

ANNEX B

HACCP-MPIP Plan:

Detection and Removal of Defective Carcasses

MPIP processors must be HACCP recognized and their HACCP system must include the defect detection process as per the following HACCP-MPIP plan.

HACCP- MPIP Plan Organoleptic Defect Detection							
Process Steps	CCP/ Hazard Number	Hazard Description	Critical Limits	Monitoring Procedures	Deviation Procedures	Verification Procedures	HACCP Records
<p>Preselection; Detection and removal of obviously condemnable carcasses for chickens and fowl (for turkeys see sub section 9.2) prior to evisceration (under MPIP, there are no assigned detection activities for obviously condemnable carcasses after evisceration based on external examination).</p> <p>Ref.:MPIP policy document sub section 9.4</p>	CCP-3B	Inadequate detection-removal by accredited carcass defect detectors of obviously condemnable carcasses which could contaminate the evisceration line or could represent a health hazard or are not considered wholesome.	Each carcass is examined prior to evisceration and all carcasses with specified defects are removed from the evisceration line. Performance equivalent to CFIA inspectors as demonstrated by compliance with applicable AQL's	<p>Team Manager (TM) monitors detection of defective carcasses regularly (e.g. 1x/hr) by observing accredited carcass defect detectors. Cavity and viscera defect detectors (post-evisceration) inform TM of undetected carcasses on an on-going basis.</p> <p>*Gvt monitoring: Further to examination of selected carcasses, Evisceration Floor Inspector and/or the veterinarian provides feedback to defect detectors and TM.</p>	<p>TM takes appropriate operational corrective actions (e.g. line speed reduction of 10%, additional line employee(s), etc.) TM instructs-retrains-replaces accredited carcass defect detectors and has employee(s) reaccruited as necessary.</p> <p>*Gvt monitoring: Evisceration Floor Inspector monitors the effectiveness of deviation procedures and informs VIC and TM of any unsatisfactory measures. VIC may take additional measures**.</p>	<p>QA verifies records and utilizes sampling plans indexed by AQL, for lot-by-lot inspection (e.g. ISO 2859-1 Sampling procedures for inspection by attributes)</p> <p>*Gvt verification: VIC correlates inspector's results (1x/shift) (ISO 2859-1)</p>	<p>Team Manager and QA log records.</p> <p>*Gvt Records from the VIC & Evisceration Floor Inspector</p>
<p>Cavity and Viscera Defect Detection ; Detection and removal of carcasses with specified viscera and cavity defect(s) including those requiring off-line reprocessing, carcasses with extensive processing defects and carcasses suspected as having generalized pathology.</p> <p>Ref.: MPIP policy Document, sub section 11.4</p>	CCP-5B	Inadequate detection-removal by accredited cavity and/or viscera defect detectors of carcasses with viscera and/or cavity defects which could contaminate the evisceration line or could represent a health hazard or are not considered wholesome.	Each carcass cavity and each viscera pack examined for defects by accredited cavity and/or viscera defect detectors All carcasses and/or viscera with specified defects removed from the evisceration line. Performance equivalent to CFIA inspectors as demonstrated by compliance with applicable AQL's	<p>TM monitors regularly the detectors' procedures and ability to detect defective carcasses and viscera (e.g. 1x/hr) by observing on-line detector(s).</p> <p>*Gvt monitoring: Gvt Evisceration Floor Inspector observes slaughter activities on an on-going basis and conducts (1x/hr) sampling (ISO 2859-1) to monitor defect detectors' performance and inform TM and VIC of any real or perceived loss of control on the line.</p>	<p>As appropriate, TM takes appropriate operational corrective actions (e.g. line speed reduction of 10%, additional line employee(s), etc). TM instructs-retrains-replaces designated employee(s).</p> <p>*Gvt monitoring: Evisceration Floor Inspector monitors the effectiveness of deviation procedures and informs VIC & TM of any unsatisfactory situations. VIC may take additional measures**.</p>	<p>QA verifies records and utilizes sampling plans indexed by AQL for lot-by-lot inspection (e.g. ISO 2859-1 Sampling procedures for inspection by attributes)</p> <p>*Gvt verification: VIC correlates inspector's results (1x/shift) (ISO 2859-1)</p>	<p>Team manager and QA log records.</p> <p>*Gvt Records from the VIC & off-line inspector</p>

* Gvt:- government; insp.:- inspector; TM;- team manager; MOP;- meat hygiene Manual of Procedures; FPS;- Finished Products Standards program; QA;- quality assurance; VIC;- Veterinarian-in-Charge

**VIC may submit samples for histopathology or microbiology tests, may update establishment trainers ,etc. if unusual pathology or diseases present in a flock

HACCP-MPIP Organoleptic Defect-Detection							
Process Steps	CCP/Hazard Number	Hazard Description	Critical Limits	Monitoring Procedures	Deviation Procedures	Verification Procedures	HACCP Records
<p>On-line Trimming ; On-line removal of trimmable defects (on-line trimmable conditions)</p> <p>Ref.: Finish Product Standards program ,MPIP policy document Section 14 and Annex D</p>	CCP-5B	Failure by designated company employee(s) to handle trimmable defects correctly i.e. to trim localized pathology and correct dressing and/or processing defects which could represent a health hazard or are not considered wholesome.	All trimmable defects (as specified in the FPS) are removed by designated employees. All defective carcasses unmanageable on-line must be removed for off-line reprocessing (CCP-6B). Ready-to-chill carcasses pass FPS prechill tests	TM monitors on-line defect detection and removal regularly (e.g. 1x/hr) by observing on-line trimmer(s). Accredited employee(s) perform (1x/hr) FPS prechill tests for trim and processing defects.	TM takes appropriate corrective actions (e.g. line speed reduction of 10%, additional line employee(s), etc). TM instructs-retrains-replaces designated employee(s). Process action as per FPS program including product retention and rework if indicated.	QA verifies (once a day) the processing & dressing FPS compliance at pre and post-chill levels.	Team manager and QA log records. FPS test records.
<p>Reprocessing & Reconditioning Carcasses Off-line or on-line reprocessing or off-line salvaging for faecal contamination or off-line salvaging of carcasses removed for e.g. Airsacculitis in clavicular air sacs or trimming off-line extensive pathology or processing defects e.g. large Cellulitis lesions</p> <p>Ref.: Ch.4, MOP</p>	CCP-6B	Failure by designated company employee(s) to handle trimmable defects correctly i.e. to trim localized pathology and correct dressing and/or processing defects which could represent a health hazard or are not considered wholesome.	All trimmable defects (as specified in the FPS) are removed by designated employees. Zero tolerance for identifiable faecal contamination in reprocessed carcasses or salvaged product.	TM monitors off-line defect removal by observing employees on a regular basis (e.g. 1x/hr) Designated employee tests salvaged product and/or reprocessed carcasses and reconditioned carcasses	TM takes appropriate corrective action, e.g. additional line employee(s) or TM instructs-retrains-replaces on-line trimmer(s), etc. Defective ready-to-chill product retained and reworked	QA verifies (once a day) the reprocessing and reconditioning operations for correct procedures and compliance with FPS criteria.	Team manager and QA log records. Test records by designated employee(s)

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**VIC may submit samples for histopathology or microbiology tests, may update establishment trainers ,etc. if unusual pathology or diseases present in a flock