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- A.3** **Presentation Standard for Carcasses and Viscera Presented for Sorting and Veterinary Disposition**
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A.1 Traditional Presentation Standard**A.1.1 Introduction**

This traditional presentation standard is to be used for the presentation of carcasses and viscera under the Traditional method of inspection.

Consistent postmortem presentation is a must in order to ensure optimal inspection efficiency for all classes of poultry. Therefore, carcasses presented for postmortem inspection shall be hung in such a way so as to facilitate the examination of the external surfaces, the internal cavity, the internal organs and the viscera.

This standard is provided to assist the operator in applying and maintaining reasonable and achievable standards for presentation. It provides an objective means of monitoring and assessing the acceptability of carcass presentation for inspection. It will also provide a tool to create more uniform presentation nationwide.

While testing of these standards is designed for the inspection team, the standards may also be used by the operator as a guide to develop quality control for presentation.

A.1.2 General Requirements

It should be understood that the presentation standard does not require a specific number of plant employee presenters. Instead it establishes a standard of consistent presentation which must be met.

A.1.2.1 Operator's Responsibilities

The operator is responsible for providing consistently adequate presentation of carcasses for inspection. Therefore the operator must:

- Train and assign plant employees in the proper presentation of carcasses for inspection;
- Provide a rack to place carcasses for examination during presentation checks;
- Provide lighting as specified in chapter 2 of this manual; and
- Provide adequate space for the presenter and for the performance of presentation testing. (Three feet is recommended for presentation testing.)

A.1.2.2 CFIA responsibilities

The inspection staff monitor presentation compliance by performing presentation tests at each inspection station and on each evisceration line and take appropriate action when the presentation standards are not met.

The inspectors must:

- Carry out the test required to assess the presentation of carcasses for inspection.
- Communicate test results and any requirement for corrective measures to appropriate plant personnel.

A.1.3 Defects associated with improper presentation**A.1.3.1 Defects monitored by the presentation standard****A.1.3.1.1 Outside carcass errors**

- **Front or side** (weight of 11)
Carcasses arriving with other than the back toward the inspector
- **Hung by one leg** (weight of 9)
Carcasses arriving with both legs not properly suspended in the shackle
- **Carcasses swinging** (weight of 6)
Carcasses arriving with sufficient swinging motion to interfere with the inspection process. Excessive swing is defined as movement at 30 degrees or more to the chain and away from the inspector.
- **Viscera not uniform** (weight of 8)
Carcasses arriving with viscera on the opposite side of normal presentation or in the middle of the abdominal opening.
- **Contaminated viscera** (weight of 6)
Carcasses arriving with contaminated viscera requiring the inspector to wash his/her hands.
- **Viscera below wing** (weight of 12)
Carcasses arriving with the heart and/or the liver (and/or the spleen in the case of birds over 8 weeks) below the wing breast joint.
- **Viscera not free** (weight of 10)
Carcasses arriving with viscera not adequately separated from the abdominal fat pad and suspended alongside the carcass. If only a cross strip of fat is present, it will be considered that the viscera are free.
- **Viscera in shackle** (weight of 8)
Carcasses arriving with visceral organs hung in shackle.
- **Out of sequence** (weight of 15)
Carcasses arriving on guide bar out of sequence for the inspection station due to kick-out malfunction or missing the kick-out.
- **No viscera** (weight of 20)
Carcasses arriving without viscera. Those carcasses arriving with a single or two organs i.e. heart and/or liver (and/or the spleen in the case of birds over 2.7 kg.) missing will be scored with a weight of 5.

A.1.3.1.2 Inside carcass errors

- **Membrane** (weight of 2)
Carcasses arriving with inside cavity obstructed by air sac membranes from viscera to cavity.
- **Opening cut** (weight of 1)
Carcasses arriving with inside cavity obstructed by inadequate opening cut. This includes cross strips of skin, the anus or cloaca still in the carcass or any other obstacle to appropriate inspection located in the area of the opening cut. It has been found that a cut made within 2 cm (3cm for turkey) to the point of the keel is an adequate opening.
- **Not reflected** (weight of 2)
Carcasses arriving with the viscera not reflecting the appropriate abdominal flap.
- **Parts inside** (weight of 1)
Carcasses arriving with one or more of the visceral organs left in the cavity.
* For Fowl hearts only, corrective action and retesting will not be required if there are three or more occurrences of "Parts Inside".
- **Contamination inside** (weight of 6)
Carcasses arriving with contamination occurring on the inside surfaces of the carcass.
- **Mutilation** (weight of 2)
Carcasses arriving with internal mutilation caused by the vent or evisceration equipment.

A.1.3.1.3 Line speed

Each carcass per minute exceeding the current maximum equals one error with a weight of 5.

A.1.3.2 Other defects controlled by the HACCP System

The following categories of carcasses will be signaled for hang-back by the inspector and be hung back by the inspector's helper. They shall be controlled by the operator as part of the establishment's written HACCP system which specifies how the operator shall assure that hung-back carcasses are handled promptly and hygienically. No error will be recorded on a presentation check for:

- **Not opened** - Carcass arrives at the inspection station with no opening cut made in the carcass.
- **Not drawn** - Carcass arrives at the inspection station with opening cut made but with viscera insufficiently drawn to permit inspection.
- **Two legs out of shackle** - Carcass arrives at inspection station hung by neck or wing.

Hung-back carcasses shall not be allowed to accumulate on the rack and shall be identified and separated from carcasses hung back on the rack for the salvage of portions. The dressing errors shall be corrected as quickly as possible and the carcass returned to the evisceration line to prevent product deterioration.

A.1.4 Presentation monitoring by CFIA personnel**A.1.4.1 Sampling method**

Each test (random tests and retests) consists of two separate 10 carcass observations, one for outside errors and the second for inside errors.

The sampling must be done at constant intervals, e.g., every fifth carcass, every third carcass, etc. To avoid sample bias, randomly select a carcass by picking one, then count a predetermined number of carcasses, e.g., third one, and then examine this carcass and corresponding viscera. This carcass shall be the first one of the sample. Repeat the procedure for each subsequent carcass until the required number are examined.

The outside of 10 carcasses per station will be checked for any of the listed **outside** errors. This test will be conducted off-line with the person conducting the test standing behind and between the presenter and the inspector. Each error observed will be recorded on the Traditional Presentation form included in Annex F.

Then at the same station, but with the person doing the test standing on line between the presenter and the inspector, 10 additional carcasses will be observed for listed **inside** errors. Each error observed will be recorded on the Traditional Presentation form included in Annex F.

The last part of all checks is the line speed check.

The outside and inside errors are converted to a weighted score, and added to any line speed error to determine the total nonconformance for each inspection station.

A.1.4.2 Sampling frequency

The frequency of presentation checks on each eviscerating line should be based on the operator's ability to control its presentation. Twice per 8 hour shift is a suggested frequency; this can be reduced with growing confidence in the operational compliance. The frequency can also be increased with loss of confidence. The minimum frequency rate for any station should be once per 8 hour shift.

A.1.4.3 Aggregate results and actions required

During a random sampling:

- If any test result has a total nonconformance weight of 40 or more, the line speed must be reduced by 10 % immediately, corrective actions implemented and a retest conducted within 10 minutes. The increment used for the line speed increase is equivalent to the increment used for line speed reduction.
- If any 10-carcass weighted nonconformance total is 25 through 39 (or 3 or more of the same presentation error), the operator is required to take immediate corrective action before a retest of the affected station is done within 10 minutes.

During a retest:

- If any retest total is 25 or more (or 3 or more of the same presentation error), the line speed must be reduced by 10 % immediately, corrective actions implemented and a retest conducted within 10 minutes.
- Line speed reductions of 10 % continue on each retest until a total of 24 or less and 2 or less of any one error is achieved or the third line speed reduction in a row for presentation has taken place.
- Line speeds will be allowed to increase 10 % up to the maximum allowed only after presentation control is satisfactory (24 or less and 2 or less incidences of the same error) has been demonstrated. When line speeds are increased by allowed increments, process control must again be demonstrated for this station at the higher line speed, as soon as possible and not more than 10 minutes after each increase.

When three consecutive line speed reductions for presentation nonconformance on one line do not result in acceptable presentation on that line, the VIC must:

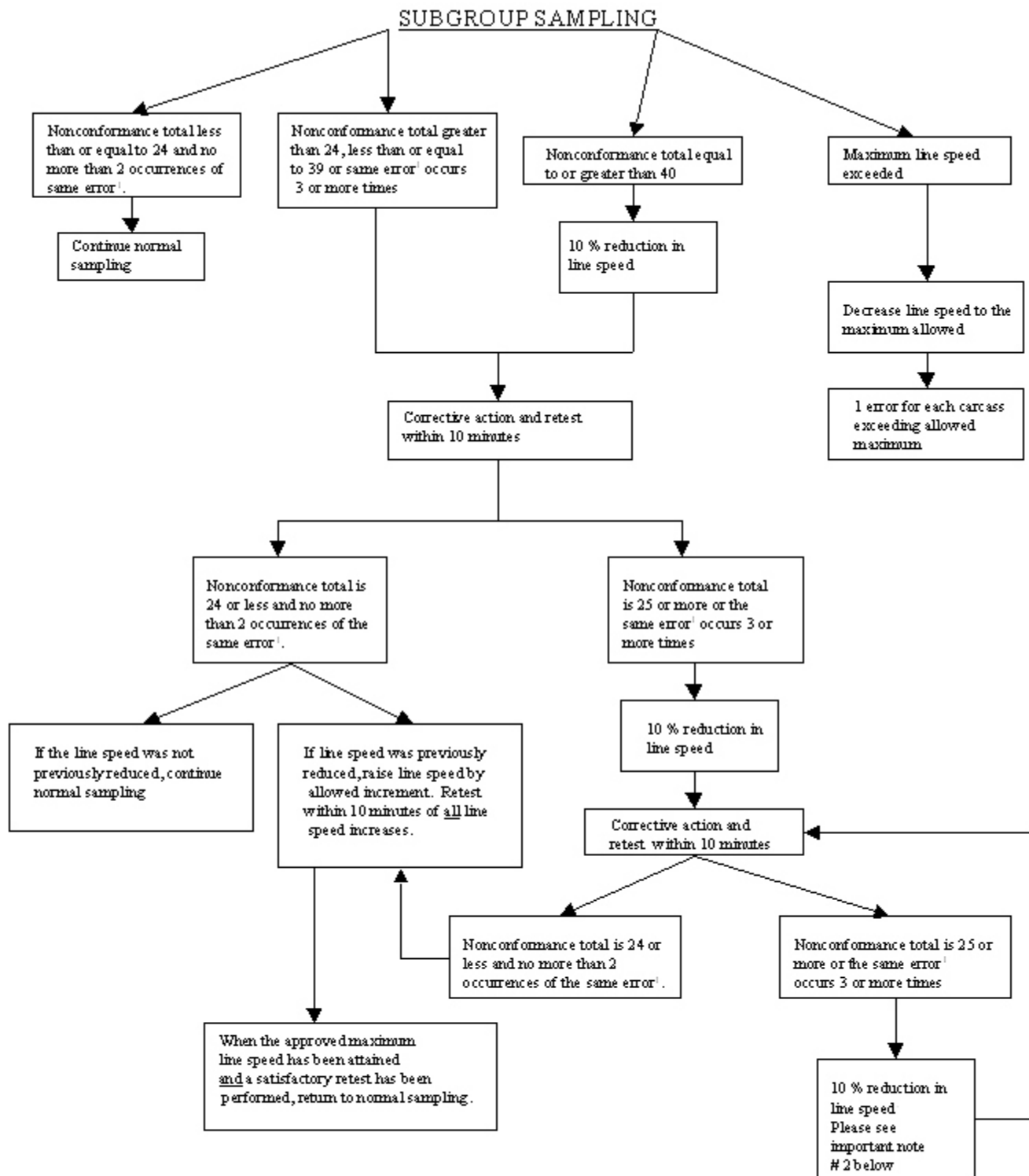
- evaluate the presentation problem;
- determine the effect the presentation problem is having on postmortem inspection and operational sanitation;
- determine acceptable presentation at less than 70 % of optimum line speed.

A.1.4.4 Records

Because of shift to shift and day to day differences in plant staffing and supervision, the presentation results of each shift and each production day will be independent of all other presentation results. There will be a new presentation form and a new start for each station, each shift and each production day.

An example Traditional Presentation Standard monitoring form is available in Annex F of this chapter.

A.1.5 Traditional Presentation Standard Monitoring Decision Tree



* Important notes:

1. Line speed can only be reduced by 10 % three times, after which the VIC shall decide which corrective measures are to be taken.
2. For Fowl hearts only, three or more occurrences of "Parts Inside" will not be considered as an error.

Each line/Station - Measured 2/shift

A.2 Presentation Standard for the CPIP or MPIP Inspection System**A.2.1 Introduction**

This standard is applicable to the CPIP and MPIP methods of poultry inspection.

Presentation standards aid accredited cavity and viscera defect detectors to carry out their responsibilities in compliance with defect detection standards by ensuring that carcasses and corresponding viscera are presented in a uniform and consistent manner. Presentation standards are also designed to ensure that evidence of disease is not lost (e.g. missing viscera) nor hidden (e.g. inadequate abdominal opening) during visual examination by the defect detectors.

Effective control by the operator over the presentation of carcasses and viscera reduces the verification frequency and corrective actions by inspection personnel. Additionally, industry employees must be empowered to take immediate action whenever they notice a potential loss of control. This includes loss of presentation control e.g. excessive missing viscera.

A.2.2 General Requirements

Presentation standards are applicable to all types of evisceration procedures regardless of the technology used, i.e. whether manual evisceration or automated evisceration equipment leaves the viscera either attached or physically separated from the corresponding carcass.

An operator may incorporate or shall reference this ISO-based standard in the establishment's HACCP system.

The operator may develop their own presentation standard, in which case it shall, be comprised of the following minimum criteria:

- nonconformances listed in sub section 5
- minimum frequency of hourly testing for normal level;
- performance criteria must ensure a minimum of 95% compliance;
- samples must be selected on a random basis and
- acceptability of testing protocols and corrective actions shall be determined by the VIC.

Presentation monitoring tests are performed on each evisceration at a presentation test station is located after evisceration and prior to viscera detection. Carcasses correctly identified by the cavity defect detectors for removal by the helper/trimmer shall not be included in the sampling for the presentation tests.

All industry employees performing presentation tests shall be trained and accredited as per the Training and Accreditation Protocol.

A.2.3 Defects Related to Improper Presentation**A.2.3.1 Defects to be monitored by Presentation Standard**

During presentation monitoring, the following three defects shall be counted as presentation errors. These defects are described in sub section 5.1. and included within the ALL for presentation tests:

- (1) No Viscera
- (2) Viscera Parts Missing
- (3) Inadequate Abdominal Opening

A.2.3.2 Other Defects to be controlled by HACCP System

The following six defects (1 to 6) shall not be included as errors as part of the presentation tests and are not included in the ALL for the presentation tests. Rather, they shall be controlled as part of the establishment's HACCP system.

- (1) unopened carcass - carcass without any abdominal incision;
- (2) viscera not removed from cavity - carcass with an abdominal incision but viscera are not sufficiently drawn from the abdominal cavity to permit detection or inspection;
- (3) carcass not hung by legs - carcass hung by the neck or a wing;
- (4) water pooled within the cavity* which may mask evidence of pathological and/or processing defects (e.g. Airsacculitis and faecal contamination);
- (5) contaminated viscera - severe contamination to the extent that evidence of pathology is obscured (e.g., generalized Airsacculitis); and
- (6) hearts and livers not visible - viscera portions to be examined are present, but hidden behind the gizzard on a consistent basis.

* Water sprays are only allowed within a "recognized HACCP system". Refer Chapter 19 of this manual for more information on the requirements for the use of water sprays.

Carcasses with presentation defects (1) to (3) shall be removed from the line (before or by the helper/trimmer) for verification of cavity and viscera defects. They shall be identified and kept separate from carcasses for salvaging and not be allowed to unduly accumulate on racks. Errors shall be corrected as quickly as possible, and the carcasses rehung on the line in order not to compromise product safety due to bacterial multiplication. If not, they shall be condemned as "plant rejects". Refer to Chapter 19 of this manual for more information on "plant rejects".

A.2.4 Presentation Standard Monitoring**A.2.4.1 Description of Presentation Errors**

The following is a description of presentation errors for all methods of evisceration (e.g., manual or automatic), and all types of evisceration equipment regardless of whether the viscera remains attached or is completely removed from the carcass:

- **No Viscera:**

Carcasses are presented without the viscera or the viscera is presented with the heart and liver missing. To count as an error in fowl, the duodenum must be missing as well.

- **Viscera Parts Missing:**

For chicken and turkey - presentation of the viscera with over $\frac{1}{2}$ of the heart **or** over $\frac{1}{2}$ of the liver missing. There must be at least one intact lobe of the liver present for defect detection purposes.

For fowl - presentation of the viscera with over $\frac{1}{2}$ of the heart **or** over $\frac{1}{2}$ of the liver missing **or** the duodenum missing, with a maximum of one defect per carcass.

Multiply the total number of hearts missing by 0.1. If a missing heart is combined with a missing liver **or** a missing duodenum, a maximum of one defect is counted.

For mature poultry, including chicken roasters, missing spleens count as an error if a significant percentage are missing as determined by the VIC.

- **Inadequate Abdominal Opening:**

Presentation of carcasses with an inadequate abdominal opening makes it impossible to examine the abdominal cavity properly. This may result from pieces of skin or flesh obstructing the opening, the anus or cloaca that have remained attached, or any obstacle located in the incision hampering the presentation and view inside. The abdominal opening must be large enough to allow presentation and examination of the inside of the carcass. For chicken and light fowl, a cut made within 2 cm or $\frac{3}{4}$ " , and (3 cm for Turkey, Heavy Fowl, Roaster) of the point of the keel is considered to be an adequate opening.

Mutilated carcasses which have obstructions which interfere with examining the cavity shall also be scored as an "Inadequate Abdominal Opening"

Unless specified otherwise, each of the above listed errors will receive a score of one (1) with a maximum of one (1) error allowed per carcass.

A.2.4.2 Testing Frequencies

The frequency of monitoring and verification tests on each eviscerating line shall be based on the establishment's ability to maintain uniform carcass presentation. This frequency may be reduced when there is confidence in the establishment's presentation control, or it shall be increased when this confidence has been lost, according to section 6 , Presentation Standards Decision Tree For Chickens, Fowl & Turkeys, as follows:

MONITORING & VERIFICATION FREQUENCIES				
Test Type	Minimum Frequency per Inspection Level			Maximum Frequency
	Reduced	Normal	Tightened	
Monitoring by the industry Presentation Standard Monitor	Once per 4 hours	Once per hour	10 minutes after each decrease or increase in line speed	As required to monitor control over the presentation of carcasses and viscera
Verification by CFIA Staff	Once per shift	Once per ½ shift	Once per 2 hours	As required for CFIA to verify control by the industry presentation standards monitor over the presentation of carcasses and viscera

A.2.4.3 Sampling Procedure

The sampling must be done at constant intervals, e.g., every fifth carcass, every third carcass, etc. To avoid sample bias, randomly select a carcass by picking one, then count a predetermined number of carcasses, e.g., third one, and then examine this carcass and corresponding viscera. This carcass shall be the first one of the sample. Repeat the procedure for each subsequent carcass until the required number are examined.

The last step consists of checking the line speed.

The total of error incidences is the score for that inspection station and eviscerating line.

A.2.4.4 Sample Size and acceptance / rejection criteria

The sample size and the applicable accept and reject numbers shall be governed by the line speed range as shown in the following table. The Inspection Levels, (Normal, Reduced and Tightened) shall be governed the test score and the applicable switching rule as illustrated by the Decision Tree in Section 6.

PRESENTATION STANDARDS FOR CHICKEN, FOWL & TURKEYS ACCEPT AND REJECT NUMBERS, ALL = 4%, DOUBLE & SINGLE SAMPLING PLANS				
Line Speed Ranges: (cpm)	Inspection Level and Type of Sampling	Sample Size	Accept	Reject
20 to 53 (H*)	Reduced Double Sampling	1st 13	0	4
		2nd 13	3	6
	Tightened Double Sampling	1st 32	1	4
		2nd 32	4	5
54 to 167 (J*)	Reduced Double Sampling	1st 20	1	5
		2nd 20	4	7
	Tightened Double Sampling	1st 50	2	5
		2nd 50	6	7
168 plus** (K*)	Reduced Double Sampling	1st 32	2	7
		2nd 32	6	9
	Tightened Double Sampling	1st 80	3	7
		2nd 80	11	12

cpm: carcasses per minute

* H, J & K are sample size code letters from the publication

Statistical Aspects of Food Quality Assurance by Subhash C. Puri, Agriculture Canada

Original source: ISO/2859-1, International Organization for Standardization (ISO), Central Secretariat, Geneva.

** no line speed maximum provided operating in compliance with MPIP requirements

N.B. If the total of missing viscera reaches half of the rejection number, the VIC shall determine if the defects are significant considering the pathology associated with the specific flock; or there has been 3 consecutive corrective actions without regaining presentation control.

A.2.4.5 Corrective Actions

Management has the responsibility to implement timely and effective corrective actions immediately following each presentation test indicating that the number of presentation defects has reached or exceeded the reject number. In each case, they must inform CFIA personnel and must conduct an investigation to determine the probable cause to help decide on the best course of corrective action.

Corrective actions implemented by the operator commonly include one or more of the following:

- equipment adjustment and/or maintenance;
- adding employees;
- reducing the line speed (if e.g. extra time is required by the defect detectors (and inspectors under CPIP) to examine the carcass and/or viscera due to excessive presentation defects);
- changing the flock (if e.g. extra time is required for the birds to empty their intestines); and
- temporarily suspending the hanging of live birds.

A retest shall be done within 10 minutes of each failed test in order to evaluate the corrective action(s) implemented.

If a line speed reduction is chosen as the corrective action by the operator or is enforced by CFIA Staff, then retests must be done 10 minutes after each line speed decrease or increase.

Immediately following a failed presentation test at the tightened inspection level (box #10, decision tree, sub section 6), the presentation standards monitor shall notify the designated representative of the establishment operator and the inspector shall brief the VIC. An automatic line speed reduction of 10% shall be implemented if a line speed reduction was not included as a corrective action following previous failed If the corrective action taken by the operator fails to reduce the number of nonconformances, then the operator and the VIC, shall assess if the line speed should be returned to the normal speed or if another 10% line speed reduction is warranted.

If three consecutive tests are rejected under the Tightened Inspection Level, the operator and the VIC shall:

- determine to what extent the deviations from the presentation standards affect the detection of defective carcasses and viscera;
- evaluate and approve further corrective action(s);
- determine if live hanging operations may continue.
- The operator shall evaluate and assure the safety and wholesomeness of affected product (Evaluation results shall be confirmed by the VIC).
- A written action plan, endorsed by the operator and designed to resolve and prevent a recurrence and including amendments to the HACCP system, shall be submitted to the VIC.

In the case of recurring noncompliance, unusually high condemnation rates or consistently ineffective corrective action, the VIC shall be kept aware of all test results for analysis and possible further action.

A.2.4.6 Records

A separate Presentation Log form (see annex F of this chapter) shall be used for each category of shift (e.g. the same form may be used for a number of consecutive day shifts until the form is full). If more than one species are slaughtered, the log must clearly indicate which tests correspond to which species slaughtered e.g. with inserted blue or red vertical lines.

Because of differences of personnel and supervisors between shifts, test results for each shift shall be considered independently. The inspection level for the next shift (e.g. Tuesday day shift) shall be the same as that stipulated by the last presentation test for the previous applicable shift (e.g for the Monday day shift).

A.2.4.7 Line Speed

The line speed must be recorded for all tests. There is no maximum line speed for MPIP provided operations remain in compliance with MPIP requirements . However, if the line speed is reduced as a corrective action, then exceeding the decreased line speed is counted as a defect. Furthermore, management must immediately correct the line speed to that specified within their written presentation control program.

A.2.5 CFIA Responsibilities

CFIA staff shall ensure that the presentation standards program has been implemented and is being performed according to the establishment's written program. Time(s) for the presentation test(s) shall be randomly selected prior to the start of the shift. This may be accomplished by performing independent verification tests and/or correlation tests with the industry monitor.

The **Decision Tree for Presentation Standard** section 6 of this chapter, is to be used by the presentation standards monitor, and for reference by CFIA.

A veterinarian or inspector may perform an additional presentation test at any time as an additional assurance of process control or if they feel that standards are not being met for any reason.

A.2.5.1 Independent Verification Tests

CFIA's independent verification tests shall be performed according to the following parameters:

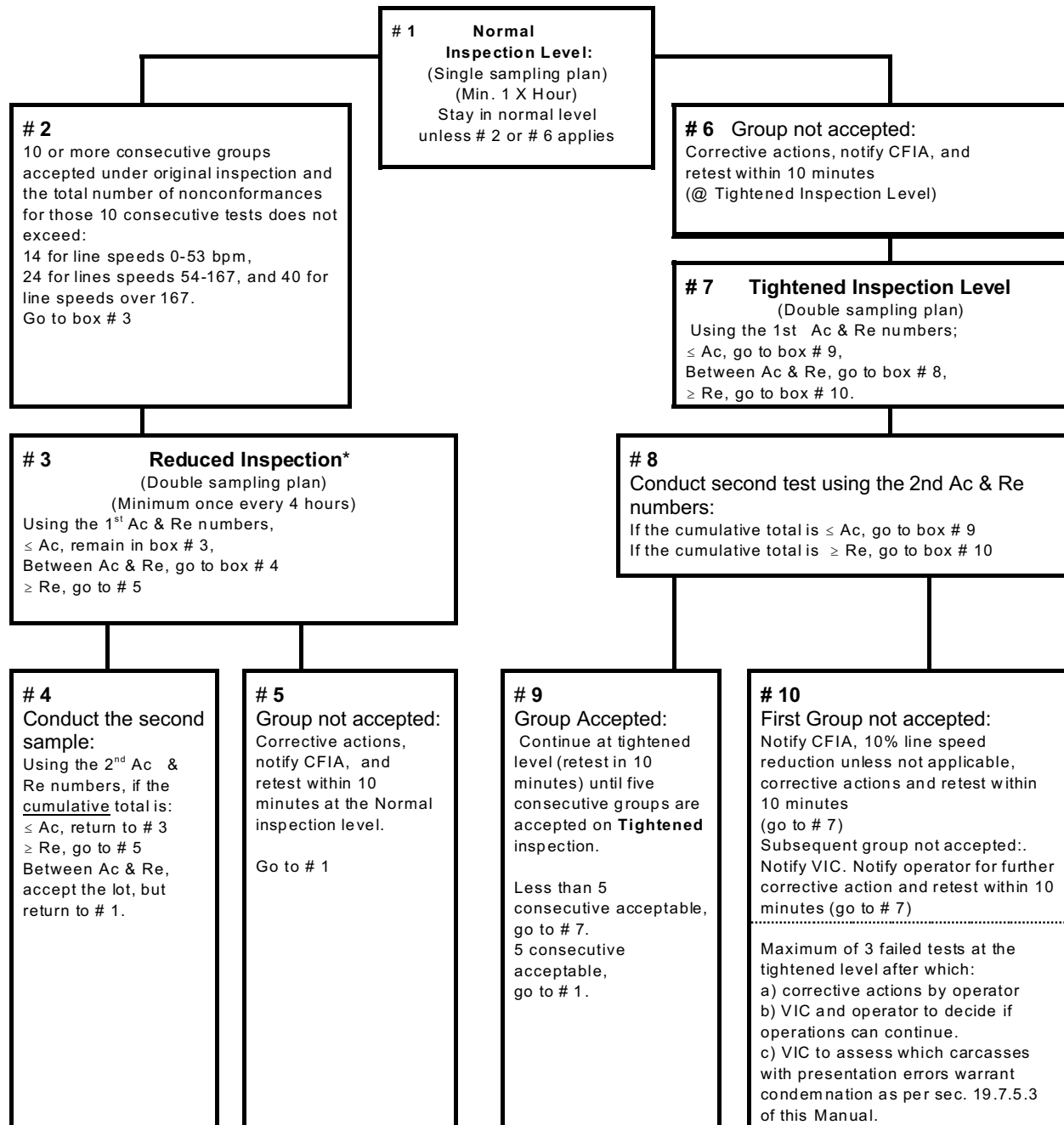
- Tests shall be performed on each evisceration line at the frequency indicated in section 4.2 and according to the procedure described in sub section 4.3
- Tests are performed at the same inspection level at which the establishment is currently sampling.
- If the test result is equal to or exceeds the rejection number in sub section 4.4, the operator shall perform an immediate retest at the present level and, if required, then initiate any action according to the decision tree in subsection 6.
- The result of each test shall be compared to the establishment's monitoring record. If the CFIA test result is not in agreement with the establishment's tests, the Inspector shall discuss the test results with the (industry) presentation standards monitor and inform the VIC.
- Test results may be recorded on a separate Presentation Log (see annex F of this chapter) or on the establishment's records such that CFIA tests can be distinguished from tests conducted by the establishment's presentation standards monitor.

A.2.5.2 Correlation Tests

Correlation testing consists of CFIA conducting an evaluation of a test being performed by the establishment's presentation standard's monitor according to the following parameters:

- If space permits, a member of the inspection staff shall examine the same carcasses at the same time as the industry monitor.
- The monitor will be evaluated for the correct interpretation of defects, completion of forms, correct application of the ISO switching rules and the implementation of corrective actions if necessary.

A.2.6 Decision Tree for CPIP / MPIP Presentation Standard Monitoring



- A Normal Level test may be performed at any time using Normal Level accept and reject numbers as an additional assurance of process control.

Note: At any time, the VIC or an inspector under veterinary supervision may enforce the *MIA* and *MIR* which will take precedence over actions recommended in this decision tree.

A.3 Presentation Standard for Carcasses and Viscera Presented for Sorting and Veterinary Disposition**A.3.1 General Requirements**

Presentation standards apply to veterinary examination stations on moving lines or stationary racks or carousals, and where sorting has been carried out beforehand by a CFIA inspector, at the sorting location.

It is the operator's responsibility to ensure that the presentation of carcasses and viscera held for sorting and/or veterinary examination is acceptable. The operator is responsible for training and designating staff to present carcasses for sorting and/or veterinary evaluation according to the presentation standards.

A helper/trimmer shall be provided at the request of the sorting inspector or the veterinarian. As instructed by the sorting inspector or the veterinarian, the helper/trimmer shall manipulate carcasses (especially turkeys) and viscera to facilitate sorting or veterinary examination, dispose of carcasses and/or viscera, eviscerate carcasses, trim carcasses, return carcasses to the evisceration line or transport them to the off-line salvage or reprocessing station, etc.

Carcasses shall be presented so as to permit the sorting inspector / veterinarian to visualize the carcass and the corresponding viscera without requiring him/her to handle either the carcass or the viscera ("Hands-off" dispositions). This may be achieved by the careful positioning of the carcass and viscera on specially designed equipment or by the assistance of a helper/trimmer.

Viscera shall be completely removed from the abdominal cavity to allow visual examination and, if necessary, palpation of organs and intestines. They shall remain attached (traditional evisceration) or synchronized (new evisceration technology) to the carcass.

Contents from the cloaca and/or from the severed gastro-intestinal tract shall not contaminate the carcass. Viscera shall never be placed back into the abdominal cavity to prevent contamination from leaking gastro-intestinal contents.

To prevent cross-contamination, carcasses shall be presented so as to avoid contacting each other. Alternatively, all carcasses in contact with condemned carcasses shall be disposed of by the operator as "plant rejects" if they are not condemned by the veterinarian for generalized pathology.

All poultry carcasses that are held for veterinary evaluation shall be clearly identified such that it is readily apparent which carcasses require CFIA examination. **Carcasses with processing defects shall not be presented for sorting nor for veterinary disposition** (e.g. imperfect bleeding, overscald, mutilation, small carcasses, not opened, not eviscerated, partially opened and/or eviscerated, contamination, etc.). Carcasses with processing defects may be passed through the sorting station provided that they are clearly identified such that no examination is required by the CFIA inspector at the sorting station. The operator shall assure that effective corrective and preventative action is taken to control processing defects.

Effective corrective and preventative action shall be taken by establishment staff when presentation standards are not met.

A.3.2 Testing of Presentation Standards

The evaluation of presentation standards is performed by sampling according to ISO sampling plan 2959-1 on the basis of sample code F of inspection level I.

Inspection level I and the acceptable quality level (AQL) of 4% are used, as in the case of evaluation of the presentation of carcasses subject to inspection and/or detection.

To avoid sample bias, a carcass is randomly selected from the line or a stationary hook, and the carcass located a predetermined number of carcasses away (for example, two carcasses) is then selected. The carcass chosen by this method and the corresponding viscera are examined and constitute the first item of the sample. This procedure is then repeated for each subsequent carcass until the requisite number of carcasses have been examined.

The following table contains the accept/reject criteria for samples:

Sample code	Type of sampling	Sample size	Accept number	Reject number
F	Normal	20	2	3

A.3.3 Presentation Defects

The following defects are part of the presentation standards and are counted as errors on the presentation log for carcasses held for veterinary examination:

Lack of uniformity in presentation:

- a carcass not presented in a uniform way;
 - a carcass rotated 45° beyond the maximum allowed according to the method agreed upon by the Veterinarian-in-Charge (VIC) and the operator;
 - processing defects such as uneviscerated or inadequately opened carcasses
- Each carcass not presented in a uniform way is counted as one defect.

Viscera not visible:

Viscera are not visible for veterinary examination (e.g. viscera inside the abdominal cavity);

Each carcass with viscera not visible is counted as one defect.

Viscera missing:

A carcass is presented without its viscera (liver/heart and duodenum for fowl);

Each carcass without corresponding viscera is counted as one defect.

Line speed :

In the case of a moving veterinary line, the line speed shall not exceed 20 carcasses/minute;

A.3.4 Testing Frequency

Presentation tests are to be conducted by CFIA inspectors and/or establishment staff . The tests set out in this section promote constant, objective analysis of compliance with presentation standards.

Initially, presentation standards tests shall be conducted by industry once per shift. After achieving acceptable presentation for 10 consecutive shifts under CFIA oversight, routine testing of presentation standards is no longer required. Thereafter, testing of presentation standards for sorting or for veterinary dispositions is to be conducted whenever it is believed that standards have not been met or when additional assurance is needed. There is no maximum or minimum testing frequency.

A presentation test may be carried out at any time on retained carcasses by CFIA.

A.3.5 Corrective Action

It is management's responsibility to implement effective corrective action at the appropriate time. The establishment is therefore responsible for developing and implementing suitable corrective action.

If a presentation test result is equal to the rejection number indicated in the previous table, corrective action shall be taken. Another assessment test shall be conducted within ten minutes, on the basis of the same table.

If the establishment uses a moving line to transport carcasses subject to veterinary examination, the maximum speed of the line shall respect this presentation standard. Corrective action shall be taken and approved by the VIC in order to ensure that the established speed is respected.

A.3.6 Compliance Measures

In the case of deficiencies concerning the facility requirements for the sorting or veterinary workstations or of deficiencies related to the presentation of viscera or carcasses for sorting or veterinary disposition, the VIC will initiate appropriate compliance measures such as verbal warning, official written notice, deficiency reported on a (monthly) Establishment Inspection Report (CFIA 1427), suspension of issuance of official condemnation certificates for a lot of poultry, warning or suspension of inspection, etc. whenever one or more of the following deficiencies occurs :

- absent or malfunctioning facilities for sorting or veterinary workstations; or
- lack of a helper/trimmer to provide assistance upon request by the sorting inspector or veterinarian; or
- excessive presentation defects as judged by the veterinarian in charge.

A.3.7 Records

A form entitled "Presentation Log for Veterinary Examination or Sorting Locations may be found in Annex F of this chapter.