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Guideline Summary of NMD Technical Procedures All Red Meat Species (*ie all species excluding Poultry*)

All Species (excl. poultry) NMD technical specification, section reference, description.
Documented System / NMD Programme
<p>1.2 Table 1 (<i>Premises means MEs and PHs and Domestic equivalents</i>):</p> <p>a) Bovine, Ovine, Ostrich & Emu (<i>All Premises including domestic, EU &/or US Listed</i>): Participation Mandatory</p> <p>b) Bobby calf and Caprine (<i>EU &/or US Listed</i>): Participation Mandatory.</p> <p>c) Cervine – farmed (<i>domestic and EU Listed</i>): Participation Mandatory.</p> <p>d) Other Species or Premises: <i>Programmes are developed after consultation with the NZFSA – refer Table 1 for requirements.</i></p>
<p>1.3 NMD is now a NZ standard. If a domestic premises elects to conduct NMD for bobby or caprine it must comply with all requirements of NMD.</p>
<p>1.2, 6.6 Sampling plans must be adequately documented.</p> <p>All sections, 2.10.1.1, 2.10.1.3, 2.10.3, 2.10.4: Any variance from NMD technical specifications must be documented, and be approved by NZFSA VA (<i>consultation with NZFSA may be sought prior to approval</i>).</p>
Demographics & Reports
<p>1.4 Demographic Premises details 5.5.1, 5.5.3 (re premises responsibilities)</p> <p>Details are to be documented and submitted to the NZFSA NMD Administrator when processing commenced AND whenever the process, species, premises or personnel changes. (using Form in Appendix 1).</p> <p>Electronic data records submitted to NMD shall further identify the process. Sample descriptors include: week beginning date (<i>Monday</i>), species (<i>refer below</i>) class (<i>refer below</i>), day, time of day, shift, run, process type (<i>eg. hot, cold, warm boning, gas depelting, steam vacuum etc</i>), name of sampler, collection time of samples, product details, etc.:</p> <p>NOTE: Lab reports should include the information supplied by the Premises AND the Premises should verify that this information was submitted to the NMD (particularly by Off-site Labs).</p> <p><i>Premises NMD controller should be informing the Lab & Samplers of processing schedules (so that appropriate sampling can be achieved – eg. of classes)</i></p>
<p>5.5.1, 5.5.4 All results must be reported to the NMD (NZFSA) no later than 2 weeks after date of sample collection.</p> <p><i>In practical terms, this means that results should be submitted to NMD on a weekly basis (ie the week after sample collection). Off-site laboratories may submit the results, however, the Premises must ensure that current submissions were made.</i></p>
Product to be Sampled, Frequency of Sampling and Sample Number
<p>2.6.1.3 Primal and BP meat produced from carcasses of another premises shall be sampled as if derived from the boning premises. <i>Premises of carcass origin shall be identified in records (under “product description”).</i></p> <p><u><i>Secondary processors are not required to sample product from another premises that has either been chilled in the carton or thawed from frozen.</i></u></p>
<p>2.3 Table 2, 2.9 Table 7 Post Slaughter Carcasses, Primal Cuts & Bulk Pack Meat</p> <p>Sampling of each product type is performed weekly</p> <p><u>For EU and US Listed - Samples are collected from:</u></p> <p>Bovine, B/Calf & Caprine: five (n=5) carcasses (3 sites/carcass) + five (n=5) primal cuts + five (n=5) bulk pack cartons] five (n=5) carcasses only (1 site/carcass)],</p> <p>Ovine: five (n=5) carcasses (1site only [Y-cut]/carcass)</p>

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Cervine *farmed*: three (n=3) carcasses (3 sites/carcass) + two (n=2) primal cuts].
O&E: two (n=2) carcasses only (1 site/carcass)].
* For BP whole tissue sampling, refer to 3.4.2 below.

For Domestic and non EU and non US Listed - Samples are collected from:

Bovine: one (n=1) carcasses only (3 sites/carcass),
B/Calf & Caprine: *Not required under NMD*
Ovine reduced sampling : five (n=5) carcasses (1site only [OYC]/carcass)

Cervine: three (n=3) carcasses per week, (3 sites) + two (n=2) primal cuts per week

O&E: one (n=1) carcasses only (1 site/carcass)].

2.10.1.5 The initial item shall be randomly selected. Each item shall be selected, sampled and returned to the line before the next item to be sampled is collected.

NOTE: Where sampling is not required under NMD Technical Procedures, Operator is to ensure an approved sampling programme.

2.3-Table 2, 2.4, 2.6.1.2, 2.7.8, 2.9 Table 7 Post-Chill Carcasses (cold and warm boned only)

Applies to EU and/or US Listed premises only. Domestic only or export (non-EU and non-US) are excluded.:

Bovine, B/calf & Caprine only

- Samples are taken at the beginning of the season (1 October or thereafter when "usual" chiller loading capacity is achieved, B/calf may be earlier due to short season – s2.4).

- Samples are also taken when the NMD Programme is commenced or the chiller Operating Parameters change significantly.

- 30 carcasses must be sampled [ie. 5 carcasses per week for 6 consecutive processing weeks, if sampling takes more than 6 weeks it must be justified].

2.2.1, 2.2.3, 2.2.4, 2.3-Table 3 Very Low Throughput (VLT) Premises - Based on throughput of previous season:

EU &/or US Listed (VLT): Bovine, Cervine: ≤ 100 / week Caprine & B/calf : ≤ 400 / week Ovine*, O&E: Not Applicable

Export (non-EU & non-US) or Domestic (VLT): Bovine and Cervine : ≤ 100 / week All other Species: Not Applicable

If the above limit is exceeded in any week, sampling must be done at the normal rate for the remainder of the season.

2.2.1, 2.2.3, 2.3-Table 2 Very Low Throughput (VLT) Sampling:

EU &/or US Listed (VLT)

Bovine, B/calf & Caprine: sample one (1) item /wk of each product (Carcass, Primal, BP) per week to a total of 16 samples (ie. If the season is less than 16 weeks, sample more items per week). (For Post Chill Carcasses, collect 1 sample/wk for 6 wks)

Cervine: as per Bovine for Carcass & Primal. (For Post Chill Carcasses, no samples are required)

Ovine, Ostrich & Emu: Not Applicable

Export (non-EU & non-US) or Domestic (VLT): Cervine: as for EU &/or US listed All other Species: Not applicable

Note: For NMT moving windows (Bovine, B/calf), standard sampling can only be discontinued when the window is NOT in "m-alert".

Salmonella Testing Programme – Salmonella Performance Standard

Applies to all products (except chilled carcasses) and all species, except ovine.

2.5, 2.7.7 = 8.2.22 Figure 10, 2.8, Table 6, 2.9 Table 7

2.5.1 Group 1 Salmonella: Bovine, Bobby Calf, Caprine, Cervine

Seasonal sampling window commencing at the beginning of the season 1 October, or earlier for bobby calves.

- Testing shall continue for a minimum 16 week PSW for each product. Sampling may cease with accredited verifier (NZFSA VA)

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approval (in writing) where no detection's occur.

- The PSW is to be followed the next season by a 6 week SSW for each product.
- Detections result in immediate re-commencement of a new PSW in the next sampling week.
- Premises shall continue sampling into the next season if the season is shorter than the PSW or SSW. The PSW or SSW carries over into the next season.
- Where Significant modifications to an RMP have been made to Premises or Process, a PSW shall immediately commence.

2.5.2 Group 2 Salmonella: Ostrich & Emu - Salmonella sampling every processing week

Sampling Location within the Process

2.6.1.1 for Carcasses Post-Slaughter, samples must be collected:

- no later than 30 minutes after PM Inspection, before any processes are conducted that may impact on the NMD carcass sampling sites
- dead rail may be used for sampling,
- Bobby calves immediately after inspection, after navel removal, and prior to any further trimming.

Samples must NOT be collected from:

- product Detained by VA, MAF or <asure>,
- sampling sites that have undergone processes that may impact on the microbiological consequences of slaughter and dressing (such as; *stacking, gross trimming, washing, rail stimulation, worker contact during marshalling etc.*)

NOTE: Rotate through chains on weekly basis in Premises with multiple chains.

Record: time of sampling, run, shift, species, class and process type (eg. *inverted, traditional, gas depelting, hot boning, cold or warm boning, vacuum decontamination etc.*)

2.6.1.2 for Carcasses Post-Chilling

Note 1 *This does not apply to hot boning*

- samples must be collected within the chiller,
- a) within 24 hrs after onset of chilling; or,
- b) If held in the chiller for <24hr immediately prior to: quartering, boning, loadout, entering freezer (if carcasses are to be frozen) or wrapping (if carcasses are to be wrapped and transported).
- *Onset of chilling is defined as the time when last carcass is loaded and door closed, or when the data logger is attached and activated.*

Record: chiller identification, boning process (eg. cold/warm boning), number of hours chilled, neck strung carcasses etc.

2.6.1.3 Primal & Bulk Pack Meat

Primal Cuts* (Bovine, B/calf, Caprine, Cervine.):

- collect samples immediately prior to vacuum packing, wrapping or bulk packing into cartons.
- sample cuts from from an original surface at a corresponding site to that for carcass samples. (see Table 4: primal cut descriptors)
- Bovine, bobby calf, caprine: hindquarter cuts only. Note that bovine primal cuts do **not** include rump
- Venison only: sample hindquarter cuts AND forequarter cuts. *Also, record whether de-sinewed or intact.*

Bulk Pack (85-95VL)* (Bovine, B/calf, Caprine.):

- collect samples immediately prior to closing and sealing / strapping a full carton.
- rotate on a weekly basis through different BP (85-95VL) products. Where no boneless product is produced, sample from Trim (60-85VL). See Table 5: Bulk pack descriptors.

*Note 1: rotate sampling through rooms on weekly basis in Premises with multiple boning rooms.

*Note 2: primal and bulk product descriptors, are available on the web based data entry sheets.

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Record: time of sampling, species, class, description of boning process (cold, warm, hot), primal cut type, bulk product type and bulk VL/CL %

Carcass Sampling Sites

2.7, Table 7 Sampling sites for Post Slaughter Carcasses are described in the text and photographs for each species.

Bovine 2.7.1, Fig. 3: Rump (Hindleg site), Flank, Brisket (Note that "rump" is situated on the hindleg above the tail)

Ovine 2.7.2.1, Fig. 4: Forequarter Y-cut only

Caprine 2.7.2.2, Fig. 4: Outside hind-leg, Flap, Forequarter Y-cut

B/calf 2.7.3, Fig. 5: Fore-rump, Flank, Foreleg *Note: the side that APC/E. coli swabs are collected from must be recorded.*

Cervine - *Traditional* 2.7.4.1, Fig. 6: Posterior hind-leg, Sternum, Inside foreleg

Cervine - *Inverted* 2.7.4.2, Fig. 7: Inside hind-leg, Brisket, Inside foreleg

Porcine 2.7.5, Fig. 8: to be developed

Ostrich & Emu 2.7.6, Fig. 9: Leg Hung: Inside Leg (no premises using Wing Hung)

2.7.8, Table 7 Post Chill Carcass Sampling

Select the same site on the opposite side of the same carcass sampled Post Slaughter (*unless Salmonella sampling is being done – then choose another Carcass*). *NEVER sample a site that has previously been sampled.*

Observe the method used to ensure fresh carcasses previously sampled are traced/identified.

Where matching is impractical, post chill samples may be selected randomly from a single chiller, rotating weekly around all chillers (up to a max. of six chillers)

2.7.7, Figure 10, Table 6 & Table 7

APC/E.coli & Salmonella Sampling (Bovine, B/calf, Caprine, Cervine, O& E)

Carcasses: Two individual sets of samples are to be collected; one set for APC/E. coli AND one set for Salmonella (*as required for PSW or SSW*). The Salmonella samples form a pooled composite from all sites and carcasses.

Samples for APC/E. coli are to be collected from a single carcass side, alternating sides between carcasses for each new sample. The side of the carcass APC/E. coli swabs are collected from on bobby calves must be recorded (s 2.7.3).

Separate samples for Salmonella analysis are collected from the opposite side of the carcass to the APC/E. coli sample (*for adult Bovine, another side may be substituted if the opposite side is not available*).

Primal Cuts: from the APC/E. coli swabs taken, the Lab pools these samples for the Salmonella composite (ie., NO Salmonella swabs are taken - also ref 4.9.1.2)

Bulk Pack: from the pooled whole tissue samples, the Lab samples for APC/E. coli AND Salmonella - also ref 4.9.1.2

Note 1: For Ovine carcasses, only APC analysis is required, E.coli & Salmonella results are NOT required.

Note 2: Salmonella samples are NOT taken from Post-Chill Carcasses.

Note 3: for Sweden, Finland and Iceland and any other country requiring Sampling as per Sweden, Salmonella Sampling cannot be conducted as per 4.5 and 4.6 – refer specific Country Requirements.

Sampling Plan – Random Rotational Sampling

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2.10 Weekly sampling plan – Random Rotational Sampling

To ensure complete evaluation of the process is made samples must be selected randomly such that every animal has an equal chance of selection.

Where there are multiple red meat species processed a single selected time period can be used to sample all species

2.10.1 First priority: to sample the required carcasses, cuts and bulk for each species each processing week. Ensure that a random sampling plan is being applied for each species.

2.10.1.1 Random/rotational selection of Day:

All processing days for which a species is processed must be available for selection.

Initial random selection of a day must be followed by rotation through the remaining days until all available processing days have been sampled (*random selection only is not permitted - refer example in Table 8*).

Note 1: Ovine: Apply random/rotational selection to all days. Where practical constraints exist and less days are available for selection in a week, variation must be approved by NZFSA VA.

2.10.1.2 Random/rotational selection of class

For all Species, sampling shall be conducted weekly on a Random/Rotational basis (*a random sample selection macro is available from NMD Administrator*). One Class per Species is to be sampled each week

Bovine: prime, bull, cow Bobby Calf: veal Caprine: goat Cervine: fallow, 'other'-wapiti, red, hybrid, sika
O & E: ostrich, emu –*when both are processed* Ovine*: lamb (*only sample sheep when lamb is not available*)

**Note 2: For cervine only fallow and "other" need to be recorded for NMD purposes. Only 2 classes are defined.*

.All classes within a species must be covered over the equivalent number of weeks eg bovine has 3 classes, the 3 classes must be selected over the 3 week period in any order. Refer Table 9

Note: Carcasses, primal cuts and bulk pack meat to be sampled within a given week shall preferably be from the same class (unless limited by processing).

2.10.1.3 For Shift premises, samples must be collected alternately (on a weekly basis) from each shift – see Table 10 (*all shifts must be sampled - ref. 2.9.3 for modifications*).

Note 1: Variation to ovine may be approved by NZFSA VA.

2.10.1.4, 2.10.1.5 Random Selection of Run and Time

Choice of Run and Time within run must be randomly selected. (*Every Carcass, Primal Cut or Bulk Carton must have an equal chance of selection – refer Table 11 for examples*).

The initial item only (*such as a carcass or cut or carton*) is randomly selected (*eg. using time or carcass body number*). Subsequent items are chosen after the previous item is returned to the line.

If the carcass, cut or BP carton is unsuitable, select the next available.

Tolerance of 10 min either side of the time selected is acceptable, unless time segments (*not be greater than 20 minutes*) are used.

2.10.2 Departure from Originally Selected Sampling Period. (*refer 2.10.2 for details*) Changes from originally selected random sampling must be justified. Re-selection of days, shifts, class, product type, run or time, must be made randomly from remaining available options.

Sampling may commence +/- 10 min where the time selected is near the end of a run (*except where 20 minute blocks are selected*).

The key task is to collect the carcass, cuts and BP for each species each week. Where there is insufficient product, remedial actions may be taken (*eg. incomplete cartons, across runs, shifts or days, different classes, multiple product types, - refer 2.10.2 priorities*).

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3.4.2, Table 7 Bulk Pack whole tissue samples:

Collect samples from 5 Cartons.

For each carton, excise and pool **Five (5) x 10g** samples (*refer Fig. 11 and text details*).

Transport to the Laboratory

3.5.2, 3.5.5 Samples in bead bottles may be transported without diluent.

3.5.2, 3.5.3, Table 20 At Collection and during Transport, samples must be placed in an insulated container with a frozen coolant (*Samples must not directly contact coolant. Samples must never be frozen*).

3.5.2, 3.5.3, 3.5.5 During Collection and Transportation, sample temperatures (T_{int}):

- should not exceed **5°C**, and must not exceed **10°C***. *A refrigerator operating between 0°C - 5°C must be used to Store samples.*
- Where diluents are used, these must be maintained at T_{int} until analysis commences.

**Note: Temp. at arrival to the laboratory should typically be <5°C, but may be up to 10°C*

3.5.3 Swab & whole tissue samples: During transport, temperatures must be verified on occasion (*eg. data logger – refer to Manual for placement*).

For cold boned tissues, regular temperature logging must be performed from collection until analysis to ensure temperatures (T_{int}) are maintained.

3.5.4 Hot or warm boned whole tissue samples must be cooled rapidly to <5°C* before transportation or storage (*ie subsequent storage in a 0-5°C refrigerator*).

Trials must be conducted to ensure that: i) Temp. falls rapidly to <5°C, ii) Samples do not freeze, iii) Transportation times can be met, iv) For **hot boned** meat *E. coli* 916 inoculated into samples prior to cooling can be recovered satisfactorily.

**Note: a freezer may be used to cool samples rapidly, but the procedure must not freeze tissue or cold shock bacteria*

3.5.1, 3.5.3, Table 20 Sample analysis must be initiated within 24 hours of collection for individual samples or within 24 hours of collection of the first sample if multiple samples are collected.

On occasions when practical issues dictate, but not routinely, the maximum period between collection and analysis may be up to 30 hours (*reasons must be recorded*).

Note: Times apply to all laboratories and samples (On-site, Off-site, day shift samples and night shift samples)

Analysis Required

1.7.1 A LAS approved laboratory must perform all analyses.

– *refer to Laboratory Signatories (& Approved Laboratories) on Internet site: <http://www.nzfsa.govt.nz/animalproducts/milab/index.htm>*

Registers and Lists:

[Approved Laboratories List](#)

Registers and Lists - [Laboratory signatories](#)

2.7 Table 6 & 2.9 Table 7 Testing for *APC*, *E. coli* and *Salmonella* is required for Bovine, B/calf, Caprine, Cervine, O&E. *APC only* for Ovine

– *refer to Laboratory Signatories and Appendices of Official/Discretionary Tests on Internet site: www.nzfsa.govt.nz/animalproducts/milab*

Official Test numbers for APC: 2.1.2 spread plate, 2.1.3 Petrifilm or 2.1.4 Spiral plater

Official Test number 2.2.2 Petrifilm *E. coli*

Official Test number 2.4.3 *Salmonella*

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Report is to be signed by a LAS signatory with above tests in their scope.

Note: for Sweden, Finland and Iceland and any other country requiring Analysis as per Sweden, Salmonella Analysis cannot be conducted as per s4.9. – refer specific Country Requirements. Note that sampling requirements are different as well.

Microbiological Targets

6.1 In-house microbiological targets shall be set and results presented in a manner to facilitate early detection and visualisation of loss of control.

5.5.3 Regular Statistical Process Control Reports shall be produced including an appropriate analysis relative to Targets (eg. *trend analysis, statistical process control charts*)

6.2, 6.4 National Microbiological Targets (NMTs; Bovine & Bobby Calf) m-alert limits *E. coli*

6.2.1, 6.4.2 An ***E. coli* moving window (m)** shall operate for Carcasses (pooled sites, Post-slaughter), Primal Cuts and Bulk Pack, comprising 15 samples (3 weeks).

An "**m**" **Alert** shall be elicited for:

- Bovine: when ≥ 5 /15 samples have *E. coli* detections. (refer 6.2.1)
- Bobby calf: when ≥ 5 /15 samples have *E. coli* detections exceeding the 80th percentile.

Bobby calf (refer 6.4.2):

- Carcasses >17 cfu/cm² (log1.23)
- Primal Cuts >2 cfu/cm² (log 0.32)
- Bulk product >120 cfu/gm (log 2.08)

In response, the company shall:

- immediately review the process
- document factors that might have compromised hygiene
- take corrective action (if appropriate)
- NZFSA VA need not be notified

Note: NMTs are not designed as pass/fail criteria, nor will they routinely be used to detain product nor withhold certification when product is processed according to IS5 or an RMP.

6.2, 6.4, National Microbiological Targets (NMTs; Bovine and Bobby Calf) M-alert limits *E. coli*

6.2.2, 6.4.3 An ***E. coli* Upper Limit (M)** shall operate for Carcasses (each site, Post-slaughter), Primal Cuts and Bulk Pack.

An "**M**" **Alert** shall be elicited when ≥ 2 / 5 samples in any week have *E. coli* detections exceeding the following (ref 16.4.6, 16.5.4):

Bovine (Table 28):

- All products >100 cfu/cm² (log 2.00)

Bobby calf (Table 29):

- Carcasses >129 cfu/cm² (log 2.11)
- Primal Cuts >100 cfu/cm² (log 2.00)
- Bulk product >955 cfu/gm (log 2.98)

In response, the company shall:

- immediately review the process
- document factors that might have compromised hygiene
- take corrective action (if appropriate)
- NZFSA VA shall immediately be notified

Note: NMTs are not designed as pass/fail criteria, nor will they routinely be used to detain product nor withhold certification when product is processed according to IS5 or an RMP.

6.5 Ovine NMT 95th percentile "m" limits: APC

Applies to domestic only, and export non-US Listed (which includes premises that are non-US Listed but export to EU)

An **APC moving window (m)** shall operate for the Carcass Y-cut site comprising 15 samples (3 weeks).

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An "m" Alert shall be elicited when $\geq 3 / 15$ samples have $APC > \text{Log } 4.65 \text{ cfu/cm}^2$ ($>44668 \text{ CFU/cm}^2$)

In response, the company shall implement the actions detailed in s 6.5 for a First, Second or Third "m alert".

The Window is reset after an alert.

Note: NMTs are not designed as pass/fail criteria, nor will they routinely be used to detain product nor withhold certification when product is processed according to IS5 or an RMP. Notwithstanding this the premises must provide evidence that ovine NMT is reviewed each processing week and responses to m-alerts conducted as per section 6.5

6.6 All Species: A Documented System (and Record Keeping) for monitoring performance against Premises Targets and NMTs, and performing process reviews in accordance with s5.10 of IS8 (refer to NMD Technical Procedure s6.6 for details), shall be maintained. The accredited verifier (NZFSA VA) must have recognised the validity of documentation, and assessed & approved process review procedures prior to implementation.

Documentation shall include:

- Authorities, - Review Procedures (upon notification of 'Alert'), - Product Disposition, - Corrective Actions, - Preventive Actions.

(Note: Premises shall record results of review procedures when premises targets are exceeded, and for notified "alerts". Records shall include consequent corrective and preventive actions).

6.7, Table 30 Ranked Listings (Quarterly Profiles).

6.7.1 Bovine and bobby calf **6.7.2** Ovine (For domestic and US Listed premises) **6.7.3** Caprine, cervine, ostrich and emu
6.7.4 Ranking and alerts

Premises will be ranked for APC/E. coli based on the 80th percentiles/NMT for each species.

Premises eliciting an "Alert" shall be highlighted in **bold**, and should* immediately review the process and document factors that resulted in the "Alert" (If a premises has sufficient information to justify NOT conducting a review, it would be expected that these should be documented – ie doing nothing is not a justifiable option).

(Note: VA Verification of Quarterly Prevalence data and "alerts" may be used to gauge how the premises is performing relative to national averages, but this performance does not carry any non-compliance weight (unless the premises is also not achieving In-house or National Targets and has not taken an appropriate and documented response).

6.8, Table 31 The Salmonella Performance Standard (SPS) is described for All Species, including requirements for response to "alerts" (any detection).

- **6.8.1 Group 1 Salmonella:** Bovine, Caprine, Bobby Calf, Cervine. *Salmonella sampling is NOT required for Ovine*

Alert: Nil tolerance. *Refer to the responsibilities of the Premises, the accredited verifier (NZFSA VA) and NZFSA.*

- **6.8.2 Group 2 Salmonella:** Ostrich & Emu Currently not developed