

Chapter 12 Dressing of Carcasses

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12. Introduction

Fresh meat is at risk from microbiological contamination through contact with food poisoning bacteria from skin or gut contents during dressing, as even healthy animals can carry bacteria, for example, E.coli O157, Salmonella, Campylobacter, Yersinia, and Listeria. Poor working practices will increase this risk. Meat can be contaminated with grease, dirt, specified risk material or with metal and other foreign bodies in meat plants. Contamination can be transferred from meat to other foods including ready-to-eat products. Procedures are needed to minimise the risk of such hazards causing illness in consumers.

Examples demonstrating the importance of dressing of carcasses:

Problem	Effect	Possible outcome
Poor evisceration technique	Meat exposed to avoidable contamination	Contamination of meat with food poisoning bacteria such as Salmonella
Insufficient training of staff responsible for dressing	Poor working practices	Increase risk of contamination of meat
Poorly cleaned equipment	Exposure of meat to cross contamination	Risk of cross contamination between carcasses or batches of meat
Inadequate spatial separation	'Clean' and 'dirty' areas, exposed meat, and poorly cleaned/non-cleanable contact surfaces are not adequately separated	Risk of cross contamination between carcasses or batches of meat
Inadequate temperature controls or storage	Failure to keep meat at low temperatures	Growth of bacteria encouraged, and contamination of meat with food poisoning bacteria such as Salmonella

12.1. Application of carcase dressing regulations

Dressing of carcases may occur in slaughterhouses both with and without specific slaughter (killing) facilities. See chapter 1 'Introduction' and section 1.2 on 'Approval of fresh meat establishments'.

Regulation 853/2004 Annex III

- **Mammals** – the provisions of 853/2004 Annex III Section I (Meat of domestic ungulates) apply to the production and placing on the market of meat from even-toed farmed game mammals (deer and boar) unless the competent authority considers them inappropriate.
- **Ratites (flightless birds)** – the provisions of 853/2004 Annex III Section II (Meat from poultry and lagomorphs) apply to the production and placing on the market of meat from ratites. However, those of Section I (Meat of domestic ungulates) apply where the competent authority considers them appropriate. Appropriate facilities must be provided, adapted to the size of the animals under 853/2004 Annex III Section III: Farmed Game: points 1 and 2.

Regulation 854/2004

The regulation lays down the requirements for post-mortem inspection. The principal purpose of post-mortem inspection is to supplement ante-mortem inspection and to detect:

- diseases of public health significance
- diseases of animal health significance
- residues or contaminants in excess of the levels allowed by legislation
- the risk of non-visible contamination
- other factors which might require the meat to be declared unfit for human consumption or restrictions to be placed on its use
- visible lesions that are relevant to animal welfare such as beating or long standing untreated injuries

After inspection, the meat is either:

- passed as fit for human consumption
- declared unfit for human consumption, or
- detained for further examination

For additional information see:

- the FSA Manual for Official Controls at:
<https://www.food.gov.uk/enforcement/approved-premises-official-controls/manual>
- the FSS Manual for Official Controls at:
<http://www.foodstandards.gov.scot/publications-and-research/manual-for-official-controls>
- the DAERA VPHU Manual for Official Controls at:
<https://www.daera-ni.gov.uk/articles/veterinary-public-health-unit-manual-official-controls>

12.2. TSE controls

853/2004 Article 1 point 6a

This Regulation (853/2004) shall apply without prejudice to relevant animal and public health rules, including more stringent rules laid down for the prevention, control and eradication of certain transmissible spongiform encephalopathies (TSEs).

TSE testing – EU legislation lays down the rules for the prevention, control and eradication of TSEs, including the testing of animals under active surveillance – see chapter 20 on ‘TSE testing’.

Specified risk material (SRM) – all SRM from carcasses is to be removed, separated, stained and disposed of in accordance with the legislation - see separate chapter on ‘SRM removal’.

12.3. Animal by-products

Animal by-products are any animal carcass, part of an animal carcass, or any material of animal origin, not intended for human consumption. The intention is the important point since all products of animal origin would be considered to be ABPs if they were not intended for human consumption.

Animal products therefore, become ABPs because they are either unfit and/or unsafe, or the food business operator decides that they will not be used for human consumption. Once this decision has been made (for example, where they are labelled as such) the ABPs cannot then revert to being a foodstuff; the ABPs must be kept out of the food chain. EC and national legislation establish strict health rules so that they are properly identified, handled, stored, transported, processed, used or disposed of.

For more information, see the separate ‘Edible co-products industry guide’, which includes a chapter on animal by-products at: <https://www.food.gov.uk/business-industry/guidancenotes/meatregsguid/coproductbyproductguide> or http://www.foodstandards.gov.scot/downloads/Industry_Guide_1.pdf

12.4. EC poultry meat marketing standards regulations

The regulations seek to protect EC consumers by setting uniform standards for the marketing of poultry meat intended for human consumption and providing informative labelling. They also protect the producer against unfair competition. They cover the classification by quality, weight, packaging (including labelling), water content and storage and also specify the criteria that must be met before claims about certain types of farming can be made.

They apply to – whole carcasses, parts and offal of the following species of poultry - domestic fowl (*Gallus domesticus*); ducks; geese; turkeys; and guinea fowls.

They do not apply to – prepared or preserved poultry (for example, cooked, processed, treated or value added products), poultry meat intended for export from the EC, sales from farms with an annual production of under 10,000 birds (providing the farmer supplies fresh poultry meat from the holding in the same locality as that of the producer or in a neighbouring locality), or delayed evisceration poultry such as Traditional Farm Fresh turkeys. For additional information see:

<http://webarchive.nationalarchives.gov.uk/20130402151656/http://www.defra.gov.uk/food-farm/food/food-industry/poultry-industry/>¹

12.5. Legal requirements for dressing of carcasses

The following sections set out the requirements of the regulations for dressing of carcass meat.

A. General requirements

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Legal requirement

852/2004 Annex II Premises: Chapter I point 7

A1. Food premises have adequate lighting.

853/2004 Annex III White meat Slaughterhouses: Section II Chapter II points 2(a)

A2. To avoid contaminating meat, (white meat slaughterhouses) must:
a) have a sufficient number of rooms, appropriate to the operations being carried out.

853/2004 Annex III Red meat Slaughterhouses: Section I Chapter II point 2(a)

A3. To avoid contaminating meat, (red meat slaughterhouses) must:
a) have a sufficient number of rooms, appropriate to the operations being carried out.

A1. to A3. Compliance regarding design and layout of carcass dressing areas

Make sure that:

- there is adequate lighting
- there are sufficient rooms for the operations being carried out to ensure the adequate separation of certain processes so that meat does not become contaminated

A1. to A3. Good practice

Adequate lighting levels can help operatives undertake hygienic dressing, enable checks on visible carcass hygiene to be undertaken, and assess the effectiveness of cleaning. As a guide these minimum levels are considered adequate: 540 lux at inspection points, 220 lux in workrooms.

¹ The link refers to an archived page of the Defra website which has not been updated. Some of the information may still be useful. To be aware: Council Regulation (EC) No. 1234/2007 has been repealed and replaced by Regulation (EU) No. 1308/2013 of the European Parliament and of the Council. The Poultry meat (England), (Scotland), Wales), (Northern Ireland) Regulations 2011 implement Council Regulation (EC) No. 1234/2007 and Commission Regulation (EC) No. 543/2008 in England, Scotland, Wales and Northern Ireland.

TIP



Lighting – High intensity lighting is recommended.

See chapter 2 'Design and facilities' at 'A10.'

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Legal requirement

852/2004 Annex II Food Premises: Chapter I point 2

- A4.** The layout, design, construction, siting and size of food premises are to:
- ... provide adequate working space to allow for the hygienic performance of all operations
 - be such as to protect against the accumulation of dirt, contact with toxic materials, the shedding of particles into food and the formation of condensation or undesirable mould on surfaces
 - permit good food hygiene practices, including protection against contamination ...

852/2004 Annex II Rooms: Chapter II points 1, 1(f)

A5. In rooms where food is prepared, treated or processed ... the design and layout are to permit good food hygiene practices, including protection against contamination between and during operations. In particular (f) surfaces (including the surfaces of equipment) in areas where foods are handled and in particular those in contact with food are to be maintained in a sound condition and be easy to clean and, where necessary, to disinfect.

853/2004 Annex III Section 1 Red meat slaughter: Chapter II point 3, Section II White meat slaughter Chapter II point 3

A6. (Slaughterhouses) must have facilities for disinfecting tools in hot water supplied at a temperature of not less than 82°C or by an alternative method having an equivalent effect.

853/2004 Annex III Slaughterhouses: Section I Chapter II points 4 and 5, Chapter IV point 12 and Section II Chapter II points 4 and 5, Chapter IV point 6

A7. The equipment for washing hands used by the staff engaged in handling exposed meat must have taps designed to prevent the spread of contamination.

A4. to A7. Compliance regarding design for hygienic dressing of carcasses

Make sure that:

- there is adequate space to allow for hygienic performance of all operations and permit good hygiene practices, including protection against contamination between and during operations
- staff engaged in handling exposed meat have facilities with taps designed to prevent the

spread of contamination

A4. to A7. Good practice

Take account of the hygiene requirements for dressing procedures and post-mortem inspection. See chapter 2 on 'Design and facilities' at 'D8.', 'D9.' and 'D12.'.

Consider particularly the need to minimise the risk of contamination by having adequate working space with regard to throughput, the separation of 'clean' and 'dirty' processes and areas; as well as protecting the meat from chemicals, condensation, dirt, and other contaminants.



Legal requirement

853/2004 Annex III Slaughterhouses: Section I Chapter II points 4 and 5, Chapter IV point 12 and Section II Chapter II points 4 and 5, Chapter IV point 6

A8. Lockable facilities for the refrigerated storage of detained meat and separate lockable facilities for the storage of meat declared unfit for human consumption.

A9. Post-mortem inspection is to be carried out under suitable conditions with suitable facilities.

A8. and A9. Compliance regarding storage of detained or unfit meat

Make sure that:

- there is lockable refrigerated storage for detained meat and separate lockable facilities for the storage of unfit meat
- there are suitable facilities for post mortem inspection to be carried out

A8. and A9. Good practice

Meat may be detained for further inspection or while awaiting information, for example, results of tests or identification checks. There should be no opportunity for cross contamination between fit and unfit meat. A detained facility may be a cage with separate drainage (or a drip tray) within a chiller in premises slaughtering small numbers.

TIP



Hygienic storage – Install suitable and cleanable fittings, equipment and surfaces that can easily be maintained.

See chapter 2 on 'Design and facilities' at 'D10. Facilities for detained meat', 'D10. Facilities for unfit meat'.



Legal requirement

853/2004 Annex III Slaughterhouses: Section I Chapter II point 2(e) and Section II Chapter II point 2(e)

A10. Have slaughter lines (where operated) designed to allow constant progress of the slaughter process and to avoid cross-contamination between the different parts of the slaughter line. Where more than one slaughter line is operated ... there must be adequate separation of the lines to prevent cross-contamination.

853/2004 Annex III White meat Slaughterhouses: Section II Chapter II points 2(b)-(c)

A11. To avoid contaminating meat, (white meat slaughterhouses) must:

- b) have a separate room for evisceration and further dressing, including the addition of seasonings to whole poultry carcasses, unless the competent authority authorises separation in time of these operations ... on a case-by-case basis
- c) ensure separation in space or time of the following operations:
 - (i) stunning and bleeding
 - (ii) plucking or skinning, and any scalding
 - (iii) dispatching meat

853/2004 Annex III Red meat Slaughterhouses: Section I Chapter II point 2(b)-(c)

A12. To avoid contaminating meat, (red meat slaughterhouses) must:

- b) have a separate room for the emptying and cleaning of stomachs and intestines, unless the competent authority authorises the separation in time of these operations on a case-by-case basis
- c) ensure separation in space or time of the following operations:
 - (i) stunning and bleeding
 - (ii) in the case of porcine animals, scalding, depilation, scraping and singeing
 - (iii) evisceration and further dressing
 - (iv) handling clean guts and tripe
 - (v) preparation and cleaning of other offal, particularly the handling of skinned heads if it does not take place at the slaughter line
 - (vi) packaging offal
 - (vii) dispatching meat

A10. to A12. Compliance regarding separation of carcass dressing activities

Make sure that:

- there is constant progress of the slaughter process

- cross contamination is avoided between the different parts of the slaughter line and, where more than one line is operated, there is adequate separation to prevent cross contamination
- there are sufficient rooms for the operations being carried out to ensure the adequate separation of certain processes so that meat does not become contaminated

A10. to A12. Good practice

The design of the slaughter line (where operated) should allow progressive working which avoids regular contact between carcasses.

Effective separation of clean and dirty operations is important in minimising sources of contamination. Only where spatial separation is impossible should time separation be used and then only with an effective cleaning and disinfecting regime between operations.

See chapter 2 on 'Design and facilities' at 'D3. to D5.'.

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Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 19

A13. Where (red meat) establishments are approved for the slaughter of different animal species or for the handling of carcasses of farmed game and wild game, precautions must be taken to prevent cross-contamination by separation either in time or in space of operations carried out on the different species.

Separate facilities for the reception and storage of unskinned carcasses of farmed game slaughtered at the farm and for wild game must be available.

853/2004 Annex III Section II Slaughter Hygiene: Chapter IV point 3

A14. Where (white meat) establishments are approved for the slaughter of different animal species or for the handling of farmed ratites and small wild game, precautions must be taken to prevent cross contamination by separation either in time or in space of the operations carried out on the different species.

Separate facilities for the reception and storage of carcasses of farmed ratites slaughtered at the farm and for small wild game must be available.

A13. and A14. Compliance regarding separation of multiple species

- If different species are handled, prevent cross-contamination by separation either in time or space.

A13. and A14. Good practice

See information in '12.1. Application of carcase dressing regulations' and chapter 2 on 'Design and facilities' at 'D1. and D2.'.



Legal requirement

853/2004 Article 3 point 2 and Commission Regulation (EU) No 101/2013

A15. Food business operators shall not use any substance other than potable water - ... - to remove surface contamination from products of animal origin, unless the substance's use has been approved ...

A15. Compliance regarding removal of contamination

- Use only potable water or EU approved substances for the removal of surface contamination from meat or other products of animal origin. Follow the conditions of use and always follow the manufacturer's instructions.

A15. Good practice

Visible contamination is normally removed by trimming.

Potable water – see chapter 3 on 'Water supply'.

Approved substances – anti-microbial treatments for food of animal origin may be approved by the European Commission following a risk assessment by the European Food Safety Authority (EFSA). This will include: overall efficacy, microflora changes and implications, potential for introducing other food safety hazards, occupational safety, impact on the environment, effects on sensory properties and quality of the product, feasibility and effectiveness of control under commercial conditions, toxicological implications of residues and reaction products and consumer perception.

A15. Compliance regarding use of lactic acid

- Lactic acid solutions for use in slaughterhouses must be prepared from lactic acid which complies with the specifications set out in Regulation (EC) 231/2012. This lays down specifications for certain food additives, including lactic acid.

A15. Good practice

Under Regulation 101/2013 food business operators (FBOs) may use lactic acid to reduce surface contamination only on bovine carcasses or half carcasses or quarters in slaughterhouses, subject to certain conditions. However, there is no obligation on FBOs in slaughterhouses to use it.

The application of lactic acid must be applied:

- only to carcasses, or half carcasses or quarters of meat from bovine animals
- either by spraying or misting using from 2% to 5% lactic acid solution in potable water at temperatures of up to a maximum of 55°C
- under controlled and verifiable conditions integrated in a HACCP-based management system including, at least, the following:

- sampling of carcasses for the purposes of assessing compliance with microbiological criteria as required by Regulation (EC) 2073/2005 must be carried out before the application of lactic acid solutions on the carcasses or half carcasses or quarters
- as part of a HACCP plan verify by periodic monitoring the concentration of lactic acid during treatment and ensure that this is documented and recorded
- as part of the HACCP plan continuously monitor by instrumental measurements the temperature of the lactic acid solution during treatment and ensure that this is documented and recorded
- only to carcasses with no visible faecal contamination; and so that it does not result in any irreversible physical modification of the meat

Food business operators (FBOs) operating slaughterhouses in which lactic acid solutions are used to reduce microbial surface contamination of entire carcasses or half carcasses or quarters of meat must inform the FBO receiving the treated carcasses or half carcasses or quarters of meat of the treatment of the meat. This information should be documented.

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Legal requirement

853/2004 Annex III Section 1 Red meat slaughter: Chapter II point 3, Section II White meat slaughter: Chapter II point 3

A16. (Slaughterhouses) must have facilities for disinfecting (sterilising) tools in hot water supplied at a temperature of not less than 82°C or by an alternative method having an equivalent effect.

A16. Compliance regarding disinfection of tools

- Disinfect tools in hot water supplied at a temperature of not less than 82°C or by an alternative method having the equivalent effect².

A16. Good practice

Start each work period with clean and disinfected tools. Rinse tools to remove visible dirt before they are disinfected, for example, in a knife steriliser. Knives and other tools should be rinsed and disinfected often. Equipment such as splitting saws and brisket saws should be dismantled regularly for a thorough cleaning.

Knives – it is important to clean knives and disinfect after cutting through contaminated tissues such as skin. Less frequent cleaning and disinfection may be acceptable when, for example, exposing kidneys for inspection.

Scabbards – can be a source of contamination of disinfected knives, but may be used for health and safety reasons, for example, to carry knives across workrooms or for use where bovine heads are dressed and handled. Never use a scabbard for both clean and dirty knives. Only put clean knives in a clean scabbard. In slaughterhouses, knives placed in scabbards are considered dirty and should be treated as such, unless the scabbard can be effectively disinfected.

² Equivalent methods of disinfection – any agreed alternatives to the requirement for 82°C will be notified by an agreed change to this guidance.

Steels – disinfect steels after cleaning and do not use in a way that contaminates clean, disinfected knives. Leaving steels in a knife steriliser may damage them.

Grading probes – see chapter 5 on ‘Cleaning’ at ‘D1.’.

For additional information on facilities for disinfecting tools/approval of alternatives, see chapter 2 on ‘Design and facilities’ at ‘D8.’.

L

Legal requirement

852/2004 Annex II Personal Hygiene: Chapter VIII point 1

A17. Every person working in a food-handling area is to maintain a high degree of personal cleanliness and is to wear suitable, clean and, where necessary, protective clothing.

A17. Compliance regarding personal hygiene

- Make sure that every person working in a food-handling area maintains a high degree of personal cleanliness.

A17. Good practice

All staff must comply with the company’s personal hygiene procedures, particularly handwashing and wearing of protective clothing.

See chapter 8 on ‘Personal hygiene’.

L

Legal requirement

852/2004 Article 5 point 1

A18. Food business operators shall put in place, implement and maintain a permanent procedure or procedures based on the HACCP principles.

A18. Compliance regarding HACCP-based procedures

- Put in place, implement and maintain a permanent procedure or procedures based on HACCP principles.

A18. Good practice

HACCP-based procedures are necessary to ensure that food safety hazards, notably microbiological cross-contamination during dressing, is minimised. This is done by setting and applying operational limits and procedures for dressing. Contamination of meat, particularly with faecal material, is likely to occur if sufficient care is not taken throughout the process.

Set out in the HACCP plan, the procedures for controlling hazards, the limits that are to be monitored, the checks to be carried out, the corrective actions to be taken to ensure the safety of the meat and the records to be kept of those checks and actions.

See '12.1. Application of carcass dressing regulations' and chapter 9 on 'HACCP principles'.

The requirements on hygiene prerequisites for all establishments are set out in chapters 3 on 'Water supply', 4 on 'Maintenance', 5 on 'Cleaning' and 6 on 'Pest control'.

L

Legal requirement

852/2004 Annex II Training: Chapter XII point 1

A19. Food business operators are to ensure that food handlers are supervised and instructed and/or trained in food hygiene matters commensurate with their work activity.

A19. Compliance regarding training, instruction and supervision

- Make sure that food handlers are instructed and/or trained in food hygiene matters commensurate with their work activity.

A19. Good practice

Before allowing staff to dress carcasses without direct individual supervision, instruct them in hygienic dressing, awareness of food safety principles especially about the hazards associated with raw meat and about personal hygiene, the need to follow instructions and to report failing controls promptly.

Supervise staff as appropriate. Issue reminders if lapses occur. Keep accurate, dated individual training records to show what instruction/training has been given.

See chapter 7 on 'Training'.

B. Wild game

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Legal requirement

853/2004 Annex III Section IV Chapter II: point 2

B1. (Large wild game) The trained person must carry out an examination of the body, and of any viscera removed, to identify any characteristics that may indicate that the meat presents a health risk. The examination must take place as soon as possible after killing.

853/2004 Annex III Section IV Chapter III: point 1

B2. (Small wild game) The trained person must carry out an examination to identify any characteristics that may indicate that the meat presents a health risk. The examination must take place as soon as possible after killing.

853/2004 Annex III Section IV Chapter II: points 1, 3, 4, 5, 6 and 8a as amended by Commission Regulation 150/2011

B3. After killing, large wild game must have their stomachs and intestines removed as soon as possible and, if necessary, be bled.

B1. to B3. Compliance regarding initial examination and actions

- One trained person in a hunting party must, except in exceptional circumstances, carry out an initial examination of game that is accepted by an approved game handling establishment.

B1. to B3. Good practice

Game supplied to approved game handling establishments is to have been examined by a trained person with sufficient knowledge and skill to identify abnormal characteristics or any that may indicate that the meat presents a health risk.

Large wild game – see 'B4. and B5'.

Trained person (hunter) – see the 'Wild game guide' at section 1 'Hunters of wild game' on guidance for suppliers of wild game at:

www.food.gov.uk/business-industry/farmingfood/wildgameguidance/.

L

Legal requirement

853/2004 Annex III Section IV Chapter II: points 1, 3, 4, 5, 6 and 8a as amended by Commission Regulation 150/2011

B4. (a) (Large wild game) If no abnormal characteristics are found during the examination referred to in point 2 of B1., no abnormal behaviour was observed before killing, and there is no suspicion of environmental contamination, the trained person must attach to the animal body a numbered declaration stating this.

Hunters must comply with any additional requirements imposed in the Member State where hunting takes place, in particular to permit the monitoring of certain residues and substances in accordance with Directive 96/23/EC.

(b) (Large wild game) In other circumstances, the head (except for tusks, antlers and horns) and all the viscera except for the stomach and intestines must accompany the body. The trained person who carried out the examination must inform the competent authority of the abnormal characteristics, abnormal behaviour or suspicion of environmental contamination that prevented him or her from making a declaration in accordance with (a).

(c) (Large wild game) If no trained person is available to carry out the examination referred to in point 2 in B1. in a particular case, the head (except for tusks, antlers and horns) and all the viscera except for the stomach and the intestines must accompany the body.

853/2004 Annex III Section IV Chapter III: points 2, 3 and 4

B5. (Small wild game) If abnormal characteristics are found during the examination, abnormal behaviour was observed before killing, or environmental contamination is suspected, the trained person must inform the competent authority.

B4. and B5. Compliance regarding wild game notification

- The trained person who carries out the initial examination of game must inform the competent authority of the abnormal characteristics, abnormal behaviour or suspicion of environmental contamination.
- The competent authority may authorise that heads of animals susceptible to *Trichinella* infestation be sent to a technical plant for the production of game trophies. The technical plant shall be indicated in the declaration of the trained person. A copy of the declaration shall be sent to the technical plant.

B4. and B5. Good practice

Absence of abnormal characteristics

If no abnormal characteristics are found during the examination, observed before killing, or there is no suspicion of environmental contamination, this must be declared by the trained person. This declaration must also indicate the date, time and place of killing.

The declaration need not be attached to the animal body and may cover more than one animal body, provided that each animal body is appropriately identified and the declaration bears an indication of the identification number of each animal body covered by it, with the corresponding date, time and place of killing. All animal bodies covered by a single declaration may only be sent to a single game-handling establishment.

The head and the viscera need not accompany the body to the game-handling establishment, except in the case of species susceptible to Trichinosis (wild boar), whose heads (except for tusks) and diaphragm must accompany the body.

Heads of animals, including species susceptible to Trichinella infestation, for example, wild boar, may be sent to a plant registered in accordance with Article 23 of Regulation (EC) No. 1069/2009 for the production of game trophies. The plant shall be indicated in the declaration of the trained person. A copy of that declaration shall be sent to the plant. There is an exemption from registration for non-commercial operators and private individuals (more information is available from APHA). The regulation requires that the operator must ensure safe sourcing, treatment and use of the heads. APHA may also carry out official controls on the operator on a risk basis to ensure compliance with these conditions.

Presence of abnormal characteristics

If abnormal characteristics or behaviour have been identified, then the competent authority needs to be informed. In the case of suspicion of notifiable disease, report to:

- an Animal and Plant Health Agency Divisional Office for GB: <https://www.gov.uk/government/organisations/animal-and-plant-health-agency/about/access-and-opening>, or
- the Divisional Veterinary Office for NI: <https://www.daera-ni.gov.uk/contact>

Otherwise, for:

Large game – a numbered declaration must be attached to the body of each animal stating that, following an examination, the animal has been found to be free of any abnormal characteristics, behaviour or environmental contamination and the date, time and place of killing, or indicate where this is not the case.

Alternatively, a single declaration may be provided to cover more than one animal body, provided that each animal body is appropriately identified and the declaration bears an indication of the identification number of each animal body covered by it. In cases where a single declaration is provided, the bodies may only be sent to a single game handling establishment.

Where the results of the Trichinella examination of the carcass are positive, an official veterinarian (OV) or approved veterinarian will carry out an official check to verify the proper handling of the head in the technical plant.

Small game – a declaration may be attached to trays or cartons to inform the competent authority of any abnormal characteristics, behaviour or environmental contamination.

Specimen forms – see the 'Wild game guide'.

If the correct documentation is not provided the carcasses must be disposed of as animal by-

product in accordance with Regulation (EC) 1069/2009 and the Animal by-products (Enforcement) Regulations 2011.

Immobilon™ - 'Eat not' ear tags – veterinary surgeons administering large animal immobilon™ (etorphine & acepromazine) or any other immobilising medicine not licensed for use in a food-producing animal, must mark permanently, with an appropriate tag in each ear, any deer (farmed or wild) or, if relevant, dispose of the carcass, to ensure, so far as practicable, that such animals will not enter the human food chain.

Animals tagged in this way are not to enter the human food chain.

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Legal requirement

853/2004 Annex III Section IV Chapter II: points 1, 3, 4, 5, 6 and 8a as amended by Commission Regulation 150/2011

B6. Meat of large wild game may be placed on the market only if the body is transported to a game handling establishment as soon as possible after the examination referred to in point 2 in B1. The viscera must accompany the body as specified in point 4 in B4. The viscera must be identifiable as belonging to a given animal.

B7. During transport to the game handling establishment, heaping must be avoided.

B6. and B7. Compliance regarding transport of wild game

- Large wild game is to have been transported to a game handling establishment as soon as possible after an initial examination accompanied by appropriate parts identified as belonging to a given animal.
- Small wild game are to have been transported to a game handling establishment as soon as possible after an initial examination and chilled within a reasonable time after killing to a temperature of not more than 4°C throughout the meat unless the climate makes active chilling unnecessary.

B6. and B7. Good practice

Accept only carcasses accompanied by the appropriate viscera identified as belonging to a given animal.

Accompanying viscera (feral wild boar) – as a species susceptible to Trichinosis, the head (except tusks) and diaphragm must accompany the body unless a declaration has been made – see example declaration at the end of this chapter. The OV will carry out Trichinella testing.

Accompanying viscera (deer) with a trained person's (hunter) declaration – the body need not be accompanied by the head and viscera, which can be removed immediately after killing.

Accompanying viscera (deer) without a trained person's (hunter) declaration – the head (except for antlers and horns) and all the viscera (except for the stomach and intestines, such as heart, lungs and liver) must accompany the body.

Correlation of carcasses and parts – if an animal is declared unfit for human consumption its parts will also be unfit. It is therefore necessary to be able to match all parts of the animal taken from the carcass before post mortem inspection as belonging to that one animal.

L

Legal requirement

853/2004 Annex III Section IV Chapter II: points 1, 3, 4, 5 and 6 and also point 8 as amended by Commission Regulation 633/2014

B8. (Large wild game) Chilling must begin within a reasonable time after killing and achieve a temperature throughout the meat of not more than 7°C. Where climactic conditions so permit, active chilling is not necessary.

B9. In addition, unskinned large wild game may be skinned and placed on the market only if, (i) before skinning it is stored and handled separately from other food and not frozen, (ii) after skinning, it undergoes a final inspection in a game-handling establishment in accordance with Regulation (EC) No 854/2004. Unskinned large wild game may be sent to a game handling establishment in another Member State only if, during transport to that game handling establishment, it is accompanied by a certificate conforming to the specimen set out in the Annex to Commission Implementing Regulation (EU) No 636/2014 issued and signed by an official veterinarian attesting that the requirements set out in BL4 as regards the availability of the declaration, when relevant, and the accompaniment of relevant parts of the body, have been complied with. In case the game handling establishment, close to the hunting area, is in another Member State, transport to this game handling establishment need not be accompanied by the certificate but by the declaration of the trained person referred to in B1, taking into account the animal health status of the Member State of origin.

853/2004 Annex III Section IV Chapter III: points 2, 3 and 4

B10. Meat of small wild game may be placed on the market only if the body is transported to a game handling establishment as soon as possible after the examination referred to at point 1 in B2.

B11. (Small wild game) Chilling must begin within a reasonable time after killing and achieve a temperature throughout the meat of not more than 4°C. Where climatic conditions so permit, active chilling is not necessary.

B8. to B11. Compliance regarding preparation of wild game for market

- Large wild game is to have been transported to a game handling establishment as soon as possible after an initial examination accompanied by appropriate parts identified as belonging to a given animal.
- Small wild game are to have been transported to a game handling establishment as soon as possible after an initial examination and chilled within a reasonable time after killing to a temperature of not more than 4°C throughout the meat unless the climate makes active chilling unnecessary.
- Unskinned large wild game are stored and handled separately from other food and not frozen.
- Large wild game carcasses are chilled within a reasonable time after killing to a temperature of

not more than 7°C throughout the meat unless active chilling is unnecessary due to climate.

B8. to B11. Good practice

Chilling – in the UK except for the coldest time of year, and where storage and transport times are short, active chilling will be necessary to attain the required temperature. See chapter 10 on 'Temperature controls'.

Freezing – large, in-fur wild game is not to be frozen before processing. Small, in-fur, in-feather wild game may be frozen before processing.

Storage – keep skinned and in-fur large wild game separate. Keep in-fur, in-feather small wild game separate from skinned and de-feathered carcasses.

See the 'Wild game guide' on guidance for suppliers of wild game.

L

Legal requirement

853/2004 Annex III Section IV Chapter II: points 7, 8a(ii) and 9 as amended by Commission Regulation 633/2014

B12. Large wild game delivered to a game handling establishment must be presented to the competent authority for inspection.

B13. In addition, unskinned large wild game may be skinned and placed on the market only if after skinning it undergoes a final inspection in a game-handling establishment in accordance with Regulation 854/2004. The OV is to check that a health certificate conforming to the specimen set out in the Annex to Regulation 636/2014 or the declaration(s) accompanies the unskinned large wild game transported to the game-handling establishment from the territory of another Member State, in accordance with point 8(b) of Chapter II of Section IV of Annex III to Regulation 853/2004. The OV is to take account the content of that certificate or declarations(s).

853/2004 Annex III Section IV Chapter III: points 6 and 7

B14. Small wild game delivered to a game-handling establishment must be presented to the competent authority for inspection.

B12. to B14. Compliance regarding official inspection

- Game sent to approved game handling establishments is to be subject to official inspection.

B12. to B14. Good practice

See 'C3. to C7.'.

L

Legal requirement

853/2004 Annex III Section IV Chapter II: points 7, 8b and 9

B15. The rules laid down in Section I, Chapter V, apply to the cutting and boning of large wild game.

853/2004 Annex III Section IV Chapter III: points 6 and 7

B16. The rules laid down in Section II, Chapter V, apply to the cutting and boning of small wild game.

B15. and B16. Compliance regarding dressing and cutting

- Wild game meat is to be cut and boned in the same way as the equivalent domestic species.

B15. and B16. Good practice

For dressing of large wild game carcasses – see 'C.'

For dressing of small wild game carcasses – see 'D'.

Cutting – see chapter 14 on 'Cutting of Meat'.

C. Dressing of domestic ungulates and large game

L

Legal requirement

853/2004 Annex III Section I Chapter VI: points 1 – 6

... meat from domestic ungulates that have undergone emergency slaughter outside the slaughterhouse may be used for human consumption only if ...

C1. An otherwise healthy animal must have suffered an accident that prevented its transport to the slaughterhouse for welfare reasons.

C2. A veterinarian must carry out an ante-mortem inspection of the animal.

C1. and C2. Compliance regarding acceptance of bodies for dressing

- Only animals that have suffered an accident that prevented transportation on animal welfare grounds and have been subject to ante-mortem inspection go for human consumption.

C1. and C2. Good practice

Advise suppliers of the conditions that have to be met before bodies can be accepted for dressing.

Farmed game – see chapter 11 on ‘Acceptance and slaughter of animals’ at E and G and Annex 11 and 12.

Emergency slaughtered animals – see chapter 11 on ‘Acceptance and slaughter of animals’, at F, G and Annex 9.

L

Legal requirement

853/2004 Annex III Section I Chapter VI: points 1 – 6

... meat from domestic ungulates that have undergone emergency slaughter outside the slaughterhouse may be used for human consumption only if ...

C3. A declaration by the FBO who reared the animal, stating the identity of the animal and indicating any veterinary products or other treatments administered to the animal, dates of administration and withdrawal periods, must accompany the slaughtered animal to the slaughterhouse.

C4. A declaration issued by the veterinarian recording the favourable outcome of the ante-mortem inspection, the date and time of, and reason for, emergency slaughter, and the nature of any treatment administered by the veterinarian to the animal, must accompany the slaughtered animal to the slaughterhouse.

853/2004 Annex III Section III: points 3(h) and (i) and point 4 (on farm slaughter of bison)

C5. A declaration by the FBO who reared the animals, stating their identity and indicating any veterinary products or other treatments administered, dates of administration and withdrawal periods, accompanies the slaughtered animals to the slaughterhouse.

C6. During transport to the approved establishment, a certificate issued and signed by the OV or Approved Veterinarian, attesting to a favourable result of the ante-mortem inspection accompanies the slaughtered animals.

853/2004 Annex III Section III point 3(j) and point 4 (on farm slaughter of bison) as amended by Commission Regulation 150/2011

C7. By way of derogation from point 3(j), the competent authority may authorise that the attestation of the correct slaughter and bleeding and of the date and time of slaughter be included only in the declaration by the food business operator referred to in point 3(j), provided that:

(i) the holding is situated in a Member State of region, as defined by Article 2(2)(p) of Directive 64/432/EEC which is not under health restrictions in accordance with Union law or national legislation

(ii) the food business operator has demonstrated the appropriate level of competence to slaughter animals without causing the animals any avoidable pain, distress or suffering in accordance with Article 7(2) of Regulation (EC) No 1099/2009 and without prejudice to Article 1q2 of that Regulation

C3. to C7. Compliance regarding declaration of bodies accepted for dressing

- Animals are accompanied by owners' declarations and veterinary certificates with any viscera removed under veterinary supervision.

C3. to C7. Good practice

If the correct documentation is not provided to the operator the carcass must be disposed of as animal by-product in accordance with Regulation (EC) 1069/2009 and the Animal by-products

(Enforcement) Regulations 2011, having regard to the need for any statutory testing that is required, for example, TSE testing.

See chapter 11 on 'Acceptance and slaughter of animals' at 'F5' and 'F6'.

L

Legal requirement

853/2004 Annex III Section I Chapter VI: points 1 – 6

... meat from domestic ungulates that have undergone emergency slaughter outside the slaughterhouse may be used for human consumption only if ...

C8. The slaughtered and bled animal must be transported to the slaughterhouse hygienically and without undue delay. Removal of the stomach and intestines, but no other dressing, may take place on the spot, under the supervision of the veterinarian. Any viscera removed must accompany the slaughtered animal to the slaughterhouse and be identified as belonging to that animal.

C9. If more than two hours elapse between slaughter and arrival at the slaughterhouse, the animal must be refrigerated. Where climactic conditions so permit, active chilling is not necessary.

853/2004 Annex III Section III: points 3(h) and (i) and point 4 (on farm slaughter of bison).

C10. Slaughtered and bled animals are transported to the slaughterhouse hygienically and without undue delay. If transport takes more than two hours, the animals are, if necessary, refrigerated. Evisceration may take place on the spot, under the supervision of the veterinarian.

C8. to C10. Compliance regarding transport of bodies accepted for dressing

- Animals are accompanied by owners' declarations and veterinary certificates with any viscera removed under veterinary supervision.
- Bodies are transported hygienically and without delay. If the time between slaughter and arrival at the slaughterhouse is more than 2 hours, the animal is refrigerated unless active chilling is unnecessary due to climate.

C8. to C10. Good practice

Confirm that when the bodies of farmed game animals or emergency slaughtered animals arrive at the premises they are under refrigeration if necessary (usually in the UK except for the coldest time of year, and where storage and transport times are short, active chilling will be necessary) and are accompanied by owner declarations and veterinary certificate.

See chapter 11 on 'Acceptance and slaughter of animals' at 'A'.

L

Legal requirement

853/2004 Annex III Section I Domestic Ungulates: Chapter VI points 7 and 8

C11. The slaughtered animal must be fit for human consumption following post-mortem inspection carried out in the slaughterhouse in accordance with Reg. 854/2004 including any additional tests required in the case of emergency slaughter.

854/2004 Annex I Section I Chapter II D point 1

C12. Carcasses and accompanying offal are to be subjected without delay after slaughter to post-mortem inspection. The slaughter line speed and the number of inspection staff present are to be such as to allow for proper inspection.

853/2004 Annex III Section IV Large Wild Game: Chapter II points 7 and 8

C13. Unskinned large wild game may be skinned and placed on the market only if after skinning it undergoes a final inspection in a game-handling establishment in accordance with Reg. 854/2004. The OV is to check that a health certificate conforming to the specimen set out in the Annex to Regulation 636/2014 or the declaration(s) accompanies the unskinned large wild game transported to the game-handling establishment from the territory of another Member State, in accordance with point 8 of Chapter II of Section IV of Annex III to Regulation 853/2004. The OV is to take account the content of that certificate or declaration(s).

C11. to C13. Compliance regarding post-mortem inspection

- Follow the OV's instructions to ensure that post-mortem inspection of all slaughtered animals is carried out under suitable conditions in accordance with Regulation 854/2004.

C11. to C13. Good practice

Regulation 854/2004 lays down the requirements for post-mortem inspection – see '12.1. Application of carcase dressing regulations'. After the inspection, the OV/OA can:

- pass the meat as fit for human consumption
- declare the meat unfit for human consumption
- detain the meat for further examination following rectification

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 12

C14. Slaughterhouse operators must follow the instructions of the competent authority to ensure that post-mortem inspection of all slaughtered animals is carried out under suitable conditions in accordance with Regulation 854/2004.

854/2004 Annex I Section IV Chapter IX B2

C15. Meat infected with *C. bovis* is to be declared unfit for human consumption. However uninfected parts of animals not generally infected with cysticercus, may be declared fit for human consumption after cold treatment.

C14. and C15. Compliance regarding *Cysticercus bovis* (*C. bovis*)

- Follow the OV's instructions to ensure that post-mortem inspection is carried out under suitable conditions in accordance.

C14. and C15. Good practice

When not generally infected with *C. bovis*, parts of an animal may be declared fit for human consumption if they undergo cold treatment for a specified time at a set temperature; 14 days at a temperature not exceeding -10°C or 21 days at a temperature not exceeding -7°C.

The carcase will be cut up to determine the extent of contamination. Those parts that are not contaminated should be boxed and placed in cold storage. The boxes will be detained and officially labelled to ensure that they are not used until the OV is satisfied that the meat has received satisfactory treatment and can be health marked and despatched.

For additional information on 'Hazards in meat production' see chapter 1 'Introduction' section 1.3.

Special arrangements – if there are no suitable cold storage facilities at the slaughterhouse, the meat can be sent to an approved standalone cold store for treatment by arrangement with the OV. A charge will normally be made for an Authorised Officer (AO) to visit the cold store to check the treatment and, if there is no cause for concern, to release the meat. Each box must be labelled '*C. bovis* - Detained'. The transfer permit that must accompany each pallet of boxes must include the total number of boxes being consigned to the cold store and the number of carcasses that have been boxed. The AO will sign and return the permit to the originating plant and, once released, the boxes can be identification marked by the cold store and despatched.

L

Legal requirement

853/2004 Annex III Section I Domestic Ungulates: Chapter VI points 7 and 8

C11. The slaughtered animal must be fit for human consumption following post-mortem inspection carried out in the slaughterhouse in accordance with Reg. 854/2004 including any additional tests required in the case of emergency slaughter.

C16. Food business operators must follow any instructions that the official veterinarian may give after post-mortem inspection concerning the use of the meat.

C11. and C16. Compliance regarding meat from emergency slaughtered animals

Follow the OV's instructions:

- to ensure that post-mortem inspection of all slaughtered animals is carried out under suitable conditions in accordance with Regulation 854/2004
- regarding any additional tests that may be required for an emergency slaughtered animal, or the use of its meat after post-mortem inspection

C11. and C16. Good practice

The health mark should be applied to all emergency slaughter carcasses passed as fit for human consumption. See chapter 16 on 'Food traceability' at C3.

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 16(a)-(d)

C17. After post-mortem inspection...

C17. Compliance regarding meat unfit for human consumption

After post-mortem inspection make sure that:

- tonsils of cattle, pigs and solipeds (horses) are removed hygienically
- parts unfit for human consumption are removed as soon as possible from the clean sector of the slaughterhouse
- meat detained or declared unfit for human consumption and inedible by-products do not come into contact with meat declared fit for human consumption
- viscera or parts of viscera remaining in the carcass, except for the kidneys, are removed entirely and as soon as possible, unless the OV authorises otherwise

C17. Good practice

OV decisions – note that among other reasons, the OV will declare meat unfit for human consumption if it indicates patho-physiological changes, contains other than permitted SRM, shows soiling, faecal or other contamination or, in the OV's opinion, it may constitute a risk to public or animal health or is for any other reason not suitable for human consumption under 854/2004 Annex I Section II Chapter V (p), (r), (s), (u).

Detained meat – divert carcasses to a lockable, refrigerated facility for storage of detained meat for further inspection - see 'A8. and A9.'.

Storage and removal of unfit meat – place unfit meat in a designated, labelled container out of contact with fit meat and remove the container when full or at the end of the day. See chapter 18 on 'Waste management'. There should be separate lockable facilities for the storage of meat declared unfit for human consumption – see 'A8. and A9.'.

Edible co-products and animal by-products – see the guidance available at www.food.gov.uk/foodindustry/guidancenotes/meatregsguid/coproductbyproductguide.

See chapter 14 on 'Cutting of meat' for further information.

L

Legal requirement

853/2004 Annex III Section IV Large Wild Game: Chapter II points 7 and 8

C18. Large wild game delivered to a game-handling establishment must be presented to the competent authority for inspection.

854/2004 Annex I Section IV Chapter VII B point 2

C19. Post-mortem inspection procedures described for (red meat) animals are to be applied to the corresponding species of farmed game.

C18. and C19. Compliance regarding post-mortem actions

- Follow the OV's instructions to ensure that post-mortem inspection of all slaughtered animals is carried out under suitable conditions in accordance with Regulation 854/2004.

C18. and C19. Good practice

Operator rectification – meat presented for post-mortem inspection should be free from visible faecal and other contamination.

If contaminated meat is presented, official inspection staff will divert it to the detained rail or area until action has been taken by the operator to remove the contamination and re-present the meat for inspection – see 'C22. and C23.'.

Some defects can be removed under official supervision and re-presented for inspection and health marking. Other defects will render the carcass and parts unfit for human consumption. Where certain pathological defects are detected, for example, bruising, these may, by agreement

with the OV, be removed by the operator at the final inspection area. Otherwise, official inspection staff will divert the carcass to the detained rail or area for a final decision on fitness.

L

Legal requirement

854/2004 Annex I Section I Chapter II D point 3

C20. For post-mortem inspection the OV will require certain carcasses to be submitted split lengthways down the spinal column. The OV may also require any head or any carcass to be split lengthways.

C20. Compliance regarding splitting carcasses

- For post-mortem inspection the OV will require certain carcasses to be submitted split lengthways down the spinal column. The OV may also require any head or any carcass to be split lengthways.

C20. Good practice

Splitting carcasses – unless the OV authorises otherwise for a specific reason, split carcasses of domestic solipeds lengthways down the spinal column. The OV may also require splitting of any carcass or head.

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 15

C21. Blood or other offal of several animals collected in the same container before completion of post-mortem inspection.

C21. Compliance regarding blood collection

- If the blood of several animals is collected in the same container before post-mortem inspection is completed, the entire contents are to be declared unfit for human consumption if the carcass of one or more of the animals concerned has been declared unfit for human consumption.

C21. Good practice

If blood is intended for human consumption and an animal is declared unfit for human consumption, its blood will also be unfit. It is therefore necessary to be able to match batches of blood collected before post mortem inspection to individual animals.

Collect any blood intended for human consumption hygienically, for example by using a hollow knife.

OV decisions – note that the OV is to declare meat unfit for human consumption if it consists of blood that may constitute a risk to public or animal health owing to the health status of any animal

from which it derives or contamination arising during the slaughter process; 854/2004 Annex I Section II Chapter V(t).

Blood not intended for human consumption is an animal by-product – see ‘12.3. Animal by-products’.

L

Legal requirement

853/2004 Annex III Section I Domestic Ungulates: Chapter VI point 3

C22. Any viscera removed (from emergency slaughtered) animals must accompany the slaughtered animal to the slaughterhouse and be identified as belonging to that animal.

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 13

C23. Dealing with parts of a slaughtered animal subject to post-mortem inspection.

C22. and C23. Compliance regarding correlation of carcasses and parts

- Make sure that, until post-mortem inspection is completed, parts of a slaughtered animal subject to such inspection (including emergency slaughtered animals):
 - remain identifiable as belonging to a given carcass
 - do not come into contact with other carcasses, offal or viscera, including those that have already undergone post-mortem inspection
 - however, the penis may be discarded immediately provided it shows no pathological lesion

C22. and C23. Good practice

If an animal is declared unfit for human consumption its parts will also be unfit. It is therefore necessary to be able to match parts of the animal, including batches of blood (see ‘C21.’) or fat when intended for human consumption, taken from the carcass before post mortem inspection, as belonging to that one animal.

If removed before post-mortem meat inspection, most parts of each animal must accompany the carcass to allow a full inspection to take place.

Make sure that:

- slaughtered animals are dressed and treated in such a way as not to prevent or hinder official inspection
- no carcasses are cut up
- no action is taken to destroy or alter evidence of disease unless specific guidance on a case by case basis allows
- no part, is removed from the establishment until post-mortem inspection is completed and any required samples are taken except:

- for all species, the penis if not intended for human consumption, provided retention was not required following ante-mortem inspection
- for sheep and goats, the head, if no part of it is intended for human consumption – 854/2004 Annex I Section IV Chapter II point 1
- for relevant species: the hide or skin - see 'C29. and C30.'

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 7(c)

C24. ... evisceration ... must be carried out without undue delay and in a manner that avoids contaminating the meat.

C25. Measures must be taken to prevent the spillage of digestive tract content during and after evisceration and to ensure that evisceration is completed as soon as possible after stunning.

C24. and C25. Compliance regarding evisceration

- Carry out evisceration without undue delay.
- Prevent the spillage of digestive tract contents during and after evisceration.

C24. and C25. Good practice

Instruct staff how to avoid opening the digestive tract and why it is important to prevent such contamination of the carcass.

The risk of faecal contamination may be reduced by rodding and/or bunging.

Rodding – the oesophagus can be sealed by mechanical methods such as tying, elastic/rubber rings, plastic clips or starch cones. Rodding is usually carried out straight after bleeding is completed to prevent the escape of ruminal fluid or contents, which would contaminate the tissues of the head and neck. Alternatively this may be carried out after hide/fleece removal to minimise contamination of the throat.

Bunging – reduce faecal contamination by placing a bag over the rectum and securing it in place with an elastic band. Specialist bunging equipment is available for pigs, which cuts round the orifice and pushes rectal content back up the rectum and so prevents spillage. For sheep rectal contents can be milked, or milked and tied, or milked and clipped as well as bunged.

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 7(d)

C26. ... skinning, evisceration and other dressing must be carried out without undue delay and in a manner that avoids contaminating the meat.

C26. Compliance regarding processing

- Carry out skinning, evisceration and other dressing without undue delay, avoiding contamination of the meat.

C26. Good practice

Once an animal has been stunned, bleeding and dressing should be a continuous process. Schedule breaks accordingly.

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 18(a) and (b)

C27. When destined for further handling:
(a) stomachs must be scalded or cleaned
(b) intestines must be emptied and cleaned

C27. Compliance regarding stomachs and intestines

- When destined for further handling, scald or clean stomachs; empty and clean intestines.
- Unless otherwise authorised, provide a separate room for the emptying and cleaning of stomachs and intestines.

C27. Good practice

If intended for human consumption, scald or clean stomachs and empty and clean intestines thoroughly with potable water, before despatch from the slaughterhouse.

Cleaning of green offal should take place in a separate room, or at a separate time if authorised at approval, to avoid cross contamination – see 'A10. to A12.' and 'A13. to A14.'

Section XIII Annex III of Regulation 853/2004 sets out requirements for treated stomachs, bladders and intestines. See the 'Edible co-products industry guide at: www.food.gov.uk/foodindustry/guidancenotes/meatregsguid/coproductbyproductguide.

Staff handling green offal should not handle other fresh meat unless they first wash their hands and other parts of the body that were contaminated and change protective clothing if necessary.

Remove labelled containers used for the collection and disposal of gut content from the work area when full and at the end of the day.

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV: points 7(b)

C28. ... skinning ... must be carried out without undue delay and in a manner that avoids contaminating the meat. In particular:

(b) during the removal of hides and fleece:

(i) contact between the outside of the skin and the carcase must be prevented.

(ii) operators and equipment coming into contact with the outer surface of hides and fleece must not touch the meat.

C29. Carcases and other parts of the body intended for human consumption must be completely skinned, except for porcine animals, the heads of ovine and caprine animals and calves, the muzzle and lips³ of bovine animals and the feet of bovine³, ovine and caprine animals. Heads, including muzzle and lips⁴, and feet must be handled so as to avoid contamination of other meat.

C28. and C29. Compliance regarding skinning and depelting

- During the removal of hides and fleece, prevent contact between the outside of the skin and the carcase.
- Operators and equipment that have come into contact with the outer surface of hides and fleece must not touch the meat.
- Skin carcases and other parts intended for human consumption, completely except for pigs and certain heads, muzzle and lips of bovines and feet – see 'C29. and C32.'.

C28. and C29. Good practice

Mechanical methods (for example, crocodile clips and papers) may be used to reduce the risk of the carcase being contaminated from the in-rolling of the hide/fleece during its removal.

After the initial cut through the skin a second clean knife should be used for further skinning.

Wash hands frequently and make sure that carcases do not touch either equipment or, if skinned on a cradle, the floor.

De-pelting of lambs (insufflation) – if gas is used as an aide to pelt removal, the process needs to be carried out hygienically, taking into account e.g:

- preventing contamination at the injection site

³ Amended by 1662/2006 Annex II point 1a

⁴ Amended by 2074/2005 Implementing Measures Article 5(f)

- sanitising needles to prevent contamination between carcasses
- the type of gas, which must either be food grade or filtered compressed air (not one directly drawn from the abattoir environment)

Carcases handled in this way should be included in the company's microbiological testing plan.

Hides and skin – when intended for food use (for example, production of gelatine and collagen) hides and skins must derive from animals that have passed ante- and post-mortem inspection.

Hides and skins are classed as category 3 animal by-products when the operator decides not to use them for human consumption – see '12.3. Animal by-products'.

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 14

C30. Both kidneys must be removed from their fatty covering. In the case of bovine and porcine animals, and solipeds, the peri-renal capsule must also be removed.

C30. Compliance regarding kidneys

- Remove both kidneys from their fatty covering.
- In the case of bovine and porcine animals and solipeds, also remove the peri-renal capsule.

C30. Good practice

Remove kidneys to facilitate post-mortem inspection. Correlate to carcasses for inspection.

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV: point 9

C31. When not skinned, porcine animals must have their bristles removed immediately. The risk of contamination of the meat with scalding water must be minimised. Only approved additives may be used for this operation. Porcine animals must be thoroughly rinsed afterwards with potable water.

C31. Compliance regarding scaling of pigs

- For pigs that are not skinned, remove the bristles immediately and rinse the carcass thoroughly in potable water. The risk of contamination of the meat with scalding water must be minimised. Use only approved additives for this operation.

C31. Good practice

Use potable water to fill the scalding tank at the start of each day. Empty and clean the tank when

necessary and at the end of the day.

Keep the water at an appropriate temperature (around 60°C) to maintain effective scalding.

Vertical scalding which involves the use of steam or hot water jets as opposed to water in a tank may reduce the risk of cross contamination of the carcass via the stick wound. If used, the scald tank should be cleaned at the end of the day.

Scald tank additives are not known to be used in the UK.

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV: points 7(b), 8 and 18(c)

C29. Carcasses and other parts of the body intended for human consumption must be completely skinned, except for porcine animals, the heads of ovine and caprine animals and calves, the muzzle and lips⁵ of bovine animals and the feet of bovine⁶, ovine and caprine animals. Heads, including muzzle and lips⁶, and feet must be handled so as to avoid contamination of other meat.

C32. When destined for further handling:

(c) heads and feet must be skinned or scalded and depilated.

C29. and C32. Compliance regarding preparation of heads and feet

- Skin carcasses and other parts intended for human consumption, completely except for pigs and certain heads, muzzle and lips of bovines and feet.
- Skin or scald and depilate the heads of pigs, sheep, goats and calves and the feet of pigs, sheep, goats and cattle when destined for further handling.
- Handle heads, muzzle, lips and feet in a way that avoids contamination of other meat.

C29. and C32. Good practice

Remove heads and feet hygienically.

If left unskinned, the heads and feet intended for human consumption must be scalded and all hair removed before dispatch from the slaughterhouse.

Feet – treat feet intended for human consumption as edible offal. Feet that have not been inspected and have not been processed are not to be despatched from the establishment as intended for human consumption.

Sheep and goat heads – if no parts are intended for human consumption – see 'C22. and C23.'.

⁵ Amended by 1662/2006 Annex II point 1a

⁶ Amended by 2074/2005 Implementing Measures Article 5(f)

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 7(d)

C33. Removal of the udder must not result in contamination of the carcase with milk or colostrum.

C33. Compliance regarding udder removal

- Remove the udder in a way that avoids contamination of the carcase with milk or colostrum.

C33. Good practice

Remove udders hygienically and avoid spillage.

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 11

C34. Carcasses and offal must not come into contact with floors, walls or work stands.

C34. Compliance regarding contact of meat with floors, walls and work stands

- Avoid carcasses and offal from coming into contact with floors, walls or work stands.

C34. Good practice

Minimise the opportunity for contact between carcasses and offal with floors, walls and work stands by way of the layout and design of equipment and lines, control of line speed, and staff training, awareness and supervision.

Where such contact is difficult to avoid completely, the installation, maintenance and treatment of surfaces as 'food contact surfaces' will reduce the risk of contamination.

Dropped meat policy – the procedures for dealing with meat that has fallen on the floor, depend on the size of the piece of meat and the extent and nature of any possible contamination. Trim large pieces of red meat of visible contamination before processing is resumed. Pieces that are not suitable for trimming should be disposed of as unfit food.

L

Legal requirement

853/2004 Annex III Section I Slaughter Hygiene: Chapter IV point 10

C35. The carcasses must not contain visible faecal contamination. Any visible contamination must be removed without delay by trimming or alternative means having an equivalent effect.

C35. Compliance regarding visible carcass contamination

- Make sure that carcasses do not contain visible faecal contamination. If any such contamination has occurred remove it without delay by trimming or alternative means with an equivalent effect.

C35. Good practice

Gross visible contamination of meat must be trimmed. If such contamination is detected plant staff should remove it before the carcass is presented for post-mortem inspection.

Check every carcass to ensure absence of visible contamination with faeces, enteric content, viscera, bedding, hide and hair, wool or bristle. In order to inspect in the proper way, ensure there is enough light (see 'A1. to A3.')

at the point of inspection and that the carcass can be seen from all angles, for example, mirrors can assist, but take care as glass can become a food safety hazard.

F

Visible carcass contamination (wool/hairs) – in addition to appropriately implemented procedures based on HACCP principles, minor contamination can be removed without delay by trimming or also by alternative means with an equivalent effect.

Trimming of bullet entry points – shot game carcasses may require localised trimming around bullet holes because of bruising, or more extensive trimming if there is bone/muscle damage.

OV decisions – note that the OV is to declare meat unfit for human consumption if it shows soiling, faecal or other contamination under 854/2004 Annex I Section II Chapter V(s).

L

Legal requirement

853/2004 Article 3 point 2

C36. Food business operators shall not use any substance other than potable water - ... - to remove surface contamination from products of animal origin, unless the substance's use has been approved ...

TIP



Steam vacuum can be used to remove minor visible contamination, dirt and hair from relatively smooth carcass surfaces provided that:

- a) this tool is only used to rectify **accidental** contamination of carcasses and not as a substitute for good hygiene or inadequate dressing practices, and
- b) the FBO maintains the responsibility for rectifying carcasses prior to post-mortem inspection (ie the FBO should either rectify contaminated carcasses while on the dressing line or divert them onto a rectification rail)

The vacuuming process will not remove colour tracks (for example, bile or deep contamination) which will need to be rectified by traditional knife trimming techniques.

The use of steam vacuum after FSA / FSS post-mortem inspection for cosmetic reasons is not subject to the above requirements. Once the carcasses have passed official inspection, it is the FBO's responsibility to make sure that no further contamination occurs.

C36. Compliance regarding removal of surface contamination

- Use only potable water or EU approved substances for the removal of surface contamination from meat or other products of animal origin. Follow the conditions of use and always follow the manufacturer's instructions.

C36. Good practice

Remove any visible faecal/enteric contamination before the carcass is washed or rinsed. Rinsing or showering of carcasses should be kept to a minimum using only potable water or approved substances – see 'A15. Removal of contamination'. If spraying is carried out water should be contained in such way to prevent cross contamination and waste water collected and ducted into a drain.

Washing is recommended after:

- carcass splitting to remove bone dust; take care to restrict water spray to the back bone
- the scald tank for pigs and poultry but before evisceration, to remove debris from the scald tank

Heads and tongues – wash before inspection to remove any ingested material that may hamper inspection.

OV decisions – the OV is to declare meat unfit for human consumption if it has been treated illegally with decontaminating substances under 854/2004 Annex I Section II Chapter V (I).

D. Dressing of poultry and lagomorphs including game

L

Legal requirement

853/2004 Annex III Section II Chapter VI points 6-9

D1. The slaughtered birds must be accompanied to the slaughterhouse by a declaration by the ... operator who reared the animal indicating any veterinary products or other treatments administered to the animal, dates of administration and withdrawal periods, and the date and time of slaughter.

D2. The slaughtered animal must be accompanied to the slaughterhouse by a certificate issued by the OV or approved veterinarian in accordance with Regulation 854/2004.

D1. and D2. Compliance regarding declaration of slaughtered poultry

Make sure that :

- accepted farm slaughtered poultry are accompanied by an owners declaration and a veterinary certificate.

D1. and D2. Good practice

Documentation – confirm that when the poultry arrives the birds are at no more than 4°C if a delayed evisceration bird, or under refrigeration if necessary if a 'foie gras' bird. Active chilling will be necessary in the UK except for the coldest time of year and where storage and transport times are short. Check that poultry is accompanied by owner declarations and a veterinary certificate. See chapter 11 on 'Acceptance and slaughter of animals, B, D, E and the model document at 'Annex 8.'

If the correct documentation is not provided to the operator the carcass must be disposed of as animal by-product.

L

Legal requirement

853/2004 Annex III Section II Slaughter Hygiene: Chapter IV point 6

D3. Slaughterhouse operators must follow the instructions of the competent authority to ensure that the post-mortem inspection is carried out under suitable conditions, and in particular that slaughtered animals can be inspected properly.

854/2004 Annex I Section IV Chapter VII B point 2

D4. Carcasses and accompanying offal are to be subjected to post-mortem inspection without delay after slaughter. The speed of the slaughter line and the number of inspection staff present are to allow for proper inspection.

D5. 854/2004 Annex I Section I Chapter II D point 1 Post-mortem inspection procedures described for poultry are to be applied to the corresponding species of farmed game.

D3. to D5. Compliance regarding post-mortem inspection

- Follow the OV's instructions to ensure that post-mortem inspection of all slaughtered animals is carried out under suitable conditions in accordance with Reg 854/2004.
- Carcasses and accompanying offal are to be subjected to post-mortem inspection without delay after slaughter. The speed of the slaughter line and the number of inspection staff present are to allow for proper inspection.
- 854/2004 Annex I Section I Chapter II D point 1 Post-mortem inspection procedures described for poultry are to be applied to the corresponding species of farmed game.

D3. to D5. Good practice

Regulation 854/2004 lays down the requirements for post-mortem inspection – see '12.1. Application of carcase dressing regulations'.

After the inspection, the OV/OA can:

- pass the meat as fit for human consumption
- declare the meat unfit for human consumption
- detain the meat for further examination following rectification

Carcasses and/or offal affected with general contamination by faecal material, bile, grease or disinfectants should be considered unfit for human consumption.

Rectification – rectification, including removal of unfit meat, resulting from post-mortem findings must be carried out by plant staff under official supervision (supervision of trimming may be carried out by a plant inspection assistant (PIA)). Identification of unfit meat for trimming must not be delegated to untrained individuals.

Put in place a hygienic trimming system if contaminated carcasses are to be trimmed. Any part of the carcase or offal affected with bile staining should be trimmed. Where plucking machines break the skin of poultry the underlying musculature should be considered to be contaminated and trimmed from the carcase. Meat contaminated after post-mortem inspection must not be released for human consumption.

Trimming after chilling – trimming of carcasses may be delayed until after chilling, if there is no risk of contamination to other carcasses, (does not apply to, for example, faecal contamination). In addition, arrangements are to be in place for the trimming to be done under official supervision at regular times and methods are agreed with the OV (marking and identification of parts to be trimmed) to ensure that trimming is effectively completed by plant staff.

L

Legal requirement

853/2004 Annex III Section II Slaughter Hygiene: Chapter IV point 7(a)-(c)

D6. After post-mortem inspection:

- (a) parts unfit for human consumption must be removed as soon as possible from the clean sector of the establishment.
- (b) meat detained or declared unfit for human consumption and inedible by-products must not come into contact with meat declared fit for human consumption.
- (c) viscera or parts of viscera remaining in the carcase, except for the kidneys, must be removed entirely, if possible, and as soon as possible, unless otherwise authorised by the competent authority.

D6. Compliance regarding after post-mortem

After post-mortem inspection:

- remove parts unfit for human consumption as soon as possible from the clean sector of the establishment.
- do not allow meat detained or declared unfit for human consumption and inedible by-products to come into contact with meat declared fit for human consumption.
- remove viscera or parts of viscera (except for the kidneys) remaining in the carcase entirely if possible, and as soon as possible, unless otherwise authorised by the competent authority.

D6. Good practice

OV decisions – note that among other reasons, the OV will declare meat unfit for human consumption if it indicates patho-physiological changes, shows soiling, faecal or other contamination or, in the opinion of the official veterinarian, it may constitute a risk to public or animal health or is for any other reason not suitable for human consumption under 854/2004 Annex I Section II Chapter V (p), (r), (s), (u).

Authorisation of partial evisceration (see 'D8.') – once authorised each batch would be subject to the satisfactory outcome of a post-mortem inspection of a sample of fully eviscerated as well as of partially eviscerated birds.

Detained meat – use a rail to divert carcasses for further inspection - see 'A8. and A9.'

Animal by-products – remove by-products from the clean area to reduce the risk of cross-contamination. See separate guidance available at:
www.food.gov.uk/foodindustry/guidancenotes/meatregsguid/coproductbyproductguide.

Gut content and any other animal waste should be removed or destroyed as often as may be necessary and, in any case, at least daily to avoid accumulation and thus reducing the risk of cross contamination.

Storage and removal of unfit meat – place unfit meat in a designated, labelled container away

from contact with fit meat and remove the container when full or at the end of the day. See chapter 18 on 'Waste management'. There should be separate lockable facilities for the storage of meat declared unfit for human consumption – see 'A8. and A9.'

L

Legal requirement

854/2004 Annex I Section III Chapter III A as amended by Commission Regulation (EC) No 1021/2008 [Pub OJ 18.10.08 L277/15]

D7. The competent authority may authorise the staff of poultry or rabbit slaughterhouses to carry out tasks of the meat inspectors.

D7. Compliance regarding involvement of slaughterhouse staff

- The competent authority may authorise the staff of poultry or rabbit slaughterhouses to carry out tasks of the meat inspectors:
 - they are under the supervision, direction and responsibility of the OV
 - the OV is present and supervises their activities

D7. Good practice

The FSA / FSS permits the use of trained slaughterhouse staff (known as PIAs) to carry out certain duties of meat hygiene inspectors in UK poultry and rabbit slaughterhouses, if FSA / FSS / DAERA are satisfied, on a case by case basis, that operators can implement such arrangements, based on their application of good hygiene practices and HACCP-based procedures for at least 12 months, and an analysis of:

- production and inspection records
- type of activities undertaken in the establishment
- history of compliance with the rules
- expertise, professional attitude and sense of responsibility of the PIAs with regard to food safety
- other relevant information

F

Involvement of slaughterhouse staff – availability and use of Plant Inspection Assistants in poultry and rabbit slaughterhouses to carry out practical on-line post mortem inspection.

Operators wishing to use PIAs should approach their OV so that eligibility can be assessed.

Wild game – PIAs are not permitted to inspect wild game carcasses in game handling establishments.

D7. Compliance regarding training of slaughterhouse staff

- The competent authority may authorise the staff of poultry or rabbit slaughterhouses to carry out tasks of the meat inspectors:
 - when trained to the competent authorities satisfaction in the same way as the OAs for the tasks of OAs or for the specific tasks they are authorised to perform

D7. Good practice

Training and authorisation – PIAs who have been working before 2006 will hold authorisations following training by plant OVs. Anyone without an authorisation or a PIA (pre-2006) who has not worked with the relevant species between 1 January 2006 to present, must gain an appropriate qualification before they can be authorised to work as a PIA.

Authorisation is subject to the OV being satisfied that an individual has the competence to carry out the required tasks in the slaughterhouse.

Qualification – there are specialist courses available that can lead to qualifications such as:

- Level 2 Award/Certificate for Proficiency in Poultry Meat Inspection
- FDQ Level 2 Award/Certificate/Diploma for Proficiency in Meat and Poultry Industry Skills (QCF)

Information is available from:

- The Royal Society for Public Health www.rsph.org.uk/
- Food and Drink Qualifications www.fdq.org.uk/

Supervision and performance assessment – PIAs work under the OV's supervision, direction and responsibility as members of the OV's team and are subject to regular assessment of their performance.

L

Legal requirement

853/2004 Annex III Section II Slaughter Hygiene: Chapter IV point 5

D8. ... skinning or plucking, ... and other dressing must be carried out without undue delay in such a way that contamination of the meat is avoided.

D8. Compliance regarding plucking and skinning

- Carry out skinning or plucking, and other dressing without delay and in such a way as to prevent contamination of the meat.

D8. Good practice

Scalding – using potable water, birds are scalded either by immersion in hot water or by dry hot air.

Automated plucking – when used, make sure:

- equipment is well maintained and in good working order so that it meets operational standards
- waste feathers are removed from plucking equipment and the plucking room regularly and hygienically

Manual plucking – when using the dry plucking method staff shall observe good personal hygiene to avoid possible contamination; washing hands frequently and wearing clean protective clothing.

Wax baths – may be used to de-feather ducks. Refill wax bath with clean wax as necessary. Melt used wax in a separate room and remove feather remnants and dirt before the wax is used again.

L

Legal requirement

853/2004 Annex III Section II Slaughter Hygiene: Chapter IV point 5

D9. ... evisceration ... must be carried out without undue delay in such a way that contamination of the meat is avoided. In particular, measures must be taken to prevent the spillage of digestive tract contents during evisceration.

D9. Compliance regarding evisceration

- Carry out evisceration without delay and in such a way as to prevent contamination of the meat. In particular, take steps to prevent the spillage of digestive tract contents during evisceration.

D9. Good practice

Automated evisceration – in the case of mechanised lines, poor alignment of evisceration equipment may result in damage to the digestive tract and subsequent spillage of gut contents resulting in contamination of the carcass. Adequate maintenance and adjustment of the equipment to the size of birds is important to avoid this.

Manual evisceration – frequent changing, rinsing and disinfection of knives and washing of the operatives' arms and hands should be carried out to prevent cross-contamination. Keep aprons clean or change them regularly.

Partial evisceration - the removal of intestines only (see 'effilé' below) may be permitted by the competent authority. Requests will be considered by FSA Operations Group / FSS Approval and Certification Team on receipt of a proposed method of operation – see 'D6.'

Evisceration (marketing terms) - under the EU Poultry meat Marketing Standards Regulations (see '12.4. EC poultry meat marketing standards regulations') relevant poultry carcasses must be presented for sale in one of the following forms:

- 'partially eviscerated' ('effilé', or 'roped') - in which the heart, liver, lungs, gizzard, crop and kidneys have not been removed from the carcass

- '(eviscerated) without giblets' or '(eviscerated) with giblets'

F

Partial evisceration – for 'effile' chickens, where the heart, liver, lungs, gizzard, crop and kidneys have not been removed from the carcass.

TIP



Giblets – Giblets comprise only the heart, neck, gizzard (with contents and horned (kiolin) membrane removed) and liver (without gall bladder), and other parts considered as edible by the market on which the product is intended for final consumption. If the neck remains attached to the carcass, it is not considered as one of the giblets.

L

Legal requirement

853/2004 Annex III Section II Chapter VI points 6-9

D10. In the case of poultry reared for the production of 'foie gras', the uneviscerated birds must be transported immediately and if necessary refrigerated to a slaughterhouse or cutting plant. They must be eviscerated within 24 hours of slaughter under the supervision of the competent authority.

D10. Compliance regarding evisceration of 'foie gras'

Make sure that :

- uneviscerated poultry for 'foie gras' production is transported, immediately and if necessary refrigerated, to an approved slaughterhouse or cutting plant in the same Member State for evisceration within 24 hours of slaughter

D10. Good practice

'Foie gras' – eviscerate poultry within 24 hours of slaughter.

See chapter 11 on 'Acceptance and slaughter of animals' at 'E'.

L

Legal requirement

853/2004 Annex III Section II Chapter VI points 6-9

D11. Delayed eviscerated poultry ... may be kept for up to 15 days at a temperature of not more than 4°C after slaughter. It must then be eviscerated in a slaughterhouse or cutting plant located in the same Member State as the farm of production.

D11. Compliance regarding delayed evisceration

Make sure that:

- delayed eviscerated poultry arrives at a slaughterhouse or cutting plant in the same Member State as the farm of production no later than 15 days after slaughter and at a temperature of not more than 4°C.

D11. Good practice

Delayed eviscerated poultry must arrive for evisceration no later than 15 days after slaughter.

L

Legal requirement

853/2004 Annex III Section II Slaughter Hygiene: Chapter IV point 5

D12. ... dressing must be carried out without undue delay in such a way that contamination of the meat is avoided.

D12. Compliance regarding dressing

- Carry out dressing without delay and in such a way as to prevent contamination of the meat.

D12. Good practice

Harvesting of heads, feet and offal – staff involved in these operations should not touch carcasses without first washing their hands as well as washing and disinfecting equipment frequently. Any containers used must have been cleaned and disinfected before use and be removed from the room when full.

Feet – when harvested for human consumption feet must be inspected. This means that feet must be reconciled with carcasses passed as fit for human consumption. A batching system is acceptable provided that in the case of post-mortem rejection the entire batch of feet is rejected.

Trimming – trimming of minor blemishes such as bruising is discretionary; preferably to be completed after evisceration to minimise the risk of contamination of exposed meat. Removal of more significant quantities of meat is usually impracticable with high line speeds, and in these cases an adjacent trimming area should be provided.

Dropped meat policy – have procedures to deal with carcasses or offal that have fallen on the floor. This could include the provision of a meat tray off the floor at 'weak points' in the line and trimming affected parts. Trim in-skin poultry carcasses immediately to remove visible contamination before processing is resumed. Pieces that are not suitable for trimming should be disposed of as animal by-products, in accordance with Regulation (EC) 1069/2009 and the Animal By-Products (Enforcement) Regulations 2011.

L

Legal requirement

853/2004 Article 3 point 2

D13. Food business operators shall not use any substance other than potable water - ... - to remove surface contamination from products of animal origin, unless the substance's use has been approved ...

D13. Compliance regarding washing of poultry/lagomorphs

- Use only potable water or EU approved substances for the removal of surface contamination from meat or other products of animal origin. Follow the conditions of use and always follow the manufacturer's instructions.

D13. Good practice

Washing of carcasses can reduce the microbial load, provided the washers are strategically placed. Use only potable water or approved substances – see 'A15.'

OV decisions – note that the OV will declare meat unfit for human consumption if it has been treated illegally with decontaminating substances under 854/2004 Annex I Section II Chapter V (I).

Spray wash internally and externally between different stages of evisceration to minimise the opportunity for bacterial attachment. Ensure that spray is minimised during washing and the waste water is ducted into drains to minimise cross contamination.

Potable water flumes may convey offal; water used to transport offal should not enter the offal washer.

Carcasses to be subjected to immersion chilling should be effectively washed prior to immersion.

L

Legal requirement

853/2004 Annex III Section II Slaughter Hygiene: Chapter IV points 8, 9(a) and 9(b)

D14. After inspection and evisceration, slaughtered animals must be cleaned and chilled to not more 4 °C as soon as possible, unless the meat is cut while warm.

852/2004 Annex II Foodstuffs: Chapter IX point 5

D15. ... finished products likely to support the reproduction of pathogenic micro-organisms or the formation of toxins are not to be kept at temperatures that might result in a risk to health. The cold chain is not to be interrupted. However, limited periods outside temperature control are permitted, to accommodate the practicalities of handling during preparation, transport, storage, display and service of food, provided that it does not result in a risk to health.

D14. and D15. Compliance regarding cleaning and chilling of white meat

- Clean and chill carcasses to not more than 4 °C as soon as possible after post inspection, unless the meat is cut while warm.
- The cold chain is not to be interrupted.

D14. and D15. Good practice

Cleaning – see ‘A17.’.

Trussing – may take place before chilling as long as it does not significantly delay the cooling of the meat.

Chilling – after inspection carcasses may be cut above 4°C, but meat must be chilled down to 4°C or below as soon as possible and before subsequent storage and transport from co-located cutting rooms. The cold chain is not to be interrupted except in limited circumstances, for example, while transferring food short distances. Include the procedures for maintaining the cold chain, checking and recording temperatures of the meat, and taking corrective actions if procedures fail in the HACCP plan – see chapter 10 on ‘Temperature controls’.

The EU poultry meat marketing standards regulations (see ‘12.4. EC poultry meat marketing standards regulations’) specify the methods of chilling and their corresponding terms which may appear on poultry meat labelling as ‘air chilling’, ‘air spray chilling’ and ‘immersion chilling’. They also provide for poultry to be marketed in one of the following conditions:

- fresh – not stiffened by the cooling process, and kept at a temperature not below -2°C and not higher than 4°C
- frozen – frozen as soon as possible and kept at a temperature no higher than -12°C
- quick-frozen – kept at a temperature no higher than -18° C at any time within the tolerances as provided for in Directive 89/108/EEC relating to quick-frozen foodstuffs for human consumption

L

Legal requirement

853/2004 Annex III Section II Slaughter Hygiene: Chapter IV points 8, 9(a) and 9(b)

D16. When carcasses are subject to an immersion chilling process, account must be taken of the following:

- (a) Every precaution must be taken to avoid contamination of carcasses, taking into account parameters such as carcass weight, water temperature, volume and direction of water flow and chilling time.
- (b) Equipment must be entirely emptied, cleaned and disinfected whenever this is necessary and at least once a day.

D16. Compliance regarding immersion chilling

- During immersion chilling, take every precaution to avoid contamination of carcasses, taking into account parameters such as carcass weight, water temperature, volume and direction of water flow and chilling time.
- Empty, clean and disinfect equipment is entirely emptied, whenever this is necessary and at least once a day.

D16. Good practice

Immersion chilling lowers the temperature of poultry carcasses. But it is considered inappropriate for carcasses that are subject to delayed/partial evisceration.

It is recommended that carcasses for immersion chilling should be effectively washed both inside and out by spraying prior to immersion. The water or ice and water should be continuously renewed at an adequate rate with carcasses moving in the opposite direction to the flow of water. Carcasses should not remain in the equipment for longer than is strictly necessary.

Potable water – see chapter 3 on 'Water supply'.

Cleaning – immersion chilling equipment must be entirely emptied, cleaned and disinfected whenever necessary and at least once a day to prevent the build up of microbiological contaminants.

Operators using immersion chilling to reduce carcass temperature may determine their own parameters but must avoid contamination of carcasses. The following advice is taken from previous legislation.

Process – after an initial carcass spray to wash both the internal and external surfaces, pass carcasses through one or more tanks of potable water or of ice and water (the contents of which is continuously renewed) using a system that propels carcasses through a counterflow of water.

Where there are several tanks, regulate the inflow of fresh water and the outflow of used water so it decreases progressively in the direction of carcass movement, with the fresh water being divided

between the tanks.

Parameters – for carcass spraying use the following quantities of water for carcasses weighing:

- below 2.5 kg, at least 1.5 litres
- between 2.5 kg and 5 kg, at least 2.5 litres
- above 5 kg, at least 3.5 litres

For immersion chilling use a minimum water flow for carcasses weighing:

- below 2.5 kg, 2.5 litres per carcass
- between 2.5 kg and 5 kg, 4 litres per carcass
- above 5 kg, 6 litres per carcass

Water temperature at the points of entry and exit of the carcasses:

- + 16 °C and + 4 °C respectively, the aim is for carcasses to reach 4 °C as soon as possible.

Chilling time – avoid keeping carcasses in the first tank longer than 30 minutes (or 40 minutes for poultry slaughtered by the Jewish method) and in other tanks for longer than is strictly necessary.

Monitoring – use calibrated control equipment to measure and record:

- (i) water consumption during spray washing
- (ii) water temperature in each tank at carcass entry and exit points
- (iii) water consumption during immersion
- (iv) the number of carcasses in each of the weight-ranges above

Evaluate the correct functioning of the chillers by monitoring results of periodic microbiological tests on contamination of the carcasses with total bacteria and enterobacteria before and after immersion.

Records – keep the results of these checks.

L

Legal requirement

853/2004 Annex III Section II Chapter VII added by Implementing Measure 2074/2005 Annex VII 2(b)

D17. FBOs shall ensure that poultry meat that has been treated specifically to promote water retention is not placed on the market as fresh meat but as meat preparations or used for the production of processed products.

D17. Compliance regarding water retention agents

- Do not market poultry meat that has been treated specifically to promote water retention as 'fresh' meat.

D17. Good practice

Meat which has been treated in such a way can be marketed as a meat preparation or used for the production of processed products.

L

Legal requirement

Poultry Meat Marketing Standards Regulations

D18. Water content of 'frozen' and 'quick-frozen' whole chickens must not exceed stated values for marketing in the EU.

D18. Compliance regarding water content

- Water content of 'frozen' and 'quick-frozen' whole chickens must not exceed stated values for marketing in the EU.

D18. Good practice

The EU Poultry Meat Marketing Standards Regulations (see '12.4. EC poultry meat marketing standards regulations') requires that frozen and quick-frozen whole chickens may only be marketed within the EU if the water content does not exceed technically unavoidable values (Art.14A(1)).

Measures must be adopted to ensure that the product from each establishment does not contain excessive water, in particular that:

- samples for monitoring water absorption during chilling and water content of frozen and quick frozen chickens are taken at least once every four working hours (Art.14A(3))
- results of the checks are recorded and kept for a period of one year and
- each batch is marked in a way that its date of production can be identified; this batch mark must appear on the production record (Art.14A(2))

See chapter 14 on 'Cutting of meat' for further information.

12.6. Official control requirements

L

Legal requirement

854/2004 Article 4 points 4c and 4h

Audits by officials of good hygiene practices shall verify that meat plant operators apply pre-operational, operational and post-operational hygiene procedures, temperature controls and controls on food entering and leaving the establishment and any accompanying documentation, continuously and properly.

854/2004 Article 4 point 5

Audits by officials of HACCP-based procedures shall verify that meat plant operators apply such procedures continuously and properly.

854/2004 Article 5 point 1

The official veterinarian shall carry out inspection tasks in slaughterhouses, game handling establishments and cutting plants placing fresh meat on the market in accordance with the general requirements of Section I, Chapter II, of Annex I, and with the specific requirements of Section IV.

12.7. Applying procedures continuously and properly

L

Legal requirement

852/2004 Article 1 point 1(a)

The operator is responsible for food safety in the food business.

852/2004 Article 5 point 1

Food business operators shall put in place, implement and maintain a permanent procedure or procedures based on the HACCP principles.

178/2002 Article 17

Food ... business operators at all stages of production, processing, and distribution within the businesses under their control shall ensure that foods ... satisfy the requirements of food law which are relevant to their activities and shall verify that such requirements are met.

12.7. Compliance regarding operator responsibilities for carcase dressing

- Operator responsibility includes applying and verifying the company's hygienic meat production procedures and taking corrective action if those procedures fail.
- Implement and maintain a permanent procedure or procedures based on the HACCP principles.

12.7. Good practice

Operator responsibility includes maintaining and monitoring hygienic meat production procedures and taking corrective action if there is a failure. These procedures should be based on HACCP principles – see 'A18.' and chapter 9 on 'HACCP principles'.

Delegation – responsibility for maintaining and monitoring of hygienic dressing procedures may be delegated to a nominated person to whom problems are reported, and who has sufficient authority to ensure that corrective action is taken when necessary.

Monitoring – check and record on a daily basis that staff are following the company procedures for slaughter, dressing, chilling, cutting and processing, for example:

- cleanliness of food handling areas, storage and transport, immersion chillers if used
- meat handling procedures, including adequate tool cleaning and disinfection
- meat temperatures in workrooms, storerooms, vehicles
- effectiveness of heat treatment, if used
- adequacy of personal hygiene practices
- microbiological testing, if carried out

Records – keep an accurate, dated account (for example, in a 'Food safety management diary/daybook') of each monitoring check observation, of issues requiring special attention, and of any corrective action taken.

Corrective action – take action when failures of the company production procedures are identified. Such action may include:

- dealing with any product that has been contaminated
- dealing with equipment failures
- establishing the underlying cause and what needs to be done to prevent similar incidents in the future
- improving staff instructions and training

Annex 1. Specimen form for large wild game declaration

FRONT

LARGE WILD GAME DECLARATION				
Tag Number:	Species:	ROE	FALLOW	RED
Date/Time of Kill:/.....		MUNTJAC	SIKA	CHINESE
Location/Estate:		OTHER.....		
Sex: M F	Weight:	(KGs)		

BACK

I declare in accordance with EU Regulation 853/2004 that no abnormal behaviour was observed before killing and there is no indication of environmental contamination. I have inspected the head, pluck and viscera without observing abnormalities.	
Notes:	
Trained person qualification:	Contact details
Name:
Signature:

Annex 2. Specimen form for submitting information on small wild game

SMALL WILD GAME INFORMATION	
Date/Time of Kill:	Location/Estate:
Number in batch:	Species: Pheasant Partridge Pigeon Hare Other
Observations:	
.....	
Trained person qualification:	Contact details
Name:
Signature:

Annex 3. Specimen form for information on several large wild game sent to a single game handling establishment

FRONT

LARGE WILD GAME INFORMATION			
Tag Number:.....	Species: ROE	FALLOW	RED
Date/Time of Kill:...../	MUNTJAC	SIKA	CHINESE
Location/Estate:.....	OTHER.....		
Number of animals:.....			
Identification number of each animal:.....			

BACK

I declare in accordance with EU Regulation 853/2004 that no abnormal behaviour was observed before killing and there is no indication of environmental contamination. I have inspected the heads, pluck and viscera without observing abnormalities or trichinella infestation*.	
In the case of game trophies, heads of animals from trichinella infestation to be sent to:	
Name & Address of Approved Technical Plant:	
.....	
Notes:.....	
Trained Person qualification:.....	Contact Details:.....
Name:.....

Annex 4. Health certificate for the trade of unskinned large wild game

FRONT

EUROPEAN UNION				Intra trade certificate							
Part I: Details of consignment presented	I.1. Consignor Name Address Country				I.2. Certificate reference No		I.2.a. Local reference No				
					I.3. Central competent authority						
					I.4. Local competent authority						
	I.5. Consignee Name Address Country				/						
	I.8. Country of origin		ISO code	I.9. Region of origin	Code	I.10. Country of destination		ISO code	I.11. Region of destination	Code	
	I.12. Place of origin Establishment <input type="checkbox"/> Name Approval Address Postal code/Region				I.13. Place of destination Establishment <input type="checkbox"/> Name Approval number Address Postal code/Region						
					I.15. Date and time of departure						
	I.16. Means of transport Aeroplane <input type="checkbox"/> Ship <input type="checkbox"/> Railway wagon <input type="checkbox"/> Road vehicle <input type="checkbox"/> Other <input type="checkbox"/> Identification: Number(s):				/						
	I.18. Description of commodity								I.19. Commodity code (CN code)		
				I.20. Quantity							
I.21. Temperature of products Ambient <input type="checkbox"/> Chilled <input type="checkbox"/>				I.22. Number of packages							
				I.24. Type of packaging							
I.25. Commodities certified for: Human consumption <input type="checkbox"/>											
/				I.27. Transit through Member States <input type="checkbox"/>							
				Member State		ISO code		Member State		ISO code	
/				Member State		ISO code		Member State		ISO code	
I.31. Identification of the commodities											
Species (Scientific name)		Identification marking		Quantity							

BACK

EUROPEAN UNION		Unskinned large wild game									
II.	Health information	II.a.	Certificate reference number								
		II.b.	Local reference number								
Part II: Certification	<p>I, the undersigned, hereby certify, that:</p> <ul style="list-style-type: none"> — All the relevant parts of the bodies of the animals and the declaration satisfied the requirements laid down in point 4, Chapter II, Section IV, Annex III to Regulation (EC) No 853/2004. — The large wild game has not been harvested in an area which for health reasons is subject to prohibition or restriction affecting the species involved in accordance with Union or national legislation. 										
	<p>Notes</p> <p>Part I:</p> <ul style="list-style-type: none"> — Box reference 1.12: Give a registration number or any other identification number. If not applicable, put 'XXX'. — Box reference 1.13: indicate the details of the game-handling establishment. — Box reference 1.19: Use the appropriate CN code amongst 0203 11 90, 0203 21 90, 0208 90 30, 0208 90 60 and 0208 90 98. — Box reference 1.2: the certification for human consumption is subject to a favourable official inspection at the game handling establishment. <p>Part II:</p> <p>The colour of the signature and stamp shall be different to that of the printing.</p>										
<p>Official veterinarian</p> <table border="0" style="width: 100%;"> <tr> <td style="width: 50%;">Name (in Capital):</td> <td style="width: 50%;">Qualification and title:</td> </tr> <tr> <td>Local Veterinary Unit:</td> <td>LVU no.:</td> </tr> <tr> <td>Date:</td> <td>Signature:</td> </tr> <tr> <td>Stamp:</td> <td></td> </tr> </table>				Name (in Capital):	Qualification and title:	Local Veterinary Unit:	LVU no.:	Date:	Signature:	Stamp:	
Name (in Capital):	Qualification and title:										
Local Veterinary Unit:	LVU no.:										
Date:	Signature:										
Stamp:											