

Industry Standard 5

Slaughter and Dressing

Preface

This industry standard contains instructions and guidelines to be followed. It represents the minimum standards with which the industry must comply to ensure continued market access.

It has been developed jointly by industry (MIA) and MAF, facilitated by the Meat Industry Standards Council, and has been adopted by the Council following extensive consultation.

It also applies to premises producing for the domestic market.

It is issued under delegated authority granted to the Director (Animal Products) of the Ministry of Agriculture and Forestry, pursuant to the Meat Act 1981 and its subsequent regulations.

Amendment Record

Amendments to this industry standard will be given a consecutive number and dated.

Please ensure that all amendments are inserted, obsolete pages are removed and the record below is completed.

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**Part A: General Procedures for All
Classes of Animal**

Introduction

1.1 HYGIENIC CONTROL OF SLAUGHTER AND DRESSING

The effective control of hygienic conditions during the slaughter and dressing of animals, and the hygienic handling of meat, are vital for the production of a clean, wholesome and safe product.

The skills and understandings of the people involved are particularly important.

A high standard of hygienic dressing will protect the health of both workers and consumers. Every procedure is to be designed to minimise contamination of product, workers, equipment and the work environment, consistent with good hygienic practice.

A number of statements in this industry standard are absolute, e.g. prevent skin roll back. It is recognised that continuous compliance is not achievable in some cases but it is expected that reasonable efforts will be made to do so. It is a matter of judgement by experienced personnel to determine the acceptability of any situation.

Control of Slaughter and Dressing

2.1 MANAGEMENT RESPONSIBILITIES

The following are the responsibility of management:

- the slaughter of animals in a humane manner;
- the dressing of animals in a hygienic manner;
- the correct presentation of carcasses and offals for inspection;
- the despatch of hygienically and completely dressed product from the slaughter-board;
- the operation of an effective quality management programme which controls slaughter and dressing methodology and identifies and corrects problems before MAF intervention;
- ongoing communication and co-operation with staff responsible for inspection and supervision.

2.2 MAF RESPONSIBILITIES

The following are the responsibility of MAF:

- the verification of compliance by the company with the regulatory requirements and the company's quality management plan;
- ongoing communication and co-operation with company staff responsible for the slaughter and dressing operation;
- the control of identified non-compliance.

2.3 ASURE NEW ZEALAND RESPONSIBILITIES

- the ante- and post-mortem inspection of animals.

Inspection staff shall ensure that within their areas of responsibility:

- hygienic practices are maintained;

- all product is properly inspected;
- the provisions of this industry standard are met;
- liaison occurs with company supervisory staff.

Overseas Inspection Requirements

- 3.1 Management shall give adequate notice to the Technical Supervisor of intended markets for product. The Technical Supervisor shall ensure that the correct inspection procedures are carried out to comply with the market requirements. Product, which is ineligible for any particular market, shall be identified and controlled to the satisfaction of the Technical Supervisor.
- 3.2 Details of overseas requirements are given in the Overseas Market Access Requirements (OMAR).

Status of Animals for Slaughter

- 4.1 All animals entering the slaughter-floor shall have undergone ante-mortem inspection and been designated as suitable for slaughter. Confirmation that ante-mortem inspection has occurred must be available for verification/audit by the post-mortem inspectors before finalising the result of inspection. The method of notification and verification shall be approved by the Technical Supervisor.
- 4.2 The inspector will validate documentation confirming that the animals have been passed as fit for slaughter. The originals of these documents shall be kept for 1 month to facilitate trace-back.
- 4.3 The company is responsible for ensuring that animals being slaughtered have been subject to and have passed ante-mortem inspection, and for dealing with documentation as prescribed by the Technical Supervisor.
- 4.4 Details of inspection procedures are given in MAF Manual 16.

General Requirements

5.1 PERSONNEL

5.1.1 Personnel shall wear protective clothing of the type and colour approved by the Director (Animal Products). The clothing shall be kept in a clean condition at all times, otherwise changed on a regular basis. Damaged clothing shall be replaced.

Aprons, protective sleeves, gloves, boots, knives, steels and scabbards shall be clean at the start of breaks and at the end of every work period (run).

5.1.2 Personnel shall wash their hands and arms whenever they contact contaminated items/surfaces or otherwise on a regular basis, at the start of work and after every break.

5.1.3 Personnel handling both external hide/pelt surfaces and exposed product shall wash their hands before touching exposed product.

5.1.4 Stun operators, classed as 'edibles personnel', may move through a door onto the ramp, provided the area in question is kept clean and not used by other yard personnel. Where this option is used, the stun operator may not enter other parts of the slaughter board. This restricted area may be extended to the landing area where animals are shackled, if this area is walled off from the rest of the slaughter board and access by other slaughter board personnel is prohibited.

5.2 EQUIPMENT

5.2.1 A requirement to "clean and sterilise" may be interpreted as "sterilised only" if the absence of the rinse does not allow materials to be baked on to the equipment, or the steriliser to become blocked and dirty.

5.2.2 All equipment (including knives) which comes into contact with the exposed product before inspection shall be rinsed clean after each carcass and sterilised regularly *, e.g. flay masters, eviscerating knives, inside/out skinning knives, anchoring chains (dehiding), kidney enucleators.

*See Section 20: *Specific Controls for Cattle*.

(a) In addition, all equipment shall be additionally rinsed after the following:

- outside-in skin incisions, except for initial small opening incisions where the knife is subsequently used for spear cuts (the requirement to rinse does not apply to cattle trotter removal);

- inside-out skin incisions if the knife is subsequently used for other dressing operations on the same carcass (consecutive inside-out skin incisions may be done on the same carcass without additional rinsing);
- (b) In addition, all equipment shall be additionally sterilised after the following:
- incision into a blind cavity, e.g. thoracic stick, ringing, brisket opening or pluck removal. (This does not include incision into joints or the spinal column or tongue)
 - incision into contaminated tissues, e.g. weasand/trachea incision, bung removal;
 - excision of diseased or defective tissue, e.g. removal of abscesses, except where sufficient clean surrounding tissue was removed, and any further work up is on the same carcass.
- (c) In addition, any equipment likely to introduce unnecessary contamination into deep tissues, shall be cleaned and sterilised before use, e.g. carcass skewers.
- (d) In addition, any contaminated equipment shall be cleaned and sterilised before contacting product.
- (e) In addition, in every circumstance, viscera tables or buggies, dehorners or equipment used for suspending carcasses or offals shall be cleaned and sterilised after each carcass or set of offals.
- 5.2.3 The contact of un-inspected meat with structures, equipment and objects (including inspection stands, neck breakers, nose rollers) shall be prevented unless there is a continuous water curtain or flush of a temperature of not less than 43 °C, flowing over a smooth non-porous contact surface so as to prevent contamination of the surface. The permanent removal of the contact surfaces on structures and objects is required during any major constructional changes to the processing area.
- 5.2.4 All equipment coming into contact with inspected product shall be cleaned and sterilised whenever contaminated and also cleaned on a regular basis.
- 5.2.5 Waste water, splash and potentially contaminating aerosols shall be confined.

5.3 DRESSING TECHNIQUES

- 5.3.1 Hygienic techniques shall be used. If multiple operations are carried out on the same carcass by the same operator, the operations posing the least risk of contamination shall be performed first. Use of unhygienic techniques and subsequent trimming shall

not occur.

5.3.2 Animals shall be stuck through the smallest skin opening consistent with good bleeding. Exceptions for religious slaughter shall require approval from the Director (Animal Products).

5.3.3 Animals shall not be dressed on the floor.

5.3.4 Carcasses shall be kept separate from one another after sticking and until the completion of inspection, except;

(a) pig and skin-on goat carcasses may come in contact with each other in the scald bath

(b) where rotation of the carcass is prevented, such that the sticking wound cannot be contaminated by the forelegs of adjacent animals, the carcasses may contact each other in the bleeding area.

5.3.5 The following opening and spear cutting techniques shall be used.

The skin may either be opened with a small cut, then a spear cut used to extend the incision (blade directed outwards), or a strip of skin may be removed (provided that there is no sawing motion of the knife).

A spear cut (blade outwards at all times) which opens and continues the incision of the skin does not require an initial opening cut.

An extension of the strip of skin technique may also be used. The skin and tissue to be removed shall be lifted (tension must be applied, by mechanical means if necessary) and a single cut shall be used to sever the skin and tissues. The area of skin removed must be kept as small as is practicable and the knife shall not come in contact with underlying product. The use of this technique is limited to removal of the scrotum, udder and skin around the anus.

•Refer section 24.7 for details on gas depelting

5.3.6 The skin shall be reflected before incisions are made into the carcass. See the species-specific sections for exceptions to this principle.

5.3.7 Water or loose dirt shall be prevented from falling from the hide or pelt on to the product.

5.3.8 Skin rollback shall be prevented.

5.3.9 Pathological lesions shall not be removed before inspection. This does not include lesions on those parts normally discarded (e.g. hooves) unless the inspector has prohibited their removal. Trimmers or operators with suitable facilities may remove

any visible contamination on carcasses prior to inspection. Trimming activities prior to inspection shall ensure that no lymph nodes and parts which may affect disposition are removed.

Companies are permitted to remove materials of plant origin from a carcass before the carcass is subjected to post mortem inspection. Any such materials detected on post mortem inspection shall be removed by the company. The following options apply:

- The inspector identifies the carcass and the carcass is trimmed as a detained carcass.
- The inspector identifies the carcass with a physical means (eg ticket) and the carcass is trimmed in a suitable area. People working in these areas shall have adequate access to facilities for washing hands and aprons and for washing and sterilising knives. There shall be adequate lighting. Any work in this area shall not adversely affect any other carcasses.

Regular checks shall be performed by MAF to ensure that trimming occurs to a satisfactory standard. If the standard of trimming or the facilities is not satisfactory, the affected carcasses shall be dealt with as a detained carcass.

(These options apply to material of plant origin only. Any other lesions shall be removed in accordance with normal procedures). Plant lesions are **not** to be recorded for the Disease and Defect system.

5.3.10 Scraps, trimmings and waste shall be disposed of into containers or chutes.

5.3.11 Heads shall be washed before they are inspected. Tongues shall be presented clean for inspection. The washing of heads and carcasses is to be such that cross-contamination between carcasses, or from un-skinned to skinned parts of the same animal, does not occur. Water shall not enter body cavities or the rectum. The controlled use of water for approved purposes is acceptable. A full-scale pre-evisceration wash is not recommended.

5.3.12 Heads shall be fully skinned except for sheep and goats (refer section 24.3) and deer (refer section 26.2.) and bobby calves (refer section 21.3). Tonsils shall be left intact and attached to the head.

#5.3.13 Neither the thyroid gland nor the muscular tissues surrounding the larynx may be salvaged for human consumption. Thyroid glands may be saved for pharmaceutical use.

5.3.14 Udders shall be removed without milk spilling on to the product. Accidental spillage shall be trimmed off immediately. Non-trimmed carcasses entering the pre-evisceration wash shall be condemned.

5.3.15 The anal area shall be completely cleared. The anal sphincter shall be left intact if

water is applied to the carcass before dressing is completed. The freed bung must not touch the skin and may be dropped into the pelvic cavity.

- 5.3.16 The gastro-intestinal tract, gall bladder, uterus and bladder shall not be punctured. A small amount of bile leakage, which may occur during post-mortem inspection, is acceptable.
- 5.3.17 Carcass cavities shall not be flushed out before inspection.
- 5.3.18 Gall bladders shall be placed in a chute or splash-proof container. Gall bladders shall not be opened or removed from condemned livers in food areas.
- 5.3.19 Lymph nodes shall be left attached for inspection. A liver presented with less than one whole node shall be designated petfood if not otherwise condemned.
- 5.3.20 Carcasses shall be passed which have a few (not exceeding 10 closely associated) isolated strands of wool or hair, and/or a few scattered specks of sand, peat, pumice or dust. It is a management responsibility to remove these before the carcass leaves the slaughterboard. A final wash or hand held steam vacuum devices may be used for this purpose.
- 5.3.21 Condemned carcasses or parts shall be secured during work breaks unless an inspector is physically present.
- 5.3.22 Carcasses falling into drains shall be condemned without trimming. Carcasses falling on the floor may be either discarded by the company (without the issue of a condemned ticket), or identified and either condemned or trimmed to the satisfaction of the Technical Supervisor. (Refer to IS3 section 11 for handling of dropped product)
- 5.3.23 Testes shall be free from defects at the time of dressing, except in the following cases:
- (i) where testes from deer are intended as co-products (see section 26)
 - (ii) where ovine testes are saved from carcasses dressed on inverted dressing systems.

Except as provided in 5.3.22 (ii) testicles shall be identified with the carcass and other offals from that carcass. Testes may be removed from the carcass and inspected with the other viscera or may be left naturally attached to the carcass and inspected with the carcass.

In the case of ovine testes collected from carcasses dressed on inverted dressing systems, the entire scrotum may be removed during preparation of the scrotal area. see IS5 Photographic Guidelines, Photographs 15a and 15b.

- (i) Testes shall be hygienically removed from the scrotum
- (ii) Testes may be placed on the viscera table along with the other offals from the carcass, or;
- (iii) Testes from several carcasses may be batched and inspected at a later stage. In

this case, the requirements for the cooling of offals (IS 6) shall apply from the time testes are removed from the carcass.

Humane Slaughter

6.1 PRINCIPLES

- Animals shall be rendered insensible to pain prior to being slaughtered by bleeding.
- The period of insensibility shall continue until death supervenes from bleeding.
- In all cases bleeding shall be carried out promptly and skilfully.
- Exceptions to this requirement may be permitted by the Director (Animal Products) for religious slaughter. The kosher method of slaughter is only permitted for the production of product for the specific consumption of the relevant religious group.

6.2 QUALITY ASSURANCE PROGRAMME

6.2.1 Licensees are to provide and operate a documented quality assurance programme for humane slaughter (stunning and sticking) which is evaluated and recognised as valid by the Verification Agency. The documented quality assurance programme must address the following details:

- Training and competency of personnel
- Type of equipment and maintenance
- Specified parameters for an effective stun
- Procedures for dealing with non-compliance by personnel and equipment, and preventing recurrence
- Internal audit and records

6.3 METHODS OF INDUCING IMMEDIATE INSENSIBILITY

6.3.1 The animals shall be restrained before stunning in a manner that adequately deals with animal welfare, the type of animal and the stunning method.

6.3.2 The following are acceptable methods of stunning:

- (a) Penetrating or percussive captive bolt types of stunning instruments operated by an explosive charge or compressed air.

Note: For cattle the point of penetration shall be over or in the cerebral hemisphere, i.e. lateral to the crossover point of lines drawn from the outside point of the eye to the rear attachment of the opposing ear.

The use of solid or frangible bullets for stunning animals is not permitted in any abattoir or export slaughterhouse but is acceptable in rural slaughterhouses, custom killing premises and pet food slaughtering premises.

Brains from animals stunned with a penetrating device cannot be saved for edible use.

- (b) Administration of an electric shock passing through the brain.

Automatic stunners occasionally give an ineffective stun and a suitable backup (e.g. captive bolt) shall be available for immediate use.

- (c) The use of carbon dioxide gas in a suitably enclosed chamber.

The apparatus shall be of a type approved by the Director (Animal Products). Gas shall be maintained in the area at a sufficient concentration to ensure the rapid onset of insensibility in the animal.

- (d) Any other methods as may be approved by the Director (Animal Products).

- 6.3.3 Whenever stunning becomes inadequate, the kill shall cease until the problem is rectified.

6.4 STUN-STICK INTERVAL

- 6.4.1 The maximum intervals currently approved by the Director (Animal Products) are:

Pigs	30 seconds
Ovine head-only electrical stun	25 seconds
Bobby calf head-only electrical stun when the halal stick is used	Stick in 10 seconds, followed within 35 seconds of stun by either heart-stopping electrical current or secondary thoracic stick.

An animal may be allowed to recover from the stun, for halal purposes, to confirm that it is not killed by the stun. However, re-stunning is necessary before slaughter.

The principles outlined in Section 6.1 must be applied in all circumstances.

- 6.4.2 There are no specified intervals for irreversible stuns but restrictions still apply as compensatory measures for stun errors. An interval exceeding 2 minutes for irreversible stun is considered excessive, except in the case of emergency slaughter where 4 minutes is acceptable.
- 6.4.3 All premises must have a stun/stick quality assurance programme which is documented and MAF approved. The MAF approval must show date of approval and signature and title of the approving officer.
- 6.4.4 Refer to the “Code of Recommendations and Minimum Standards for the Welfare of Animals at the Time of Slaughter at Licensed and Approved Premises” for further information.

6.5 STICKING (BLEEDING)

The approved methods are:

- 6.5.1 The thoracic stick, i.e. the severance of the anterior vena cava and bicarotid arterial trunk at the base of the heart. The skin is opened before the incision is made. (This does not apply to pigs.)
- 6.5.2 A transverse stab stick in the neck with an outward cutting action. The wool/hair over the stab site is to be parted first and a stiletto knife used.
- 6.5.3 A transverse incision in the neck, severing the carotid arteries. The skin is opened before the incision is made.
- 6.5.4 A transverse incision in the neck without the skin being opened first. This is the least preferred method. Extra care is necessary to ensure that contamination to the exposed tissues is minimised.

Collection of Blood

7.1 COLLECTION OF BLOOD FOR EDIBLE PURPOSES

7.1.1 Blood can be used for human consumption if:

- (a) it is derived from animals intended for human consumption which have passed ante and post mortem inspection;
- (b) it is collected in a hygienic manner approved by the Technical Supervisor, and;
- (c) positive identification can be maintained between the blood collected and donor animal(s) until such time as the donor animal(s) has passed inspection.

Note: Batch collection is acceptable. All donors contributing to the batch must meet the criteria otherwise all product in the batch will be condemned.

7.1.2 No blood shall be taken for the purposes of human consumption if it has:

- (a) been taken from a pig, or
- (b) been collected from animals condemned for disease conditions, or
- (c) been collected from a reactor to a diagnostic test, or
- (d) come into contact with the outer surface of any slaughtered animal, or
- (e) become contaminated in any way.

7.1.3 All equipment used for the collection of blood shall be of food standard and sterilised after each batch. Any equipment directly coming into contact with the animal shall be sterilised after each animal has been bled.

7.2 COLLECTION OF BLOOD AND OTHER TISSUES FOR PHARMACEUTICAL PURPOSES FROM IMMATURE CALVES

Refer Manual 7 for further details.

7.2.1 Calves must be slaughtered within 8 hours of arrival at the premises

7.2.2 Carcasses, blood and other tissues of these calves must not enter the edible human

food chain. Carcasses may be designated for use as byproducts, eg petfood. There are 2 cases where collection may occur:

Case A

A premises where edible processing occurs on the slaughter floor.

Case B

A premises where only pharmaceuticals and byproducts are being collected, ie the premises license conditions allow for the approved processing of by-products only.

- 7.2.3 In Case A blood collection from immature calves may occur on the slaughter floor. Other tissues may be collected into identified inedible containers once the inspection requirements of Manual 16 have been met. Collection of other tissues and any further processing of packing must occur in an inedible room.
- 7.2.4 In Case B collection, processing and packing can occur on the slaughter floor or in areas designated for the purpose after the inspection requirements of Manual 16 have been met.
- 7.2.5 Blood collection from immature calves can occur as per normal requirement for edible blood collection on the slaughter floor. The blood must be identified by batch or individual collection with each calf.
- 7.2.6 After collection in all cases the blood and other tissues will be deemed to be inedible. In Case A, i.e. premises storing or processing edible product, these byproducts may be frozen and stored in edible departments with edible product provided these inedible byproducts are fully packaged and sealed to the satisfaction of the Inspector, and cannot contaminate edible product.
- 7.2.7 At the time of packaging these byproducts must be labelled with the name of the contents, the statements “Not for Human Consumption” and “For pharmaceutical use only”. There must be a continuous red band around the container. Auditable inventory control systems are to be in place as part of the process approval to verify that substitution for edible product does not occur.

Delayed Evisceration

8.1 When a prolonged delay is expected or occurs MAF may require the opening up of the abdomen to assist heat loss. The extent of the opening and the disposition of the carcass and offals will be determined by the Technical Supervisor.

Note: Lunch or tea breaks are regarded as a deliberate interruption to the dressing and cannot as such be considered exceptional circumstances

8.2 Evisceration shall be routinely carried out as described in the Meat Regulations or Game Regulations

8.3 For the purposes of quantifying an acceptable lapse between stunning and the completion of evisceration, a total time of 45 minutes shall not be exceeded.

8.4 The 45 minute delay from stunning until the completion of evisceration shall be applied to the premises which cold or warm bone on the day after slaughter.

8.5 Hot Boning

In premises where dressing is deliberately interrupted, then the 90 minute boning constraint shall commence from the time of evisceration and not the end of slaughter (See IS 6)

8.6 Warm boning on the day of slaughter

In premises where dressing is deliberately interrupted then chilling performance shall be based on temperatures relative to the time of evisceration and not from the time of entry into the chiller (See IS 6)

Inspection Requirements

9.1 LOCATION

9.1.1 Adequate space shall be provided for full and unobstructed meat inspection.

9.1.2 No persons other than MAF or ASURE , or other approved persons, shall be stationed in the main chain areas set aside for head, carcass and viscera inspection.

9.2 MISSING PARTS

When parts of an animal required for inspection are not presented, the remaining offals and carcass shall be retained. An attempt is to be made to locate the missing items. These parts, when inspected, shall be condemned. The remainder of the product which has passed inspection can be released.

Export of product where missing parts have not been located or been able to be inspected is not an option except in the case of a single missing kidney. The Technical Supervisor has the discretion, following re-inspection of the animal, to allow the carcass and offals to be saved for human consumption on the domestic market.

9.3 INCOMPLETE EVISCERATION

9.3.1 Workman errors

Where incompletely eviscerated carcasses arrive at the final inspection stand because of workman errors, the carcass may be dealt with on the main chain or placed on the retain rail, together with all other parts necessary for inspection. This includes carcasses with pathological lesions of a minor nature which should not have affected evisceration. Repetitive faults may cause production to be slowed or cease (refer to Section 2.3).

9.3.2 Pathological conditions

9.3.2.1 Where there is sufficient cause for total condemnation, even when full inspection has not been performed, all parts of the animal shall be condemned.

9.3.2.2 Where there is insufficient cause for total condemnation, the inspector may allow the carcass to go to the retain rail for work-up together with all other parts necessary for inspection. The company has the option of disposing of the animal *in*

toto where work-up is not considered feasible, but while disease tickets will be drawn, a condemned ticket will not be issued.

Inspection Procedures

10.1 AUTHORITIES

Inspectors are authorised to make such incisions and inspections as are essential to determine the presence, character and extent of any condition which may have a bearing on the disposition of a carcass or any of its parts.

10.2 SAMPLING

Inspection staff are authorised to take samples for diagnostic testing whenever necessary.

Management will be informed whenever samples are being taken.

10.3 PROCEDURES FOR A LINE REQUIRING AN INCREASED INSPECTION WORKLOAD

10.3.1 When a condition requiring additional attention from inspectors (not including faulty dressing) is occurring frequently in a line, the Inspector in charge of the chain or slaughter floor will alter inspection staffing levels or require production rates to be varied.

10.3.2 Special procedures exist for caseous lymphadenitis and grass seed lines, as outlined in Section 24, *Sheep and Lambs*.

Disease and Defect Indicators

11.1 REMOVAL OF OFFICIAL MARKS

All indicators (discs, labels, tickets, etc.) used by MAF staff or Inspectors are official marks. Removal of these marks by any unauthorised person is an offence under the Meat Regulations.

11.2 IDENTIFICATION OF PRODUCT REQUIRING RE-INSPECTION

Manual 16 requires the existence of systems to identify products that need to be re-inspected. In addition to conveying information to company employees, inspectors and MAF staff as to the reasons for re-inspection and trimming, these systems also need to ensure that retained product remains under the supervision of ASURE and/or MAF until it has been passed as fit for purpose or until it has been condemned.

11.3 RETAIN LABEL (AGM74)

11.3.1 The retain label is a dark pink paper label, serially numbered, with a tear-off section.

11.3.2 The label is used to retain:

- any product pending a decision on its fitness for human consumption
- any product requiring re-inspection .

11.3.3 Retained product, when not under the direct supervision of an Inspector, shall be held in a MAF retention facility, i.e. a lockable chiller or cold store or lockable area within a chiller or cold store. Lockable rails are not adequate in EC- or US – listed premises.

11.4 CONDEMNED STAMP

The condemned stamp is a triangular stamp with the word CONDEMNED on it which is dipped in green ink before use.

The inspector shall place sufficient impressions on any condemned carcass, part or viscera to clearly indicate condemnation.

11.5 GREEN PAPER SQUARES

11.5.1 Green paper squares may be applied to:

- the paunch (in cattle, deer, sheep and lambs)
- the maw (in pigs).

Final Carcass Inspection

12.1 After receiving relevant information from the head, viscera and carcass inspectors, the final carcass inspector shall decide whether to:

- pass the carcass;
- or have the carcass diverted to the retain rail for further examination and to retain the head and viscera if necessary;
- or condemn the carcass and, if necessary, the head and viscera.

12.2 Carcasses will be passed if they are:

- free from diseases or defects, apart from minor bruising (< 6 lesions of maximum 50 mm greatest dimension and 25 mm deep), for all animals except farmed deer, and
- free from diseases or defects, apart from minor bruising (100 mm in its greatest dimension and <5 deep), for farmed deer only, and
- are clean, (not exceeding 10 closely associated) isolated strands of wool or hair, and/or a few scattered specks of sand, peat, pumice or dust. It is a management responsibility to remove these before the carcass leaves the slaughterboard. A final wash or hand held steam vacuum devices may be used for this purpose.
- free from materials of plant origin.

Viscera Table (or Gut Buggy) Operations

13.1 BEFORE INSPECTION

- 13.1.1 No offal or viscera shall be removed from the viscera table until inspection is completed.
- 13.1.2 Work-up operations on the viscera table shall be kept to a minimum until after inspection. To facilitate inspection, certain activities may be approved by the Technical Supervisor.

13.2 AFTER INSPECTION

13.2.1 Removal of edible products

The separation of weasand, paunch and intestines shall take place after all other edible products have been removed from the viscera table, unless separate trays are provided.

13.2.2 Petfood material

Food handlers shall wash their hands and arms after handling material which has been designated by an inspector as petfood. The removal of petfood material shall be done hygienically and in a manner which does not affect the collection and hygienic handling of product.

The requirement to wash hands and arms does not apply for kidneys that are disposed of as petfood for the sole reason of their possible cadmium contents. The washing requirement continues to apply if the kidneys are designated petfood for other reasons regardless of their possible cadmium contents.

13.2.3 Condemned material

All condemned material shall go over the end of the viscera table, or be tipped from a gut buggy directly into a condemned material chute. Slinks can be transported in secure facilities to the foetal blood room. Condemned heads may be removed by a non-food worker, or a food worker using a hook or similar device.

Any material which goes over the end of the viscera table must be treated as condemned.

Condemned material shall be kept inaccessible in secure locked facilities until denatured (secure locked facilities are not required for domestic abattoirs).

Retain Rails

14.1 **CARCASSES**

- 14.1.1 The entry point to the retain rail shall be after the carcass inspector(s) and before the scales and optional final carcass wash. The carcasses on the retain rail shall be kept separated from one another until after they have been passed by an inspector.
- 14.1.2 A dead rail may be provided for those carcasses which require more time to make them acceptable. Carcasses on the dead rail shall be kept separate from one another at all times.
- 14.1.3 A carcass bearing the retain label shall not be attended to by company employees until after examination by an inspector.
- 14.1.4 No condemned or un-passed carcasses or parts are to be left on or beneath the retain rails or on viscera tables during work breaks unless they are under the direct control of an inspector or denatured in an approved manner.

14.2 **OPERATIONAL PROCEDURES**

Detained carcasses which have not passed inspection are to be placed in the detain facility or held on the retain rail. Carcasses may subsequently be passed without restriction or be released for boning under specified conditions.

The maximum permitted holding time on the retain rail for both warm and cold boning operations is 30 minutes. In a hot boning situation, any holding time must be included in the 90 minutes specified by IS 6.

14.3 **CONDEMNATION IN LIEU OF DETAIN FACILITIES**

For New Zealand standard only, the company may elect to dispose of detained carcasses by condemnation.

Before this option is selected, the Technical Supervisor shall inform the company of disease conditions and defects which are likely to cause carcass detention and therefore carcass condemnation and discuss the potential implications (including disposal of condemned carcasses).

If this option is selected ALL carcasses which are detained under regulation 128 of the Meat Regulations 1969 and regulation 113 of the Game Regulations 1975 shall be condemned, and the conditions outlined below shall apply.

14.4 **COMPANY RESPONSIBILITIES**

- 14.4.1 Company personnel shall be adequately trained in the recognition of defects and their hygienic removal.
- 14.4.2 Any parts removed shall be placed into a condemned chute or container and shall not be dropped on to the floor.
- 14.4.3 Hygiene shall be maintained. Hands shall be washed, and knives and equipment shall be washed and sterilised after each carcass, or immediately if they become contaminated.

Final Dressing Procedures

- 15.1 After carcass inspection company personnel shall attend to passed carcasses by removing:
- (a) minor contamination (by washing or trimming)
 - (b) minor bruising
 - (c) the umbilicus
 - (d) the root of the penis
 - (e) heifer udder remnants
- before the carcass leaves the slaughterfloor.

Procedures for Defective Animals (Suspects)

16.1 ANTE-MORTEM PROCEDURES

Refer to Manual 4.

16.2 ARRANGEMENTS FOR SLAUGHTER

The Technical Supervisor shall consult with management to arrange the time of slaughter of suspects, after which the slaughter board shall be fully or partially cleaned and/or sterilised depending on the post mortem findings and the degree of contamination of the slaughter floor.

16.3 PROCESSING OF SUSPECTS

- 16.3.1 All personnel concerned shall be told when suspect animals are being presented for slaughter so that they may take the necessary precautions.
- 16.3.2 Suspect animals are retained for further inspection. Positive identification of the head, viscera and carcass shall be maintained throughout the dressing procedure. When necessary any additional tissues or organs as directed by the veterinarian shall also be retained.
- 16.3.3 A veterinarian shall supervise the inspection of heads, viscera and carcasses from suspect animals and shall make the final judgement.
- 16.3.4 The area and time of veterinary handling of suspect animals shall be confirmed by the Technical Supervisor after consultation with the company. The following two methods, or a combination of them, may be used.
- 16.3.5 After normal inspection is completed, the head, viscera and carcass, (with the AgM74s attached) shall be retained in the retain area for re-inspection and final judgement by a veterinarian.
- 16.3.6 The carcass is held as long as necessary at the final inspection point. The carcass, with the head on the head rail and the viscera on the viscera table or in the gut buggy (all identified with AgM74s), shall receive the necessary inspection under the immediate supervision, and subject to the final judgement, of a veterinarian.

Note: The duties normally assigned to a veterinarian may be performed at domestic premises by the supervising meat inspector or sole charge inspector.

16.4 FURTHER INVESTIGATION

Suspect carcasses retained for further investigation shall not be branded with the inspection legend. They shall have retain labels attached to each carcass, quarter or side, and shall be held chilled in a MAF security area. Retained carcasses may be boned and held in carton form (Refer to Meat IS 6)

Cases for Veterinary Disposition

17.1 A veterinarian shall make a final judgement of:

- (a) animals designated SUSPECT
- (b) animals in which tuberculosis is found
- (c) any other cases predetermined by the veterinarian
- (d) any case where a meat inspector is in doubt and arranges for the carcass, head and specific viscera to be retained with AgM74s.

The duties normally assigned to a veterinarian may be performed at domestic premises by the supervising meat inspector or sole charge inspector.

Branding with the Inspection Legend

- 18.1 For application and security of the brands and inspection legend refer to the Overseas Market Access Requirements (Manual 12)

Pet Food Carcasses

- 19.1 Certain categories of carcasses which would otherwise be condemned may be salvaged for pet food at company discretion. Refer to IS 7.
- 19.2 For disease statistics, petfood carcasses shall be recorded as condemned.
- 19.3 The carcass inspector shall make one knife slash per side of petfood carcasses from (and including) the hind leg, along the back and over the shoulder.
- It is then management responsibility to:
- excise all lesions and immediate surrounding tissue, placing them in a condemned container or chute.
- make a second knife slash per side parallel to the first one.
- brand the carcass with the petfood stamp, using black ink, four times per side (leg, loin, rack and shoulder) so that the ink penetrates the identification slashes.
- 19.4 These procedures shall be completed before the carcass leaves the killing floor, MAF ancillary facilities, or other specified area approved by the Technical Supervisor.

**Part B. Specific Controls for
Individual Species**

Cattle

20.1 SLAUGHTER AND DRESSING

20.1.1 Standards

The export standard for cleaning and sterilisation of equipment is that equipment coming in contact with exposed product prior to inspection must be washed and sterilised between carcasses

20.1.2 Sticking (bleeding)

All cattle shall be bled in a hanging position, except those slaughtered in accordance with Muslim or Jewish rites.

20.1.3 Trotter removal

Although not good manufacturing practice, trotters may be removed by incision directly through the skin and joint in cattle.

20.1.4 Skinning the head

The internal and external cheek muscles shall not be dropped before inspection. This permits the head inspector to fully inspect these muscles in their natural position.

The company shall ensure that heads presented for inspection:

- are clean
- have the tongue properly dropped
- have the head lymph nodes present and intact.

20.1.5 Viscera table

- a) The boots worn by the eviscerator(s) on the viscera table shall have a clear distinguishing mark approved by the Technical Supervisor.
- b) These boots shall only be worn on the eviscerating stand, or on the viscera table or in the washing compartment, and shall be washed regularly with 82°C water.
- c) A cabinet designed to prevent cross contamination between the eviscerator's

boots and their other footwear shall be provided on the stand.

d) Changing of footwear shall take place on the stand.

20.1.6 Presentation

The carcass shall be split before the final inspection.

20.2 TB CARCASSES

Suspect carcasses awaiting laboratory confirmation shall not be branded but shall be tagged and held in MAF retention facilities. Carcasses may be boned and the product held in cartons (see IS 6).

Tb-confirmed or reactor carcasses that have been passed for the domestic market shall be branded.

20.2.1 Branding in all premises

The inspection legend shall be applied four times per side (shoulder, rack, loin and leg).

20.2.2 Branding in export premises

The carcasses shall be further identified with either:

- the correct markings according to NZS 8403:1987, or
- other nationally agreed grade striping approved by the Director (Animal Products), or
- a roller brand consisting of vertical parallel stripes to be continuously or intermittently repeated down the length of the carcass in the same position as the markings in NZS 8403: 1987. The stripes shall be 5 mm wide and separated from one another by 5 mm spacing. The width of the brand to be such that at least four bars are present. The length shall be such that they produce a readily visible brand. The brand colour is restricted to chocolate brown.

Carcasses may be released, boned under MAF supervision and placed in plain cartons without being branded as in section 21.2.4.

20.3 BOVINE PIZZLES

20.3.1 Definition: The bovine pizzle is the entire penis of bull or steer that has been severed from its pelvic attachment to the carcass and freed from the prepuce.

Without prejudice, bovine pizzles which are whole organs, severed from all attachments to the carcass and are free from disease and defects may be branded and/or certified for export (if requirements of OMAR (M12) are met as fit for edible purposes.)

The pizzle is to be removed from the carcass during dressing and presented for post-mortem inspection identified with other offals from that carcass. The pizzle is to be kept separate from other offals in the same manner as exists for tongues.

Bovine pizzles must satisfy the inspection criteria in Manual 16 if they are to be further processed and handled in offal rooms in a manner similar to tongues and consistent with the requirements of IS 6, offals

It must be noted that this is a New Zealand Standard. The acceptance of bovine pizzles produced to this standard by any market will need to be determined on a case by case basis.

It should be noted that some markets do not recognise tissues derived from the urogenital system as edible products regardless of the methods of production.

Bobby Calves

21.1 DRESSING

The dried up portion of the umbilical cord shall be removed by trimming before the hide is removed, but the skinned umbilicus shall be left intact for inspection.

21.2 VELLS

Vells contaminated with ingesta or intestinal contents may be saved for rennet extraction (refer to IS 6 and 7). They shall be handled separately from edible product.

21.3 HEADS

Eyelids, pieces of scar and related tissue (less than 2 cm in diameter) at the horn bud site and tissue within the lacrimal fossa (wax eye), but not extending beyond the rim of the depression, are not regarded internationally as significant sources of cross contamination. The head is still considered to be fully skinned if it still has these tissues.

Where heads and tongues are not saved for human consumption small amounts of hide around the poll and eyes are acceptable.

Pigs

22.1 SEPARATION OF DRESSING AREAS

The area in which scalding and de-hairing (including gambrelling and singeing) are performed shall be physically separated from the area in which carcasses are eviscerated and inspected (except in abattoirs where separation by time may be acceptable).

22.2 SLAUGHTER AND DRESSING

22.2.1 Pig blood shall not be used for edible purposes.

22.2.2 Pigs shall be scalded effectively at a water temperature above 59°C. The temperature shall not fall below 59°C for scalding. Water hotter than 64°C is likely to result in unacceptable damage to the skin surface.

22.2.3 The skin need not be opened before the stick is made.

23.2.4 Pigs scalded before sticking shall be condemned.

22.2.5 After scalding and scudding, pigs shall be scraped and washed to remove all hair, bristles, scurf and claws. These operations shall **precede** removal of eyelids and ear canals, and trimming the stick wound. Hand held steam vacuum devices are permitted to be used (refer to TD 99/79)

Pigs need not be scalded and scraped if they are to be skinned. When skinning is practised it shall be carried out before evisceration.

22.2.6 No opening other than the stick wound shall be made into the carcass before it leaves the work-up area for the evisceration area.

23.2.7 Carcasses shall be physically separated from one another from the point of dehairing and/or the associated scraping table until the head, viscera and carcass have passed inspection. Procedures during bleeding, scalding and scraping are to ensure that contamination of the sticking wound is minimal.

22.3 EDIBLE LUNGS SAVED FROM SKIN-ON ANIMALS

Lungs may be saved for edible purposes from are dressed with skin-on provided that they have not been immersed in any water during scalding and dehairing

procedures.(See section 23 for Goats)

Carcasses are to be suspended from the hind legs throughout scalding and dehairing.

Goats

23.1 OVINE EQUIVALENCE

The specific procedures for sheep and lambs shall also apply to goats.

23.2 HIDE-ON CARCASSES

The hide may be left on the carcass. The hair shall be removed in the same manner as for pig processing, which includes scalding at a minimum temperature of 59°C. Other methods, which must include a scalding phase, may be approved by application to the Director (Animal Products).

23.3 EDIBLE LUNGS SAVED FROM SKIN-ON ANIMALS

Lungs may be saved for edible purposes from those that are dressed with skin-on provided that they have not been immersed in any water during scalding and dehairing procedures.(See section 22 for Pigs)

Carcasses are to be suspended from the hind legs throughout scalding and dehairing.

Sheep and Lambs

24.1 **TERMINOLOGY**

Unless otherwise specified, the word “sheep” used in this section refers to ovine animals of any age or sex.

24.2 **INTERIM HOCK REMOVAL SPECIFICATION**

24.2.1 Use of automatic trotter removers.

24.2.2 Automatic trotter removers shall be rinsed after each carcass unless the trotter is removed distally to the joint and the stub is subsequently shortened.

24.2.3 If for any reason the shears are grossly contaminated they shall be washed and sterilised between trotters.

24.2.4 The area where the trotter is cut off shall be exposed:

- either by complete skinning of the joint
- or by the removal of a strip of skin from the surface of the trotter facing the shears operator. The strip shall start above the joint and widen as it extends down the trotter. The strip shall be wide enough to allow the skin to move freely over the joint. The remaining skin shall be gathered to the rear of the trotter as it is held for removal.

24.2.5 The removal of the trotter by cutting through wool and skin distally to the joint and subsequent shortening of the stub after completion of pelting is also acceptable.

24.2.6 Manual trotter removal

The standard for the removal of hocks by knife remains unchanged ie cutting through pelt and wool is not permitted unless it occurs after the joint is severed. If the pelt is cut in this manner the knife shall be rinsed between trotters.

24.2.7 Pre-evisceration wash

24.2.8 Unskinned/incompletely skinned trotters may only enter the pre-evisceration wash if the wash water does not contact them.

24.2.9 Incompletely skinned and woolly heads are only permitted through the pre-evisceration wash provided that the wash is a low pressure high volume wash.

In such circumstances incompletely skinned and woolly heads must be below the carcass. Water contacting the head must only be run-off from the rest of the carcass.

24.3 DRESSING OF HEADS

24.3.1 The inspection of heads and tongues is unnecessary unless the parts are required for human consumption or if any part of the carcass or offals of adult animals is intended for USA. Uninspected heads are designated “condemned” and controlled accordingly, unless salvaged for pet food (24.3.4.4).

A documented approval from the Technical Supervisor is required.

24.3.2 Where inspection is required the heads do not have to be completely skinned. The degree of skinning will depend on:

- a) importing countries' requirements;
- b) the intended end use of the head and tongue;
- c) methods of conveying heads and extracting brains;
- d) the presence of a pre-evisceration wash;
- e) operational requirements.

24.3.3 Eyelids, pieces of scar and related tissue (less than 2 cm in diameter) at the horn bud site and tissue within the lacrimal fossa (wax eye), but not extending beyond the rim of the depression, are not regarded internationally as significant sources of cross contamination. The head is still considered to be fully skinned if it still has these tissues.

24.3.4 Presentation

24.3.4.1 *Heads and tongues for human consumption*

A fully skinned head, and clean head and tongue shall be presented for inspection with the pharynx and buccal cavity visible to the inspector. The inspector will not see the dorsal or lateral surfaces. These shall be checked by the company before removal from the table or carcass, and discarded if substandard. Repetitive non-compliance is a dressing fault.

24.3.4.2 *Tongues only, required for human consumption*

The head shall be skinned sufficiently to expose the pharynx and buccal cavity for inspection and to ensure hygienic removal of the tongue.

Present clean tongue for inspection.

24.3.4.3 *Brains only, required for human consumption*

The head shall be completely skinned unless an exemption is approved by the Director (Animal Products).

24.3.4.4 *Salvage for petfood*

If some parts of the head and tongue are saved for petfood and some for human consumption, then all parts shall be treated as intended for human consumption.

If neither the head nor the tongue is required for human consumption, any parts of the head can be salvaged for petfood without inspection, provided they are not defective in any way and not derived from carcasses condemned for disease conditions. Salvage may occur before inspection using batch collection procedures. A documented approval from the Technical Supervisor is required.

Certain countries require that pet food is inspected.

24.4 **ANCILLARY INSPECTION SITES**

24.4.1 The company may provide a suitable area after the scales for ancillary inspection sites.

24.4.2 Within these facilities company employees may, while under ASURE supervision, attend to:

- a) pre-ticketed minor pleurisy and sarcocyst cases;
- b) high incidence lines of CLA and grass seeds, where the whole line is deemed to be affected.

ASURE staff will inspect the carcasses and cancel disease indicator tickets when the carcasses are acceptable.

24.4.3 Hands shall be washed and knives and equipment washed and sterilised after each carcass, or sooner if they become contaminated.

24.4.4 The ancillary inspection sites shall:

- a) be a separate, well-defined area of the slaughterboard or cooling floor;
- b) have floor drainage which does not flow on to the main cooling floor or slaughterfloor, so possible contamination of carcasses which have passed inspection is avoided;
- c) have adequate hand-wash, steriliser and area wash down facilities;
- d) have the same intensity of lighting as inspection areas (750 lux; refer to IS 2);
- e) have provision for the disposal of condemned carcasses, parts and material without contamination of the work area or other carcasses (e.g. Ainedible” buckets and a suitably located Acondemned” chute);
- f) be clearly marked “ancillary inspection sites”.

24.5 CASEOUS LYMPHADENITIS AND GRASS SEED LINES

24.5.1 When:

- known high prevalence lines are presented for slaughter, and
- other high occurrence lines are found during inspection on the slaughterfloor,

they may be dealt with in the ancillary facilities.

All carcasses in the line, except those condemned or diverted to the immediate retain rail, shall be sent to the ancillary facilities.

24.5.2 Any system of identification may be used, provided the Technical Supervisor is satisfied that positive control of the carcasses is maintained to ensure they arrive in ancillary facilities (or in another specified suitable area).

24.5.3 The final carcass inspector shall permit transfer to the ancillary facilities, of carcasses with:

- a) no obvious lesions,
- b) grass seed lesions

- c) small encapsulated CLA lesions, and
- d) minor pleurisy and sarcocyst cases carrying the appropriate tickets.

Note: These minor pleurisy and sarcocyst cases may be kept with their line when the CLA line goes directly to, and is dealt with in, Ancillary Facilities.

24.5.4 Company employees shall:

- a) in the case of CLA, incise the prescapular, precrural and superficial inguinal (in both male and female) lymph nodes;
- b) remove all CLA lesions under ASURE supervision;
- c) maintain appropriate hygiene standards at all times.

24.5.5 Company employees shall attend to minor pleurisy, grass seed and sarcocyst cases in the ancillary facilities, or the immediate retain rail on the slaughterfloor.

24.5.6 ASURE staff shall re-inspect the carcasses.

24.5.7 An alternative method for dealing with the line.

Management may have company employees incise the lymph nodes before inspection on the main chain, provided there is sufficient space. In this case conveniently located hand wash facilities and sterilisers shall be provided. This will permit main chain inspection of incised nodes without having to transfer the line to ancillary facilities. To complete node incision and full inspection the chain speed may have to be slowed.

24.6 HANDLING CONDEMNED OVINE HEADS

24.6.1 The following section outlines the procedures, if either of the following two incidents occur:

- a) Handling both condemned ovine heads and edible heads on the viscera table without the mandatory washing of hands.
- b) Misdirecting condemned heads into the edible chute containers

Note: “Products” indicates brains, eyes, head meats and whole heads.

24.6.2 Where an operator has handled heads as in 24.6.1 (a) and/or (b) the following procedure is to be implemented:

- Condemn all contaminated edible heads and product if they are available
- Where any product contact surface (e.g. chute) has been or may have been contaminated by condemned material it shall be cleaned and sterilised before being used for edible heads.

24.7 OVINE GAS DE-PELTING

24.7.1 Process

Gas de-pelting of ovine carcasses may be carried out using either:

- a) food grade bottled carbon dioxide, or
- b) compressed air. When compressed air is generated on-site, the air shall be filtered, the source must be clean and external to the building. The filters shall comply with ISO 8573.1 for filtering air that is used in contact with food.

The injection needle shall be sterilised before use on each carcass according to a documented process.

Premises intending to use gas de-pelting on a production basis shall have an approved HACCP plan, refer to MISC Circular 99/MISC/7 and OMAR 99/196. Note: production basis will include all commercial production whether processing is continuous or intermittent and dependent on EU market eligibility.

24.7.2 Microbiological monitoring

Initial Studies

For premises where no previous approved gas de-pelting studies have been carried out:

- a) a microbiological validation of the process shall be conducted, in conjunction with commercial studies, according to the requirements for validation of HACCP plans, *Guide to the Implementation of HACCP Systems in the Meat Industry, Appendix IX.2, Section 13, Slaughter and inverted dressing of sheep and lambs*.
- b) An initial study must show that gas de-pelting performs at least as good as the existing process control, as determined immediately after pelting at the NMD site(s).
- c) Validation should also include visual assessment of the process and take into consideration other carcass sites which may be appropriate to use for microbiological validation and CCP determination.
- d) Processes which meet the criteria specified in 24.7.2 (a), (b) and (c) above may be deemed to be validated by personnel in the Verification Agency who hold NZQA unit standard 12626.

- e) The lot of product produced from initial studies may only be released after microbiological validation has satisfied the condition in point 24.7.2
 - any lot of product that fails to satisfy the condition in point 24.7.2
 - shall be regarded as failed process product, see IS 6 Section 2.
- f) The results of the validation study shall be retained, and be provided to MAF Food on request. [This may be necessary for market access purposes.]

24.7.3 On-going processing

For processing on a production basis, i.e. where the premises has carried out initial trials in accordance with section 24.7.2 and has a validated and approved HACCP plan, routine sampling of gas de-pelted carcasses shall be carried out according to the requirements of the NMD. NMD Data from gas de-pelted carcasses shall be identified on manual report forms (or electronic equivalent) by entering "gas de-pelted" (GDP) in the process description box.

24.8 **OVINE PIZZLES**

24.8.1 The ovine pizzle is the entire penis of a male ovine animal that has been severed from its pelvic attachment to the carcass and freed from the prepuce. Without prejudice, ovine pizzles which are whole organs, severed from all attachments to the carcass and are free from disease and defects may be branded and/or certified for export (if market access has been negotiated) as fit for edible purposes.

24.8.2 The pizzle is to be removed from the carcass during dressing and presented for post-mortem inspection identified with other offals from that carcass.

24.8.3 The inspection criteria for pizzles is outlined in Manual 16.

Ovine pizzles that pass inspection are to be further processed and handled in offal rooms consistent with the requirements of IS 6, offals.

24.8.4 It must be noted that this is a New Zealand standard, the acceptance of ovine pizzles produced to this standard by any market will need to be determined on a case by case basis.

It should be noted that some markets do not recognise tissues derived from the urogenital system as edible products regardless of the methods of production.

24.9 **OVINE KIDNEY ENUCLEATION**

24.9.1 The use of filtered compressed air to remove the kidney capsule of ovines is permitted, however cortical damage should not occur with this practice.

Horses

25.1 GREY OR WHITE COLOURATION

The attachment of one shoulder of each carcass shall be loosened before inspection to permit the inspector to examine the muscles and lymph nodes beneath the scapular cartilage for melanosis and melanomata.

Farmed Deer

26.1 ASIAN EDIBLES

26.1.1 Eye teeth

Collect after the head has been inspected and after any other edible head meats are removed.

26.1.2 Tails

Tails may be removed by an incision directly through the skin providing the tail stub is subsequently removed and discarded.

26.1.3 Pizzles, tendons and tails

Inspection of the individual items is not required. Products are eligible for collection if they have been derived from animals that have been passed as fit for human consumption.

The licensee is responsible for ensuring that the items are collected from eligible animals, that a quality check is made to exclude defective items, and that procedures for hygienic collection, handling and preparation are in place

26.2 SKINNING OF DEER HEADS

26.2.1 Dressing of heads

Deer heads are to be presented for inspection. However, heads do not have to be completely skinned. A documented approval from the Technical Supervisor is required if complete skinning is not carried out.

The degree of skinning will depend on:

- Importing country requirements;
- The intended end use of the head and tongue;
- Methods of conveying heads and extracting brains;
- The presence of a re-evisceration wash;
- Operational requirements

Eyelids, pieces of scar and related tissue (less than 2 cm in diameter) at the antler bud site and tissue within the lacrimal fossa (wax eye), but not extending beyond

the rim of this depression, are not regarded internationally as significant sources of cross contamination. The head is still considered to be fully skinned if it still has these tissues.

26.2.2 Presentation of deer heads

Heads from which nothing is to be saved

For heads from which nothing is to be saved, heads may be presented for inspection in the partially skinned state provided that:

- (a) there is no opportunity for cross contamination with product;
- (b) the head shall be skinned sufficiently to expose the pharynx and the buccal cavity;
- (c) all lymph nodes are left in situ and exposed for inspection.

Heads where tongues are saved

For heads where tongues are saved, heads may be presented for inspection in the partially skinned state provided that:

- a) there is no opportunity for cross contamination with product;
- b) the head shall be skinned sufficiently to expose the pharynx and the buccal cavity and permit hygienic removal of the tongue;
- c) all lymph nodes are left in situ and exposed for inspection.

Heads where head meats/brains are saved

For heads where head meats/brains are saved, heads shall be presented for inspection in the fully skinned state. Tonsils shall be left intact and attached to the head.

26.3 TB CARCASSES

26.3.1 Retained carcasses

Suspect carcasses awaiting laboratory confirmation shall not be branded but shall be tagged and held in MAF detain facilities (the requirements of IS 6.17 apply). Carcasses may be boned and the product held in cartons.

Wild Game

27.1 Heads of feral deer are required to be retrieved.

It is strongly recommended that the head remains attached to the carcass. Heads may be detached under the following conditions:

- Positive identification (as defined in section 9.6) of the carcass, viscera and head shall be maintained from the time of bleeding through to post mortem inspection.
- The method by which positive identification will occur shall be documented. The system shall be approved and audited by the Technical Supervisor. The method used shall be permanent and indelible, for example: imprinted plastic tags fixed to the skin of the carcass, head and if necessary, the viscera.

27.2 Skinning and Completion of Dressing

Refer to Manual 14, section 14.83.