

Meat Processing News

Department of Animal Sciences and Industry
Kansas State University Agricultural Experiment Station and Cooperative Extension Service

USDA FSIS HACCP Hotline Trends

A second set of "Questions and Answers" on HACCP were recently released by FSIS. Several of the questions asked by industry and inspection personnel are presented here. The entire document can be accessed through the internet at:

<http://www.fsis.gov/oa/haccp/hq2ind.htm>

- Q.** What is the appropriate appeal process for industry?
- A.** If the establishment disagrees with inspection of personnel's decisions, the decision can be appealed through the chain of command, Inspector in Charge, Circuit Supervisor, District Office, and Headquarters.
- Q.** Does each entry on HACCP-generated records have to be signed and dated?
- A.** Regulation 417.5(b) states: Each entry on a record maintained under the *HACCP plan shall be made at the time the specific event occurs and include the date and time recorded, and shall be signed or initialed by the establishment employee making the entry.* In addition, Regulation 417.5(c) states *that prior to shipping product, the establishment shall review the records associated with the production of that product to ensure that all critical limits were met and, if appropriate, corrective actions were taken, including the proper disposition of product. Where practicable, this review shall be conducted, dated, and signed by an individual who did not produce the record(s).*

- Q.** If the establishment has slaughter and only simple processing, is it necessary to have more than one HACCP plan?
- A.** It is acceptable for slaughter and simple processing to be covered with the same plan. It is also considered acceptable for these to be covered by separate plans.
- Q.** Does a zero tolerance failure mean a system failure?
- A.** If fecal contamination is found by off-line inspection personnel after the final rail in red meat plants or on poultry carcasses at the entrance of the chiller or beyond

through the performance of FSIS verification procedures, this is considered a deviation from a critical limit. This is not documented as monitoring noncompliance, but is not considered a system failure at this point.

- Q.** What corrective actions meet 417.3 for zero tolerance when fecal contamination is found?
- A.** All of the product, back to the last acceptable check, must be held. This means that all product prior to the last acceptable fecal check is considered potentially contaminated.

To contact FSIS's HACCP Hotline, call 800-233-3935 and press 2.

HACCP Training Workshop

A HACCP training workshop will be held August 21-23 at Kansas State University. You will learn about the HACCP regulation, the seven principles of HACCP, and how to develop a HACCP plan. If you are interested in attending and have not received the bright gold registration form, or if you would like additional information about the workshop, contact Liz Boyle 785-532-1247 or Kelly Getty 785-532-0191.

HACCP Videos, Books and Software Available for Loan

K-State Research and Extension received a variety of HACCP training and reference materials including videos, books and computer programs from FSIS. These materials are available to Kansas meat and poultry processors to review and use for a loan period of two weeks. To receive a descriptive list of the available materials and the loan/return procedure, contact Kay Fechter at 785-532-6131.

Upcoming Events

■
K-State HACCP
Workshop
August 21 to 23
Manhattan
Contact Liz Boyle
(785) 532-1247 or
Kelly Getty
(785) 532-0191

■
K-State HACCP
Workshop
September 18 to 20
Parsons
Contact Liz Boyle
(785) 532-1247 or
Kelly Getty
(785) 532-0191

■
Final HACCP Prepara-
tion
September 23
Kansas City
Contact NAMP
(703) 758-1900
or AAMP
(717) 367-1168

■
Preventing and
Managing a Food Safety
Crisis
September 24 and 25
Kansas City
Contact NAMP
(703) 758-1900

Profitability Tips for Cured Meat Products— Part I

Warrie J. Means, Ph.D.
University of Wyoming

Below are tips for increasing the profitability of cured meat products. Many have been used successfully by more than one individual. Although most are relatively simple and seem blatantly obvious, it is unlikely that any one plant has thought of or tried all of the ideas listed. Some ideas may not be practical for your particular operation.

Equipment

- Buy a smokehouse. If you don't have one, get one.
- Modernize your smokehouse to one that has humidly control.
- Improve the functionality of your current smokehouse. Check to see that all of the elements are working in the electric house. Determine the relative humidity that your house operates at when processing various products using wet-bulb-dry-bulb calculations.
- Invest in vacuum packaging equipment and use it for cured meat products to increase shelf life and improve appearance.
- Purchase and use a vacuum tumbler. Product quality, consistency and yields will increase.
- Use equipment that will allow incorporation of more water into your cured meat products.

Ingredients/recipes

- Use brown sugar, maple syrup or honey in your brine cured products for a more distinctive flavor. These ingredients are also "label friendly."
- Use real hickory wood to smoke products. You may develop better color and flavor than other wood sources or liquid smoke. This will depend on your smokehouse.
- Use phosphates to improve yields.
- Use a "ham spice" to differentiate your products from others.
- Develop different types of curing recipes. Charge more for the "special cure."
- Develop recipes that include the maximum amount of water, taking into account water lost during cooking.

HACCP Implementation Timetable for Small Plants

After working with large plants on HACCP implementation, FSIS made the following suggestions to assist small plants in planning a schedule that would allow them to implement HACCP by the January 25, 1999, deadline. We strongly recommend that plants implementing HACCP in January 25, 2000, allow one year for HACCP plan development.

May-July 1998: Attend HACCP training.

Complete by August 1998: Perform hazard analyses in three steps: (1) Draft and verify product flow diagram; (2) identify potential hazards, and (3) select critical control points (CCPs).

Complete by August 1998: Set critical limits for CCPs and establish corrective actions.

Complete by September 1998: Prepare a record-keeping system for monitoring CCPs and select verification procedures.

Complete by October 1998: Correlate above steps into HACCP plan(s) and train employees to use the HACCP plan(s).

November 1998-January 15, 1999: Validate and reassess HACCP plan(s).

January 25, 1999: Implement HACCP plan(s).



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Meat Processing News is published for Kansas meat processors by the Department of Animal Sciences and Industry, Kansas State University Agricultural Experiment Station and Cooperative Extension Service.

For more information or questions, please contact K-State Research and Extension, Animal Sciences and Industry at (785) 532-1247.

A handwritten signature in cursive script that reads "Elizabeth Ernst Boyle".

Elizabeth Ernst Boyle, Ph.D.

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K-State, County Extension Councils, Extension Districts, and U.S. Department of Agriculture Cooperating. All educational programs and materials available without discrimination on the basis of color, race, national origin, religion, sex, age, or disability.

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