Saskatchewan's Domestic Meat Inspection Standard

Saskatchewan

PREAMBLE

The requirements of this standard were developed in cooperation with domestic establishment operators licensed under *The Animal Production Regulations,* the Saskatchewan Food Industry Development Centre Inc. and the Saskatchewan Ministry of Agriculture.

In an effort to ensure this standard is accurate and reflects its purpose, joint meetings are held between the above listed parties to review and continually improve the requirements in this standard on an as-needed basis.

The Saskatchewan Domestic Meat Inspection Program is a voluntary program and applies to operator owned premises that are accepted and licensed by the minister.

Anyone considering establishing, constructing, extending, renovating, altering or operating a domestic establishment should be aware that in addition to the requirements of *The Food Safety Regulations* and these standards, approvals from other ministries, agencies and/or local municipalities may also be required.

The Saskatchewan Ministry of Agriculture has agreed to assist other regulatory bodies by gathering, recording and sharing information.

PURPOSE

These standards have been developed to assist operators to meet the regulatory requirements contained in *The Animal Production Regulations*. In addition, the standards are used by inspectors as a means of verifying adherence to the regulations. As such, these standards should be read in conjunction with *The Animal Production Regulations.*

It is expected that all domestic establishments be constructed and operated in accordance with these standards and in compliance with *The Animal Production Regulations.* Alternatives to the standards will be considered where the operator can demonstrate equivalency to the prescribed requirements.

APPLICATION

Persons who intend to participate in the Domestic Meat Inspection Program are required to apply with the following information as a minimum:

a. their legal address;
b. A complete set of drawings and specifications, including:
    i. a site plan with a compass north point;
    ii. the flow of operations from animal receiving through to the shipping and/or retail area;
    iii. the purpose of each room or area to be used;
    iv. the equipment layout in relation to product flow;

   v. the location of hand wash stations throughout the establishment; and
   vi. the location of hose bibs for cleaning floors, walls, etc.
c. construction material details for floors, walls, ceilings and work surfaces such as counters;
d. details regarding the potable water supply;
e. methods of Specified Risk Material (SRM) waste removal;
f. the species of animals to be slaughtered and the maximum number of animals to be slaughtered per day during the licence period;
g. the days of the week and anticipated hours of operation during which slaughter will take place;
h. meat products to be processed and the type of meat products anticipated to be processed; and
i. details regarding other activities such as pet product manufacturing or wild game processing.

To apply, please contact:

Phone:	306-787-2150
Fax:	306-798-0096
E-mail:	chris.smith@gov.sk.ca
Mail:	Saskatchewan Ministry of Agriculture Livestock Branch – Domestic Meat Inspection Program 202-3085 Albert Street Regina, SK S4S 0B1

The minister may request other information that the minister may reasonably require to determine whether to issue a licence or to determine the terms and conditions to be set out in the licence if applicable.

Within 30 days after receiving an application for a licence and the information that the minister has required, the minister may:

1. Issue the licence: If the minister is satisfied that the person applying for the licence has complied with *The Animal Production Act and Regulations* and that it is appropriate to issue the licence; or
2. Refuse to issue the licence: A written notice regarding this decision and the reasons for the decision will be provided to the person applying as soon as possible after making the decision.

For those persons who would like to licence more than one premises, a separate application is required per premises.

Prior to constructing, extending, renovating or making modifications to a premises or operations which result in changes to information provided in the licence application the

changes must be reported, in writing, to the Ministry of Agriculture for pre-approval and licence amendment.

Contents

A. Premises

A.1 Outside Property

1. The facility is located away from or protected against potential sources of external contaminants that may affect the hygienic operation of the facility and/or may compromise the safety of meat products, ingredients and packaging materials.
2. The surroundings/roadways are free of debris and refuse, adequately drained and maintained to minimize environmental hazards.

A.2 Lairage

A.2.1 General Lairage Design, Construction and Maintenance

1. Lairage directly attached to the abattoir is adequately separated from where meat products, ingredients and packaging materials are processed, stored or otherwise handled to prevent contaminants from entering those adjacent work rooms.
2. Lairage is designed, constructed and maintained:
    a. so access is controlled by the operator to prevent unauthorized entrance;
    b. to be of adequate capacity to accommodate intended slaughter volumes;
    c. with adequate ventilation to maintain air quality for animals;
    d. to provide animals with adequate protection from environmental extremes;
    e. in a manner conducive to effective cleaning; and
    f. in a manner which would not cause injury to animals.
3. Lairage has a separate area that is capable of accommodating poultry and domestic rabbit crates or that is equipped with pens for:
    a. housing and inspection of animals of each species separate from animals of all other species;
    b. segregation of animals considered to be a danger to other animals;
    c. holding animals that are injured, sick or suspected of being sick or identified as being on hold or condemned.

A.2.2 Red Meat Animal Lairage Design, Construction and Maintenance

1. Red meat animal lairage is designed, constructed and maintained so that:
    a. unloading can be carried out without physical gaps between the transport vehicles and the unloading dock to prevent injury or escape;
    b. floors, ramps, gangways, chutes and pens provide secure footing for animals and prevent injury during movement; and
    c. ramp(s) are at an angle allowing animals to move without injury.

A.2.3 Poultry and Domesticated Rabbit Lairage Design, Construction and Maintenance

1. Poultry and domesticated rabbit lairage is designed, constructed and maintained with provisions for cleaning and sanitizing crates and transport vehicles.

A.3 Building

A.3.1 General Building Design, Construction and Maintenance

1. The building is designed, constructed and maintained:
    a. to ensure secure access to prevent unauthorized entrance;
    b. to prevent leakage from the roof, air intakes, foundation, walls, doors, and/or entry of contaminants and pests;
    c. to prevent contamination of meat products, ingredients and packaging materials with the location of catwalks, mezzanines, stairways and ladders;
    d. to facilitate cleaning by sealing the joints between the floors and walls;
    e. to effectively separate incompatible operations;[1]
    f. to provide hygienic operations by means of a regulated flow from point of entry to the building to the finished product; [1]
    g. to effectively prevent cross-contamination due to flow of:
        i. employees;
        ii. meat products, ingredients and packaging materials;
        iii. waste and inedible; and
        iv. equipment and utensils; [1]
    h. to ensure living quarters are separated from and do not open directly into where meat products, ingredients and packaging materials are processed, stored, or otherwise handled;
    i. with office facilities for the exclusive use of the inspectors and facilities for the protection and storage of the equipment and supplies of inspectors;
    j. to ensure washrooms, lunchrooms and change rooms are separated from and do not open directly into where meat products, ingredients and packaging materials are processed, stored or otherwise handled unless they are equipped with self-closing door devices; [1]
    k. with rooms/areas of sufficient size to accommodate intended activities within;
    l. to provide for the storage of waste and inedible in so separate and adequate facilities are;
    m. to prevent cross-connection between:
        i. the effluent of human wastes and production drainage wastes; and
        ii. potable water lines and non-potable water supply systems;
    n. so non-potable water has a separate and readily identifiable distribution system;
    o. so that the sewage and waste effluent systems are routed or controlled in such a manner which would not cause contamination in the event of leakage;

[1] If the building is not designed to effectively separate incompatible operations and/or to prevent cross-contamination, operational procedures to control cross-contamination must be in place.

p. so that drainage and sewage systems are equipped with functional traps and vents;
q. so that floors permit liquids to drain to outlets or procedures are in place to prevent pooling of liquids;
r. so that rooms and areas are equipped with adequate hose connections necessary for sanitation and processing activities carried out therein and are protected against back-flow or back siphonage;
s. so that floors, walls, doors, windows, ceilings, overheads and other structures are: light in colour to facilitate cleaning, smooth, easy to clean, impervious, prevent contamination, prohibit deterioration, are suitable for the activities in each area and are free from any noxious constituents;
t. so that rail heights are high enough to prevent contamination of suspended carcasses.

Minimum recommended rail heights are:

Species	Bleeding Rail	Dressing Rail	Cooler Rails
Cattle/bison/elk	3.7 m (12.1 ft)	3.1 m (10.1 ft)	3.1 m (10.1 ft)
Calves	2.7 m (8.9 ft)	2.4 m (7.9 ft)	2.4 m (7.9 ft)
Horses	4.3 m (14.1 ft)	3.4 m (11.2 ft)	3.4 m (11.2 ft)
Sheep & Goat	2.4 m (7.9 ft)	2.0 m (6.6 ft)	2.0 m (6.6 ft)
Swine	3.1 m (10.1 ft)	2.6 m (8.5 ft)	2.4 m (7.9 ft) *
* When heads are not removed from dressed carcasses 2.7 m (8.9 ft) distance is recommended.			

u. with rails and rail support systems which do not cause contamination, can be easily cleaned and are free from any noxious constituents.

2. Only food grade lubricants are applied to overhead rail systems.

A.3.2 Lighting

1. Lighting is appropriate such that food colour is not altered and the intended production or inspection activity can be effectively conducted. Lighting shall be at a minimum, at the working height:
    a. 110 lux in storage areas;
    b. 220 lux in production areas;
    c. 220 lux in ante-mortem inspection stations; and
    d. 540 lux at post-mortem inspection stations.
2. Light bulbs and fixtures in areas where there are meat products, ingredients and packaging materials are of a safety type or are protected to prevent contamination in case of breakage.

A.3.3 Ventilation

1. Ventilation provides sufficient air exchanges to prevent unacceptable accumulations of steam, condensation or dust and to remove contaminated air. If equipped, filters are cleaned or replaced as appropriate.

2. Ventilation systems ensure that air flows from the least contaminated areas to the most contaminated areas or physical barriers and/or time separation procedures are in place to prevent contamination.

A.3.4 Slaughter Room

1. The slaughter room is a designated room.
2. The knocking box is suitable for handling animals of the species and size to be slaughtered and designed and operated on to prevent unnecessary injury to animals.
3. Bleeding areas are covered, steeply graded to drain(s) or operational procedures are in place to restrict blood to that area.

A.3.5 Inedible Room

1. Where inedible materials are stored at the establishment, there is a designated inedible room that:
    a. is of a size that can accommodate the intended volume of inedible materials without delay or backlog, and without posing a biological risk to meat products, ingredients and packaging materials or sources of contamination to the remaining areas of the building;
    b. is equipped with adequate ventilation to prevent objectionable odours from entering all other areas of the building; and
    c. has a separate loading dock for removal of inedible material.
2. The inedible room is equipped with refrigeration where inedible material (with the exception of salted hides) is to be regularly stored for periods longer than 24 hours.

A.4 Sanitary Facilities

A.4.1 Employee Facilities

1. Washrooms have hand wash stations with hot and cold or warm potable running water, soap dispensers, soap, sanitary hand drying equipment or supplies and cleanable waste receptacles.
2. Hand washing notices are posted.

A.4.2 Handwashing Stations and Sanitizing Installations

1. Handwashing stations, for the sole purposes of hand washing, are operated hands-free and are in sufficient number to maintain sanitary conditions, given the number of employees and nature of the anticipated activities and are situated in locations that are readily accessible to maintain such conditions.
2. Handwashing stations are directly drained except for the slaughter room as long as food safety is not compromised as a result.
3. Handwashing stations are maintained and are provided with hot and cold or warm potable running water, soap dispensers, soap, sanitary hand drying equipment or supplies and cleanable waste receptacles.

4. Sanitizing installations (such as knife sanitizers and boot dips) for operational equipment and utensils with potable water at 82°C (180°F) or higher or manufacturer-specified chemical concentrations are accessible in areas where there are contamination risks.

A.5 Water and Ice Quality, Protection and Supply

A.5.1 Water and Ice Supply Requirements

1. Water and ice meet the following standards:
    a. Total coliform bacteria = zero per 100 mL
    b. E. coli bacteria = zero per 100 mL
    c. Nitrate = less than 45 mg/L.
2. Hoses and taps are designed to prevent back-flow or back siphonage.
3. Filters are kept effective and maintained in a sanitary manner.
4. The volume, temperature and pressure of the potable water/steam are adequate for all operational, hygienic and sanitation demands.
5. Water or ice storage facilities are adequately designed, constructed and maintained to prevent contamination.

A.5.2 Water and Ice Testing and Record Requirements

1. Testing is done by an accredited laboratory.
2. Sample collection and submission is conducted as per laboratory directions.
3. Test results are reported to the inspection body.
4. Water sampling location varies between tests to ensure the entire system is monitored.
5. Temporary water is sampled from a location subsequent to the holding tank.
6. Laboratory analysis includes coliform and E. coli bacterial counts and nitrate chemical composition.
7. Water potability testing is done as per the applicable source and frequency category:[2]
    a. Private water sources (e.g. wells, dugouts, etc.):
        i. standard frequency: once each calendar month; or
        ii. reduced frequency: at such a time that 12 consecutive months of potable test results are achieved, testing frequency can be reduced to quarterly. Quarterly frequency can remain in effect as long as water remains potable.
    b. Municipal water sources: once per calendar year.
    c. Temporary water sources: first load of each different source during every such occurrence.
8. Water potability testing is conducted after boil water advisories have been withdrawn.

[2] Saskatchewan Ministry of Agriculture reserves the right to alter required testing frequency and analysis parameters at their discretion. This can include, but is not limited to, increasing or decreasing required testing frequency and altering lab analysis parameters.

9. Water potability testing is conducted immediately after making alterations which may result in system contamination (ex. treatment system installation/maintenance; well pump replacement; changing/rerouting/adding piping).
10. Ice potability testing is done at least once per year for each in-house source.[2]
11. Records of analysis include:
    a. laboratory name;
    b. water or ice source;
    c. sampling location (test site);
    d. sampling date; and
    e. results.
12. Records are kept on file for at least 5 years from the sampling date.

A.5.3 Non-Potable Water Deviation Procedures

1. Where results indicate water to be non-potable the inspection body is immediately notified.
2. Where any result indicates between one to nine coliforms:
    a. retesting to confirm initial non-potable results is conducted immediately from the same source and prior to any system changes or corrective actions (i.e. before cleaning, disinfection);
    b. where non-potable water results are confirmed via the retest, appropriate corrective action must be taken and subsequent sample results confirming potability are required.
    c. Where water retest results indicate water is potable, no corrective action is required, and initial results are attributed to sample error.
3. Where any result indicates presence of 10 or more coliform; and/or any number of E. coli; and/or 45 mg/L or more nitrates:
    a. operations cease;
    b. all product must remain under operator control;
    c. retesting to confirm initial non-potable results is conducted immediately from the same source and prior to any system changes or corrective actions (i.e. before cleaning, disinfection);
    d. where non-potable water results are confirmed via the retest:
        i. operations remain stopped and a food safety analysis is conducted on affected product; and
        ii. cause of contamination must be determined, appropriate corrective action taken and subsequent sample results confirming potability are required. Operations resume once approval is granted by the appropriate government body (i.e. Ministry of Agriculture, CFIA, etc.);
    e. where water retest results indicate water is potable, product under operator control can be released and regular operations may resume.

A.5.4 Non-Potable Ice Deviation Procedures

1. Ice made at the source since the last satisfactory test results is discarded. The operator may purchase ice that meets potability criteria until the issue is resolved.
2. An investigation to determine cause of contamination is conducted and corrective action taken to eliminate recurrence.
3. Newly made ice is submitted for testing. The new ice must meet potable water specifications before it can be used.

B. TRANSPORT, SHIPPING, RECEIVING AND STORAGE

B.1 Food carriers

1. Food carriers are designed, constructed, maintained and cleaned to prevent contamination, damage and deterioration of food and packaging material.
2. Food carriers are equipped to maintain product that requires refrigeration in a refrigerated or frozen state unless transit is less than two hours.

B.2 Shipping and Receiving

1. Loading and unloading is conducted in a manner that prevents:
    a. outside contaminants from entering the building or food carrier; and
    b. damage, deterioration or contamination of any meat product, ingredient and packaging materials.
2. Returned, defective or suspect meat products are clearly identified and isolated, where it is assessed to determine the appropriate disposition.
3. Only properly labelled/identified meat products, ingredients, packaging materials and non-food chemicals are received into the building.
4. Incoming meat products, ingredients, packaging materials and non-food chemicals are assessed at receiving to ensure that their conditions are satisfactory and ensure food safety.
5. Shipping and receiving rooms are refrigerated where products are not immediately transferred for distribution or refrigeration.

B.3 Storage

1. Meat products, ingredients and packaging materials are handled and stored in a manner to prevent damage, deterioration and contamination.
2. Non-food chemicals are stored in correctly labelled containers and in a manner that prevents contamination of meat products, ingredients, packaging materials or food contact surfaces.
3. Shelving units are of sufficient design to allow for easy cleaning of the floor and to allow for inspection beneath.
4. Cooler temperatures are maintained at 4°C (39°F) or lower with the exception of:
    a. the drip cooler where temperatures may temporarily exceed 4°C (39°F) after the introduction of warm carcasses; and

   b. the inedible cooler, which is maintained at 10°C (50°F) or lower if contents are stored for more than 24 hours.
5. Freezer temperatures are maintained at -18°C (0°F) or lower.
6. Meat products, ingredients and packaging materials are not in direct contact with the floor.
7. Ingredients are stored in labelled, closed containers.

C. EQUIPMENT DESIGN, CONSTRUCTION, INSTALLATION AND MAINTENANCE

1. Equipment is designed, constructed, installed and maintained so that:
   a. it is capable of delivering the requirements of the process and the sanitation practices;
   b. it is accessible for cleaning, sanitizing, maintenance and inspection and can be disassembled for those purposes;
   c. contamination of the meat products, ingredients, packaging materials and food contact surfaces is prevented during operations;
   d. if required, it permits proper drainage to prevent contamination;
   e. it is smooth, non-corrosive or maintained in a manner that prevent corrosion, non-absorbent, non-toxic, free from pitting, cracks and crevices where there are food contact surfaces; and
   f. it is, where necessary, exhausted to the outside to prevent condensation.
2. Utensils are constructed of non-wood, non-toxic materials, do not present a hazard that could contaminate meat products, ingredients and packaging materials and are easy to clean and sanitize.
3. Compressed air which directly contacts meat products, ingredients and packaging materials or food contact surfaces must be effectively filtered.

D. PERSONNEL

D.1 Training of Personnel

1. All personnel:
   a. receive appropriate training on hygiene and on the process and tasks for which they are responsible; and
   b. are qualified to perform their duties.
2. Training is delivered at the start of employment, whenever changes are made and reinforced at appropriate intervals.

D.2 General Hygiene Procedures

1. Every person who engages in the preparation, packaging, labelling, storing or other handling of a meat product, ingredient or packaging material:
   a. observes high standards of personal cleanliness and hygiene;
   b. cleans their hands:
      i. before engaging in the activity and as frequently as necessary during the activity; and

        ii. when leaving an area where a meat product or ingredient is being prepared, packaged, labelled, stored or otherwise handled, before returning to that area; and
    c. keeps their protective clothing, including waterproof clothing, in a sound, clean and sanitary condition.
2. Every person who uses gloves when handling meat products, ingredients or packaging materials:
    a. thoroughly washes their hands before putting on gloves and before changing into a new pair;
    b. changes or washes gloves as soon as they become soiled or torn and before commencing a different task; and
    c. stores and handles gloves in a manner that minimizes contamination.
3. Every person who engages in the preparation, packaging, labelling, storing or other handling of a meat product, ingredient or packaging material, or who works in any area with food contact surfaces, adheres to hygienic practices while on duty to prevent contamination and the creation of unsanitary conditions.
4. Every person who enters or is in any area where there is a meat product, ingredient or packaging material wears clothing and footwear that are sound, clean and in a sanitary condition.
5. Every person who enters or is in any area where a meat product, ingredient or packaging material is exposed wears an appropriate clean hair covering and, if appropriate, a beard and mustache covering.
6. Every person who enters or is in any area where a meat product, ingredient or packaging material is prepared, packaged, labelled, stored or otherwise handled refrains from spitting, chewing gum, smoking or consuming tobacco products or consuming food or drink.
7. Persons engaged in the preparation or packaging of a meat product, ingredient or packaging material do not wear objects or use substances if the object or substance may fall into or otherwise contaminate the meat product, ingredient or packaging material unless sufficiently protected.
8. Personal effects are not stored where a meat product, ingredient or packaging material is prepared, packaged, labelled, stored or otherwise handled.
9. Visitors and contractors follow all general hygiene procedures.

D.3 Personnel Health Status

1. No person who is suffering from or is a known carrier of a communicable disease or who has an open or infected lesion works in any area where there is a danger of contaminating a meat product, ingredient or packaging material or a food contact surface with pathogenic microorganisms.

2. Any person who has or appears to have symptoms of a disease or illness that could be transmitted through a meat product shall report the symptoms, disease or illness to the operator and the operator determines whether the person should undergo a medical examination or be excluded from certain areas of the premises.
3. No person with open cuts or wounds handles meat products, ingredients, packaging materials or food contact surfaces unless the injury is completely protected by a secure waterproof covering.

E. SANITATION

1. The facility, equipment, utensils, work gear, food carriers and all other areas are maintained in a sanitary condition.
2. Equipment, utensils and food contact surfaces utilized for poultry and red meat are cleaned and sanitized before changing over from poultry to red meat.
3. Sanitary conditions are maintained during operations.
4. Cloths, for the sole purpose for wiping food contact surfaces, are immersed in a sanitizing solution before each use. The sanitizing solution is changed frequently to ensure it remains effective.
5. Sanitation is conducted at a frequency which maintains sanitary conditions.
6. Sanitation of equipment follows manufacturer recommendations or a cleaning procedure which is deemed equivalent.
7. Application of sanitation chemicals is done according to manufacturer recommendations.
8. Water used for sanitizing purposes is maintained at 82°C (180°F).
9. Contamination of meat products, ingredients and packaging material is prevented during sanitation.
10. Equipment, utensils, work gear and rooms are visually checked for cleanliness by the operator and re-cleaned, if necessary, prior to beginning production or use.
11. Inedible equipment and utensils which remain in the inedible area are cleaned and sanitized at a frequency which minimizes risk of contamination and stops odours from entering other areas.
12. Inedible equipment and utensils utilized in processing areas shall be thoroughly cleaned and sanitized after each production day.
13. Every crate and transport carrier that has been used to transport poultry or domesticated rabbits for slaughter are cleaned and sanitized thoroughly before leaving the premises.

F. WASTE, SEWAGE AND INEDIBLE HANDLING AND DISPOSAL

1. Hazards associated with waste, sewage and inedible are controlled to maintain food safety.
2. There is an identification system in place for equipment and utensils used for the collection and holding of waste and inedible.
3. Waste and inedible containers are cleanable, durable and leak-proof.
4. Waste and inedible containers located outside the building are equipped with covers which are kept closed.

5. Inedible that is stored within the facility for more than 24 hours is kept at 10°C (50°F) or lower.
6. SRM is handled and disposed of as per federal requirements and according to Appendix A: Specified Risk Material.
7. Waste and inedible is handled and disposed of at a frequency that minimizes risk of contamination and unsanitary conditions.

G. PEST CONTROL

1. There is a person, or company, assigned responsibility for pest control.
2. Pest control activities and their frequency maintains a pest-free environment.
3. Pest control activities do not pose a food safety risk.
4. Pest control devices do not pose a food safety risk.
5. Pest control chemicals are:
    a. approved for use in a food manufacturing facility.
    b. used according to manufacturer's directions; and
    c. used in a manner as to not contaminate meat products, ingredients, packaging materials or food contact surfaces.

H. MANUFACTURING AND RECALL

1. Meat product manufacturing processes are designed to ensure food safety.
2. Only safe, wholesome ingredients are used in the manufacturing of meat products.
3. Packaging material is food grade and of the type that can protect the product from contamination in the conditions under which it will be normally stored, transported, sold or otherwise handled.
4. Ambient air, compressed air or gases utilized in processing equipment that contact product or packaging does not contaminate meat product or packaging.
5. Food additives are approved by the *Food and Drugs Act (Canada)*.
6. Nitrate/Nitrite and phosphate levels do not fall outside limits set out in the *Food and Drugs Act (Canada)*.
7. Process, product and equipment/utensil flow does not cause cross-contamination or food safety risk.
8. Incompatible operations are adequately separated so as not to cause food safety risk.
9. There is an accurate written formula for each meat product processed which contains information identifying the specific ingredients.
10. Thawing is performed in air or water and conditions are controlled to ensure meat surface temperature does not exceed 4°C (39°F) for longer than two hours.
11. When thawing raw meat or poultry, contamination of other products is prevented.
12. Dry ingredients are mixed or measured in a separate room or in a designated area to prevent damage, deterioration or contamination of left-over ingredients or nearby meat products.
13. Allergens are controlled by:
    a. production sequencing to ensure allergen carry-over does not result in undeclared allergens in subsequent meat product;

   b. cleaning and sanitizing between meat products containing different allergens or when moving from allergen-containing to allergen-free meat products;
   c. ensuring ingredient preparation procedures do not result in contamination with undeclared allergens; and
   d. using rework in a manner which does not result in contamination of meat products with undeclared allergens.
14. Fully cooked red meat products are heated to an internal temperature of 71°C (160°F) or another acceptable time-temperature combination is reached.
15. Fully cooked poultry products are heated to an internal temperature of 74°C (165°F) or another acceptable time-temperature combination is reached.
16. Shelf-stable meat products have a minimum of 100 ppm nitrite/nitrate, a minimum of 2.5% salt, are fully cooked and meet one of the following sets of requirements:
   a. the pH of the finished product is of 4.6 or less, regardless to its final water activity (Aw); or
   b. the Aw of the finished product is 0.85 or less, regardless of its final pH; or
   c. the pH is 5.3 or lower and the finished product has an Aw of 0.90 or lower.
17. Cooked products are rapidly and continuously cooled so that internal temperatures reach:
   a. 54°C (129°F) to 27°C (81°F) in 2 hours; and
   b. 27°C (81°F) to 4°C (39°F) in 5 hours.
18. Where processing rooms are not maintained at 10°C (50°F) or lower:
   a. exposure time is under two hours for non-shelf stable meat products;
   b. equipment left idle for greater than two hours is cleaned and sanitized before reuse; and
   c. accumulation of meat and fat on continuously used equipment is removed every four hours.
19. When food safety is compromised or potentially compromised, meat products are identified, isolated and evaluated, and:
   a. should it be determined that the meat products are unsafe for human consumption, the operator:
      i. notifies, the inspector and applicable government officials; and
      ii. initiates a recall of product that was distributed to the public, or to a retail or wholesale food establishment; and
   b. corrective actions are taken to ensure the safety of meat products and to prevent recurrence of the deviation.
20. Records necessary to recall meat products are kept, including:
   a. incoming material;
   b. shipping; and
   c. customer complaints and outcomes.
21. Inspection body approval is arranged prior to making modifications to critical food safety manufacturing steps.
22. Equipment used to measure critical food safety manufacturing steps is accurate and does not cause contamination of meat products.

I. MEAT INSPECTION STAMP, LEGEND AND LABEL

1. The Domestic Meat Inspection stamp is applied:
    a. to carcasses approved for human consumption;
    b. under the supervision of an inspector; and
    c. with edible ink.
2. The Domestic Meat Inspection legend or Domestic Establishment number is applied to retailed product packaging.
3. Product labels declare all contained priority allergens, sulphites and gluten. Priority allergens include:
    a. tree nuts (almonds, Brazil nuts, cashews, hazelnuts, macadamia nuts, pecans, pine nuts, pistachios or walnuts);
    b. peanuts;
    c. sesame seeds;
    d. wheat and triticale;
    e. eggs;
    f. milk;
    g. soybeans;
    h. crustaceans and molluscs;
    i. fish; and
    j. mustard seeds.
4. Labels on packaged meat products include:
    a. name of the manufacturer;
    b. common name of the meat product; and
    c. an accurate list of ingredients.

*__Note__: There are federal labelling requirements that go beyond this program that operators are required to comply with and are not included in inspection under this program.

J. ANTE-MORTEM, STUNNING, SLAUGHTER, CARCASS DRESSING AND POST-MORTEM

J.1 Ante-mortem

1. Animals are handled in a humane manner.
2. When animals arrive at the abattoir, the operator or qualified employee conducts an initial ante-mortem examination of the animal's welfare and suitability for slaughter and appropriate action is taken for animals requiring special handling or immediate euthanasia.
3. Animals are not moved over injured or non-ambulatory animals during unloading or handling.
4. No goad or electrical prod is applied to:
    a. an unhealthy animal; or
    b. the anal, genital or facial region of an animal.
5. Non-stunned, non-ambulatory animals are not moved or caused to be moved.
6. Non-ambulatory animals are euthanized or slaughtered without being moved.

7. Stressed hogs that are trembling, have patchy skin discolouration and have laboured breathing are:
    a. not moved or caused to be moved;
    b. slaughtered immediately in place or left undisturbed for a recovery period of 45 minutes whereupon:
        i. stressed hogs which recover can be moved directly to slaughter; or
        ii. stressed hogs which do not recover are euthanized or slaughtered immediately in place.

*__Note__: Bovine animals that are down and OTM are eligible for BSE sample submission. The animal owner should be notified, and arrangements made for BSE sample submission, through CFIA or a local veterinarian.

8. Animals suspected of a reportable disease(s) are immediately reported to the applicable regulatory authority.
9. Animals are placed in secure and clean pens or crates whichever is applicable.
10. Animals are protected against inclement weather, heat and frostbite.
11. Different species of animals are kept separate from each other.
12. Every animal that is obviously diseased or injured is immediately segregated from apparently healthy animals.
13. Every animal that is a potential danger to other animals is immediately segregated from those other animals.
14. Holding pens/crates used for animals awaiting slaughter are not used in a manner that results in their overcrowding.
15. Animals are not kept longer than the below prescribed times without being provided suitable feed and water. Special weather circumstances, such as hot and humid weather, must be taken into consideration to prevent animal suffering:
    a. Ruminant, horse, ostrich, rhea and emu:
        i. FEED: more than 24 hours
        ii. WATER: more than 24 hours
    b. Swine:
        i. FEED: more than 24 hours
        ii. WATER: more than 12 hours
    c. Poultry and domesticated rabbit:
        i. FEED: more than 18 hours
        ii. WATER: more than 18 hours.
16. No animal is slaughtered unless the animal has been subjected, within 24 hours before the time of slaughter, to an ante-mortem inspection performed by an inspector.
17. No animal is slaughtered unless the slaughter has been authorized by an inspector.
18. On the request of an inspector, an animal is made available to be re-inspected, even if the slaughter of such animal had been authorized; and the operator does not slaughter such animal until re-inspected and re-authorized.

19. If an operator or an inspector suspects that an animal shows a deviation from normal behaviour or appearance, the animal is held for a detailed inspection and instructions regarding its disposition.
20. Animals identified by inspectors to require immediate slaughter for humane consideration proceed to slaughter without delay.
21. Instructions from an inspector that an animal must be condemned or must be placed on hold and segregated from all other animals for rest, treatment or slaughter are complied with.
22. Every animal destined for slaughter that dies by a means other than slaughter is condemned and handled as per inspector instructions.
23. Every condemned animal is segregated and identified as condemned in a manner satisfactory to the inspector.
24. Every animal identified as condemned on ante-mortem is euthanized in lairage or the inedible products area and the carcass of such animal handled as per inspector instructions.
25. The operator ensures that:
    a. every animal designated as suspect by an inspector is segregated and on hold; and
    b. a carcass derived from a suspect is identifiable until completion of post-mortem inspection.
26. No animal identified as being on hold shall be slaughtered without the authorization of an inspector.

J.2 Stunning and Slaughter

1. Animals are handled, stunned and slaughtered in a humane manner.
2. No animal, other than poultry or domesticated rabbit, is suspended for the purpose of slaughter unless, immediately before being suspended, it is rendered unconscious or killed by an approved method.
3. Every animal that is slaughtered is, before being bled:
    a. rendered unconscious in a manner that ensures that it does not regain consciousness before death, by one of the following approved methods:
        i. by delivering a blow to the head by means of a penetrating or non-penetrating mechanical device in a manner that causes immediate loss of consciousness;
        ii. by exposure to a gas or a gas mixture in a manner that causes a rapid loss of consciousness;
        iii. by the application of an electrical current in a manner that causes immediate loss of consciousness; or
        iv. by use of a firearm in a manner that causes immediate loss of consciousness.
4. Rapid decapitation of poultry is not used for routine slaughter but can be used as a back–up method when stunning problems occur.
5. Stunning is not done by manual means, such as delivering a blow to the head with a hammer or similar device.

6. When firearms are used to stun animals, suitable measures are taken to ensure the safety of inspectors during the discharge of the firearm.
7. No equipment for restraining, rendering unconscious or slaughtering any animal is used:
    a. unless the person using the equipment is trained and able to do so without subjecting the animal to avoidable distress or avoidable pain; or
    b. where the design, condition, or method of use of the equipment might subject the animal to avoidable distress or avoidable pain.
8. Back-up stunning equipment is available for immediate use in case primary stunning equipment fails.
9. Animals are assessed for sensibility by the operator and re-stunned, if necessary, before being bled.
10. Stunned animals are discharged from the knocking box in a manner which does not result in contamination.
11. Bleed time between slaughter and dressing is a minimum:
    a. poultry and domesticated rabbit – 90 seconds; and
    b. red-meat animals – 30 seconds.
12. Emergency/alternative slaughter is conducted according to the procedures outlined in Appendix B: Emergency/Alternative Slaughter.

J.3 Slaughter Records

1. The operator maintains records respecting every animal slaughtered that contain the following:
    a. the date the animal was purchased or otherwise acquired;
    b. the name and address of the person from whom the animal was purchased or otherwise acquired;
    c. a description of the animal purchased or acquired from the person mentioned in (b) and the quantity purchased or acquired;
    d. the date the animal that was purchased or acquired was slaughtered;
    e. the national livestock identification information of any animal purchased or acquired, if that animal is required by law to have that information;
    f. information that the minister considers sufficient to enable an inspector to trace the origins of an animal; and
    g. all information respecting specified risk material that an operator is required to keep by an Act or an Act of the Parliament of Canada.
2. Required records are provided to an inspector upon request.

J.4 Carcass Dressing

1. The age of cattle is determined before head removal and Specified Risk Material (SRM) is removed and handled of as per federal requirements and according to Appendix A: Specified Risk Material.
2. Precautionary measures related to Chronic Wasting Disease (CWD) are taken when handling Cervid carcasses including, but not limited to, deer, elk and moose as per Appendix D: Chronic Wasting Disease Precautionary Measures.

3. Dressing is carried out in a manner that prevents contamination of the carcass and its parts. Specific areas requiring extra care include:
    a. hide/skin opening incisions;
    b. stick wound;
    c. urinary tract, digestive tract and reproductive organ removal; and
    d. handling, freeing, dropping or tying of the rectum and lower intestinal tract.
4. Evisceration takes place within:
    a. two hours from stunning for red meat species; and
    b. 30 minutes from stunning for poultry and domesticated rabbit.
5. Inedible material is immediately trimmed/removed in a manner which prevents contamination of edible materials.
6. Water is not used as a method to remove contamination.
7. Carcasses and parts are not wiped with any material which may contaminate or spread contamination.
8. Carcass parts are harvested as per Appendix C: Carcass Parts.
9. Carcasses receive a final wash or approved antimicrobial treatment only after inspector approval.

J.5 Post-mortem

1. Operators of an establishment:
    a. inform the inspector of observed abnormalities prior to removal;
    b. present all carcasses and parts for post-mortem inspection at a rate and in such a way as to permit proper inspection (i.e. proper presentation of viscera, etc.);
    c. maintain accurate identification of a carcass and its parts until inspection is completed; and
    d. provide and maintain adequate facilities and equipment for inspection of all carcasses and parts including:
        i. adequate space;
        ii. lighting;
        iii. access to hose/sink;
        iv. knife sanitizer;
        v. viscera cart;
        vi. inspection stand; and
        vii. ladder.
2. Only carcasses and parts approved by an inspector are used for human consumption.
3. Carcasses and parts with evidence of abnormalities or contamination are handled according to the applicable inspector instructions:
    a. Hold until the localized contamination or condition has been removed or treated;
    b. Hold pending testing or other investigation;
    c. Hold pending Veterinarian consultation;
    d. condemned as unfit for human consumption and salvaged for animal food, pharmaceutics, or research;
    e. condemned and disposed of in an approved manner.

4. Carcasses suspected of a reportable disease(s) are immediately reported to the applicable regulatory authority.

J.6 Chilling

J.6.1 Red Meat Carcass Chilling

1. Hot carcasses are not placed into a cooler with carcasses which have already been chilled to 7°C (45°F) or lower.
2. Carcasses are placed into the cooler in a manner which promotes continuous and uniform cooling.
3. Carcasses in drip/holding coolers shall not touch walls, floors or other sources of potential contamination.
4. Surface temperature of carcasses reach 7°C (45°F) or lower within 24 hours of evisceration.
5. After reaching a surface temperature of 7°C (45°F), internal temperature lowers in a continuous manner to 4°C (39°F) or lower.

J.6.2 Red Meat Carcass Parts Chilling

1. Red meat carcass parts are chilled immediately upon harvesting.
2. Red meat carcass parts are chilled continuously to a surface temperature of 7°C or lower within 12 hours after harvesting.
3. After reaching a surface temperature of 7°C (45°F), internal temperature lowers in a continuous manner to 4°C (39°F) or less.

J.6.3 Poultry and Domesticated Rabbit Carcass Chilling

1. Chilling process lowers the internal temperature to, and maintains the temperature at, 4°C (39°F) or lower in a time as designated in the following table:

Weight of Dressed Carcasses	Initial Time (hours) to Reach ≤ 14°C	Additional Time (hours) to Reach ≤ 6°C	Additional Time (hours) to Reach ≤ 4°C
Under 1.8 kg	2	2	4
1.8 kg to 3.6 kg	2	4	4
3.6 kg to 5 kg	2	6	4
5 kg to 7 kg	2	8	4
7 kg to 12 kg	2	10	4
Over 12 kg	2*	10	6
* In this weight category, the temperature to reach within the first two hours is ≤ 16°C.			

J.6.4 Poultry and Domesticated Rabbit Carcass Parts Chilling

1. Poultry and domesticated rabbit carcass parts are chilled to 4°C (39°F) or lower within two hours.

K. WILD GAME

1. Inspected meat product not intended to be used as an ingredient in wild game product is removed from the area prior to beginning wild game processing.
2. Wild game or product containing wild game is immediately identifiable.
3. Wild game product packaging does not include reference to or imply inspection under the Domestic Meat Inspection Program.
4. Wild game carcasses and products are handled and stored in a manner as to avoid contamination of inspected meat products which are not intended to be utilized in wild game product.
5. Precautionary measures related to Chronic Wasting Disease (CWD) are taken when handling Cervid carcasses including, but not limited to, deer, elk and moose as per Appendix D: Chronic Wasting Disease Precautionary Measures.
6. Rooms, areas, equipment and utensils used for wild game processing are cleaned and sanitized prior to starting the processing of any inspected meat products.
7. Pre-operational inspection and re-cleaning, if necessary, is carried out prior to processing of inspected meat products.

*__Note:__ Frequency of inspection may increase during wild game season.

L. PET PRODUCTS

1. Inedible material collected for pet products does not contain:
    a. specified risk material;
    b. parasites transmissible to carnivores; or
    c. material from carcasses condemned for septicemia, toxemia, congestion syndrome or any reportable disease.
2. Inspected meat product not intended to be used as an ingredient in pet product is removed from the area prior to beginning pet product processing.
3. Pet product is immediately identifiable.
4. Pet product packaging does not include reference to, or imply inspection under, the Domestic Meat Inspection Program.
5. Pet products are handled and stored in a manner as to avoid contamination of inspected meat products which are not intended to be included in pet products.
6. Rooms, areas, equipment and utensils used for pet product manufacturing are cleaned and sanitized prior to starting the processing of any inspected meat products.
7. Pre-operational inspection and re-cleaning, if necessary, is carried out prior to processing of inspected meat products.
8. Pet products containing any material which may pose a food safety risk to humans are stored, handled and manufactured using equipment and utensils which are not used for product intended for human consumption.

M. RETAIL AREA

1. Design, construction, maintenance and operation of retail areas prevents contamination of meat products, ingredients, packaging material and processing equipment and utensils.
2. Refrigerated or freezer retail units used for storing or displaying products maintain product at 4°C (39°F) or lower or -18°C (0°F) or lower respectively.
3. The storage of raw products in retail display cases/units does not cause contamination or potential contamination of cooked products in the retail display cases/units.
4. Retail customers accessing processing areas adhere to general food hygiene procedures.

APPENDIX A: Specified Risk Material

Introduction

Specified Risk Material (SRM) is defined as the skull, brain, trigeminal ganglia, eyes, tonsils, spinal cord and dorsal root ganglia of cattle aged 30 months or over (OTM) and the distal ileum of cattle of all ages. The removal and separation of SRM from slaughtered cattle prevents tissues that may contain Bovine Spongiform Encephalopathy (BSE) prions from entering the human food and animal food chains.

Every operator of a domestic establishment involved in the slaughter of cattle and/or the cutting and deboning of bovine carcasses/quarters, is responsible for adhering to current federal SRM requirements.

Note: Updates to federal requirements may not be reflected in this Appendix. Federal requirements will always supersede this appendix where differences exit.

SRM Directives and Procedures

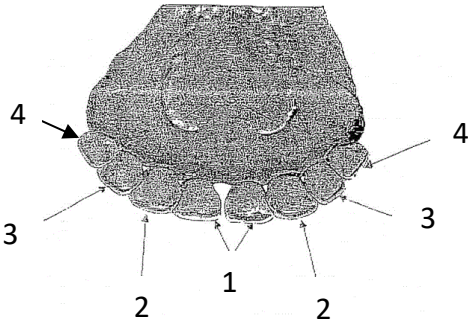
Permits:
Under certain operational circumstances the operator of a domestic establishment may require a CFIA-issued SRM permit. Obtaining a permit requires the operator to develop, implement and maintain a written SRM control program. In order to understand if your operation requires such a permit, please contact the CFIA at **1-866-788-8155**.

Age Determination:
The age of cattle can be established by reliable documentation (Canadian Cattle Identification Agency (CCIA)), copies of birth date documents issued by registered breed associations (recognized under the *Canadian Animal Pedigree Act*) that indicate the date of birth of the animal or by examining the teeth of the animal.

When reliable documentation is available, it shall be used as the primary means of determining the age of animals. However, the documentation would be invalid should a fifth permanent incisor be erupted. Birth date documentation must be kept on file for a minimum of two years from the date of slaughter. If the operator chooses to only use dentition for aging, birth date document retention is not applicable.

Cattle aging by dentition is based on the characteristic developmental timeline for the 8 incisor teeth from the deciduous (temporary, milk, baby) teeth to permanent (adult) set as the animal matures. As a general rule the deciduous incisors are present at birth or shortly thereafter (two weeks) and are then replaced by larger permanent incisors as follows:

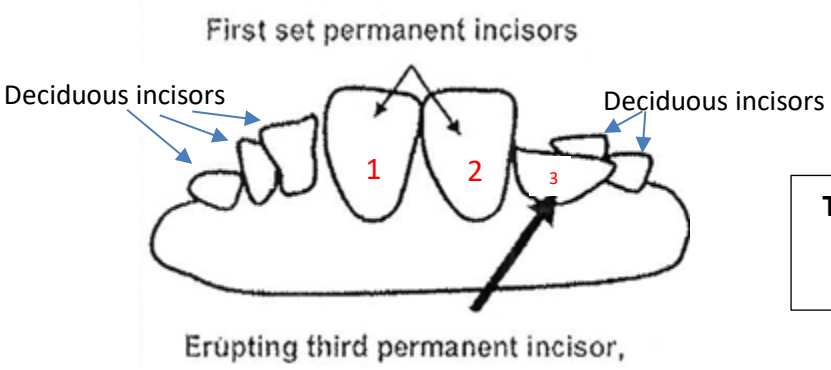
1. Central incisors: 1 ½ - 2 years,
2. Lateral central incisors: 2 - 2 ½ years,
3. Lateral incisors: 3 years, and
4. Corner incisors: 3 ½ - 4 years.



NOTE: When we age cattle we look at the number of individual permanent incisors (not pairs).

Cattle are considered to be aged 30 months or older (OTM) when they have more than two permanent incisor teeth erupted (Not sets of incisors, individual teeth). Cut off between UTM and OTM is as follows:

- **Two permanent central incisors (labeled 1 on above diagram) plus <u>one</u> erupted permanent tooth from the two lateral central incisors (labeled 2 on above diagram).**



This animal would be classified as OTM due to the erupting third permanent incisor.

Cattle will be considered as less than 30 months of age (UTM) as long as the third permanent tooth has <u>not</u> erupted.

A permanent tooth is considered erupted when any part of the tooth is protruding through the gum. This will include teeth that have erupted behind or in front of the existing deciduous incisor.

Distinguishing Temporary from Permanent Teeth:

Deciduous incisors are easily distinguishable from permanent. They are much smaller and whiter than permanent incisors. Deciduous incisors are often more triangular in appearance than newly developed permanent teeth.

All deciduous incisors – smaller, whiter and more triangular.

All permanent incisors – larger, less white and more rectangular. Note last permanent corner incisor coming in (arrow).

UTM Specimens:

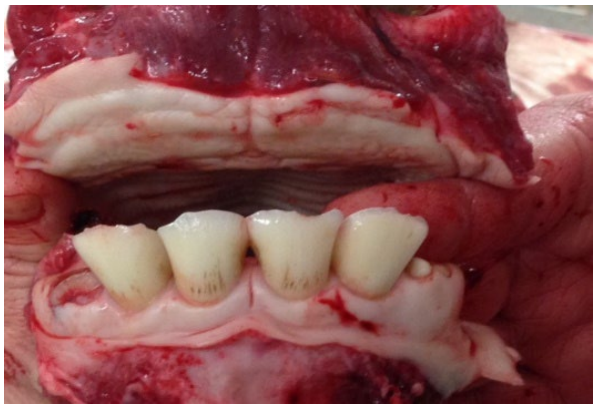
UTM - all deciduous incisors

UTM - all deciduous incisors

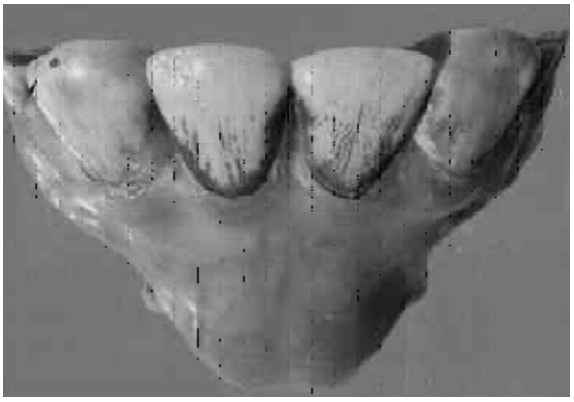
UTM – animal has first pair of permanent incisors (central incisors), all other incisors are deciduous.

OTM Specimens:

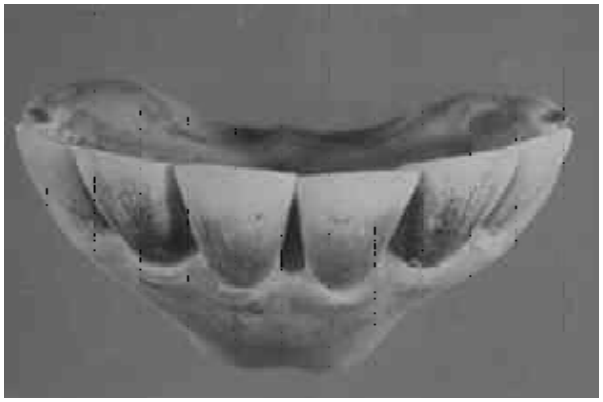
OTM – Note the erupting 5th and 6th permanent incisors



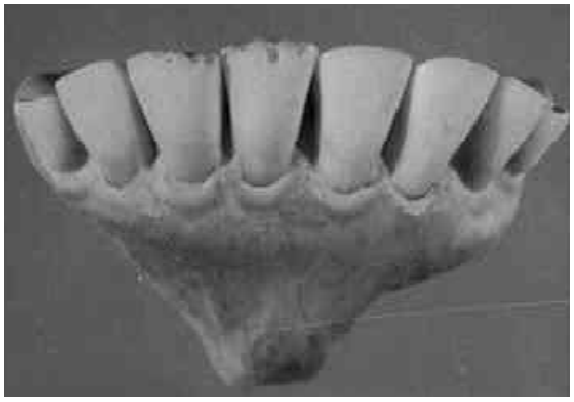
OTM – Note the erupting 5th and 6th permanent incisors



OTM – 4 permanent incisors

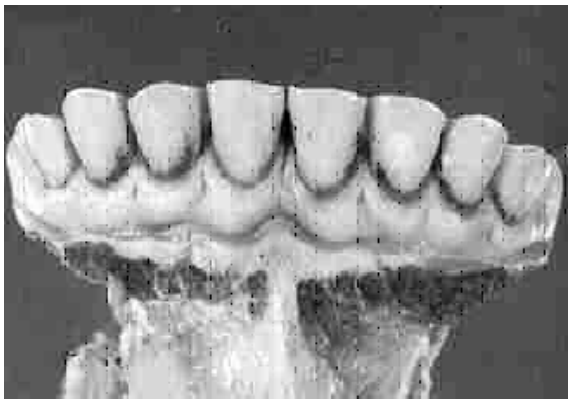


3-4 years old

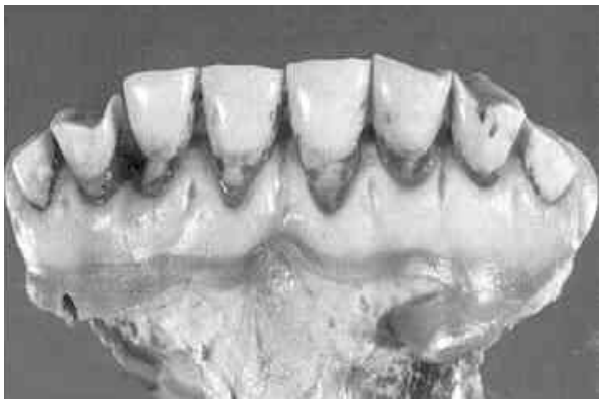


4 to 5 years old

5 to 6 years old

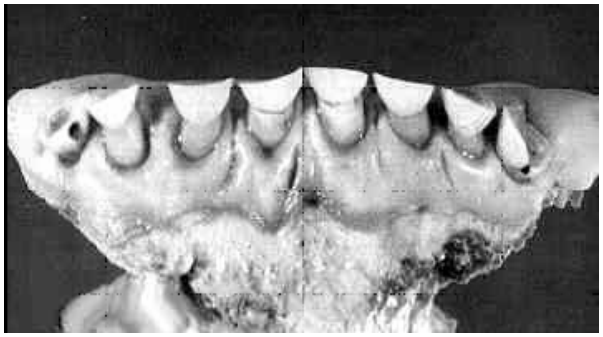


6 to 7 years old

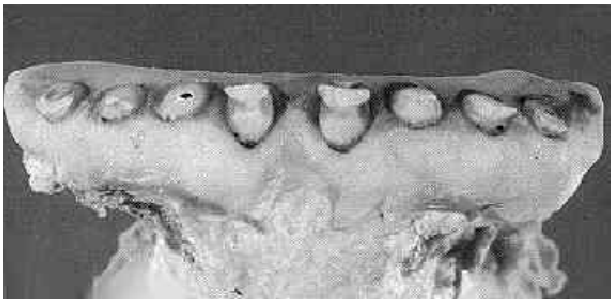


7 to 8 years old

8 to 9 years old



9 to 10 years old



10 to 15 years plus

Alternatively, the operator may decide to treat all slaughtered animals as being derived from OTM animals and the entire list of SRM tissues would be removed from all carcasses regardless of their age.

If the operator slaughters OTM cattle and if operationally achievable, they should be grouped and slaughtered in a definable group at the end of production.

SRM Removal:

Stunning:
Any brain tissue that has been externalized at the time of stunning prior to bleeding from OTM cattle is collected and handled as SRM. The operator's control program must ensure that the exposed brain matter externalized at the time of stunning and any leakage through the stun hole does not contaminate or enter meat products and/or animal food. Brain tissue that has fallen on the floor must be discarded as SRM.

Head Removal:
Age determination of cattle must be completed prior to head removal to ensure cross-contamination with SRM does not occur. For removing an OTM head, the method is to:

1. use a non-SRM knife to partially separate the head by severing the muscle and connective tissue up to the junction of the occipital condyles and the first cervical vertebrae;
2. a uniquely identified, dedicated knife (i.e. colour coded) for SRM removal is then used to sever the spinal cord. The SRM knife must be rinsed and sanitized between OTM animals; and
3. the non-SRM knife is again used to complete the removal of the head by severing the remaining muscle and connective tissue.

The skull, brain, trigeminal ganglia, eyes and tonsils of OTM cattle must be handled and disposed of as SRM. The operator must ensure head removal does not contaminate the carcass with SRM and must take measures to prevent the contamination of edible products.

Harvesting of the tongue, cheek meat and other portions for human and/or animal consumption must be achieved without contamination with SRM or other contaminants.

Distal Ileum:
The distal ileum is defined as the ileo-cecal junction and at least 200 cm of the attached uncoiled small intestine proximal to the ileo-cecal junction. The distal ileum is considered SRM in cattle of all ages. The operator shall either:

a) remove and dispose of the entire small intestine; or
b) remove and dispose of the distal ileum.

OTM Carcass Splitting and Staining:

Three splitting options are currently accepted for use in Saskatchewan domestically inspected facilities including:

<u>CENTER SPLITTING:</u>
The carcass splitting saw should separate the vertebral column in the midline to facilitate removal of the spinal cord. This is known as "center splitting".

If the carcass splitting saw is equipped with an automatic rinse system, the exhaust water must be ducted away from carcasses and other edible and inedible products. The water-exhaust effluent should be adequately trapped or channeled to SRM stream.

The operator shall immediately identify any improperly split carcasses that do not have the spinal cord completely exposed and take appropriate corrective measures to completely remove the spinal cord in the evisceration area.

Use of chain link gloves to remove spinal cord is prohibited unless covered with an intact rubber glove to minimize the risk of cross-contamination.

Where staining requirements apply, the operator must apply CFIA approved ink to the exposed vertebral column of each OTM carcass side following the removal of the spinal cord and before chilling.

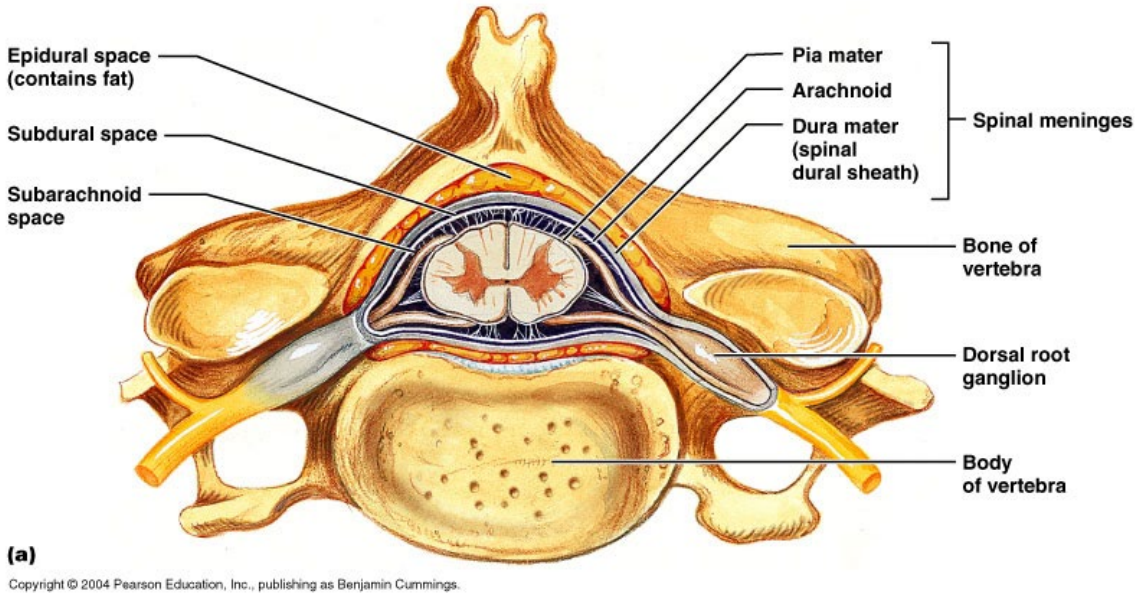
SIDE SPLITTING:

The operator may "side split" the carcass leaving the vertebral column intact with the dorsal root ganglia in one half of the carcass. Since the spinal cord remains intact and completely enclosed within the vertebral canal, there is no requirement to remove the spinal cord. Where staining requirements apply, the vertebral column must be stained with CFIA approved ink.

COMPLETE VERTEBRAL COLUMN REMOVAL:

The operator may remove the entire vertebral column along with all DRG during slaughter. Where staining requirements apply, the removed vertebral column must be stained with CFIA approved ink.

Dorsal Root Ganglia (DRG):
The DRG from OTM carcasses must be removed and disposed of as SRM. To ensure complete removal of the DRG, the vertebral column of OTM cattle (excluding the vertebrae of the tail, the dorsal and transverse process of the thoracic and lumbar vertebrae and the wings of the sacrum) must be removed and disposed of as SRM. Removal of the OTM vertebral column should not cause the removal of DRG with the edible muscle tissue. Therefore, the cut separating the edible muscle from the vertebral column must leave a minimum of 1 inch (2.5 cm) of tissue in place from the vertebral arch to ensure no DRG are inadvertently included with edible meat.



Cutting/Deboning:
Storage of SRM-containing carcasses must not cause cross-contamination.

If SRM-containing carcasses are transported off site for removal of the vertebral column, the facility must track those carcasses until the vertebral column is removed and disposed of as SRM. The inspector will verify the operator's reconciliation of the number of SRM-containing carcasses/sides/quarters with the number of SRM-containing carcasses deboned and cut-up.

Utensils, Equipment and Containers:
All utensils and equipment dedicated for SRM use must be colour-coded or visually discernable and cleaned and sanitized between uses.

All SRM containers shall be labelled SRM/MRS and shall be cleaned and sanitized after being emptied and prior to reuse.

Non-dedicated carcass splitting saws used to center split OTM carcasses must be cleaned and sanitized before being used on non-OTM carcasses.

Utensils, equipment and containers which become contaminated or are potentially contaminated with SRM must be cleaned and sanitized before use.

Retention and rework of carcasses harbouring residual SRM:
The operator must verify the complete removal of all SRM. Any carcass or part that is found to be harbouring SRM (e.g. spinal cord) must be immediately reworked and successful SRM removal verified.

Enhanced Feed Ban Controls and SRM Management

Segregation and Staining of SRM:
The operator who requires a CFIA-issued permit must have a written segregation protocol, which they must follow. Due to structural differences in the facilities, procedures for separating and isolating SRM may vary. In general, the separation of SRM should occur as soon as possible and care must be taken to avoid the contamination of meat products. SRM should be placed in dedicated, clearly labeled SRM containers and regularly moved to the inedible products areas for staining. SRM must be stained with CFIA-approved ink.

All SRM and carcasses containing SRM must be stained by the operator with an CFIA-approved ink. The operator, who is required to be permitted, must develop, implement, and maintain a written SRM control program for the segregation and staining of SRM in dedicated containers. If the operator chooses not to segregate SRM, all inedible tissues will be considered SRM and must be stained.

Cattle condemned and euthanized on the ante mortem inspection and those that are found dead and contain SRM must be marked with a wide stripe down the back of the head and length of the spine using a permanent dye that is also safe for consumption by animals.

Note: Unborn fetuses/calves recovered from the uterus of a slaughtered cow are not considered SRM. Calves and term fetuses with body hair found on the ground at the facility is considered SRM.

The only exception to staining is for those facilities where no SRM and no inedible (including components derived from cattle carcasses) leave the facility (i.e. not transported).

Floor Waste:
All floor waste in areas where SRM is removed or handled shall be treated as SRM. Any collection system for containing gross debris (i.e. drain covers/traps) must be emptied and the content shall be disposed of as SRM.

The floor waste generated in other areas, without any contact with SRM issues, will not be considered SRM. This also applies to areas where the distal ileum and vertebral columns are removed because the SRM is effectively contained within these tissues.

Where there are effective controls to prevent floor from contact with SRM, floor waste and debris collected from the corresponding drain covers and traps do not need to be disposed as SRM. An acceptable method of containing and preventing floor contamination with SRM in areas where SRM is removed or handled is through the implementation of strategic physical barriers such as troughs, trays, raised floor curbing or other acceptable methods that can achieve the equivalent effects. The operators who require a CFIA issued permit should have a written SRM control program in place to the satisfaction of the CFIA Inspector to prevent cross contamination of the floor from SRM in these specific areas.

Waste Water Material:
In areas where SRM is removed or handled, facilities should have in place a wastewater pre-treatment screening system consisting of a screen size no more than 4 mm in diameter or an equivalent control system than ensures the equivalent outcome. The solid material recovered from the wastewater screening system will be considered SRM.

In operations not utilizing wastewater pre-screening systems wastewater often goes into a septic tank, and the septic tank solids are considered SRM when removed from the premises (transported under a CFIA-issued permit). An equivalent outcome may be achievable for small abattoirs for areas where SRM is removed or handled by use of a squeegee and/or sweeping SRM material into an SRM container.

Animal material and debris recovered from wastewater screening system (i.e. floor drains/covers) will not need to be treated as SRM if there are effective controls in place to prevent the wastewater floor debris from becoming contaminated in areas where SRM is handled or removed. Operators who require a CFIA-issued permit and who wish to exempt the materials and debris recovered must have a written program in place satisfying the requirements of the CFIA Inspector.

Transporting SRM:
SRM, in any form, must be transported under a CFIA-issued permit. Owners of companies or vehicles who wish to transport OTM carcasses or SRM should contact the local CFIA District Office to obtain the required permit(s).

SRM Record Requirements:
SRM records must be maintained for 10 years by every person who is required to remove or stain SRM. All licensed meat facilities must keep records, which include:

1. Name and address of the facility
2. Date of SRM removal and staining
3. Combined weight of SRM and carcass(es) considered to be SRM that is shipped, transported or received
4. Number of carcasses
5. Name of dye used (not required if no SRM and no inedible (including components derived from cattle carcasses) leave the facility (i.e. not transported)
6. CCIA tag numbers
7. Date and method of destruction or containment if done on site or date of transportation of SRM from the facility
8. Name and address of the person or company transporting the SRM
    a. Individuals or companies transporting SRM must have a valid CFIA permit
9. Name and address of the final destination of the SRM
    a. Individuals or companies receiving SRM must also have a valid CFIA permit and the facility operator must ensure and include in the written program, that only transport vehicles with a valid permit are used to remove SRM from the facility

References

Inspection of Specified Risk Material (SRM) controls in non-federally registered cattle abattoirs

CFIA Meat Hygiene Manual of Procedures, Chapter 17, Annex D: Specified Risk Materials
Food and Drug Act (Canada)
Food and Drug Regulations (Canada)
Health of Animals Act (Canada)
Health of Animals Regulations (Canada)

Specified Risk Material (SRM) – Removal from Cattle Slaughtered at Provincially Licensed Meat Facilities, Alberta Agriculture and Rural Development, Meat Inspection Branch.

APPENDIX B: Emergency/Alternative Slaughter

Purpose: To allow the humane slaughter of animals that are fit for slaughter, on farm, feedlot, assembly yard or after-hours at an abattoir, in circumstances where transport or delay in slaughter would be inhumane and/or could cause injury to people and/or itself. Situations in which this may occur include:

1. An animal that cannot be loaded and transported humanely due to:
    a. recent injury (e.g. broken leg);
    b. development of a condition that impedes movement or may cause it to go down during transport (e.g. severe rupture/hernia, bloat);
    c. aggressive behaviour which may result in injury to itself and/or its handlers during loading; and
    d. escaped animal which cannot be readily caught and may injure itself and/or its handlers.
2. An animal that can be loaded humanely under *Health of Animals Regulations*, but requires immediate slaughter, after normal abattoir hours, due to:
    a. a condition (e.g. bloat, acute urethral blockage, grain overload) which, if not alleviated, will cause undue suffering and result in systemic changes making the animal unfit for slaughter.
3. An animal has become injured at a slaughterhouse while awaiting slaughter (after hours).

Authorization to conduct: Must be authorized by an inspector appointed under *The Animal Products Act* or a veterinarian where an inspector is not available to conduct ante-mortem inspection without delay. The abattoir operator must also have agreed to accept the carcass in the time frame required.

Time to conduct: This will depend on the reason for slaughter. If due to an acute injury or worsening condition, slaughter is to occur without delay (24 hours or less of observance of injury/condition). If this cannot be done the circumstances must be reviewed with the inspector/veterinarian and a decision made whether immediate euthanasia is required or if it is possible to maintain the animal without undue suffering until slaughter occurs (e.g. relief of bloat with a stomach tube).

It is the responsibility of the producer to contact the abattoir operator immediately upon becoming aware of any injury or condition for which emergency/alternative slaughter would apply. The abattoir operator is subsequently responsible for arranging emergency/alternative slaughter with an inspector, or where an inspector is unavailable (for ante-mortem), a veterinarian.

Ante-mortem inspection: Ante-mortem inspection must be conducted prior to slaughter by an inspector or veterinarian, and the *Approved Emergency/Alternative Slaughter Form* completed. The form must accompany the carcass where slaughter is done outside an abattoir's premises (e.g. owner's property, assembly yard, auction market) or be filled out by the veterinarian when

attending after-hours slaughter at an abattoir. It is the abattoir operator's responsibility to supply the *Approved Emergency/Alternative Slaughter Form* to the veterinarian, verify its completion and present it to the inspector conducting post-mortem inspection.

Ante-mortem dispositions: Regular ante-mortem disposition criteria apply. Where a food animal is deemed unfit for slaughter, it must be immediately euthanized, condemned and properly disposed of. When an inspector is unsure of fitness for slaughter the domestic meat inspection veterinarian will be contacted as per normal procedure within an abattoir.

Stunning and bleeding: Where the food animal is approved for slaughter, the inspector or veterinarian is to ensure it is humanely stunned. In addition, sticking of the animal is to be carried out immediately following stunning and bled for a period of not less than 30 seconds.

Appropriate bleed time must be allotted to ensure death by exsanguination before loading onto conveyance for transport or starting dressing procedures when done within an abattoir. The time of stunning must be noted by the inspector or veterinarian on the *Approved Emergency/Alternative Slaughter Form.*

Carcass transportation to abattoir: Carcass must be transported immediately, in a manner which does not increase food safety risk, to the abattoir for further processing. The trailer must be clean so that further contamination of the bled animal does not occur. Care must be taken that bodily fluids are contained. **Stunning to evisceration must not exceed two hours** and may need to be shorter depending on method of transportation and weather. This is to ensure hygienic processing and food safety.

Note: Bovine carcasses – SRM requirements as per the federal *Health of Animals Act* and *Regulations* apply. Before proceeding with emergency slaughter of cattle of any age, the abattoir operator and/or transporter must have CFIA issued permits to transport and receive SRM. The abattoir operator has an option to have a yearly permit or if needed, they can get a Time Sensitive Permit from CFIA. In these situations, prospective transporters are to telephone **1-866-788-8155** (direct TSP line) or **1-800-442-2342** and request assistance in obtaining a time-sensitive SRM permit.

Carcass dressing and post-mortem inspection: All Saskatchewan's Domestic Meat Inspection Standards apply for the hygienic and safe production of meat products. This also includes applicable SRM requirements for bovine.

Inspection will only proceed when the **completed** emergency/alternative form is approved by the inspector.

Where deterioration of the carcass occurs, the inspector has the right to refuse inspection and the carcass will not be approved.

Post-mortem disposition: Disposition of carcass and parts follows standard protocol where abnormalities/pathological lesions are detected. Kidney Inhibition Swab (KIS) testing is to be conducted for all emergency/alternative slaughter cases to verify that there are no drug residues in the carcass and/or parts approved for human consumption.

Emergency/Alternative slaughter fees:

Inspection fees: Regular fees apply – minimum four-hour charge, overtime as applicable.
Veterinary fees for emergency/alternative slaughter ante-mortem inspection: Operator and/or producer responsibility.

Approved Emergency/Alternative Slaughter Form

Owner's Location or Abattoir (circle one)

The meat inspector or veterinarian must complete this form at the time of slaughter (except where noted). The form must accompany the carcass or be left with abattoir when slaughter is done at the abattoir. Abattoir operator must complete their part of form. Please see back of form for more information.

Species Slaughtered: ☐Cattle ☐Bison ☐Hogs ☐Sheep ☐Other: _____

Animal Description: (color, breed, markings)
_____

Age of Animal: _____ Approved Ear Tag #: _____

Reason for slaughter: ☐ Inhumane to transport ☐ Worsening condition ☐ Behaviour/size of animal

Describe condition identified above: _____

Has the animal undergone proper withdrawal times for any drugs or treatments that it received**?** ☐ Yes ☐ No ☐ N/A

(Animal that has not undergone proper withdrawal times is unfit for slaughter)

ANTE-MORTEM INSPECTION, STUNNING, BLEEDING, TRANSPORT

☐ No abnormalities were observed on ante-mortem, **or**

☐ This animal revealed signs of _____

☐ I verify that this animal is fit for slaughter, was humanely stunned, properly bled, and loaded intact into appropriate conveyance

Date of slaughter: _____ Time of stunning: _____ am/pm Time after bleeding: _____ am/pm
(dd/mm/yyyy)

SRM Transport Permit # (required for cattle):_____ (phone **1-866-788-8155**)

We hereby certify that the above information is accurate:

_____ _____
Owner of Animal Signature Veterinarian/Inspector Signature

_____ _____
Owner (Print Name) Veterinarian/Inspector (Print Name), Practice/Clinic Name

_____ _____
Date: (dd/mm/yyyy) Date: (dd/mm/yyyy)

To be filled in by the Abattoir Operator

Date and time carcass arrived at abattoir: _____ _____am/pm
(dd/mm/yyyy) (time)

Operator: _____ _____ _____
Signature Print Name Abattoir Number

To be filled in by the Meat Hygiene Inspector

Date and time carcass was inspected: _____ _____am/pm
(dd/mm/yyyy) (time)

Disposition (if condemned provide reason):_____

Inspector: _____ _____ _____
Signature Print Name Inspector ID#

Version: 2025-03-31

In certain circumstances, the humane slaughter of animals that are fit for human consumption may be approved on farm or after-hours at an abattoir, where transport or delay in slaughter would be inhumane, and/or could cause injury to people or the animal.

The following steps will be followed in making the determination as to whether the carcass will be accepted.

1. Acceptance of a carcass must be pre-approved. Carcasses cannot be accepted without prior notification by a producer of their intent to ship the carcass, and approval by both the operator of the abattoir and the abattoir's Inspector in Charge (alternately the Lead Inspector) that the situation warrants emergency/alternative slaughter, and the abattoir and inspector can accommodate the request.
2. The slaughter of an animal must be supervised by a veterinarian or inspector. All veterinary costs associated with the slaughter of the animal must be borne by the producer or abattoir operator.
3. The veterinarian/inspector must provide written documentation of the reasons and conditions of slaughter as per "Approved Emergency/Alternative Slaughter Form", including:
    a. confirmation that in the veterinarian/inspector's opinion the transport of the animal or delay in slaughter would be inhumane;
    b. an ante-mortem inspection confirming the health of the animal before slaughter;
    c. confirmation slaughter was undertaken humanely;
    d. the date and time animal was shot/stunned, time after bleeding and bleeding was adequate; and
    e. carcass is transported whole (including head) in an appropriate conveyance such that the carcass remains adequately clean, no food safety risk occurs and bodily fluids do not leak onto roadways.
4. The abattoir operator and inspector must be notified immediately upon arrival of the carcass at the abattoir. The operator must complete the form with time of arrival and sign. The maximum time from slaughter to evisceration of the carcass at the abattoir is two hours but may be shorter based on each circumstance (see **Note** below). Carcasses must be eviscerated immediately upon arrival at the abattoir.

    Note: Shorter delivery times may be specified dependent on delivery method, the ante-mortem health status of the animal and weather conditions.

5. Final disposition of the carcass will be based on the combined ante-mortem and post-mortem findings. Approved carcasses will be marked with the Domestic Meat Inspection stamp.
6. Approval under this protocol does not convey other necessary approvals such as SRM permitting responsibilities. The SRM transportation permit is a requirement from the Canadian Food Inspection Agency (CFIA) for moving dead cattle or their parts. Getting and meeting the SRM permit requirements is the responsibility of the person who will be transporting the carcass to the abattoir. The permit can be obtained by calling the CFIA at **1-866-788-8155.**

APPENDIX C: Carcass Parts

Only carcass parts harvested under hygienic conditions, derived from approved carcasses and which are free from pathological lesions, parasites and contamination may be identified as edible meat products.

Part	Processing Requirements
Feet	✓ scalded ✓ hooves removed ✓ proximal end of the foot (i.e. the exposed surface of the articulation), which has been contaminated during the scalding and cleaning process, is resected
Brain	**Brain from OTM cattle is ineligible due to SRM.** **Brain from sheep/goat aged over 12 months is ineligible due scrapie.** **Brain from Cervidae aged 12 months or older is ineligible due CWD.** ✓ no processing requirements
Heart	✓ major blood vessels removed to within two cm of their origin from the external surface of the heart ✓ os cordis (heart bone) removed if present
Liver	**Horse liver is ineligible due to high cadmium content.** ✓ gall bladder removed
Lungs	✓ trachea and main bronchi split to examine for parasitic infestation and presence of contamination ✓ keep separate from other meat products until the trachea is opened and washed
Spleen	✓ must not included as an ingredient in meat products
Gastro-Intestinal Tract	**Distal ileum from all cattle ineligible due to SRM.** ✓ control of hazards associated with contamination and cross-contamination of other meat products during preparation, including control of aerosols and movement of employees must be maintained ✓ opening, emptying and cleaning must be performed in an area that is physically separated from the evisceration area ✓ air flow and employee movement must prevent contamination or cross-contamination Cleaning: ✓ emptying and cleaning must occur as soon as possible ✓ rinse with potable water until the water dripping away is clear ✓ trim visible contamination or defects after rinsing ✓ cleaned portions of gastro-intestinal tract can be sold as is or be refined Refining: • consists of scalding with warm water or refining chemicals according to manufacturer's specifications • Canadian regulations prescribes mandatory refining for:

Part	Processing Requirements
	○ The complete removal of the mucosa of the gastric compartments of ruminants and of the monogastric stomach when the intent is to use these by-products in the fabrication of prepared meat product; and ○ The complete removal of the mucosa in the preparation of casings. ○ Casings may be prepared from cleaned portions of gastro-intestinal tract, bladders and esophagi. ○ Portions of gastro-intestinal tract shall be refrigerated pending further processing, if not otherwise preserved, as they are sensitive to deterioration during storage. Saturated salting of portions of gastro-intestinal tract and casings will have an effective anti-microbial and preservation function. ○ In the case of a urinary bladder, it may be identified and used as a natural casing for a meat product if the content and mucous lining are removed and it is washed and tested for cleanliness. It shall also be inverted and placed in brine for at least 12 hours and subsequently rinsed with water. **Tripe (rumen and reticulum), omasa and abomasa:** The rumen and reticulum must be separated from the omasum-abomasum and emptied of their contents (separate room or time separation required). Care must be taken not to contaminate the outside surface of these organs and the proper utensils must be used. After the paunch is emptied of its contents, it is spread over a cone-shaped table and washed under a continuous spray of water. The paunch is carefully cleaned inside and out using knives and curry combs. Paunches are presented for examination and are then either chilled or scalded. The purpose of scalding is to remove the superficial surface of the mucous membrane. A perforated revolving cylinder is used for the scalding operation. An approved scald additive may be added to facilitate the operation. Tripe must be rinsed and re-examined. The end-product is then dried and chilled for further processing. Tripe should be prepared in a room separate from the slaughter floor.
Kidney	**Horse kidneys are ineligible due to high cadmium content. Kidneys from ostriches, rheas and emus shall also be condemned unless growers/processors desire to save kidneys as edible and provide data indicating that levels of heavy metals (primarily Cadmium) are within a range acceptable to Health Canada.** ✓ may be left on the carcass or removed and prepared with the other viscera. ✓ incise deeply, soak in water and wash before incorporating into a meat product.
Uteri	✓ must be from animals which have never been pregnant
Testicles and Penis	✓ remove testicles from scrotum ✓ store separately from other parts

Part	Processing Requirements
Fat	✓ collect from carcass as quickly as possible and refrigerate or render without delay to prevent rancidity
Tail	✓ no processing requirements
Heads	**Heads from OTM cattle are ineligible due to SRM.** **Heads from animals which have been shot are ineligible due to physical hazard from bullet.**
Head Meat	**Head meat must be free of SRM.** ✓ cheek meat may be harvested after inspection for *C. bovis*. ✓ OTM Cattle tongue must be removed at the junction of the caudal vallate papillae to ensure tonsils remain with the head and disposed of as SRM.
Esophagus Meat	✓ cut through esophageal musculature distally adjacent to the stomach without cutting into the mucosal lumen ✓ pull esophagus away from the stomach, leaving the mucosal lining attached to the stomach
Blood	✓ collection procedure requires pre-approval by the Ministry of Agriculture ✓ prevent blood clotting v using either an approved anti-coagulant or via mechanical defibrinating (not with hands) rinse and sanitize blood collection equipment between each carcass or lot
Udder and Mammary Gland	✓ must be harvested from animals which have never been pregnant
Thymus gland (sweet bread)	✓ no processing requirements

Appendix D: Chronic Wasting Disease Precautionary Measures

Chronic Wasting Disease (CWD) is prevalent in parts of Saskatchewan. Eradication of CWD from wild deer, elk and moose is no longer an option and efforts are being redirected to monitoring the disease distribution and infection rate in the province.

Operators are to ensure the following precautionary measures are taken when handling cervid carcasses such as deer, elk and moose:

a. wear rubber or latex gloves;
b. before accepting a live animal or carcass, inspect it to ensure it is free of signs of illness and visible decomposition or contamination;
c. minimize the handling of tissues most at risk of being infected with CWD (nerve tissue such as brain, spinal cord, eyes, spleen, tonsils and lymph nodes):
    i. if removing antlers, use a saw designated for this purpose only and ensure the blade is thoroughly cleaned and sanitized immediately after use;
    ii. if center splitting, thoroughly clean and sanitize the saw immediately after use;
    iii. if removing the head, thoroughly clean and sanitize the knife immediately after contacting the spinal cord and before detaching remaining tissues holding the head to carcass;
    iv. bone out the meat from the carcass and remove all fat and connective tissue. This will also remove lymph nodes; and
d. immediately after cervid processing, thoroughly clean and sanitize equipment and work areas.

Waste from cervid carcasses should be properly contained and disposed of in an approved landfill or other acceptable method of disposal to minimize potential environmental contamination with the CWD prion. For more information on disposal, contact your local Ministry of Environment office.

APPENDIX E: Dispute Resolution

Saskatchewan Domestic Meat Inspection Program - Dispute Resolution Committee

Purpose: This Dispute Resolution process is a tool for industry to utilize if they feel they are being treated unfairly by an inspector on the application or interpretation of the standards or regulations. Prior to filing a complaint through the Dispute Resolution Committee (herein known as the Committee) the facility operator should attempt to come to an agreement with the inspector, inspection manager and Ministry representative. Issues around condemnation cannot be brought forward to this committee.

Issues related to service delivery should be brought forward directly to the Ministry (in written form). The Ministry will deal with these directly on a case-by-case basis. When applicable, they will provide feedback to all operators.

Committee Membership:
Membership shall include:

a. One ministry representative;
b. One industry representative - must not be directly involve in the dispute; and
c. One representative from the Food Centre – must not be inspector directly involved in dispute.

Procedure:

1. The operator completes a Dispute Resolution Form and submits it to the ministry's meat inspection program lead, within 30 days of written notification from inspector.
2. The ministry lead will review the Dispute Resolution Form for completeness and follow-up with the operator if necessary. At this time the ministry lead may also contact the operator and/or the FC Food Inspection Program Manager to rectify the issue prior to calling the Committee together. If this is not possible, then proceed to the next step.
3. The ministry lead will arrange for the Committee to meet. This may be via teleconference, video conference, in-person or at the facility where the dispute is taking place:
    a. The Committee should attempt to use cost neutral options wherever possible, i.e. teleconference.
    b. The Committee may request that the inspector-in-charge and the operator participate for part of the meeting. If one of the sides is called into the meeting the other side will also be provided the same opportunity.
    c. **Note: this initial meeting should take place within 3 business days of the ministry lead receiving the Dispute Resolution Form.**
4. The Committee will meet to discuss the dispute and decide if additional information is needed. If additional information is required, then the Committee will collect the information and reconvene at an appropriate time to make final recommendations.
5. As part of the recommendations the Committee should determine if a change to the standard, interpretation guide or any other supporting document is required.

6. Upon conclusion, the Committee's recommendations report will be shared with:
    a. All Committee members;
    b. Complainant operator;
    c. FC Food Inspection's Program Manager; and
    d. Ministry's Meat Inspection Manager.
7. Those tasked with responding to Committee's recommendations will respond within two (2) weeks of receiving the recommendations or respond to an alternate agreed upon time frame.
8. The Committee will review each response and determine if the response is adequate. If the response is deemed to not be adequate, the Committee will advise the responder in satisfying the recommendation as soon as reasonably possible.
9. The Ministry has final decision-making power on all disputes and will explain why the decision has been made in writing to the Committee. The Ministry will ensure that their response does not hinder food safety or animal welfare.
10. The Ministry will notify all operators on the decision if it affects their facilities (e.g. if there is a policy change or change to the standard or interpretation guide or other supporting document).
11. Each member of the Committee will keep a copy (either electronically or hard copy) of all relevant information that would include, but not be limited to:
    a. Operator's completed Dispute Resolution Form;
    b. Information gathering method and documents;
    c. Committee meeting documents; and
12. Committee recommendations report.

Dispute Resolution Form (to be filled out by operator)

If more space is required please attach a separate sheet to this form.

Issue:		
Current Actions to Date: *(includes inspector's observations/recommendations, any correspondence with Ministry, Inspector Supervisor etc.)*		
Supporting Evidence: *(may include data from operator, lab tests, research etc.)*		
Implications on Food Safety: *(if any)*		
Implications for Business: *(if any)*		
Implications for Industry: *(if any)*		
Completed by: *(please print)*	**Signature:**	**Date:**

Glossary

Accurate thermometer: A thermometer that is accurate to within +/- 1°C.

Animal: A live animal raised in captivity for the purpose of producing animal products.

Animal food: Any meat product that has been identified for use in:

a. food for animals; or
b. pet products.

Animal product: Any product produced by or from an animal and includes any part of an animal, whether edible or inedible, and any by-product of an animal or imitation animal product.

Ante-mortem examination: In respect of an animal that is slaughtered, the examination of the animal, or the examination of a sample from a shipment of animals, and the examination of documents in respect of the animal or the shipment of animals, by the operator.

Ante-mortem inspection: Any procedure, or test conducted by an inspector or Veterinarian on an animal to determine whether the animal is suitable for slaughter.

Approved: Approved by an Inspector appointed pursuant to *The Animal Products Act*.

Bleeding: Severing the major arteries to produce rapid blood-loss and subsequent death by exsanguination.

Building: All parts of a domestic establishment with the exception of lairage.

Carcass: For the purpose of this standard, a slaughtered animal.

Clean: Free from dirt, contamination and disease.

Cleaning: Removal of soil, food residue, dirt, grease and other objectionable material.

Compatible: In respect of activities, activities that can take place at the same time in the same area and do not create a potential risk of contaminated meat products. In respect of food or other materials, products that are capable of existing together in the same area at the same time without creating a potential risk of contaminated meat products.

Condemn: In respect of an animal, carcass or meat product, to determine that the animal, carcass or meat product is inedible. Condemned materials must be handled and disposed of in a manner that avoids contamination of other meat products.

Contaminate: To make unfit for intended use by the introduction of unwholesome, unsafe or undesired elements.

Contaminated: Containing a chemical, physical or biological hazard, or being in a condition that constitutes a health hazard to humans.

Crate: A transport or lairage container for birds and domesticated rabbit.

Critical food safety manufacturing step: any action or activity used to prevent or eliminate a food safety hazard or reduce it to an acceptable level.

Cross-contamination: An occurrence when contamination is transferred from one food or surface to another, carried by utensils, hands, towels, or other food. Cross-contamination of food is a common factor in the cause of food-borne illnesses.

Cured: In respect of an edible meat product, that salt together with at least 100 p.p.m. of sodium nitrite, potassium nitrite, sodium nitrate or potassium nitrate, or any combination thereof, was added to the meat product during its preparation.

Deviation: A failure to meet required critical food safety manufacturing step(s), or a failure to meet a standard identified in Saskatchewan's Domestic Meat Inspection Standard.

Direct food contact surface: Any surface or object a meat product or ingredient is intended to contact during normal processing operations

Directly drained: Either connected to the sewage system or discharging of fluid waste directly into a drain inlet.

Disease: Any departure, from the normal state of health, which leads to a disturbance of normal body functions.

Domestic abattoir: The premises, or part of a premises, with respect to which a licence has been issued and in which:

a. animals are slaughtered for the purpose of processing meat into food for human consumption;
b. carcasses are stored; and
c. includes the area in the premises or part of the premises containing the first cooler after the area in which the animals are slaughtered.

Domestic establishment (establishment): A domestic abattoir or a domestic processing facility.

Domestic processing facility: The premises, or part of a premises, that is not a domestic abattoir and with respect to which a licence has been issued, in which meat products intended for human consumption are processed in a form other than a form intended for immediate human consumption.

Dress: Refers to:

a. in respect of a carcass other than a pig, goat or poultry carcass;
    i. to remove the skin, head and developed mammary glands and the feet at the carpal and tarsal joints;
    ii. to eviscerate; and
    iii. except in the case of a sheep, calf or domesticated rabbit carcass, to split.
b. in respect of a pig carcass, to remove the hair, toenails and developed mammary glands or to remove the things set out in subparagraph (a)(i) in the manner set out therein, and to eviscerate and split;
c. in respect of a poultry carcass, to remove the feathers, hair and head, the feet at the tarsal joints, and the uropygial gland and to eviscerate; and
d. in respect of a goat carcass, to remove the hair, head, toenails and developed mammary glands or to remove the things set out in subparagraph (a)(i) in the manner set out therein and to eviscerate.

Easily cleanable surface: A surface that is readily accessible and of such material and finish and so fabricated that food residue or other matter foreign to the surface may be effectively removed by normal cleaning methods.

Edible: With respect to a meat product, that the meat product is fit for human consumption.

Equipment: Any item, stationary or mobile, manual or mechanical, other than a utensil, that is used in domestic establishment operations. Includes meat product, inedible and waste containers.

Establishment number: The number assigned to a domestic establishment.

Euthanize: Humanely kill an animal for purposes other than for production of edible products.

Eviscerate: Refers to:

a. the removal of the respiratory and digestive system and the other thoracic and abdominal organs, which may include the reproductive and urinary system, in respect to:
    i. a carcass derived from a young chicken whose live weight was 2.7 kg or less; or
    ii. a carcass derived from a young duck whose live weight was 4 kg or less.
b. in respect to a carcass derived from a bird other than a chicken or duck, referred to in (a), the removal of the respiratory, digestive, reproductive and urinary systems and the other thoracic and abdominal organs; and
c. in respect to any other carcass, the removal of the respiratory, digestive, reproductive and urinary systems, except the kidneys and the other thoracic and abdominal organs.

Facility: All elements of the building(s) and lairage.

Finished product: Product that will undergo no further processing or transformation by the establishment. **Note**: A product that undergoes further processing or transformation by another establishment is a finished product, in the context of the first establishment and a raw material or an ingredient in the context of the second establishment.

Food: As defined by the *Food and Drugs Act*, includes any article manufactured, sold or represented for use as food or drink for human beings, chewing gum and any ingredient that may be mixed with food for any purpose whatever.

Food additive: Any chemical substance that is added to food during preparation or storage and either becomes a part of the food or affects its characteristics for the purpose of achieving a particular technical effect and includes nutrients.

Food carrier: Conveyance transporting meat products under the control or arrangement of the domestic establishment operator.

Food contact surface: Includes direct and incidental food contact surfaces.

Food grade material: A material that is used in the construction of utensils, equipment and food contact surfaces that does not allow the migration of deleterious substances or imparts colours, substances, tastes or odours to the food and is safe, durable, corrosion-resistant, smooth, easily cleanable and resistant to pitting, chipping and scratching.

Food safety: A concept that food will not cause harm to the consumer when it is prepared and/or eaten according to its intended use.

Formula: In respect to a meat product, the

a. ingredients of the meat product and the components of the ingredients thereof, including food additives;
b. proportions of those ingredients and components; and
c. method of manufacture and the results of any test conducted on the meat product.

Fresh meat product: A meat product which as not been cooked or preserved.

Hazard: From the perspective of the production of edible meat and meat products, refers to any biological, chemical or physical agent or factor, or a condition of the meat or the environment in which meat products are produced, processed, handled or stored that may directly or indirectly cause a meat product to be unsafe for human consumption.

Hold: Any product or thing identified as being under the official control of FC Food Inspection Services.

Hygiene: Conditions or practices conducive to health - as related to personal cleanliness or sanitation.

Impervious: A surface that is constructed of a material that prevents the passage or entry of moisture.

Incidental food contact surface: Any surface or object not intended to contact food but is likely to do so and could result in contamination if left unclean or unmaintained.

Inedible: Determined by an inspector to be contaminated or otherwise unfit for human consumption. Categories of inedible products include:

a. food waste;
b. condemned meat products (SRM included); or
c. non-SRM, non-condemned products:
    i. salvaged for animal food;
    ii. salvaged for medicinal purposes;
    iii. treated by the operator as condemned meat products and which are by their nature not edible (feathers, hides, hair, manure, intestinal contents, etc.).

Inedible room: The part of a facility in which inedible meat products are received, held, processed, shipped or otherwise dealt with.

Ingredient: An individual unit of food that is combined with one or more other individual units of food to form an integral unit of food. This includes food additives.

Insensible (unconscious): An animal that has been stunned and will not sense pain or discomfort during slaughter.

Inspector: A person mentioned in Section 3 of *The Animal Products Act.*

Knocking box: Restraint device for holding animals while stunning.

Lairage: An area of a domestic establishment dedicated to animal receiving, handling and housing, and includes live animal receiving, pens/crates used for housing animals at the abattoir, chutes, crowds and alleyways, but does not include the knocking box.

Licence: A licence issued pursuant to *The Animal Production Regulations.*

Living quarters: The residence of person(s) and their pets.

Meat inspection legend: A mark applied to meat products or packaging that indicates that the meat has been inspected and is fit for human consumption.

Meat inspection stamp: The stamp that an inspector imposes or causes to be imposed on a carcass at the time of inspection to indicate that the carcass is approved for human consumption.

Meat product: Refers to:

a. the edible part of an animal carcass that is the muscle associated with the skeleton, tongue, diaphragm, heart, gizzard or mammalian oesophagus, with or without accompanying and overlying fat, together with those parts of the bones, skin, sinews, nerves, blood vessels and other tissues that normally accompany the muscle and are not ordinarily removed in dressing a carcass;
b. the blood or edible by-product of an animal, including edible organs; and
c. a product containing anything described in sub-clause (a) or (b).

National livestock identification: Identification issued by the Canadian Cattle Identification Agency (CCIA), Canadian Sheep Identification Program (CSIP), PigTRACE or any other federally or provincially mandated identification used to prove ownership of an animal and for livestock traceability.

Non-ambulatory animal: An animal which is unable to stand without assistance or to move without being dragged or carried, regardless of size or age. Non-ambulatory animals are also called downers. This includes, but is not limited to, acutely split animals and animals that require hobbles to assist in the healing of injuries or to prevent further injury to itself.

Non-food chemical: All chemicals used, handled or stored at a domestic establishment but which are not intended to be included into food.

Non-food contact surface: Any surface or object which is not expected to contact product, direct or incidental food contact surfaces under normal operations.

Operator: A person who holds a valid licence issued pursuant to *The Animal Production Regulations.*

Packaging: The activity of placing meat products into packaging material(s).

Packaging material: Food grade materials used for packaging meat and meat products including containers and bulk containers. This also Includes labels.

Parts: Anything originating from a carcass whether edible or inedible. This would include, but not be limited to, organs, blood, tail, head, feet, muscles, hide, etc.

Post-mortem inspection: The inspection of the carcass or parts of a carcass of an animal by an inspector or veterinarian.

Poultry: Any species of bird, with exception of ostrich, rhea and emu, that is slaughtered and processed as an animal product.

Premises: All elements in the building(s) and building surroundings: the outside property, roadways, drainage, building design and construction, product flow, sanitary facilities, and water quality, protection and supply.

Pre-operational Inspection: A check for cleanliness and sanitary conditions completed by the operator before operations commence.

Procedure: A fixed, step-by-step sequence of activities or courses of action, each with a definite start and end point, that must be followed in the same order to correctly perform a task.

Processing: Any activity performed on a meat product.

Processing area: Any area where processing activities are performed.

Record: Any record, book or other document, and includes any information that is recorded or stored by electronic means.

Red meat animal: Any animal other than poultry slaughtered and processed as an animal product. Includes ostrich, rhea and emu.

Retail area: Any establishment or part of an establishment where food is displayed for purchase for the ultimate consumer.

Return to sensibility: An animal which was effectively stunned but has regained sensibility before death by blood-loss.

Rework: To include a partially or fully processed meat product into a new batch, lot or production date of product.

Sanitation: Includes cleaning and sanitizing activities.

Sanitize: To treat clean surfaces by heat or chemicals to reduce the level of micro-organisms to a level that will not compromise the safety of the meat product.

Sanitizing installation: A source maintained with potable hot water at a minimum temperature of 82°C (180 °F), or manufacturer specified chemical concentration.

Sensible (conscious): An animal which is awake and senses pain and discomfort.

Slaughter: To kill an animal with the express purpose of processing it for human consumption.

Slaughter room: An area of an establishment in which animals are stunned, bled and dressed.

Stored: Placed in an area and not included for immediate production.

Storage area: The area of an establishment in which anything is stored.

Stun: To render an animal unconscious or insensible to pain prior to slaughter by an approved method.

Suspect: In terms of ante-mortem inspection means an animal which shows clinical signs of systemic or disseminated illness which is likely to result in carcass condemnation and for which enhanced post-mortem inspection is required to verify suitability for human consumption. In terms of food and packaging materials, means may be contaminated or otherwise unfit for human consumption.

Uninspected meat: Meat and meat product which has not been inspected and approved.

Unsanitary condition: The condition of a place or premises, or a circumstance, that

a. presents or might present a threat to the health of any person;
b. prevents or hinders, or might prevent or hinder, the suppression of disease; or
c. has contaminated, tainted or polluted food, or may contaminate, taint or pollute food, in a manner that presents or might present a threat to the health of any person.

Utensil: Any portable implement used in the manufacture, storage, preparation and transportation of food.

Viscera: The internal organs of an animal.

Waste: Unwanted materials left over from processing. Includes, but is not limited to garbage, discarded packaging materials, broken pallets, discarded construction materials, etc.

“Where necessary", "Where appropriate", "Adequate" and "Sufficient" as referenced in Saskatchewan’s Domestic Meat Inspection Standard, means intended outcome(s) of applicable standard(s) can be met via procedures, equipment and controls established by the operator. In determining whether a requirement is necessary, appropriate, adequate or sufficient to achieve the objectives of the standards, account should be taken of the nature of the operation/activity and of intended use. Inspectors evaluate whether intended outcomes are met through conducting inspections.

Wild game: A wild animal which has not been raised in captivity hunted for the purpose of meat for human consumption.