quality Assurance Board: an independent subsidiary Board within Bord Bia which has overall responsibility for policy in relation to the operation of the Quality Assurance Scheme.

1.5

NORMATIVE REFERENCES FOR THE STANDARD

This Standard has been derived bearing in mind the requirements of the following legislation and standards:

- Recognised international Quality Management Systems (such as ISO 9000).
- Hazard Analysis and Critical Control Point analysis (HACCP, such as outlined by Codex Alimentarius (1997) and as contained in IS 343: 2000).
- Relevant National and EU derived legislative requirements.
- EN45011 (1998): General Criteria for Certification Bodies Operating Product Certification.

1.6

CAUTIONARY NOTES

Although every effort has been made to ensure the accuracy of this Standard, Bord Bia cannot accept any responsibility for errors or omissions.

It is not a requirement that the Processor be registered to any part of ISO 9001: 2000 or I.S. 343: 2000, nor is it implied that meeting the requirements of this Standard will automatically mean full compliance with the ISO 9001: 2000 or I.S. 343: 2000 Standards. The Standard can, however, provide a basis for the attainment of the ISO 9001: 2000 and/ or I.S. 343: 2000 Standards, or equivalent.

Bord Bia is not liable for any potential or estimated loss of earnings (by applicants or members) resulting from compliance with any requirement of this scheme or in regard to the consequences of being found to be in breach of Critical or other requirements.

2 Scheme Regulations

Scheme Regulations

This section contains important general information for Processors and forms part of the overall requirements of the Standard. It is crucial that Processors take sufficient time to read and fully understand this section of the Standard (Scheme Regulations, all sub-sections).

CONTENTS

- 2.1 Eligible Beef and Beef Products
- 2.2 Membership Requirements
- 2.3 Control and Monitoring
- 2.4 Certification Decisions
- 2.7 Revision Updates
- 2.8 Notification of Change
- 2.9 Use of the Quality Logo

2.1

ELIGIBLE BEEF AND BEEF PRODUCTS

Only cattle sourced from producers certified under the Producer Standard are eligible for inclusion in the Scheme.

Qualifying categories of cattle are:

- Bulls,
- Steers,
- Heifers,
- Cows.

Imported product may also be eligible for inclusion provided that it is sourced from a quality assurance scheme that has been deemed equivalent by the Bord Bia Technical Advisory Committee.

Only products that are derived from fresh meat that has undergone no treatment other than refrigeration (chilling or freezing) are eligible for inclusion in the scheme i.e.:

- Carcase Beef,
- Bone-in quarters,
- Bone-in cuts,
- Pre-packed cuts (e.g. Vac-Pack or MAP),
- Mince meat.

Other value-added beef products that have been produced using fresh meat may also be marketed under the scheme subject to a specific application being made in this regard.

2.2

MEMBERSHIP REQUIREMENTS

Membership of the Scheme is voluntary and open to all Beef Abattoirs and Beef Processors that are approved and/or licensed in accordance with relevant national and/or EU regulations.

Processors seeking membership must initially apply in writing to the Certification Body (or Bord Bia) using the application form that is provided on request.

The application will then be evaluated and, if appropriate, a full independent audit of the Processor will be carried out to evaluate the capability of the applicant to meet all the requirements of the Standard.

When the Processor is deemed to have complied with the requirements of the Standard as determined by independent audit, the Processor will be considered for certification under the Scheme. The Processor will be required to sign an Undertaking and Indemnity Form prior to certification.

When certified, the Processor will be issued with a Membership Certificate and will be listed on a database/register.

The Member Processor is thereafter permitted to use the Quality Assured Logo on approved specified product/packaging and/or related documentation.

Member Processors will be charged an annual membership fee.

Database Information:

The names of all certified Processors will be published on the BQAS register/database.

2.3

CONTROL AND MONITORING

Control

Overall control of the Scheme will be exercised by the Bord Bia Quality Assurance Board. This Board is representative of the relevant sectors of the food industry and collaborates with the Technical Advisory Committee, which is responsible for drafting the Standard and formulating required amendments.

The decision of the Quality Assurance Board on any matter relating to the control or operation of the Scheme is final.

Monitoring

After the initial successful application, monitoring of Processor's compliance with the requirements of the Standard will be carried out by Bord Bia or its nominated agents through audit.

Each Processor will be independently audited at determined intervals (at a minimum once per year). Professional Auditors with sectoral experience will carry out these audits and a full report will be issued to the Processor.

Bord Bia reserves the right to carry out Audits or Spot Checks on an unannounced basis for the purposes of verifying compliance with the requirements of the Standard or to determine that corrective/preventive actions specified during audit are in place.

Bord Bia reserves the right to remove samples of Beef for the purposes of testing by an independent Laboratory that is accredited to ISO 17025 to determine compliance with the requirements of the Standard.

Auditors are entitled to seek access to, make copies of, or take extracts from official Veterinary office documentation, with the agreement of the Veterinary Officer on site.

Auditors are entitled to seek access to relevant regulatory reports.

2.4

CERTIFICATION DECISIONS

The decision to grant, extend or remove certification of a Member of the Quality Assurance Scheme will be made by the Certification Body. This decision will be made primarily on the basis of the audit findings, but other factors (such as failure to meet regulatory compliance or other food safety requirements, or previous audit history) may be taken into consideration in arriving at the certification decision.

The membership certificate must be returned in the event that the Certification is withdrawn.

2.5

APPEALS

The Processor may appeal decisions that affect membership status by writing to the Certification Body (or Bord Bia) within four weeks of the date of issue of the result of the audit. The request to appeal will be acknowledged and followed up by the Certification Body.

2.6

COMPLAINTS

The Processor may complain with regard to the audits or any other aspect of the operation of the scheme. All complaints must be in writing and must be addressed to the Certification Body (or Bord Bia). All such complaints will be acknowledged and followed up.

2.7

REVISION UPDATES

Users should note that only this latest edition now applies. When future changes occur, updates will be issued in whole or in part and the obsolete sections must be destroyed.

2.8

NOTIFICATION OF CHANGE

In the event that the ownership, structure or management of the Processor changes, or in the event that the Management Representative changes, Bord Bia or its nominated Certification Body must be immediately informed.

2.9

USE OF THE QUALITY LOGO

The Quality Assured Scheme Logo is a registered Trade Mark. It is the property of Bord Bia and must only be used with the Bord Bia's full knowledge and written approval.

Bord Bia reserves the right to take appropriate action against companies that use the Logo without proper authorisation or without observing all the requirements of the Standard.

Bord Bia reserves the right to withdraw permission to use the Logo where evidence indicates that the requirements of the Standard are not being met.

The Beef Quality Assured Logo must conform to the logos that are available in printed and electronic form from Bord Bia.

All costs in applying the Logo must be fully borne by the Processor.

In addition to the conditions outlined in Processor Standard (relating to Identification and Traceability), the following conditions also apply to the use of the Logo on product:

1. When used on packaging, the Logo must always include the designated Plant Number. In addition, it must be placed in a prominent position and must not be obscured in any way.
2. The size of the Logo must be at least 25mm².
3. The Logo may be pre-printed, incorporated in a brand label, or applied as an individual sticker but not as part of a price/weight/date label.
4. Prior to using the Logo, Processors must contact Bord Bia for the most up-to-date version and guidelines for its use.

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3 Processor Requirements

Processor Requirements

CONTENTS

Management Responsibility

- 3.1 Quality Policy Statement
- 3.2 Organisation
- 3.3 Management Review
- 3.4 Quality System
- 3.5 HACCP and GMP Plans
- 3.6 Resources

Process Management

- 3.7 Customer Contract Requirements
- 3.8 Purchasing, Supplier and Materials Controls
- 3.9 Animal Welfare
- 3.10 Animal Transport and Animal Receipts
- 3.11 Processing
- 3.12 Bone in and Boneless Meat
- 3.13 Final Product Release
- 3.14 Product Identification and Traceability
- 3.15 Processing, Storage, Dispatch and Transport
- 3.16 Control of Non-Conforming Product
- 3.17 Special Requirements For Mince

Measurement and Improvement

- 3.18 Internal Audits
- 3.19 Inspection and Testing
- 3.20 Control of Inspection, Measuring and Test Equipment
- 3.21 Improvement

General Hygiene and GMP

- 3.22 Plant and Facilities
- 3.23 Maintenance

Environmental Hygiene

- 3.24 Breakables
- 3.25 Exterior, Structure and Grounds
- 3.26 Interiors: General
- 3.27 Entry to production
- 3.28 Interior Walls
- 3.29 Ceilings and Overheads
- 3.30 Floors
- 3.31 Drainage
- 3.32 Doors
- 3.33 Windows
- 3.34 Lighting
- 3.35 Water, and Water Treatment
- 3.36 Knives, Sterilisers, Hoses and Other Equipment
- 3.37 Extraction and Ventilation
- 3.38 Cleaning Materials and Storage
- 3.39 Effluent Treatment
- 3.40 Food Trays
- 3.41 Electronic Fly Killers
- 3.42 Waste Disposal General

Personnel Hygiene

- 3.43 General
- 3.44 Medical Records
- 3.45 First Aid
- 3.46 Personal Hygiene
- 3.47 Personnel Clothing and Locker Rooms
- 3.48 Personnel Facilities including Canteens
- 3.49 Toilet Facilities
- 3.50 Washing Facilities in Production

Management Responsibility

3.1

QUALITY POLICY STATEMENT

- a) Processors must have a Quality Policy, which must include a commitment to the objectives of the Bord Bia Beef Quality Assurance Scheme and to complying with all current food safety, regulatory and customer requirements.
- b) The Quality Policy must be approved by senior management and prominently displayed on the premises.
- c) All staff must be aware of the location of the Quality Policy.
- d) *The Quality Policy should include a commitment to Continuous Improvement, Safety in the Workplace, and to providing appropriate information, training and equipment for all employees.*
- e) *The Quality Policy should be communicated, understood and implemented by all staff and employees.*
- f) *The Quality Policy should be regularly reviewed for suitability and effectiveness.*

3.2

ORGANISATION

Management Responsibility

- a) An organisation chart must be available showing the reporting structure.
- b) The commitment of senior management to the effective implementation of the requirements of this standard must be clearly demonstrated and communicated.
- c) The responsibilities of key personnel must be documented.
- d) Management must be able to demonstrate an adequate level of technical support with appropriate qualifications and other resources for the effective implementation of the Standard.
- e) **In the event that a critical non-compliance (including regulatory sanctions) is identified during internal audits or routine checks, the Processor must immediately notify Bord Bia and/or the Certification Body and implement the procedures as outlined for critical non-compliances in the Introduction 1.2 (Critical).**

- f) Management must define the person(s):
 - i) That has responsibility for ensuring compliance with regulatory requirements (see Appendix 1: Reference Information) and compliance with the requirements of this Standard,
 - ii) That has responsibility for non-conforming product management,
 - iii) That has responsibility for corrective and preventive action management,
 - iv) That has responsibility for food safety (who ideally should be independent of the production function).
- g) Management must define the person(s) who is responsible for ensuring compliance with the hygiene requirements and must establish an acceptable system to demonstrate that the requirements are being met.

Management Representative

- h) The Processor must officially identify a Management Representative who, irrespective of other responsibilities, has responsibility for ensuring that the requirements of the Beef Quality Assurance Standard are met.
- i) In the event of the Management Representative being changed, the Certification Body (or Bord Bia) must be immediately notified in writing.

MANAGEMENT REVIEW

3.3

- a) Management, which must include senior Management, must meet at least once each year with a clearly defined agenda to:
 - i) Review the complete Quality System for improvements opportunities,
 - ii) Ensure that all aspects of the Quality System as specified in these requirements remain suitable and effective, and that preventive or corrective actions are assigned, documented and implemented,

- iii Review all Quality System data (including audit reports, customer complaints, customer satisfaction data, process and non-conformance data, etc.) to establish and assign responsibility for improvements,
 - iv Set out Quality Improvement Objectives for the next year.
- b) Minutes of this meeting must be retained.

3.4

QUALITY SYSTEM

Quality Documentation

- a) Processors must document their own Quality System, which must incorporate the requirements of this Standard and their interaction with other parts of the Quality System.
- b) This system must consist of documentation that details the Processor's response to each requirement of this Standard and that includes or references related operational documents, procedures and plans.
- c) The Quality System documentation (such as Hygiene procedures, work instructions, procedures, specifications, etc.) must be accessible so that all employees clearly understand their roles and responsibilities in the operation of the process.
- d) The Quality System must incorporate the Standard Operational Procedures (SOPs) identified in the DAF Publication (see Appendix 3, Meat Plant SOPs).

Quality Assurance Control Plan

- e) Processors must document (such as by flow-chart) how the process is managed to ensure the quality and safety of the product.
- f) Documentation must be available that demonstrates that the essential "Pre-requisite" requirements of Good Manufacturing Practice (GMP) and Good Hygiene Practice (GHP) have been adequately addressed at all appropriate steps, including procurement and in accordance with Appendix 3, Meat Plant SOPs.

Document and Data Control

Note: It is recommended that the requirements for document and data control as outlined in ISO 9001: 2000 be adopted.

- g) All documents and data (including relevant external documentation such as this Standard, Customer and Regulatory documentation) that relate to the requirements of this Standard must be managed and controlled as part of the Quality Management System. At a minimum, the Processor must ensure that:
 - i Only current issues of all documents are available for use,
 - ii All documents are authorised,
 - iii A procedure for issue of new documents, or amending existing documents, or removal of obsolete documents is in place and is effective,
 - iv Data is reviewed and signed off by an authorised person,
 - v A master list of documents and procedures exists identifying the current revisions status,
 - vi Applicable documents of external origin must be identified and effectively controlled.
- h) This Standard is subject to document control. When revisions are deemed necessary and issued by Bord Bia, it is the responsibility of the Processor to ensure that their Standard is correctly updated (see Scheme Regulations Section 2.7).

Records

- i) All records must be controlled (e.g. by signing and dating) and must be maintained at a secure and easily accessible location for a minimum period of three years unless otherwise specified (e.g. for SRM).

Improvement Plans

- j) Processors must carry out an analysis of current and future market requirements including those of a regulatory nature, audit reports, customer complaints and incidences of non-conformance. This can be included in the Management Review.
- k) *Management and key operational staff should have received an appreciation of the tools and techniques of Total Quality Management/Continuous Improvement.*

3.5

HACCP AND GMP PLANS

Note: All processors are required to demonstrate compliance with Commission Decision 2001/471/EC (see Appendix 1: Reference Information) on microbiological testing. This incorporates a requirement to have a continuum of satisfactory results over the prescribed period. Auditors carrying out audits under the Beef Quality Assurance Scheme must be given access to these results to verify ongoing compliance.

- a) **The Processor must have a Hazard Analysis Critical Control Point (HACCP) plan that shows how product/process safety is ensured through control and prevention (Critical).**
- b) This plan must be supported by senior Management, it must be put in place by a multidiscipline team and at least one member of this team must have received formal training in the application of HACCP Principles.
- c) **At a minimum the HACCP plan must include (all Category 1):**
 - i) **A Flow Diagram showing all the steps of the total process involved and identifying those that are Critical Control Points (CCP),**
 - ii) **A documented analysis of the hazards and risks at each step (chemical, microbiological and foreign bodies),**
 - iii) **For each CCP, the limits that must be met to ensure control of this CCP must be defined,**
 - iv) **For each CCP, the monitoring required to ensure that control is maintained at this point,**
 - v) **For each CCP, the corrective action to be taken if a deviation occurs,**
 - vi) **For each step and CCP, the responsibilities, procedures and records that are applicable.**
- d) A record of the preliminary risk assessments made must be retained.
- e) **The HACCP plan must be verified/tested annually at a minimum to ensure that it is effective (Category 1).**
- f) The HACCP plan must be supported by the GMP and GHP Plans.
- g) *The HACCP System should be modelled on I.S. 343: 2000 issued by the National Standards Authority of Ireland (Food Safety Management Incorporating HACCP) or on an equivalent recognised standard.*

3.6

RESOURCES

Reference Information

- a) Processors should maintain up-to-date information on all developments relevant to the operation of the BQAS.
- b) The Processor should maintain a list of all current relevant Statutory Instruments defining regulations for processors for easy use and reference (see also Appendix 1, Reference Information).

Animal Welfare

- c) Processors that carry out slaughtering must have at least one formally trained Animal Welfare Officer responsible for ensuring that animal welfare standards are maintained; Processors must also ensure that the person carrying out slaughtering holds a current licence for this activity.

Training

Note: It is a legal requirement that operatives are trained in their duties.

- d) The person with overall responsibility for training must be identified.
- e) Processors must carry out a review at least annually to identify the training needs of all staff and to verify the effectiveness of the training given.
- f) **All operational staff, including maintenance staff, must receive induction and on-going food hygiene and HACCP training, and records of this must be maintained (Category 1).**
- g) Training records must be maintained for all personnel performing key tasks.

Process Management

3.7

CUSTOMER CONTRACT REQUIREMENTS

Product and Process Design and Development

- a) Processors must be able to demonstrate that relevant regulatory and customer requirements incorporating HACCP principles have been taken into account in the design of new products and processes.
- b) Where the shelf life of products needs to be defined, a process for establishing it must be documented and validated under ideal and predictable conditions of use and records maintained.
- c) A schedule must be maintained for the monitoring of shelf life of products.

Customer List and Specifications

- d) Processors must maintain a list of all customers to whom product is being supplied under the BQAS.
- e) The Customer list and all agreed contracts must be reviewed at least once each year.
- f) A documented specification must be maintained for each product supplied to each customer under the BQAS.
- g) There must be a procedure to ensure that contracts are reviewed prior to acceptance to determine that all requirements including documentation can be met prior to acceptance.

3.8

PURCHASING, SUPPLIER AND MATERIALS CONTROLS

General

- a) Processors must maintain a list of suppliers that have been approved to supply materials or services that could affect product quality or safety.
- b) The process of approving suppliers prior to purchasing materials that come in contact with the product must include an appropriate risk assessment and must define appropriate controls.
- c) All approved supplier lists must be reviewed at defined intervals to maintain accuracy of the information and this review must include a risk assessment analysis.
- d) All materials that could affect product quality or safety must be checked and approved before use. A record of these approvals must be maintained.

- e) The storage of all materials that could affect product quality or safety must be managed in a way that ensures continuing fitness for purpose.
- f) All materials must be stored on site and used in a manner that prevents chemical, physical or microbiological contamination of product.

Beef Producer (Supplier)

- g) Records must be available to demonstrate that beef to be marketed under the Scheme was only sourced from Producers who have been certified under the BOAS or an equivalent scheme approved in advance by Bord Bia (Critical).

Animal Pre-selection

Note: An ante-mortem veterinary inspection of all cattle is completed by the Veterinary Inspector and documented to establish that all cattle are in conformity with the provisions of national regulations.

- h) Processors must provide suitable facilities for conducting the ante-mortem inspection (see Appendix 3, Meat Plant SOPs).

Water

- i) All water, steam or ice (that can come in contact with the product) must be potable and meet the requirements of the EC (Quality of Water intended for Human Consumption) Regulations 1988 (S.I. 88 of 1988 as amended) (Category 1).
- j) A sample of water must be tested at least monthly (at a minimum for the parameters described below) and the results retained. The samples must be taken from multiple sites by trained personnel (Category 1).
- k) In the event that the source of the water is changed at any time, the new source must be tested for compliance and approved before use (Category 1).
- l) Microbiological analysis of the water must comply with the following at a minimum:

TVC @22°C	<100 per ml
TVC @37°C	< 10 per ml
Total Coliforms	0 per 100ml
<i>E. coli</i>	0 per 100ml
- m) If there is a failure, an alternative compliant supply must be used immediately. Corrective measures must be taken. The original supply may be reused when it has been demonstrated to be compliant.

- n) Non-potable water is not permitted in the plant except where dedicated pipes are used and the Non-Potable water pipes are clearly distinguished from Potable pipes to prevent inadvertent use.
- o) Where chlorination is installed, the dosing system must incorporate an alarm device and must be designed so that the minimum chlorine contact time is 20 minutes at peak demand at a free chlorine level of less than 1 ppm with a target of 0.2-0.5 ppm.
- p) There must be measurement of residual chlorine in treated water at least twice daily, and records retained.
- q) Where alternative disinfection systems are used (e.g. ozonation, membrane filtration, etc.), these must be designed so that operators can easily determine that they are operating effectively.
- r) A programme must be in place to prevent organic matter build up in tanks (e.g. Drain the system annually, Use a cleaner / sanitiser to clean the storage tanks etc., Then flush with clean water).
- s) There must be a water distribution system map or drawing, showing, source, storage, Hot and Cold distribution in the plant and the locations of the sampling points.
- t) Storage Tanks must conform to the following specification:
 - i Manufactured from inert material,
 - ii Covered and fitted with an Inspection Hatch,
 - iii Water inlet at the top of the tank (to prevent sediment disturbance),
 - iv Water outlet at the bottom of the tank,
 - v Fitted with screened vent pipes.

Detergents and Sanitising Materials

- u) The Processor must have on file current certificates of suitability for use in meat processing for Soaps, Detergents, Marking Inks, Lubricants and Packaging Materials.
- v) All such materials and chemicals must be stored in a manner that permits control over their use.
- w) All such materials must be inspected on delivery to ensure suitability for use in the plant (correct labelling, integrity of packaging, correct specification, etc.).

3.9

ANIMAL WELFARE

Animal Welfare and Lairage

- a) Lairage and slaughter staff must be able to demonstrate competence and compassion in their handling of cattle.
- b) All lairage staff must have received training in the handling of cattle by a trained animal welfare officer in consultation with the veterinary inspectors and a record maintained.
- c) Lairages must be included in the plant cleaning and sanitation programme.
- d) Staff member(s) with defined responsibility for lairage management must be available to oversee the unloading and the subsequent passage of animals through the lairage to the point of stunning and slaughter.
- e) Animals must be unloaded with care in a calm, unhurried manner.
- f) Goads must only be used as a last resort when the animal refuses to move. They may only be used on hindquarters and only when the animal is free to move forward.
- g) The lairage must be covered to provide protection for the animals from inclement weather conditions and must be ventilated.
- h) The walls, floors and pens must be made of strong and durable material, free of sharp edges that could cause injury, and the floors must be made of non-slip material.
- i) Lairage surfaces must be designed for ease of maintenance and cleaning.
- j) Potable water must be supplied to the drinking points in all pens and be available at all times and, in addition, feed racks must be supplied where animals are held overnight.
- k) The stocking densities in the lairage pens must be maintained at a level that will prevent stress and injury while allowing movement of the cattle.
- l) All drains must be trapped and securely gridded.
- m) Lighting must be available for inspection at convenient points, but live cattle must not be exposed to continuous bright artificial light.
- n) *Animals entering the abattoir should, where possible, be maintained and penned in the groups in which they have been transported.*

- o) A designated DAF approved detention pen must be provided.
- p) Fractious and excitable stock must be penned separately.
- q) *Livestock have sensitive hearing and are stressed by excessive noise and therefore, noise should be minimised. Factors to consider are:*
 - i *Fitting gate strike posts with rubber stops,*
 - ii *Piping air exhausts (on pneumatically powered gates) outside,*
 - iii *Where hydraulics are used to power gates, locating the motor and pump away from the cattle.*

Stunning

- r) The movement of animals along the approach race towards the stunning pen must be calm and unimpeded with physical stress to the animal kept to the minimum.
- s) *Lighting should encourage animals to move forward from subdued lighting in the approach race to the brighter stunning area.*
- t) The approach race must be designed and constructed to prevent cattle from being distracted by what is happening outside the race.
- u) *There should be an exit facility immediately prior to the stunning area to enable cattle to return to the lairage if required.*
- v) All animals must be stunned in DAF approved stunning pens, using DAF approved stunning methods. Stunning pens must conform with the following:
 - i Be designed to avoid noise and distress or injury to the animal,
 - ii Be well lit and accessible to allow inspection of stunning and slaughter to take place,
 - iii Be maintained in good condition.
- w) The stun to stick time must ideally not exceed 45 seconds (unless otherwise stipulated by the Veterinary Officer or Customer) followed by the use of the two-knife sticking technique.
- x) Stunning techniques must be effective as demonstrated by records (e.g. double stunning) and a spare gun must be kept in reserve at all times.
- y) The daily maintenance of stunning instruments must be documented.
- z) Casualty animals must be slaughtered humanely by trained operatives.
- aa) No electrical stimulation or dressing procedures must be carried out until after bleeding has taken place.

3.10**ANIMAL TRANSPORT AND ANIMAL RECEIPTS**

- a) **Processors must maintain a list of approved livestock hauliers (that are not Producers own transport) (Category 1).**
- b) A register must be maintained showing that the approved hauliers have received and signed for a copy of the Teagasc Animal Welfare requirements and the DAF guidelines on animal transport, which are included with this Standard.
- c) Processors must inspect all transport vehicles using a checklist based on these guidelines documents on a planned basis (ideally this would be conducted using the DAF Animal Transport Inspection Report reproduced in Appendix 2).
- d) **A record of every delivery of animals for slaughter to the factory must be maintained showing at a minimum (All Category 1):**
 - i **Delivery truck registration number,**
 - ii **Haulier and/or driver name,**
 - iii **Number of cattle in the delivery,**
 - iv **Time of collection and delivery,**
 - v **Delivery information that will allow traceability of animals originating on BQAS participating Producers farms.**
- e) Facilities to clean and disinfect animal transport must be provided on site.

3.11**PROCESSING**

Carcase Selection

- a) The carcasses must be classified/graded by the DAF Inspectorate.
- b) In the event that the carcase is regraded, the amended documentation must be signed by the DAF inspectorate.

Carcase Dressing

- c) Procedures for dressing carcasses must be in place to prevent cross-contamination (e.g. Hide or unsanitised equipment or surfaces, Digestive tract contents spillage, Contaminated personal equipment or clothing, Other uninspected carcasses, SRM (see Section 3.42 below)).

- d) Dressing must be done immediately after slaughter and in a hygienic manner appropriate for food intended for human consumption.
- e) Dressing techniques must minimise transfer of microorganisms from the hide to the carcass surface.
- f) Task descriptions must be documented for each dressing operation to ensure operatives carry out their tasks hygienically and consistently.
- g) Dressing operations must be supervised, and the slaughter line speeds adjusted where necessary to ensure hygienic operator activity.
- h) Trimming of any visible contamination must be conducted with a sterile knife before the carcass moves to the next workstation.
- i) A two-knife technique must be used for all tasks that involve opening of the hide and the hide must be cut away from the carcass. These knives must be colour coded.
- j) All hide cuts must be “in out” or spear cut (i.e. blade cutting away from carcass) with the exceptions of the initial opening at the hock.
- k) The technique used to open the abdomen must minimise the possibility of cutting into the stomach and intestines.
- l) During evisceration, the gullet (oesophagus) must be tied or rodded and the bung must be bagged and tied.
- m) Adequate demarcation between edible and inedible products must be maintained during production i.e. clearly marked bins for each status of product must be provided.
- n) There must be a documented procedure to address accidental spillage of gut contents.
- o) There must be a documented procedure defining how removal, appropriate staining and storage of all SRM is carried out.

Chilling Regime

- p) Carcasses must be cooled so that the temperature in the centre of the striploin does not fall below 10°C within 12 hours of slaughter. Records of the cooling rate must be maintained and available for inspection. Note: this requirement may not be applicable where high voltage stimulation of carcasses is conducted.

- q) Carcasses must be chilled for a minimum period of 36 hours before de-boning (unless otherwise specified in customer requirements).
- r) Chills must have proper functioning refrigeration that ensures an even airflow and thermographs must be maintained and made available for inspection.
- s) *Carcasses should be positioned within the chill so that they are not exposed to excessive cold air and to ensure air can circulate (e.g. not placed in front of fans which could cause cold shortening).*
- t) Carcasses entering the boning hall must have a temperature of 7°C or less.

3.12

BONE IN AND BONELESS MEAT

Where supplies of Bone-In or Boneless meat products are purchased for processing in the plant, and are intended to be marketed under the BQAS, the following requirements apply.

- a) **Each consignment must be sourced from a BQAS certified Processor (Critical).**
- b) **Each consignment must be accompanied by documentation that clearly demonstrates that the beef came originally from a BQAS certified Producer (e.g. certificate of origin listing the carcass numbers and the source farms) (Critical).**
- c) Each consignment must be examined on delivery (and records maintained to demonstrate compliance) to ensure:
 - i Compliance with a written product specification,
 - ii Freedom from visible contamination or foreign bodies,
 - iii Adequate protection from the environment for chill chain maintenance,
 - iv That the product has been refrigerated in accordance with the temperature requirements in Section 3.15.

3.13

FINAL PRODUCT RELEASE

Positive Release

- a) All meat products must be inspected and positively released for dispatch according to a documented inspection procedure (including any specific tests required by customers) (Category 1).
- b) The personnel with responsibility and authority for final product approval and release must be identified in the procedure and the approval/release documentation.
- c) This inspection must ensure that all product:
 - i Is free from visible contamination before final inspection,
 - ii Meets internal and customer requirements for quality and safety.

Metal Detection

- d) Where there is a HACCP or customer requirement, all boneless products must be passed through a metal detector.
- e) Detectors must be set for optimum sensitivity for the product consistent with customer requirements and incorporate an alarm to signify the presence of metal (ferrous and non-ferrous).
- f) A schedule of testing of the effectiveness of the metal detection system must be in place.
- g) A corrective action procedure must be documented to deal with failures of the metal detection equipment.

3.14

PRODUCT IDENTIFICATION AND TRACEABILITY

- a) Processors must have in place an identification and traceability procedure that permits full traceability along the supply chain to the farm(s) of origin (Critical).
- b) Product marketed under the BOAS must be clearly marked with Processor Identification and Traceability Codes, and the Quality Assured Logo where required (Critical).
- c) The use of the Bord Bia Quality Assured Logo must be in accordance with the requirements set out in regulations (Processor Standard, Section 2) (Category 1).

3.15

PROCESSING, STORAGE, DISPATCH AND TRANSPORT

The following table summarises the temperature requirements for specific products and for production and storage rooms:

Product	Temperature Requirement
Chilled Bone-in	4°C or colder
Chilled Vac-Pack/MAP Meat	0°C ± 1°C
Edible Offals	3°C or colder
Frozen Meat	-12°C or colder
Mince	2°C or colder
Area/Room	Temperature Requirement
Production Rooms	Ambient temperature not exceeding 12°C
Transit Temperature: Chilled	0°C ± 1°C
Transit Temperature: Frozen	-12°C or colder

- a) All temperature-controlled areas must be constantly monitored (and ideally alarmed) and a permanent record available of the temperatures demonstrating that the equipment is capable of controlling storage temperatures as outlined in the table.
- b) There must be a procedure for defining and documenting the Corrective Action taken to address temperature non-conformances observed in these systems.
- c) There must be a procedure in place for the identification and segregation of non-conforming product during storage.

Storage

- d) **Product intended to be marketed under the BQAS must be clearly identifiable (e.g. by segregation, clear labelling, etc.) in storage (Category 1).**
- e) *Quality Assured product lots/batches should not be mixed with other non-assured product on pallets, racks etc. to avoid possible confusion.*

- f) All personnel involved with product storage and dispatch areas must have documented training relevant to this task.
- g) All product (including in-process product, packaging products, etc.) must be stored to ensure it is protected from damage or contamination.

Dispatch and Transport

Note: It is the responsibility of the processor and the transporter to ensure that the cold chain is maintained during loading and transport and is appropriate to the product.

- h) A record of the following checks must be maintained (all Category 1):**
 - i All transport vehicles must be inspected prior to loading to ensure they are clean, waterproof and undamaged; that door seals and air circulation ducts are intact; and that the refrigeration unit is working properly, and has a current ATP certificate,**
 - ii Containers must be checked to ensure that they are pre-cooled prior to loading,**
 - iii Product temperature must be checked prior to loading.**
- i) Records must be maintained to demonstrate the effectiveness of temperature control appropriate to the product during transit.
- j) A contingency plan must be in place to deal with refrigerated delivery breakdown.

Packaging Materials

- k) A certificate of suitability / conformance must be available for all packaging materials that come into contact with the product.

3.16

CONTROL OF NON-CONFORMING PRODUCT

- a) **There must be a documented procedure to ensure that product/material at any stage, which does not conform to requirements, is prevented from unintended use or release (Category 1).**
- b) The procedure must provide for clear identification, adequate segregation and final disposition of the nonconforming product and records of such disposition must be maintained.

- c) Incidents with a potential to cause a food safety hazard (e.g. failure of the metal detection system) must be recorded and reported in writing to the person responsible (as defined in Section 3.2).
- d) The disposition must only be conducted in a manner that permits full traceability and must only be authorised by the personnel specified in Section 3.2. Disposition can include:
 - i Reworking to meet the specification/customer requirements (e.g. by trimming),
 - ii Acceptance with or without reworking by agreed concession from the customer,
 - iii Re-grading (including where necessary re-labelling) for alternative use to which it fully conforms (i.e. so that it meets an alternative specification fully),
 - iv Rejection and destruction.

3.17

SPECIAL REQUIREMENTS FOR MINCE

Processors will be aware of the requirements for mince under the regulations S.I. 243: 1996 (see Appendix 1, Reference Information) and will have implemented procedures and systems to meet those requirements. The following requirements are specific to the Bord Bia scheme:

- a) Mince must not be produced from:
 - i Mechanically recovered meat,
 - ii Scrap cuttings/trimmings,
 - iii Condemned meat,
 - iv Bovine head meat with the exception of the masseter muscle,
 - v Carpus, tarsus and bone scrapings.
- b) Meat from which mince is obtained must not have been stored frozen for more than 18 months.
- c) During mincing the internal temperature of the meat must be monitored and must meet the following criteria:
 - i < 7°C if mincing is completed in less than 1 hour, but < 4°C ideally,
 - ii < 4°C if mincing is NOT completed in 1 hour.
- d) Staff involved in mincing meat must wear mouth and nose masks (and gloves if required by the authorised officer).
- e) Mince may only be deep frozen once.

Measurement and Improvement

3.18

INTERNAL AUDITS

- a) Processors must establish documented procedures for the scheduling, planning and the implementation of internal audits to verify internal compliance with the requirements of the Standard and the effectiveness of the Quality System, records and procedures. (Note responsibility for reporting critical non-compliances in Management Responsibility in Section 3.2 above).
- b) All corrective and preventive actions defined in these audits must be assigned and tracked until completed by the target completion dates.
- c) The records of such audits must be available for inspection.
- d) Internal auditors must have received training in the requirements of the Standard.
- e) *Internal auditors should be independent of the activity being audited and should have received formal training in auditing skills.*

3.19

INSPECTION AND TESTING

General

- a) Processors must document the procedures used for all inspection and testing as detailed in the Quality Assurance/Hazard Control Plan (see Sections 3.4 e-f and 3.5) and maintain appropriate records. Note: Particular attention must be paid to the issue of clean cattle (see DAF Clean Cattle policy).
- b) Where the Processor operates a laboratory, the competence of the laboratory staff must be demonstrated (e.g. through training records, certifications, ring tests, etc.).
- c) The suitability, effectiveness and accuracy of the test methods must be demonstrated (e.g. by reference to industry norms or other standard test methodologies and by laboratory test validation).
- d) Where testing on regulatory parameters is outsourced, the Processor must only use DAF approved Laboratories that are also independently accredited to ISO 17027.
- e) *Where testing of a non-regulatory nature (e.g. customer specified) is outsourced, the Processor should only use independently accredited laboratories.*
- f) All measurement systems must be capable of complying with regulatory requirements for accuracy.

Bacteriological Tests on Beef

Note: Processors will be aware of the necessity to maintain, monitor and verify hygiene standards. Processors will already appreciate the usefulness of testing the hygienic quality of the Beef using the Total Viable Count (TVC) method and will be aware that Commission Decision 2001/471/EC, (see Appendix 1, Reference Information) is now in place. This Commission Decision establishes the sample methodology and the limits for TVC and Enterobacteriaceae.

- g) Processors must maintain data as prescribed in Commission Decision 471:2001 that demonstrates compliance with the following:
 - i) TVC data must not exceed 5.0 log, must be ideally be less than 3.5 log, and, where TVC is between these limits, corrective action must be taken,
 - ii) Enterobacteriaceae data must not exceed 2.5 log, must be ideally less than 1.5 log and, where Enterobacteriaceae is between these limits, corrective action must be taken.
- h) *Sampling and testing should be done in accordance with recognised methods.*
- i) Bacteriological tests may be carried out in the plant laboratory provided laboratory personnel are suitably qualified and competent in microbiological methods and test equipment is suitable (see this Section a-g above).
- j) The laboratory must not have direct access to the plant and access to the laboratory must be controlled.

Note: data from other tests (such as microbiological results when available) should be analysed for trends and to indicate the appropriate corrective action.

Residue Testing

- k) **The Processor must have a residue testing programme and schedule in place for cattle from eligible farmers that complies with the DAF National Residues Monitoring Programme, and evidence demonstrating that this programme is in operation and effective must be maintained (Category 1).**
- l) Where customers require specific residue tests, these must be documented and results maintained.

- m) The Processor must have a procedure in place that defines the actions to be taken in the event that a carcass fails a residue test. This procedure must be agreed by the Official Veterinary Surgeon and include at a minimum (all Category 1):
 - i Immediate notification in writing of DAF, the Producer and Bord Bia,
 - ii Initiation of the recall/withdrawal procedure for the affected product.

Dispatch Inspection and Testing: Carcasses

- n) Records must be available to demonstrate that, prior to boning or dispatch, all carcasses have been checked according to a plan that includes at a minimum:
 - i Carcass pH is less than 5.8,
 - ii Carcass temperature is 7°C or less,
 - iii Checks for regulatory compliance (e.g. BSE, SRM, etc.).
- o) All product must be positively released.

Dispatch Inspection and Testing: Boneless Product

- p) Records must be available to demonstrate that, prior to dispatch, all boneless product has been checked according to a plan that includes at a minimum:
 - i Vacuum packs seals are airtight,
 - ii That cartons and trays, where used, are undamaged,
 - iii That product was passed through a metal detector.
- q) All product must be positively released.

Note: a list of the checks to be performed on meat prior to dispatch is included in Appendix 4.1.

3.20**CONTROL OF INSPECTION, MEASURING
AND TEST EQUIPMENT**

Note: Processors will be aware of the need to document the procedures used to control, calibrate and maintain inspection, measuring and test equipment.

The following specific requirements apply:

- a) A register of all such equipment must be maintained which includes;
 - i Identity/location,
 - ii Operating range,
 - iii Tolerance and accuracy required,
 - iv Calibration frequency and responsibility,
 - v Calibration method or reference,
 - vi Operational checking (e.g. start-up checks) to ensure continuing accuracy.
- b) Records of all calibrations with traceability to National Standards must be maintained.
- c) When a device is found to be out of calibration, an assessment of the validity of previous inspection results, the likely impacts and the appropriate corrective and preventive actions must be carried out and recorded.

3.21**IMPROVEMENT**

Corrective and Preventive Action

- a) There must be a documented and effective procedures for Corrective and Preventive action management.
- b) Corrective and Preventive actions must be tracked and their priorities appropriately identified (e.g. by means of defined time scales for completion).

Customer Complaints

- c) Processors must establish an effective procedure for handling of customer complaints, including any of regulatory origin.
- d) The procedures must clearly outline responsibilities for logging, tracking and closing off complaints in conjunction with the complainant.
- e) The complaint log and related correspondence must be maintained and be available for inspection.
- f) Food safety related customer complaints must be notified to the Official Veterinary Surgeon officer.

Product Recall

- g) Processors must document and establish an effective product recall procedure.
- h) The recall procedure must include a provision to initially contact the regulatory authorities (FSAI, DAF, etc.) prior to initiating product recall.
- i) Documentation must be maintained to demonstrate that the recall procedure was tested annually for effectiveness.

General Hygiene and GMP

Note: The FSAI has published useful guidance notes that are specific to slaughter plants (see Guidance Note 8 listed in Appendix 1) and that could be incorporated into the Hygiene (GMP and GHP) practices of the plant. These state, among other things, the need for Management to:

- Ensure that the premises and plant is designed, constructed and maintained to prevent and control the risk of contamination and comply with all relevant legislation pertaining to food safety,
- Have a Good Manufacturing Practices (GMP) plan which complies with the Hygiene and GMP Requirements as set out below and which supports the HACCP plan,
- Be able to demonstrate compliance with the requirements of the Meat Plant SOPs (see Appendix 3).

The requirements listed below define the essential management procedures necessary to implement hygiene / GMP in accordance with the BQAS. However, compliance with these requirements does not in any way lessen the responsibility on Processors to conform to existing statutory requirements and, in particular, the requirements of the Fresh Meat Directive (listed in Appendix 1).

3.22

PLANT AND FACILITIES

Site Security and Visitors

- a) Processors must ensure the site security is maintained to prevent possible product contamination.
- b) Management must document how visitors are managed to minimise risk to product.

Process Flow and Laboratories

- c) *Process flow and traffic should be arranged to prevent product contamination.*
- d) *On-site laboratories should be located and operated to prevent product contamination.*

Cleaning and Sanitation

- e) **Processors must document and implement a comprehensive plant, facilities and equipment cleaning and sanitation programme, in accordance with the Meat Plant SOPs (see Appendix 3) (Category 1).**

- f) This programme must cover all food contact surfaces and the exterior and interior of the plant including at a minimum: walls, floors, windows, drains, machines, equipment (e.g. knives, sterilisers, trays), food surfaces (e.g. conveyors), facilities, and ancillary structures including ventilation ducts, stores and the lairage.
- g) Processors must adopt a “clean as you go approach” throughout the operation and must document, monitor and record the cleaning activities and must:
 - i) State the method of cleaning, the responsible personnel, the frequency with which each item or group of items is cleaned and the materials used,
 - ii) State the frequency and method of cleaning (including safety hazards) required to ensure that the appropriate surfaces are visually clean and then sanitised.
- h) A designated person must verify the effectiveness of cleaning prior to allowing production to commence (Category 1).**
- i) Where cleaning is done by a subcontractor, a contract with full specification must be in place (Category 1).**
- j) Records verifying the effectiveness of the cleaning programme (such as microbial swabbing or rapid hygiene tests) must be maintained.

Pest Control

- k) Processors must implement a formal pest control programme and all baiting materials must be certified by the Pest contractor/ manufacturer as appropriate for the particular use (Category 1).**
- l) An annual review of the programme must be conducted to establish its suitability and effectiveness.
- m) Where baiting supplies are stored on site, the store must be kept locked.
- n) All bait stations and electronic fly killers must be secured, numbered and clearly indicated on a site map.
- o) Inspections for pest control must be made and recorded (minimum 8 visits per year) by an independent contractor.
- p) All air vents and intake points must be covered with 1.2 mm screens/meshes to prevent pest ingress.

- q) *There should be a multi-level baiting system such as:*
- *First line of defence: Perimeter with bait points at 6-8m intervals along the entire perimeter,*
 - *Second line of defence: along factory building wall,*
 - *Third line of defence: internally – where there is a risk of rodent ingress.*

3.23

MAINTENANCE

- a) A preventive maintenance programme for essential plant and equipment affecting product quality / safety must be in place (see Appendix 3, Meat Plant SOPs).
- b) Maintenance schedules and procedures must be documented.
- c) All internal maintenance staff must receive training in hygiene.
- d) All external maintenance personnel must be made aware of the company hygiene regulations prior to commencing work.
- e) Maintenance procedures must indicate the precautions taken to ensure that the product is not contaminated in any way by the maintenance activity whether carried out by own or contracted staff (e.g. ventilate production area post maintenance).
- f) A record of maintenance activities must be maintained.
- g) There must be procedure to approve equipment for re-use after maintenance is complete.
- h) *A system for accountability for tools used and equipment parts removed during maintenance should be developed and implemented.*

Environmental Hygiene

3.24

BREAKABLES

Note: Processors will appreciate that the structure and fabrication of the premises and the supply of services must be such as to prevent contamination.

The following specific requirements apply:

- a) Wood structures, pallets and fittings are not permitted in any food production area.
- b) A glass/hard plastics policy and written procedures for handling glass/hard plastics breakages in all process and storage areas must be in place.
- c) Where glass/hard plastics are present a glass/hard plastics register must be maintained.

3.25

EXTERIOR, STRUCTURE AND GROUNDS

It is important that the grounds and all areas of the premises are well presented and maintained to minimise sources of contamination. The following specific requirements apply:

- a) A perimeter fence, wall, or other suitable physical demarcation must be in place to control access to the grounds.
- b) Equipment, pallets and other materials stored in the factory grounds must be stored neatly and in clearly defined areas.
- c) Any unused buildings, service buildings etc. must be maintained in good repair and free from debris.
- d) There must be a clearance of 1 metre wide around the factory to avoid rodent infestation.
- e) Exterior finish of the premises must be maintained in sound presentable condition (i.e. no flaking paint or broken plaster).
- f) The grounds must be kept free of faecal matter and there must be no stagnant water, potholes, open drains or pools.
- g) Roofs, valleys and gutters must be maintained in good repair and free from debris and weeds.

3.26**INTERIORS: GENERAL**

- a) All pipes, pipe work, lagging, electrical cables etc. must be clean, secure and properly constructed.
- b) A schedule of internal washing and sanitation must be in operation.

3.27**ENTRY TO PRODUCTION**

- a) A procedure must be in place to ensure good hygiene practices at entry and exit from all production areas.
- b) Wash-hand basins and footwear cleaning facilities must be provided at all entry points to production areas.
- c) Taps must be knee, foot, arm or electronically operated.
- d) Paper towel dispensers and receptacles must be in place.
- e) Hand sanitising solutions or sanitising liquid odourless soap must be provided at each hand washing point.
- f) *Hand-washing water should be ideally premixed to 44°C.*
- g) Where footbaths are provided, these must be located outside production areas and be designed to ensure adequate contact with footwear and allow footwear to drain after use.
- h) *A procedure should be in place to ensure that the disinfecting solution remains at a working strength at all times.*

3.28**INTERIOR WALLS**

- a) Wall surfaces must be designed and constructed to be durable, smooth, light coloured, easily cleaned and impermeable to liquids.
- b) They must be maintained in a clean condition free from cobwebs and moulds, etc.
- c) Junctions and joints must be smooth and impervious.
- d) Wall-to-floor junctions must be coved.
- e) Ledges and sills must be sloped and kept free from dust, dirt or other miscellaneous items.
- f) Walls must be well maintained, e.g. no flaking paint or plaster, no damaged or missing tiles, all tile cracks sealed or grouted.

3.29

CEILINGS AND OVERHEADS

- a) Ceilings must be designed and constructed to be of sufficient height, smooth, light coloured and easily cleaned.
- b) All joints must be sealed and impermeable.
- c) Ceilings must be maintained in good repair, clean and be free of condensation.
- d) False or cavity ceilings must have access to the void above to enable cleaning and inspection.
- e) Girders and overhead pipe-work and structures must be clean, free from rust, dust, mould growth, flaking paint and other extraneous material.
- f) Skylights are undesirable, but where present they must be clean and be fitted with fly screens if openable.

3.30

FLOORS

- a) Floors must be constructed of durable, non-slip, water resistant material and be maintained in good condition (i.e. no holes or cracks).
- b) Floors must be kept clean and free from the accumulation of water or debris especially in corners or in areas hidden by machinery.
- c) Rubber mats or plastic meshes, where used, must be easily removed and easily cleaned

3.31

DRAINAGE

- a) Drainage must be such as to prevent risk of contamination and must include water sealed U bends to prevent gas reflux.
- b) All floors must be sloped towards the drainage channels so that stagnant pools of liquid are prevented.
- c) Drainage channels, which cross personnel working areas and passageways, must be covered with removable covers for cleaning accessibility.
- d) Fat, debris traps and grids must be fitted to all drains as specified in the legislation.

- e) *Drainage from on-site laboratories should be designed to exit the building before joining up with other waste systems.*
- f) Where manholes are present inside a premises they must be doubly sealed.

3.32**DOORS**

- a) Doors and door jambs must be constructed of durable impermeable material, be tight fitting and of smooth easily cleaned finish.
- b) Glass must not be used in doors opening into storage or production areas. Other clear shatterproof material may be used instead.
- c) All external doors and internal doors (excluding emergency doors) leading from non-process into process areas must be self-closing or otherwise screened to prevent pest ingress.
- d) All chill and freezer doors must be openable from both sides.

3.33**WINDOWS**

- a) Exterior windows in production areas must be at least 2 meters above ground, must have sloping ledges and, if opening, must be fitted with suitable and effective fly-screens.
- b) They must be constructed of shatterproof material or, if made of glass or hard plastic, must be laminated to prevent shattering.
- c) Windows, window frames etc. must be tight fitting, maintained in good condition, free from cracks, moulds, flaking paint etc. and must be kept clean.

3.34**LIGHTING**

- a) Lighting in production areas, must be designed to be permanently fixed, easily cleaned and must be protected by shatterproof covering.
- b) Lighting must be adequate at all times for the particular operation and must be of a type that does not distort colour where decisions are taken on the basis of colour.

- c) Minimum light intensities must be:
 - i. Inspections points 540 Lux,
 - ii. Work Rooms, detention pens 220 Lux,
 - iii. Storage areas and lairage pens 110 Lux.

3.35

WATER, AND WATER TREATMENT

- a) Water tanks must be kept covered.
- b) Where the water supply is derived from well(s), the well-head(s) must be designed and the area around the well-head(s) maintained to prevent contamination of the water.

3.36

KNIVES, STERILISERS, HOSES AND OTHER EQUIPMENT

- a) Knife and equipment sterilisers must be designed and constructed to be rust proof, to ensure complete immersion of the knife's blade-to-handle junction, and to ensure continuous water flow and independent drainage to a floor drain.
- b) **Knife and equipment sterilisers must be kept at a minimum 82°C when in use and checked according to a defined schedule (Category 1).**
- c) **All knives and other meat contact equipment must be sterilised prior to and during their use in production (Category 1).**
- d) Sterilisers must be located in all areas where knives or similar utensils are used and must be readily accessible to staff.
- e) *Scabbards should only be used where they are essential to health and safety.*
- f) *After removal from a scabbard or use of steel, knives should be treated as contaminated and placed in a steriliser before use.*
- g) Aprons, where used, must be subjected to frequent cleaning in wash cabinets designed to minimise the risk of cross contamination.
- h) The use of drop-hoses for apron washing is not permitted.
- i) Hoses must be maintained in a clean and tidy condition and must always be kept off the floor when not in use.

3.37**EXTRACTION AND VENTILATION**

- a) All processes which emit steam or vapours must be effectively hooded and fitted with suitable extraction equipment to prevent condensation.
- b) Suitable ventilation must be available in all process areas where steam or water vapour arises to prevent condensation.
- c) Vents from drains, sewers and rainwater drainpipes must not be located within the plant.

3.38**CLEANING MATERIALS AND STORAGE**

- a) All cleaning equipment and materials, chemicals and other substances likely to contaminate product must be stored in a lockable, secure place (ideally with appropriate bunding) away from production.
- b) *Adequate safety and protective clothing, footwear and apparatus should be available when handling such substances.*

3.39**EFFLUENT TREATMENT**

- a) Any effluent treatment plant must be operated in accordance with the relevant licences.
- b) *Where an effluent treatment plant exists on site, it should be placed as far as possible down wind and away from the plant air intake points.*

3.40**FOOD TRAYS**

- a) Facilities with adequate ventilation must be provided for the washing and sanitising of food trays.
- b) There must be separate areas for the storage of soiled trays, the washing of soiled trays and the storage of clean trays.
- c) In all cases cross-contamination between clean and dirty trays must be prevented.

3.41

ELECTRONIC FLY KILLERS

- a) There must be a programme and records for the inspection of electronic fly killers and for replacement of the light tubes.
- b) Electronic fly killers must be located away from food processing areas and from packaging equipment or packaging operations.
- c) Electronic fly killers must not be located close to or above exposed meat or food preparation areas.

Note: the effectiveness of electronic fly killers is determined to a large degree by their location and working height.

3.42

WASTE DISPOSAL GENERAL

Specified Risk Materials

Note: The handling and management of wastes is extremely important in the plant. It is therefore essential that, in relation to the handling and management of wastes, a clear distinction be made between “waste” and Specified Risk Material (SRM¹). It is crucial that any waste material that could/has come into contact with SRM is treated as SRM.

The following specific requirement applies:

- a) **The Processor must have in place a specific SRM protocol² that has been agreed with the DAF (Critical).**

1 SRM is currently defined in EC SRM Regulations 2001 (SI 164 2001) as:

1. the skull including brain, eyes, the tonsils, the spinal cord of bovine animals aged over 12 months, and the intestines from the duodenum to the rectum of bovine animals of all ages (and the vertebral column of bovine animals aged over 12 months),
2. the skull including brain, eyes, the tonsils, the spinal cord of caprine or ovine animals aged over 12 months, or which have a permanent incisor tooth erupted through the gum, and
3. the spleen of a caprine or ovine animal, and includes anything left attached to such material after dissection of the carcass and any animal matter which comes into contact with the material after it has been removed from the carcass.

2 Hauliers of SRM must be DAF approved and stringent requirements apply with regard to use of the vehicles, prevention of cross contamination etc.

Waste Management General

Note: Waste Materials are defined as follows:

- i Non-saleable animal parts,
 - ii Inedible by-products or any part of the carcass, which is discarded, and not intended for human use (i.e. parts of the carcass not normally subjected to post-mortem inspection such as hooves, horns, etc.),
 - iii Meat declared unfit for human consumption,
 - iv Stomach parts and viscera not intended for human consumption and their contents.
- b) There must be a documented programme for the management of all waste material (Category 1).**
- c) Waste materials must be controlled in the production area and must be stored in containers pending collection/disposal (see Appendix 3, Meat Plant SOPs).
 - d) Processors must have procedures to prevent waste material coming into contact with fresh meat or carcasses which have been passed fit for human consumption.
 - e) The plant cleaning schedule must include all waste handling/storage areas to minimise odours and fly infestations.

Waste Containers

Containers for use internally (i.e. within the plant) must be:

- f) Clearly identified so that they cannot be mistaken for food use containers,
- g) Clearly designated according to the type of waste (separate waste containers for SRM or High Risk material) to be disposed in them,
- h) Available at appropriate locations.

Waste Skips

Skips for waste must be:

- i) Covered at all times except when being filled and be located as far as practicable from the "Clean" area.
- j) Sited on a concrete surface that ensures that any leakage is contained and safely disposed of.
- k) Emptied according to a documented schedule, and spillages cleaned up immediately.

Condemned Materials

- l) Adequate facilities for the identification and safely handling of condemned materials must be provided.
- m) The arrangements for the handling, control and disposal of condemned materials must be agreed with the Veterinary Inspector.
- n) Where condemned or inedible material or other wastes are removed through conveyors or chutes, these must be constructed and installed in such a way as to avoid any risk of contamination of fresh meat.
- o) Enclosed chutes must be equipped with suitable access points to facilitate inspection and sanitation.

Waste Collector Approval

- p) Processors must have a documented system for the approval and on-going monitoring of animal waste hauliers. This must include clear criteria for the vehicles to be used.

Other Waste Material

- q) Discarded wrapping, packaging and other refuse must be placed in designated bins or skips so that it does not compromise the hygiene of the premises and does not provide a habitat for pests and vermin.

Personnel Hygiene

Note: Processors will be aware of their management responsibility to ensure that all aspects of personnel hygiene are addressed and to ensure compliance with the following specific requirements.

3.43

GENERAL

- a) **An Operational Hygiene Management system including personnel hygiene must be established and communicated clearly to all personnel (see Appendix 3, Meat Plant SOPs) (Category 1).**
- b) **A documented training programme for staff must be in place (see Appendix 3, Meat Plant SOPs) (Category 1).**
- c) Training records must be available to demonstrate that all operatives have been trained in the Operational Hygiene Management system.

3.44

MEDICAL RECORDS

- a) All personnel working on or handling fresh meat or meat product must have been examined by a medical practitioner and certified as having no impediment to carrying out such work. The certificate must be renewed annually and must be available for inspection.
- b) Personnel must be made aware of their responsibility to notify management of any infectious disease or condition they may be suffering from or have been in contact with that could adversely affect the safety of the product.
- c) A hygiene training programme that can be demonstrated to be effective through records must be in place that takes into account the findings of relevant reports on food handling such as the NDSC Report (see Appendix 1).

3.45

FIRST AID

- a) At least one member of staff must be trained in First Aid procedures and fully stocked first aid kits must be available to treat minor injuries.

3.46

PERSONAL HYGIENE

- a) Fingernails must be kept short, clean and unvarnished.
- b) No loose jewellery, except plain wedding rings and sleeper ear-rings may be worn by personnel working in the production area.
- c) All head hair, including facial hair must be contained (e.g. by means of a snood, mop cap or other covering) to prevent contamination of product.
- d) Operatives lifting beef quarters must also wear a protective neck shield.
- e) Cuts, sores and grazes must be completely covered after treatment with a distinctively coloured waterproof dressing incorporating a metal detectable strip and which is supplied by the company.

3.47

PERSONNEL CLOTHING AND LOCKER ROOMS

Protective Clothing

- a) All personnel (food operatives) working within the plant must be provided with light coloured protective clothing, suitable headgear and footwear.
- b) Personnel working in the lairage or handling animals must be provided with suitable clothing for the handling of animals and separate designated footwear.
- c) Clothing worn by personnel working in the lairage or handling live animals, must be clearly distinguishable and maintained separately from that worn by food operatives.
- d) Clean protective clothing must be issued daily or as required.
- e) Facilities (including individual lockers) must be provided that ensure the separation of street (civilian) and in-plant protective clothing.
- f) Specific arrangements must be in place that provide for the hygienic handling of used or contaminated clothing.
- g) A scheduled laundering of all protective clothing must be in place.
- h) Where work clothing is laundered on site, the wash cycle must exceed 80°C operating temperature.

Shower and Washing

- i) Shower facilities must be provided.
- j) All persons entering production areas of the plant must wash hands and sanitise their protective footwear. Notices to this effect must be posted in appropriate areas.

3.48

PERSONNEL FACILITIES INCLUDING CANTEENS

- a) Smoking, eating and drinking must only be permitted in designated areas and there must be clear signs to this effect.
- b) All personnel facilities (canteens, locker-rooms, toilets, rest-rooms) must be included in the plant sanitation programme and maintained in a clean condition.
- c) *Canteens should be designed to ensure separation of high and low risk workers to prevent cross-contamination (e.g. separation of people working in lairage and production areas in the canteen).*

3.49

TOILET FACILITIES

- a) All toilets, including office toilets, must be clean and adequately ventilated and toilets must not lead directly into the processing area.
- b) *There should be at least one toilet and one hand-basin per 15 male and per 10 female employees.*
- c) Odourless liquid soaps and sanitising liquids must be provided and dispensed from wall mounted units.
- d) Paper towel dispensers and a bin for used paper towels must be provided in every wash area. The use of air driers is not permitted in food production areas.
- e) Hygiene notices must be clearly displayed in all toilet areas indicating that hands must be washed after the use of the facilities.

3.50

WASHING FACILITIES IN PRODUCTION

- a) In slaughter halls, all operatives must have direct access to hand-washing facilities at their workstations.
- b) In boning halls, all operatives must have direct access to hand-washing facilities close to their individual work areas.

4 Appendices

Reference Information

RELEVANT STANDARDS, LEGISLATION, CODES OF PRACTICE

(where relevant requirements have been incorporated into the Standard).

REGULATIONS AND DIRECTIVES

- S.I. 31: 1998, European Communities (Labelling of Beef and Beef Products) Regulations 1998
- S.I. 81: 1988, European Communities (Quality Of Water Intended For Human Consumption) Regulations 1988 (as amended)
- S.I. 126: 1995, European Communities (Meat Products and Other Products of Animal Origin) Regulations. (Note: S.I. 175 amends some of the detail of S.I. 126 and must be read in conjunction with S.I. 126)
- S.I. 165: 2000, European Communities (Hygiene in Foodstuffs) Regulations, 2000
- S.I. 243: 1996, European Communities (Minced Meat and Meat Preparations) Regulations, 1996
- S.I. 307: 1991, European Communities (Materials And Articles Intended To Come Into Contact With Foodstuffs) Regulations, 1991
- S.I. 507: 1998, Control of Animal Remedies and their Residues Regulations, 1998
- Council Directive 64/433/EEC On Health Problems Affecting Intra-Community Trade In Fresh Meat, Article 5 (Condemned meat)
- S.I. 434: 1997 European Communities (Fresh Meat) Regulations, 1997 (as amended or updated) (Implements the Fresh Meat Directive 91/497/EEC)
- S.I. 164: 2001, European Communities (Specified Risk Material) (Amendment) Regulations, 2001 (implements Commission Decision 2001/233/EC of 14th March 2001)
- Council Decision 2001/471/EC laying down rules for the regular checks on the general hygiene carried out by operators in establishments according to Directive 64/433/EEC on health conditions for the production and marketing of fresh meat and Directive 71/118/EEC on health problems affecting production and placing on the market of fresh poultry meat, dated June 8 2001

QUALITY STANDARDS

- I.S. 342: 1997, Guide to Good Hygiene Practice for the Food Processing Industry in Accordance with Council Directive 94/43/EEC on Hygiene in Foodstuffs (NSAI)
- I.S. 3219: 1990
- I.S. 343: 2000, Food Safety Management Incorporating HACCP
- ISO 9000: 2000 Quality Management Systems – Requirements
- ISO 17025, General Requirements For The Competence Of Testing And Calibration Laboratories

RECOMMENDED PUBLICATIONS FROM FSAI

Compendium of Food Law in Ireland 2003. (This provides a useful guide to the various applicable meat regulations)

Guidance Note 5: Guidance Note on the Approval and Operation of Independent Meat Production Units Under EC Fresh meat legislation

Guidance Note 8: The Implementation of Food Safety Management Systems in Beef and Lamb Slaughter Plants Based on HACCP

Leaflet: The Labelling of Food in Ireland 2002

Abattoir Inspection Management Systems (LAVS, FSAI)

OTHER REFERENCES

- Safety, Health and Welfare at Work Regulations 1993 (S.I. 44 of 1993)
- Directive 89/109 EEC Packaging Food Stuffs Regulations
- Abattoir Act and amendments
- Agricultural Produce (Fresh Meat) Acts
- List of Approved Disinfectants June 1993 Disease of Animals (Disinfectants) Order. 1975 (Amendment) Order 1978: Department of Agriculture Food and Forestry
- Code of Good Agriculture Practice to Protect Water from Pollution by Nitrates: Department of Agriculture Department of the Environment July 1996

- ET 101/1991 Electrical Installations of Agriculture and Horticulture Premises: Electro Technical Council of Ireland, Dublin 12
- Teagasc Publication: A HACCP Plan for Irish Beef Slaughter (second edition)
- FÁS Training and Certification Programme for Workers in the Industrial Meat Sectors (see FÁS website)
- National Disease Surveillance Centre, Draft Report on Prevention of Food Borne Diseases, 2003 (see website: www.ndsc.ie)

AVAILABILITY OF DOCUMENTS

Irish legislation documents (referenced as follows S.I. xxx) are available from the Government Publications Sales Office, Sun Alliance House, Molesworth Street, Dublin 2 or Department of Agriculture, Food and Rural Development, Agriculture House, Kildare Street, Dublin 2 or from the Irish Statute Book website: <http://www.irishstatutebook.ie/>

Other Irish Standards (documents referenced as follows I.S. xxx) are available from the National Standards Authority of Ireland, Glasnevin, Dublin 11. Further information is available on the website: www.nsai.ie

Documents from the Food Safety Authority of Ireland are available from FSAI, Abbey Court, Lower Abbey Street, Dublin 1. Some of the documents are available through their website: www.fsai.ie

EC Regulations and Council Decisions can be accessed through the website: <http://europa.eu.int/eur-lex/en/index.html>

Department of Agriculture, Food and Rural Development

Diseases of Animals (Protection of Animals during Transport) Orders, 1995 & 1997.

ANIMAL TRANSPORT INSPECTION REPORT

To Transporter / Person in charge of animals Herd I.D./Haulier Reg. where appropriate.

Of Address

Description of Animals

TRANSPORT TYPE	TRANSPORT DESCRIPTION	
	Y	
Articulated Lorry	Vehicle I.D.	
Rigid Body Truck	Trailer I.D.	
Tractor & Trailer	Length*	
Car/Jeep & Trailer	No. of Tiers / Decks	
	Colour / Marks	

* Length of animal compartment (metres)

STRUCTURES	A	B	C
Sharp Projections			
Holes in floors			
Broken/ Loose fixtures			
Slippery floor (Poor grip)			
Internal Partition			
Ventilation apertures			
Inspection apertures			
Battens broken / absent			
Closed door distorted			
Open ramp distorted			
Side gates broken			
Tail-gate ramp absent			
Roof absent			
Other			

PROCEDURES	A	B	C
Animal handling			
Loading / Unloading			
Overloading			
Segregation			
Ramp use			

KEY	A	B	C
	For immediate correction		
		For correction within 1 month	
			For correction within time specified by Officer below

HYGIENE	A	B	C
Transport not cleaned prior to loading			

(Please note: Each item relates to non-shaded box only, to which the KEY refers. Item box(es) to be ticked where appropriate).

COMMENTS ON FAULTS FOUND:
 (Please identify time scales for correction of faults where appropriate)

OVERALL ASSESSMENT	Satisfactory	Adequate	Poor
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Signed _____ Authorised Officer. _____ County Code: _____ Date: _____

Official Address: _____

Signature of Transporter / Person in charge of animals: _____ Date: _____

The details of this inspection report will be entered into a database of non-compliant vehicles. In order that your name can be removed from the database, you are required to present your transport for re-inspection.

Date for re-inspection: _____ Time: _____

Place of re-inspection: _____ (Mart / Meat Factory)

**STANDARD OPERATING PROCEDURES FOR
SLAUGHTER AND CUTTING PLANTS APPROVED
UNDER THE EUROPEAN COMMUNITIES (FRESH MEAT)**

REGULATIONS, 1997

The list of Standard Operational Procedures as listed under is not exhaustive. It is intended to flag the major activities for which SOPs must be developed and implemented. In the development of these SOPs, Good Hygiene Practice (GHP) and Good Manufacturing Practice (GMP) must be incorporated, as appropriate. This list is published by:

Veterinary Public Health Inspection Service
Department Of Agriculture and Food
April 2002

1. Plant Sanitation [Required as a condition of Ministerial Approval]
2. Equipment Sanitation [Required as a condition of Ministerial Approval]
3. Structural Preventative Maintenance Programme [Required as a condition of Ministerial Approval]
4. Equipment Preventative Maintenance Programme [Required as a condition of Ministerial Approval]
5. Staff Training Programme [Required as a condition of Ministerial Approval]
6. Operational Hygiene Management System [including personnel hygiene and ongoing fitness to handle/work on meat]
7. Live Animal Intake and Lairage Management System [including in the case of pig slaughter plants provision for the segregation of category 3 pigs under the National Salmonella Programme, to ensure that cross contamination of live animals cannot arise; the provisions of animal welfare legislation must be incorporated in this SOP]
8. Specified Risk Material [SRM] Protocol [in beef and sheep slaughter plants]
9. BSE and Scrapie Slaughter Protocols [in beef slaughter plants]
10. National Residues Sampling Programme

11. Primary Carcase Chill Management System [including calibration and management of temperature control and recording equipment]
12. Marshalling Hall And Dispatch Management System [including meat transport vehicle control/management system]
13. Boning Hall Intake Management System [including the identification and removal of contamination] (In the case of stand alone cutting plants, the intake management system must include provision for identification checks, temperature checks, contamination inspection, and provision for rejection)
14. Boning Hall SRM Protocol [in beef and sheep cutting plants]
15. Boning Hall Management System [including temperature control and calibration of temperature control and recording equipment, handling of meat contaminated through the finding of abscesses, injection sites, meat falling from work surfaces or conveyors, equipment sterilisers, and metal detection equipment]
16. Wrapped / Packaged Meat Handling System [including metal detection and application of both commercial and veterinary control labels]
17. Vac-Pac Chill Management System [including meat transport vehicle management system]
18. Marshalling and Dispatch Management System
19. Vermin and Pest Control Programme
20. Microbiological Checks Programme for Carcase and Cut Meat, Plant and Equipment
21. Carcase and Cut Meat Traceability System [including meat recall procedures]
22. Water Storage, Treatment and Analysis (including in the case of water analysis details of the sampling point rotation through the plant)

Final Product Testing Requirements

Test	Regulatory Requirement	BQAS Limits	BQAS Reference
Micro (TVC)	Yes	< 3.5 Log	3.19.g.i
Micro (Enterobacteriaceae)	Yes	< 1.5 Log	3.19.g.ii
BSE	Yes	Not Present	3.19.o.iii
SRM	Yes	Not Present	3.19.o.iii
Residues	Yes	Not Present	3.19.l
Carcase pH		< 5.8	3.19.o.i
Carcase Temperature		< 7°C	3.19.o.ii
Metal Detection		Not Detected	3.19.q.iii
Packaging		Intact	3.19.q.ii 3.19.q.iii
Labelling		Permits Traceability	3.14.a-c
Labelling	Yes	Legal Compliance	3.14.a-c
Customer Specified Tests			3.19.l
Internally Specified Tests			3.19.a

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