1.4 APPENDIX TWO: BOVINE HACCP PLAN

Approved By: Lucy Vi Date: 18/11/2024.

AMENDMENT RECORD

Rev. No 10	Updated References to reflect new editions. Updated reference to documents to coincide with new documentation system. Updated 6. Process Flow to allow for movement of stations in slaughter process.	Janet Lea Dionne Croton	21.05.2010
Rev. No 11	Addition of Bovine Tripe into process. Updated Scope to be more precise. Exchanged position of CEO to Production Manager	Dionne Croton	24.03.2011
Rev. No 12	Updated references to include recent US OMAR version. Updated 6 process flow and 7.2 Process to reflect reality. Updated references of Production Manager to Plant Manager.	Dionne Croton	06.01.2012
Rev No. 13	Updated NZFSA to MPI VS	Debbie Smith/Tim Garrett	14.01.2013
Rev No. 14	Updated 6 process flow and 7.2 Process for inclusion of foetal blood collection	Debbie Smith	19.07.2013
Rev. No. 15	Updated Ovine Processing in Bovine Room as per minor amendment 08/11/2010	Debbie Smith	06.08.2013
Rev. No. 16	Update Hazard Analysis Table (Environment & Physical Aspect Analysis)	Debbie Smith	06.08.2013
Rev No 17	Added stimulation step to Process Flow and HACCP plan analysis	Janet Lea	28-01-2015
Rev No 18	Amendments from Annual Review 2014/15	Janet Lea	19-05-2015
Rev No 19	Amendments from Annual Review 15/16 changes to process flow and adding CCP for tripe	Janet Lea	05-10-2016
Rev No 20	Amended CCP documents to add verification steps and to change to a daily verification	Janet Lea	13/12/2017
Rev No 21	Updated 8 ZFT/Pre-Shipment form references -updated Compliance Manager to Technical Manager	Hinewai Ngatai	14-02-2018
Rev No 22	Updated 5.Product Description & Intended Use, did not include 4-9, added STEC definition	Mj Fenton	29.08.2018
Rev No 23	Annual Review process flow update	Janet Lea	23.07.2019
Rev No 24	Added the chilled shelf life for products	Janet Lea	09/01/2020
Rev No.25	Corrected the flow chart, Hazard Identification, added to definitions.	Debbie Smith	8/12/2020
Rev No. 26	Updated to cover off BRC requirements of Hazards and Beef mouthing included in flowchart	Debbie Smith	30/03/2021
Rev No. 27	Updated Definition of ZFT, included Ingesta, included unforeseen circumstance s in Table 7.2	Debbie Smith	24/05/2021
Rev No. 28	Changed Plant Manager to General Manager – Operations and Technical Manager to Technical/Environment Manager	Debbie Smith	6/7/2021

Rev No. 29	Updated HACCP plan to meet US OMAR requirements	Debbie Smith	12/01/2022
Rev No. 30	Updated Reference for ZFT	Debbie Smith	2/2/2022
Rev No. 31	Updated Corrective action for CCP	Debbie Smith	2/12/2022
Rev No. 32	Updated Verification Check the checker on ccs	Debbie Smith	19/01/2023
Rev No. 33	Updated procedure to include change in neck removal and neck trim, now after PM inspection	Debbie Smith	13/02/2023
Rev No. 34	Updated Process Flow Charts	Debbie Smith	31/03/2023
Rev No. 35	Updated process flow to reflect reality and US OMAR version	David Wild	21.05.2024
Rev No. 36	Updated Bovine HACCP Plan	Lucy Vi	18/11/2024

1. SCOPE OF HACCP PLAN

Scope	
HACCP Application:	Food Safety.
Species:	Bovine.
Process:	Slaughter and Dressing of Bovine Animals from the receipt of livestock, slaughtering and dressing, refrigeration, cutting, boning, further processing through to loadout, including the processing of edible offals, edible tripe and renderables.

2. DEFINITIONS

Control measure: Any action and activity that can be used to prevent or eliminate a food safety hazard or reduce it to an acceptable level.

Corrective action: Any action to be taken when the results of monitoring at the Critical Control Point indicate a loss of control.

Critical Control Point (CCP): A step at which control can be applied and is essential to prevent or eliminate a food safety hazard or reduce it to an acceptable level.

Critical limit (CL): A measure, which separates acceptability from unacceptability.

Good Operating Practice (GOP): The operator must document Good Operating Practices (GOP) in relevant supporting systems (also known as prerequisite programmes, good hygienic practices) before applying HACCP principles to the process. These supporting systems must comply with all relevant regulatory requirements, including the Animal Product Regulations 2021, Animal Act 1999, and Animal Product Notice Production, Supply and Processing. Each documented supporting systems should provide information on authorities and responsibilities, procedures (including control, monitoring, corrective action and operator verification), and requirements for recording requirements.

HACCP: A system, which identifies, evaluates and controls hazards that are significant for food safety.

HACCP coordinator: An appropriately trained person responsible for coordinating the application and implementation of HACCP at premises.

HACCP Plan: A document prepared in accordance with the principles of HACCP to ensure control of hazards, which are significant for food safety.

Hazard: A biological, chemical or physical agent in, or condition of, food with the potential to cause an adverse health effect.

Hazard analysis: The process of collecting and evaluating information on hazards and conditions leading to their presence to decide which are significant for food safety and therefore should be addressed in the HACCP plan.

Input: Incoming materials such as consumable or non-consumable items added to the product during the process. Consumable items include raw materials/ingredients/food additives. Non-consumable items include wrapping and packaging.

Malicious Contamination: Operator that need to report to malicious contamination or threats can do so anonymous via the inappropriate behaviour Policy September 2020.

Fraud: Policy created September 2020 and displayed around the site explained how to report Fraudulent or inappropriate behaviour.

Allergen Risks: Considered in all process. Milk Powder in the Stock yards is the only identified allergen risk at ME 132 as at September 2020.

Monitor: The act of conducting a planned sequence of observations or measurements of control parameters to assess whether a CCP is under control.

Preventative Action: Any action taken to maintain control at a Critical Control Point

Risk: A function of the likelihood and severity of an adverse health effect on the consumer as a result of exposure to a hazard.

STEC: Shiga toxin-producing *E.coli*, includes *E.coli* O157:H7 and non-O157 STEC (nSTEC) strains, in particular the Top 6 nSTECs identified by the US FDA (*E.coli* O26, O45, O103, O111, O121, and O145)
Step: A point, procedure, operation or stage in the food chain, including raw materials, from primary production to final consumption.

Verification: Review/audit in addition to those used in monitoring to determine the effectiveness of the HACCP plan in delivering expected outcomes.

ZFT: A ZFT programme that checks the effectiveness of the CCP and meets the requirements of the FSIS “US Pathogen Reduction/HACCP Final Rule. Refer Option 3, Reference USA OMAR Meat and Ratite Products S.2.6.6. HACCP FAQ.

REGULATORY LIMITS: Refer 8.4 Sampling Procedure, Section 8.4.5.8 M Limits, outlines regulatory NMD limits for Bovine

3. REFERENCES

USA OMAR amendment 29 issued May 2024
Animal Products Notice, Production, Supply and Processing 2022
Animal Product Regulations 2021
Animal Products Act 1999

NZ HACCP Standard
Technical Briefs 07/010, 07/011, 08/17

4. PREREQUISITE REQUIREMENTS

See Prime Range Meats Limited Compliance Procedures and MPI Verification Services recognition of such.

PRM Site Systems 1.0 Risk Management Programme
PRM Site Systems 2.0 Premises
PRM Site Systems 3.0 Hygiene & Sanitation
PRM Site Systems 4.0 Pre-Slaughter
PRM Site Systems 5.0 Slaughter and Dressing
PRM Site Systems 6.0 Post-Slaughter Management
PRM Site Systems 7.0 By-Products
PRM Site Systems 8.0 Quality Systems
PRM Site Systems 9.0 Market Access

5. PRODUCT DESCRIPTION AND INTENDED PURPOSE

1. Product Name(s):	Cuts and Trimmings Offal's including tripe. Carcasses Pharmaceutical – Foetal Blood
2. Product Description:	Passed ante and post mortem inspection; as fit for human and animal consumption. Product(s) meeting microbiological targets set by the company. Chilled or frozen as per regulatory and company specifications. Packed and labelled as per regulatory and company specifications.
3. How is it to be used: **(a) By a further processor:** **(b) By the consumer:**	Further processed into manufactured, retail and food service products. Cooked
4. Intended consumer:	General public (ie. no specified "high-risk" groups).

5. Packaging:	Approved food packaging materials
6. Shelf life and storage requirements:	Frozen – Within two years from approximate date of slaughter. Chilled – 90 days
7. Where it will be sold: **(a) Export market:** **(b) Local market:**	(a) EU, USA, Canada, Japan, French Polynesia, Lebanon or other overseas markets (b) New Zealand.
8. Labelling instructions: **(a) Carcass** **(b) Cartoned product**	(a) Carcasses are branded & have carcass ticket (b) Product description. (i) Product of New Zealand. (ii) Keep Frozen. (iii) Weight in kgs or lbs. (iv) Slaughter date, production date or initial date of freezing. (v) Storage instructions / Safe handling instructions. (vi) Best used by date; (if applicable) (vii) Plant name, RMP No, address and plant carton seal. (viii) Non-EU identification mark if applicable.
9. Special distribution controls required:	Prompt dispatch to chiller/freezer. (i) Chilled product storage at < 7°C (ii) Frozen product storage at <-12°C

6. Process Flow

Inputs	Process	Outputs
Cattle beast	Receipt of stock	
	↓	
	Pen	Dead stock collection & transfer to rendering
	↓	
	Ante-mortem inspection and assessment of suitability for slaughter (6.1a)	
	↓	
	Pre stun wash	
	↓	
	NAIT scan inclusive of HGP& BPQ	
	Stun	
	↓	
	Sticking	Inedible blood collection
	↓	
Weasand Clip	Stimulation	
	↓	
	Locate and Clip Weasand	
	↓	
	Head Skinning (one side only)	
	↓	
	Apply paper under skin	
	↓	
	Head removal	
	↓	Paper into rubbish bin
	Horn Cutter & Front Hock removal	Hock to rendering
	↓	
Potable Water	Head Wash / Tongue Drop	Head to rendering
	↓	If tongue touches floor, green ink applied and condemned
	Head Inspection by AsureQuality mouths cattle when required	
	↓	Tongue and Cheek Meat to edible offal
	First Leg – Flay hide	
	↓	
Gambrel	Trim off Weasand open front socks	1st leg hock and udder to Rendering
	↓	
	Change over & Second Leg – second Flay	
	↓	
Plastic Bag	Bunging & Ringing	
	↓	
	Removal of ear tag	
/Rubber ring	↓	
	Trim off weasand, open front socks	
	↓	
Crayon Marker	Hide Pull	Hide to collection bin for transfer offsite.
	↓	
	Brisket Saw & Evisceration → Gut Buggy (6.1b)	Edible Offal (6.1c)
	↓	Green Tripe/Paunch (6.1d)
	Split Saw	Foetus (6.1e)
	↓	Collection of foetal blood
	Enucleate kidneys / Trim Contamination	
	↓	
	Post-mortem inspection → Detain trim→ Re-Inspection	

Ccs Ticket Brand	**Combination CCP 1** ↓ Remove Kidney / Fat Trimmer ↓ Neck removal and neck trim ↓ Scales/Grading/Branding/Quartering Cut/100% ZFT inspection ↓ **CCP Monitoring** **Post Inspection Faecal/Ingesta Check (100% ccs inspection)**	Trim & Kidney to rendering Neck saved for edible to offal
	Chillers (6.2) **Boning Room (6.3)**	→ Dressed carcasses

Inputs	**Process 6.1 (a) Ante-Mortem**	**Outputs**
Cattle Beast	Assessment ↓ ← ↓ → Accepted unconditionally → **Presented for slaughter** Accepted conditionally → Reassessment Unacceptable	→Returned to Supplier → Approved mobs
	Reassessment ↓ Accepted conditionally → Special Care Mobs → **Presented for slaughter** Accepted unconditionally → **Presented for slaughter**	→ Approved mobs → Special Care Mobs

Inputs	**Process 6.1 (b) Gut Buggy**	**Outputs**
Gut Buggy	Inspection ↓ Separate viscera ↓ Remove offal's ↓ Edible ↓ Paunch / Green Tripe ↓ Condemned Material/ Foetus	→ Chute to Edible offal (6.1c) → Chute to Green Tripe Room (6.1d) → Foetus to Foetal Blood Room (6.1e) → to rendering

Inputs	Process 6.1 (c) Edible Offal	Outputs
Edible offal	Sorting table	
	↓	
Potable Water	Cold water wash	
	↓	
	Racked to drain	
	↓	
	Checked and trimmed of defects	
	↓	
Packaging	Bagged / Packed	
	↓	
	Bags railed to chiller	→ Chilled edible offal
	↓	
	Cartons to Blast Freezer	
	↓	
	Carton loadout	→ Frozen edible offal

Inputs	Process 6.1 (d) Tripe/Paunch	Outputs
Green Tripe	Green Tripe has fat removed	→ Fat to Rendering
	↓	
	Paunch opened lengthways, hung on hook (via winch) and contents emptied	→ Ingesta to waste drain
	↓	
Potable water	Cold water wash	
	↓	
	Visible defects / Excessive fat removed	→ To rendering
	↓	
	Rumen Pillars Removed and placed into tub – placed through to packaging room in this tub	→ As required
	↓	
Potable Water	Remaining Paunch placed into scudder with hot and cold-water wash	
	↓	
Potable Water	Cold Water Spray	
	↓	
	Tripe Racked to Drain	
	↓	
	Honeycomb and tripe separated and trimmed	
CCP2	↓	
	100% visual inspection for faecal/ingesta/parasitic lesions/foreign bodies	Contaminated Tripe Condemned to rendering
	↓	
Packaging	Product packed in cartons as per company specifications	
	↓	
	CCP 2 Monitoring – 10 tripes per run Cartons to blast freezer	
	↓	
	Carton loadout to cold storage	→ Frozen Edible Tripe → Frozen Edible Honeycomb Tripe → Frozen Edible Mountain Chain

Inputs	Process 6.1 (e) Foetal Blood Collection	Outputs
Foetus Packaging Potable Water Ice	Unborn foetus received into bleeding area in amniotic sac ↓ Amniotic sac placed on table and cut through to expose foetus ↓ Remove foetus from sac, inspect for disease or deformity ↓ Clear any amniotic fluid and make incision ↓ Insert needle from blood bag into heart ↓ When blood bag full, remove needle and tie off bag ↓ Place bag in ice slurry ↓ Foetus and placenta discarded	→Deformed or disease calves to rendering →Blood bags packed and couriered to Life Technologies in slurry →Foetus and placenta to rendering

Inputs	Process 6.2 Chillers	Outputs
Dressed carcasses Hooks	Lowerator ↓ Chilling ↓ Quartering ↓ Chiller ↓ Loadout to local market OR Boning Room (6.3)	→ Chilled dressed carcasses or quarters

Inputs	Process 6.3 Boning Room	Outputs
Chilled dressed carcasses Packaging Labels	Rail to Boning Room ↓ Pre-trim ↓ Boning Trimmers ↓ Packers ↓ Carton Inspection ↓ Weigh/label ↓ Carton Strapper ↓ (a) Chilled products ← → (b) Frozen products ↓ ↓ ↓ Carton Blast freezer Chiller ↓ ↓ Cold Store ↓ ↓	→Inedible trim to rendering

	Load out	Load-out	→ Frozen bovine cuts → Chilled bovine cuts

7. IDENTIFICATION AND ANALYSIS OF HAZARDS

CCP Code: B = Biological hazard; C = Chemical hazard; P = Physical hazard
R = Radiological Hazard, F & M = Fraud and Malicious Contamination A = Allergens

7.1 HAZARD IDENTIFICATION:

Input	Description/ Specification	Biological Hazard	Chemical Hazard	Physical Hazard	Radiological Hazard	Fraud and Malicious Contamination	Allergens
Cattle beast	Complies with regulatory requirements for animals presented for slaughter.	Bacterial pathogens associated with enteric pathogens faeces, ingesta and dirt from the gastrointestinal tract and the hide eg: Salmonella spp., Campylobacter jejuni, E. coli O157:H7 and other non O157:H7 STECS **In consideration of the above information Prime Range Meats Ltd ME132 has reassessed its HACCP plan, hazard identification and analysis, and concluded the E.coli O157:H7 and other non O157:H7 STECS is not a hazard that is reasonably likely to occur in beef exported to the United States. or any other market and confirms the HACCP Plan is continuing to meet New Zealand and US OMAR**	Chemical Residues eg Veterinary medicines, environmental contaminants	Shotgun pellets	None	None	None

Input	Description/ Specification	Biological Hazard	Chemical Hazard	Physical Hazard	Radiological Hazard	Fraud and Malicious Contamination	Allergens
		requirements. **Refer to *E.coli O157:H7 and other non O157:H7 STECS Determination of Risk. Located in the HACCP folder.*** Bacterial pathogens associated with grossly detectable abnormalities (ie: fever, abscesses), eg Salmonella spp. for fever Urine spillage is considered a contaminant. For cows-bacterial pathogens associated with contamination from mastitic milk eg, Staphylococcus aureus Parasites – e.g. *Taenia saginata**** ***The carcass is inspected for *T. saginata* during post-mortem, but existing inspection methods have low sensitivity to low grade infection of cattle. In					

Input	Description/ Specification	Biological Hazard	Chemical Hazard	Physical Hazard	Radiological Hazard	Fraud and Malicious Contamination	Allergens
		certain circumstances, *T. saginata* may still be present in the inspected and passed carcass. In these cases, a HACCP-based programme for further detection and removal of T. saginata may be applicable during boning. However, for the purposes of this generic model, and considering the rare occurrence of this hazard in beef, this hazard will not be considered any further in the hazard analysis. SRM's were considered as per US OMAR amendment 2 dated December 2008 Part 2.1 cc: "specified risk material" and spinal cord will not be removed at PRM unless a customer requires it. • Still considered as part of the Bovine HACCP. (However will not be carried out at the present time)					
Water/ice/steam	Potable water	None	None	None	None	None	None
Weasand Clip	Suitable for use	None	None	None	None	None	None

Input	Description/ Specification	Biological Hazard	Chemical Hazard	Physical Hazard	Radiological Hazard	Fraud and Malicious Contamination	Allergens
	as food contact material						
Plastic Bag /Rubber Ring	Suitable for use as food contact material	None	None	None	None	None	None
Crayon Marker	Suitable for use as food contact material	None	None	None	None	None	None
Branding Ink	Suitable for use as food contact material	None	None	None	None	None	None
Carcass Tickets	Suitable for use as food contact material	None	None	None	None	None	None
Packaging Materials	Suitable for use as food contact material	None	None	None	None	None	None

7.2 HAZARD ANALYSIS AND CCP DETERMINATION FOR CARCASSES, CUTS AND TRIMMINGS

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
Receipt of stock	Cattle beast	B-Bacterial pathogens-grossly detectable abnormalities	Refer to 7.1	No		
		C-Chemical residues	Refer to 7.1	National Residue Monitoring and Surveillance Programme and Supplier declarations (ASD) *Refer PRM Site System 4.2 Bovine Yards*	No	
Holding in Pens	Cattle beast	B-Bacterial pathogens-grossly detectable abnormalities	Micro carried over from previous step	No		
Ante Mortem exam	Cattle beast	B-Bacterial pathogens-grossly detectable abnormalities	Micro carried over from previous step	Controlled under ante-mortem examination system	No	
Pre-stun Washing	Cattle beast	None				
	Potable Water	None	Refer to 7.1			
Stun	Cattle beast	None				
Sticking	Cattle beast	B – enteric pathogens	Micro contamination of the carcass from the hide can occur at this step	Yes-correct sticking technique will minimise contamination. *Refer to PRM Site System 5.3 Bovine Slaughter & Dressing procedure*	No	
Locate & Clip weasand.	Carcass / head / offal	B – enteric pathogens	Micro contamination of the carcass with ingesta from the gastrointestinal tract (GIT) can occur at this step	Yes-correct clipping technique will minimise contamination. *Refer to PRM Site System 5.3 Bovine Slaughter & Dressing procedure*	No	
	Weasand Clip	None	Refer to 7.1			
Stimulation	Cattle beast	None				

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
Head Skinning One side	Carcass / head / offal	B – enteric pathogens	Micro carried over from previous step	No		
Head Removal	Carcass / head / offal	B – enteric pathogens	Micro carried over from previous step	No		
Horn Cutter & Fore Hock Removal	Carcass / head / offal	B – enteric pathogens	Micro carried over from previous step	No		
Head Wash & Tongue Drop	Head	B – enteric pathogens	Micro carried over from previous step	No		
	Potable Water	None	Refer to 7.1			
Head inspection by Asure Quality	Carcass Head	None		No	No	
First Leg	Carcass / offal	B – enteric pathogens	Micro contamination of the carcass from the hide can occur at this step	Yes – correct skinning technique will minimise contamination. *Refer to PRM Site System 5.3 Bovine Slaughter & Dressing procedure*	No	
Changeover & Second Leg	Carcass / offal	B – enteric pathogens	Micro contamination of the carcass from the hide can occur at this step	Yes – correct skinning technique will minimise contamination. *Refer to PRM Site System 5.3 Bovine Slaughter & Dressing procedure*	No	
Bunging & Ringing	Carcass / offal	B – enteric pathogens	Micro contamination of the carcass from the gastrointestinal tract (GIT) can occur at this step	Yes – correct ringing technique will minimise contamination. *Refer to PRM Site System 5.3 Bovine Slaughter & Dressing procedure*	No	
	Plastic Bag / Rubber Ring / Crayon Marker	None	Refer to 7.1			

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
Eartag Removal	Carcass / Offal	B – enteric pathogens	Micro contamination of the carcass from the hide can occur at this step	Yes – GMP and hygiene practices will minimise any contamination. *Refer to PRM Site System 5.3 Bovine Slaughter & Dressing procedure*		
Trim off Weasand open front socks	Carcass/Offal	B – enteric pathogens	Micro contamination of the carcass from the hide can occur at this step	Yes – GMP and hygiene practices will minimise any contamination. *Refer to PRM Site System 5.3 Bovine Slaughter & Dressing procedure*	No	
Hide Pull	Carcass / offal	B – enteric pathogens	Micro contamination of the carcass from the hide can occur at this step	Yes – correct hide removal techniques will minimise contamination. *Refer to PRM Site System 5.3 Bovine Slaughter & Dressing procedure*	No	
Evisceration / Brisket Saw	Carcass / offal	B – enteric pathogens Urine spillage	Micro contamination from the GIT can occur at this step	Yes – hygienic techniques during freeing and dropping of the bung, and prevention of puncturing the GIT or bladder will minimise contamination. *Refer to PRM Site System 5.3 Bovine Slaughter & Dressing procedure*	No	
Split Saw	Carcass / offal	B – enteric pathogens	Micro carried over from previous step	No		
Enucleate Kidney / Spinal Cord Removal (Customer Access)	Carcass / offal	B – enteric pathogens SRM	Micro carried over from previous step	No Yes – correct hygienic techniques will minimise contamination. *Refer to PRM Site System 5.3 Bovine Slaughter & Dressing procedure*	No	

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
Post- mortem inspection / Detain / Re-inspection	Carcass	B-Bacterial pathogens-grossly detectable abnormalities	Micro carried over from previous step	Controlled under the post-mortem examination system	Yes	**CCP 1 Market Access**
		B – enteric pathogens	Micro carried over from previous step	Yes – identification and hygienic trimming will remove any visible faecal contamination and reduce micro contamination on affected parts of the carcass	Yes	**CCP1 Market Access**
Gut Buggy Viscera Inspection	Offal/ Foetus	B-Bacterial pathogens-grossly detectable abnormalities	Micro carried over from evisceration step	Controlled under the post-mortem examination system	No	
		B – enteric pathogens	Micro carried over from evisceration step	Yes – post-mortem examination will identify offal's that are not acceptable for collection	No	
Head Meat	Offal	B-Bacterial pathogens-grossly detectable abnormalities	Micro carried over from evisceration step	Controlled under the post-mortem examination system	No	
		B – enteric pathogens	Micro carried over from evisceration step	Yes – post-mortem examination will identify offal's that are not acceptable for collection	No	
Neck Work Up	Carcass	B – enteric pathogens	Micro carried over from previous step	Yes – GMP & hygiene practices will minimise contamination.		
Remove Kidney / Fat Trimmer	Carcass	B – enteric pathogens	Micro carried over from previous step	No		
Neck removal and Neck trim	Carcass	B – enteric pathogens	Micro carried over from previous step	No		
Scales / Grading / Quartering Cut	Carcass	B – enteric pathogens	Micro carried over from previous step	No		
	Branding Ink	None	Refer to 7.1			

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
Post Inspection Faecal/ Ingesta Check CCP 1 Monitoring Step NAIT, HGP, BPQ scan	Carcass	B – enteric pathogens	Micro carried over from the previous step	CCP 1 Market Access monitoring step 100% ZFT Inspection of all carcasses 100% ZFT inspection Logsheet	No	
Lowerator	Carcass	B – enteric pathogens	Micro carried over from previous step	No		
Chilling of carcasses	Carcass	B – enteric pathogens	Micro carried over from previous step. Growth of mesophiles can occur if there is cooling failure	Yes – effective cooling will prevent the growth of mesophiles. *Refer PRM Site System 6.1 Refrigeration procedure*	No	
Quartering	Carcass	B – enteric pathogens	Micro carried over from previous step	No		
(a) Load-out of chilled carcasses for either further processing for export at another premises or for local trade	Carcass	B – enteric pathogens	Micro carried over from previous step	No *Refer PRM Site System 6.6 Product Loadout procedure*		
(b) Chilled carcasses to Boning room	Carcass	B – enteric pathogens	Micro carried over from previous step	No		

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
Pre-Trim Control Point	Carcass	B – enteric pathogens	Micro carried over from previous step	Yes Justified as a Control Point – Faeces / ingesta may become visible post ZFT CCP. To enhance the performance of the ZFT CCP pre-trim is a designated control point *Refer to PRM Site System 6.3 Beef Boning Room procedure*	No	
Boning and Trimming	Carcass	B – enteric pathogens	Micro carried over from previous step Growth of mesophiles can occur if there is temperature control failure	Yes – hygienic boning techniques will minimise contamination, and temperature control will prevent micro growth *Refer to PRM Site System 6.3 Beef Boning Room procedure*	No	
		P – bone in boneless product	Bone can occur in boneless product	Yes – correct boning techniques will minimise bone in boneless product *Refer to PRM Site System 6.3 Beef Boning Room procedure*	No	
Packers	Cuts & Trimmings	B – enteric pathogens	Micro carried over from previous step	No		
	Packaging Materials	None	Refer to 7.1			
Carton Inspection	Cuts & Trimmings	B – enteric pathogens	Micro carried over from the previous step	Yes *Refer PRM Site System 6.8 Carton Inspection procedure*	No	
Weigh/label Carton Strapping	Packed cuts & Trimmings	B – enteric pathogens	Micro carried over from previous step	No		

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
(a) Chilled Products: Packed cuts dispatched to chiller and chilled to ≤ 7°C	Packed cuts & Trimmings	B – enteric pathogens	Micro carried over from the previous step Micro growth can occur if there is refrigeration failure	Yes – effective refrigeration will prevent micro growth *Refer PRM Site System 6.1 Refrigeration procedure*	No	
(a) Chilled Products: Load-out	Packed cuts & Trimmings	B – enteric pathogens	Micro carried over from the previous step Micro growth can occur if there is refrigeration failure	Yes – effective refrigeration will prevent micro growth *Refer PRM Site System 6.6 Product Loadout procedure*	No	
(b) Frozen Products: Packed cuts dispatched to carton freezer and blast frozen to < -12°C	Packed cuts & Trimmings	B – enteric pathogens	Micro carried over from the previous step Micro growth can occur if there is refrigeration failure	Yes – effective refrigeration will prevent micro growth *Refer PRM Site System 6.1 Refrigeration procedure*	No	
(b) Frozen Products: Load-out	Packed cuts & Trimmings	B – enteric pathogens	Micro carried over from the previous step Micro growth can occur if there is refrigeration failure	Yes – effective refrigeration will prevent micro growth *Refer PRM Site System 6.1 Refrigeration procedure*	No	
Edible offal:						
Postmortem Inspection	Red Offal	B – Bacterial pathogens grossly detectable abnormalities	Micro carried over from the evisceration step.	Controlled under the post-mortem examination system.	No	
		B – enteric pathogens	Micro carried over from the evisceration step	Yes – postmortem examination system will identify offal's that are not acceptable for collection	No	

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
Cold wash	Red Offal	B – enteric pathogens	Micro carried over from the previous step	No		
	Potable Water	None	Refer to 7.1			
Racked to drain	Red Offal	B – enteric pathogens	Micro carried over from the previous step	No		
Checking for and trimming of defects	Red Offal	B – enteric pathogens	Micro carried over from the previous step	Yes – hygienic handling and trimming technique will minimise contamination *Refer PRM Site System 5.4 Offal procedure*	No	
Bagging/ packing	Red Offal	B – enteric pathogens	Micro carried over from the previous step	No		
	Packaging Materials	None	Refer to 7.1			
Chilled or frozen	Packed Red Offal	B – enteric pathogens	Micro carried over from the previous step Micro growth can occur if there is refrigeration failure	Yes - effective refrigeration will prevent micro growth *Refer PRM Site System 6.1 Refrigeration, 5.4 Offal procedures and CATR records*		
Storage	Packed Red Offal	B – enteric pathogens	Micro carried over from the previous step Micro growth can occur if there is refrigeration failure	Yes - effective refrigeration will prevent micro growth *Refer PRM Site System 6.1 Refrigeration, 5.4 Offal procedures and CATR records*		
Load-out	Packed Red Offal	B – enteric pathogens	Micro carried over from the previous step Micro growth can occur if the product is temperature abused	Yes – time/temperature control during loadout will prevent micro growth *Refer PRM Site System 6.6 Product Loadout procedure*	No	

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
Green Tripe / Paunch:						
Paunch fat removed	Green Tripe	B – enteric pathogens, ingesta	Micro carried over from the evisceration step or from GIT spillage	Yes – GMP temperature control will minimise micro growth Refer *PRM Site System 5.4 Offal Procedure*		
Paunch opened, hung up and contents removed	Green Tripe	B – enteric pathogens, ingesta	Micro carried over from the previous step	Yes – the proper technique for removal of ingesta will minimise contamination. Refer *PRM Site System 5.4 Offal Procedure*		
Cold water wash	Green Tripe	B – enteric pathogens, ingesta	Micro carried over from the previous step	Yes – proper washing to remove ingesta will minimise contamination. Refer *PRM Site System 5.4 Offal Procedure*		
	Potable Water	None	Refer to 7.1			
Removal of visible defects and excessive fat.	Green Tripe	B – enteric pathogens, ingesta	Micro carried over from the previous step Ingesta cleared	Yes – hygienic handling and trimming technique will minimise contamination. Refer *PRM Site System 5.4 Offal Procedure*		
Removal and Packing of Rumen Pillars	Green Tripe	B – enteric pathogens	Micro carried over from the previous step	Yes – hygienic handling and trimming technique will minimise contamination. Refer *PRM Site System 5.4 Offal Procedure*		

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
Clean in Scudder	Tripe	B – enteric pathogens	Micro carried over from the previous step	Yes – the high temperature reached in hot part of wash should minimise contamination. Refer *PRM Site System 5.4 Offal Procedure*		
	Potable Water	None				
Cold Water Spray	Cleaned Tripe	B – enteric pathogens	Micro carried over from the previous step	No		
	Potable Water	None				
Drain	Cleaned Tripe	B – enteric pathogens	Micro carried over from the previous step	No		
Separation of Honeycomb & Tripe	Cleaned Tripe	B – enteric pathogens	Micro carried over from the previous step	Yes – hygienic handling technique will minimise contamination. Refer *PRM Site System 5.4 Offal Procedure*		
Trimming & Packing	Cleaned Tripe	B – enteric pathogens	Micro carried over from the previous step	Yes – hygienic handling and trimming technique will minimise contamination. Refer *PRM Site System 5.4 Offal Procedure*		
	Packaging Materials	None				
Cartons to Blast freezer	Packed Tripe	B – enteric pathogens	Micro carried over from the previous step	Yes – effective refrigeration will prevent micro growth. Refer *PRM Site System 6.1 Refrigeration; 5.4 Offal Procedure & CATR records.*		

7.2 Process

Process Step	Inputs	Hazard reasonably likely to occur on or in the product at this step	Justification	Is there a control measure (s) for the hazard at this step?	Is the control measure at this step essential to food safety as defined by a regulatory limit or an operator-defined limit?	Critical Control Point
Storage	Frozen Tripe	B – enteric pathogens	Micro carried over from the previous step	Yes – effective refrigeration will prevent micro growth. Refer *PRM Site System 6.1 Refrigeration; 5.4 Offal Procedure & CATR records.*		
Unforeseen circumstances	Various issues	Various limiting hazards	Could be carried over from previous steps	Restore control	Corrective and Preventative Actions as described in Procedures and are known to Supervisory staff	

8. Control of Hazards: CCP No. 1

CCP Location: Controlling Fecal and Ingesta
Combination CCP (postmortem inspection, detain trim and reinspection)

Critical Limits and Justification:
No fecal and/or Ingesta contamination on any carcass.

Monitoring of CCP step:

Company ZFT inspectors monitor after the grader:

100% (all) ccs per run for fecal / ingesta contamination

Recorded on:

Section 1.0 RMP Form 1 100% ZFT Inspection log-sheet and then transferred to Section 1.0 RMP Form 5 Bovine 100% ZFT Inspection/HACCP Pre-shipment- electronic by the Supervisor.

Corrective and preventative actions:

Supervisor carries out and records corrective and preventative actions on the Process Control Check sheet. Refer to Site System 5.3 Bovine Slaughter & Dressing for corrective and preventative actions.

Corrective and Preventative Action Procedures:

Method:

Stop chain. Trim affected carcass immediately
Advise Supervisor and Asure immediately.
Supervisor to identify if personnel/process issue and retrain or remove operator.
Assess stock presentation and give feedback to the yards, discuss with Asure as to likely cause of defects.
Supervisor to monitor personnel/process closely, if compliant no further actions required, record findings on Process Control Check sheet
Add additional trimmers if available and slow the chain

NOTE: If a faecal/ingesta is identified at the Pre-Trim Inspection Control Point QC Check the Slaughter board Supervisor is to complete corrective and preventative actions.

If Rejection at the Cusum (faecal and ingesta only), the Boning Room Supervisor is to complete the Cusum Rejection Feedback Form and give to the Slaughter board Supervisor to complete corrective and preventative actions. The form is then to be forwarded to the Technical Manager.

Monitor Step Alarms and Corrective Actions

STEP 1 ALARM	CORRECTIVE ACTIONS CCP MONITOR	CORRECTIVE ACTIONS SUPERVISOR
If the critical limit is exceeded appropriate corrective and preventative action is to be taken. Details of monitoring outcomes, corrective actions and follow ups etc, are to be recorded. ➢ Supervisor or designated monitoring personnel are to record all details.	Stop the ZFT chain. The CCP Monitor will immediately notify the Asure Inspector and the Supervisor, showing them the amount and location of faecal / ingesta contamination. Immediate trimming of the faecal / ingesta contamination. Details of monitoring outcomes, corrective actions and follow ups etc, are to be recorded on the CCP ZFT log sheet.	Depending on the position of the defect and the defect type, the operation most likely to have produced the defect shall be reviewed by the Supervisor. The Supervisor can initiate corrective actions including informing the appropriate worker/s, retraining, or recalibrating techniques. After corrective actions a further five carcasses shall be inspected in the same run to confirm the process is under control. Details of monitoring outcomes, corrective actions and follow ups etc, are to be recorded on the Process Control sheet.
STEP 2 ALARM		
If a second critical defect is found on one processing run the designated monitoring personnel are to take the appropriate corrective and preventative actions	As above	As above In addition, the Supervisor will increase monitoring of slaughter and dressing and inspect a further 5 carcasses per run until the problem is resolved.
STEP 3 ALARM		
If repetitive critical defects are found on one processing run the designated monitoring personnel are to take the appropriate corrective and preventative actions	As above	As above Monitoring by the Supervisor will be increased with addition run checks (2 sets of 5 checks per run) until the problem is resolved. Responses could include reducing chain speed Additional trimmers on the Detain Supervision will be increased, and retraining will be given where necessary. If a problem is not rectified worker will be replaced The HACCP Co-ordinator and General Manager – Operations are to be notified. Additional verification by the Supervisor/Verifier to confirm any corrective actions have worked. Further actions may be taken by the HACCP Co-ordinator.

ZFT inspection is to be rotated on a regular basis to ensure the ZFT inspector remains alert. Two fully trained inspectors are to be available for ensuring the effective management of the CCP.

Record:

Record all monitoring and corrective action findings on the Process control check sheet

Product Disposition:

Restrict affected product from US markets (any product that has not had 100% ZFT inspection)

Verification Procedures:

Verification of CCP Monitoring

- Internal verification (reality check) of ZFT Inspector is carried out weekly by the Technical Team or designate. Findings are recorded on the Section 1.0 RMP Form 5 Bovine 100% ZFT Inspection/HACCP Pre-shipment - (electronically) and a hardcopy (RMP Form 8 Verification of CCP monitoring) is stapled to the Process Control Check sheet.

Justification for weekly ZFT Check the checker.

- With observations, checking and verification it has been decided that weekly checking of the ZFT allows the Company to find faults earlier than monthly verification. i.e. if something was wrong then only a few days of product would be on hold. Refer to: Form 8 Verification of CCP monitoring Check after ZFT inspector; 5 ovine /Bobby calf carcasses/10 halves bovine checked and if fecal found another 5 carcasses of all species are checked.

- Daily checks of CCP Monitoring Records and Corrective Actions are reviewed daily as part of the HACCP Pre-shipment by the Technical Manager/Officer.

STEP 1 ALARM	VERIFIER CORRECTIVE ACTIONS
If the Verifier identifies incorrect inspection or trimming technique, or undetected faecal or ingesta on inspected carcasses, appropriate corrective and preventative action is to be taken. Details of monitoring outcomes, corrective actions and follow ups etc, are to be recorded.	The Verifier will immediately notify the CCP Checker, showing them the amount and location of faecal / ingesta contamination. The Verifier will inform the AQ carcass Inspector and Supervisor and point out what has been missed The Supervisor/2IC will increase verification of the CCP. A further five carcasses (10 halves) shall be inspected in the same run to confirm the process is under control.
STEP 2 ALARM	
If a second critical defect is found on one processing day the designated monitoring personnel are to take the appropriate corrective and preventative actions	As above Increased verification of the CCP, with further 2x5 verifications per run. Increased supervision and surveillance of the slaughter and dressing process. The Supervisor/2IC will increase supervision of the CCP Checker. The Supervisor can initiate further corrective actions including informing the appropriate worker/s, retraining, or recalibrating techniques. Details of monitoring outcomes, corrective actions and follow ups etc, are to be recorded on the CCP Check Sheet
STEP 3 ALARM	
If repetitive critical defects are found on one processing day, or more than 2 successive processing days running the supervisor/2IC are to take the appropriate corrective and preventative actions	As above CCP Verification checks will be increased to each run until the problem ceases. The HACCP Co-ordinator and General Manager – Operations will be notified. Supervision will be increased, and retraining will be given if necessary. If problem is not rectified worker will be replaced. Further actions as taken by the HACCP Co-ordinator

Supporting Systems Providing Verification

COP 5 Fecal contamination results - Company Bovine fecal contamination summary and Asure

contamination summary

Microbiological NMD results - weekly sampling completed by a competent sample taker and results checked against limits set out by the NMD Technical procedures.

HACCP Pre-Shipment Verification for US/Canada/China Eligible Product

The Technical Manager or designate will conduct a review of the HACCP CCP data (CCP 100% ZFT Inspection Log Sheet) to ensure that the product produced for the day complies with the US/Canada/China OMAR. This must be carried out prior to the product being loaded out and will have the date, time and full signature recorded).

- The Technical Manager or Designate will monitor and verify that the Process Controls and Pre-Operative Check sheets have been completed daily.
- The Boning Room Supervisor checks that the HACCP pre-shipment verification section of the electronic 100% ZFT Inspection Sheet has been signed off by the Technical Manager or designate, prior to signing the loadout delivery docket for those days.
- In addition, Bovine and Bobby Calf require confirmation that final STEC results have been received for each Boning production date.

Audit

1. Internal Verification Schedule has the schedule documented for internal audits of the HACCP programme. Monthly audits are carried out to confirm that monitoring and verification frequencies have been completed.
   HACCP changes in the USA OMAR are to be reviewed as well.
2. HACCP review - completed if process needs to be reviewed or annually to comply with the requirements of the US OMAR that all elements are audited once in the calendar year.
3. External Audits.

HACCP Records:

Section 1.0 RMP Form 5 Bovine 100% ZFT Inspection/HACCP Pre-shipment – electronic.
Section 3.0 Hygiene & Sanitation Form 1 Ovine Slaughterboard Pre-Operative Inspection and **Form 7** Ovine Slaughter board Process Control Check sheet

Section 3.0 Hygiene & Sanitation Forms 3 and 4 Boning Room Pre-Operative Inspection and **Forms 9** and 10 Process Control Check sheet
Section 1.0 RMP Form 10 Pre-Trim Inspection Control Point QC Check – Bovine.
Section 6.0 Post-Slaughter Management Form 6 Cusum Rejection Feedback Form

Internal Corrective Action Request

Section 1.0 RMP Form 8 Verification of CCP monitoring (Weekly check the checker recorded on 100% ZFT inspection log sheet and a hardcopy stapled to the Process Control check sheet)

Internal Verification Audits (Monthly)

External audits

Annual HACCP Review

Pre-Shipment Verification checks

9. Control of Hazards: CCP No. 2

CCP Location: Tripe Packing Room

Critical Limits and Justification:
No positively identified ingesta, parasitic lesions and foreign bodies found on Clean Washed Tripe.

Monitoring of CCP step:

Company inspector monitoring after the Tripe has been packed:
Section 3.0 Sanitation and Hygiene – Form 42 Process Control

Corrective and preventative actions:
Supervisor carries out and records corrective and preventative actions on the Process Control Check sheet. Refer to Site System 5.4 Offal for corrective and preventative actions.

Corrective and Preventative Action Procedures:

Method: If Any contamination found: -
Condemn affected Tripe.
Advise Supervisor and Notify Green Tripe Operator
Supervisor to identify if personnel/process (machinery) issue Check a further 10 pieces of clean tripe
Supervisor to monitor personnel/process closely, if compliant no further actions required, record findings on Process Control Check sheet

Preventative Action-
Investigate whether cleaning process is operating as intended, e.g. machine settings correct, sufficient water supply etc, and correct as necessary
Investigate whether emptying and any initial rinsing/washing operations are being carried out correctly and correct if necessary.
Review emptying, cleaning, and trimming process and modify as necessary to prevent recurrence.
Investigate and confirm that the effective loading capacity of cleaning equipment being used is not exceeded.
Verify corrective actions have been effective by completing an additional check of 20 tripe products.
Review training records and understanding of requirements of operators working in these areas.

Record:
Record all monitoring and corrective action findings on the Process control check sheet.

Product Disposition:
Must establish the last clear CCP Monitoring time and date, number of cartons from that clear CCP to the current CCP and downgrade all product to NON-CHINA. Relabeling is required.

Verification Procedures:

Verification of CCP Monitoring

Internal verification (reality check) of Tripe Operator is carried out depending on performance basis by the Quality Assurance Auditor or designate. Findings are recorded on the Section 1.0 RMP Form 12 Tripe 100 Inspection - electronic and a hardcopy is stapled to the Process Control Check sheet.

Daily checks of CCP Monitoring Records and Corrective Actions are reviewed daily by the Technical/Environment Manager / Designate or General Manager – Operations.

Supporting Systems Providing Verification

Process Control Summary - Daily
Internal verification of Inspectors – on performance basis

Microbiological NMD results - weekly sampling completed by a competent sample taker and results checked against limits set out by the NMD Technical procedures.

Audit

Internal Verification Schedule has the schedule documented for internal audits of the HACCP programme. Monthly audits are carried out to confirm that monitoring and verification frequencies have been completed.
HACCP changes in the China OMAR are to be reviewed as well.
HACCP review - completed if process needs to be reviewed or annually to comply with the requirements of the China OMAR that all elements are audited once in the calendar year.
External Audits.

HACCP Records:

Section 1.0 RMP Form 12 Tripe 100% Inspection – electronic.

Section 5.0 Slaughter and Dressing, 5.4 Offal

Section 3.0 Sanitation and Hygiene, Form 42 Offal and Chiller Process Control

Internal Corrective Action Request

Internal Verification Audits (Three monthly)

External audits

Annual HACCP Review

10. Authorities and Responsibilities for HACCP Plan	
(i) Overall responsibility for HACCP plan	
Position/Designation of responsible person	General Manager – Operations / Technical/Environment Manager

(ii) Documentation and Amendment of the HACCP Plan	
Position/Designation of responsible person	General Manager – Operations / Technical/Environment Manager Significant amendments by person holding. HACCP Coordinator Unit Standard 28264.4 (upgraded bi-annually)
(iii) Monitoring (observations; inspections; testing)	
Position/Designation of responsible person	General Manager – Operations, Supervisor and/or Quality Assurance Auditor
(iv) Corrective Action Procedures (restoration of control; control and disposition of non-conforming product; prevention of recurrence)	
Position/Designation of responsible person	General Manager – Operations, Supervisor and/or Quality Assurance Auditor
(v) Operator Verification Activities (validation and revalidation; on-going audit and review)	
Position/Designation of responsible person	General Manager – Operations / Technical/Environment Manager and/or Quality Assurance Auditor NZQA 8084,8085,8086 Annual review by person holding HACCP Coordinator Unit Standard 12626/26285 (upgraded bi-annually)

11. Review of HACCP Plan

(i) The HACCP plan will remain dynamic and be subject to continuous improvement where appropriate. This will be part of the verification process.

(ii) The whole plan will be reviewed at least once every year to reassess its effectiveness. The plan will also be reassessed when new product outcomes are established, new food safety/risk management knowledge becomes available or there is a change in the raw materials/other inputs/process itself.

(iii) Prime Range Meats Ltd. may wish to re-evaluate its expected outcomes from the HACCP plan as monitoring results are collated over a period. If a CCP is continually performing well within the critical limits in the plan, consideration will be made to decreasing the resource needed for the monitoring of that CCP and re-allocating that resource to another pertinent area.

(iv) HACCP plans are documented separately but are integrated within the company's quality monitoring procedures.

12. Summary Table for Market Access CCP 1

Process Step	Hazard	CCP no.	Critical Limits	Monitoring procedures	Corrective actions	Verification procedures	Records
Post-mortem/Detain trim/ Re-inspection	B – Enteric pathogens associated with visible faecal and ingesta contamination	1	No visible faecal or ingesta contamination on any carcass	100% inspection of carcases	Stop the ZFT chain. The CCP Monitor will immediately notify the AsureQuality Inspector and the Supervisor, showing them the amount and location of faecal / ingesta contamination. Immediate trimming of the faecal / ingesta contamination. Details of monitoring outcomes, corrective actions and follow ups etc, are to be recorded on the CCP ZFT log sheet.	Reality check of CCP monitoring. Daily review of CCP records Pre-Trim Inspection Control Point Cusum Daily Pre-Shipment Check NMD - Regulatory Limits as outlined in 8.4, Sampling Procedure Section	Section 1.0 RMP Form 8 Verification of CCP monitoring-weekly Section 1.0 RMP Form 5 100%ZFT inspection (electronic) - Bovine Section 1.0 RMP Form 10 - Pre-Trim Inspection Control Point QC Check - Bovine Section 6.0 Post-Slaughter Management Form 8 and 9 Cusum checksheets and Form 6 Cusum Rejection Feedback Section 1.0 RMP Form 6 Pre-shipment Verification Checks Section 1.0 RMP Form 7 Pre-shipment Eligibility Certificate NMD reports Reports Reports

						8.4.5.8. Internal audit External audit	

Summary Table for Market Access CCP2

Process Step	Hazard	Critical Limit	Monitoring procedures	Corrective Actions	Verification procedures	Records
Tripe	B – enteric pathogens	Zero visible ingesta, parasitic lesions or foreign bodies	Monitoring of CCP is twice daily. 10 pieces inspected at each CCP monitoring.	100% inspection bovine tripe. No tripe product that has failed a CCP inspection is sent to China. All bovine tripe that has been found to have ingesta, parasitic lesions, or foreign bodies will be condemned, and the procedure as outlined below is followed. • CCP 2 INSPECTION 100% Inspection of each tripe piece for contamination - including ingesta, parasitic lesions and foreign bodies (Form 12 Ovine / Bovine Tripe RMP) Each piece of tripe is individually inspected for contamination. Any affected piece of tripe is condemned (placed into an inedible bucket and condemned) Advise the Supervisor and notify the Tripe Operator Complete Form 12 (Ovine) and Form 15 (Bovine) RMP	Reality check of CCP monitoring Microbiological monitoring Internal verification	Process Control, Tripe Inspection – CCP 2 Monitoring, Form 42 Offal and Chiller Process Control NMD reports Reports

				Preventative Action • Investigate whether the cleaning process is operating as intended, check machine settings are correct, with a sufficient water supply etc. Make any corrections as necessary. • Investigate whether emptying and any initial rinsing/washing operations are being carried out correctly and correct if necessary. • Review emptying, cleaning, and trimming processes and modify as necessary to prevent recurrence. • Investigate and confirm that the effective loading capacity of cleaning equipment being used is not exceeded. • Verify that corrective actions have been effective by completing an additional check of 20 tripe products. • Review the training records and understanding of requirements of Operators working in these areas. • Record findings on the Process Control (Form 42 Sanitation and Hygiene) If no defects are found, then the edible tripe product can be trimmed and packed according to company specifications. Edible tripe product will be removed from the room to refrigerated storage at break		

Audit Summary & Outcome:

Audit No:	Audit Date:	Auditor:	Audit Outcome:
Previous Audit Outcome: **Observations:** **Comments & Recommendations:** **Corrective Action required:** **CAR issued:** **Auditor Signature:**			
Follow up: **Auditor Signature:** **Closed Out Date:**			