



Standards for

Abattoirs, Cutting and Packing Plants



VERSION 4.0

January 2008





INTRODUCTION

ABM – representing Red Tractor Beef and Lamb

Assured Food Standards (AFS), the assurance organisation has restructured with six sector schemes integrating more closely behind the Red Tractor Logo (RTL). The re-organised Assured Food Standards (AFS) will manage the standards underpinning assurance on behalf of the whole food chain.

ABM now acts as the Beef and Lamb Sector Board for AFS and is responsible for:

- ❑ Setting Red Tractor beef and lamb assurance standards throughout the whole chain (farm, transport, markets and abattoirs)
- ❑ Licensing standards to various Certification Bodies (who will inspect and certify against them) and ensuring consistent delivery of assurance across all providers
- ❑ Maintaining a central database of all producers and businesses certified against the Red Tractor standards
- ❑ Promoting the benefits of assurance to both producers and businesses within the beef and lamb supply chain and to external bodies such as Government, Non Governmental Organisation's, Consumer organisations, etc
- ❑ Working with other beef and lamb assurance bodies throughout the UK to develop a commonly accepted approach to assurance

Scope of these standards

All ABM standards cover three main areas:

- Food Safety and Traceability
- Animal Welfare
- Environmental Protection

The Abattoir, Cutting and Packing plant standards are the final link in the beef and lamb assurance chain following farm, livestock transport and auction markets. They are intended for use within the whole sector regardless of business size (i.e. including small and medium sized abattoirs).

Revisions

The ABM Abattoir Standards have been compiled with the aid of the ABM Abattoir TAC:

- Norman Bagley, Association of Independent Meat Suppliers (AIMS)
- Jane Downes, Meat Hygiene Service (MHS)
- Ian Frood, ABM
- Annie Graham, ABP Ltd / BMPA
- Steve Leyman, British Meat Processors Association (BMPA)
- Peter Mitchell, Esca Food Solutions
- Chris Wood, G Wood & Sons Ltd / BMPA

The Standard has been updated in line with changes to current legislation and in particular HACCP requirements. In addition, the format has been rationalised and focused to avoid the duplication that was in previous versions.

It is now in 3 parts:

Core Standard:	Criteria applicable to all businesses
Module A:	Criteria applicable to abattoirs
Module B:	Criteria applicable to cutting and packing plants

Approach

ABM is aware of the duplication of Abattoir, Cutting and Packing plant standards within the industry. There has also been the need for a standard that is achievable by small/medium size operators.

ABM has decided to develop a modular route for Abattoirs, Cutting and Packing plants to become assured under the Red Tractor Scheme.

“Inspection and Certification to the BRC Standard and additional inspection to Module A and/or B of the ABM Abattoir, Cutting and Packing plant Standards”

Or, possibly more appropriate for small / medium size operators;

“Inspection and Certification to the ABM Abattoir, Cutting and Packing plant Standards as documented, incorporating the Core Standard and Module A and or B as appropriate”

UKAS (United Kingdom Accreditation Service)

These standards have been prepared within the UKAS requirements for compliance with EN45011, including industry involvement and public consultation.

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ABM Abattoir, Cutting and Packing Plant Standard

Scope and Objectives:

- The ABM Abattoir Standard covers abattoirs, cutting and packing plants.
- These Standards complement and complete the ABM Assurance Chain through farms, transport (Markets) and abattoir.
- At all times food safety, animal welfare and traceability are of high importance.
- The Company must be fully compliant with all current relevant legislation.
- The Standard aims to provide significant guidance to assist in the interpretation and incorporation of the ABM Scheme within the everyday operation of the Company.
- The Red Tractor Logo can only be put on meat derived from livestock purchased from an 'Assured Farm' and transported on 'Assured Transport' and slaughtered in an 'Assured Abattoir'.
- Certification to the ABM Abattoir Standard does not prevent the company from purchasing non-assured livestock or product, although this cannot be labelled with the Red Tractor Logo.
- The Company will be subject to an annual inspection cycle to ensure continued compliance with the standards and maintain certification.
- The Company will also be subject to random spot checks as determined by their Certification Body.

Standard:

- The standard is split into two sections. **All sites must comply with the Core Module.**
- In addition all Abattoirs must comply with Module A and all Cutting/Packing plants must comply with Module B.

CORE STANDARD

1.0 HAZARD ANALYSIS AND CRITICAL CONTROL POINTS (HACCP)

Std No	Standard	Guidance
1.1	All sites must have a fully documented HACCP system.	<i>The Company must be operating HACCP under the current legislation and the scope must be relevant to the site and production. The plant HACCP Team must be defined, have sufficient experience, and be suitably qualified to enable the team to cover all aspects of the process within the plant.</i>
1.2	The HACCP plan must be fully operational, maintained, reviewed and where appropriate, improved.	<i>The HACCP system must be the basis of food safety control. As part of the operation of HACCP, Internal audits must be carried out and documented, at least annually and include Cleaning Schedules, Temperature Controls, Pest Control, Review of Control Points and Verification of the HACCP system.</i>

2.0 MANAGEMENT PLAN

- The Company must have a Management Plan, which includes all aspects of this section.
- The Management Plan must be documented, reviewed and where appropriate, improved.

2.1 Management Structure

2.1.1	There must be a documented Management Structure.	<i>The Management Structure must show where positions of authority and responsibility are for each section of the business including Product Safety, Animal Welfare, Cleanliness and Hygiene.</i>
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2.2 Training

2.2.1	All staff must be trained appropriately to carry out their specific roles	<i>All members of staff involved in the production process must receive basic health & safety and hygiene training at induction.</i> <ul style="list-style-type: none">▪ <i>ABM recommends that all members of the process staff be trained to an appropriate national standard such as the Basic and Intermediate Food Hygiene Certificate and/or the Meat Training Council Foundation in Meat and Poultry Hygiene or similar once a suitable probationary period has passed.</i> <i>Training must be recognised by management as ongoing and further training of staff must be encouraged, be progressive, and undertaken, as needed.</i>
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2.2.2	Records of all training undertaken must be kept	
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2.3 Traceability

- The traceability system must comply with all current legislation and allow for any Voluntary Scheme verification and traceability procedures.

2.3.1	All material/product must be fully traceable	<p><i>Product/material must be traceable from raw material source to finished product and vice versa.</i></p> <p><i>The traceability system must be able to facilitate effective product recall when required.</i></p> <ul style="list-style-type: none"> • <i>Any claims of origin (e.g. English) or Farm Assurance must be identified, documented, independently audited and, where appropriate, comply with DEFRA voluntary beef labelling requirements.</i>
2.3.2	The traceability system must be tested on a quarterly basis and results recorded.	<p><i>Testing must take into consideration the number of products produced by the Company and be conducted by random product selection that reflects the different product ranges, including the species processed.</i></p> <p><i>Testing of the traceability system must be undertaken by a member of staff with senior authority and responsibility for Product Safety according to the Management Structure.</i></p>

2.4 Purchases

- The purchasing process must take into consideration processes and practices, which are critical to Product Safety, Legality and Quality.

2.4.1	The company must have an up-to-date list of all suppliers of goods used in the production process.	<i>The list of suppliers must cover all product/materials purchased by the Company which are to be used in the production process including Packaging suppliers and Cleaning material suppliers.</i>
2.4.2	Product specifications must be available where appropriate.	<i>Product specifications must be available for products that represent a food safety risk including chemicals used in the production of the end product (including the cleaning process).</i>
2.4.3	Detergents, disinfectants, sanitizers and other products approved for use in food premises must be used.	<i>These products should be effective in their intended use and correctly and adequately labelled.</i>

2.5 Product and Process Design

2.5.1	All material must be stored under conditions which minimise the risk of contamination and deterioration.	<i>The Company must take into consideration the risk of the surrounding environment and handling procedures on the safety of the product as required by HACCP</i>
2.5.2	The process flow must be designed to prevent cross contamination of raw material, packaging and finished product.	<i>This includes intake, segregation and storage of the product as required by HACCP.</i>

2.6 Documentation

2.6.1	All documents and records critical to the management and control of product safety, legality and quality must be available on request.	<i>Document and records required are: External and Internal Policy Documents and critical data as listed in appendix 2.</i>
2.6.2	All documentation must be effectively controlled to ensure they are up-to-date.	<i>All documents in use must be the latest versions, identifiable either through a version number or date.</i>
2.6.3	All documents must be authorised and dated.	<i>Authorisation must be undertaken by a member of staff with sufficient responsibility for the specific area of the business for which the document relates as per the Management Structure.</i>

2.7 Record Keeping

- Records must be kept to demonstrate product safety, legality and quality and facilitate the traceability process.

2.7.1	All documents and records must be kept as required by legislation or for a minimum of 18 months which ever is greater.	<i>All documents and records must be kept in a legible format and must be reviewed and maintained and available for inspection on request. Statutory record keeping is predetermined by legislation and relevant documents and records must be kept for the required periods. Where this is less than 18 months, the requirements of this standard must be adhered to and the records/documents kept for a minimum of 18 months. Quality documents/records not covered by legislation must be kept for a minimum of 18 months.</i>
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2.8 Corrective Action

2.8.1	The Company must have a record of all complaints.	<i>A complaint can be seen as both internal or external, either from internal hygiene audit non-conformance, foreign body contamination, product withdrawals, microbial testing results or external complaints i.e. customers or consumers.</i>
2.8.2	A documented product recall procedure must be in place and tested at least annually.	<i>The recall procedure must ensure that any product can be effectively and efficiently recalled to minimise the risk of any harm being caused to consumers. This must be tested annually as part of HACCP.</i>

2.9 Control of Non-Conforming Product

2.9.1	The company must have a procedure for the control of rejected product	<i>Rejected or “Non-conforming” product is defined as product which does not meet the requirements of the Product Specification. The product must be clearly identified, labelled and quarantined. A definition of non-conforming product is given in Appendix 3.</i>
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2.10 Microbial Testing and/or Inspection

- Suitable and sufficient in-process testing/inspection must be undertaken to ensure compliance with legal requirements.

2.10.1	Carcases and product contact surfaces must be tested, by means of microbiological testing, at regular intervals and the results recorded.	<i>A pre-determined schedule must be agreed with the site OVS. Records of these tests are to be maintained and prompt action (documented) taken when an adverse result is shown.</i>
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2.11 Good Laboratory Practice (where appropriate)

2.11.1	All laboratory testing must be appropriate to the product and according to customer specifications.	<i>Laboratory testing can be undertaken in-house or by an external contactor. Appropriate testing must be reflected in the tests, methods and frequency. A declaration from an external laboratory will satisfy that the requirements of this standard are complied with.</i>
2.11.2	Laboratory staff must be suitably qualified and/or trained in the test they are conducting.	<i>A record of this training must be kept as per the training section of these standard.</i>
2.11.3	In-house Laboratory facilities must be sited and operate such systems such as to prevent product contamination.	

2.12 Calibration

2.12.1	Relevant equipment must be regularly calibrated to ensure consistently safe and legal product.	<i>A list of what must be calibrated is shown in Appendix 4</i>
2.12.2	Records must be kept of all calibration exercises.	

2.13 Internal Hygiene Audit

2.13.1	The Company must conduct an internal hygiene audit prior to the commencement of work each day and document the results.	<i>Before each production period commences a full plant pre-production internal hygiene audit must be carried out, and documented, of all production areas, work surfaces and tools to ensure that they are of a suitable cleanliness to be used for production. A nominated member of staff with sufficient authority to prevent work starting if the hygiene standard is not correct must carry out the audit.</i> <ul style="list-style-type: none">▪ <i>ABM recommends that microbiological results from microbial testing are used as part of the audit.</i>
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2.14 Technical Support

2.14.1	The company must ensure that it is kept informed of legislation and industry developments which have an impact on food safety, animal welfare, hygiene and environmental protection.	<i>The Company must have a Technical Expert or be a Member of a Trade Association or other means of ensuring that they are kept up-to-date with the requirements.</i>
2.14.2	The company must be able to demonstrate an adequate level of technical support.	<i>An adequate level of Technical support must be capable of meeting the needs of the business and anticipating foreseeable problems. Technical support can be either in-house or by sub-contact services. A list of required services are provided in appendix 5.</i>

3.0 GOOD HYGIENIC PRACTICE

- The Company must demonstrate appropriate levels of hygiene in relation to food safety, animal welfare and environmental protection at all times.

3.1 Design and Facilities

- Abattoirs and cutting plants must comply with the requirements of the Council Directive 64/433/EEC, June 1964 and all subsequent amendments.

3.1.1	The fabrication of the site, buildings, facilities and equipment must be suitable for the intended purpose as required by current legislation.	<i>Wall, floors, ceilings, windows, doors, lighting, air-conditioning/ventilation, services and equipment must be constructed to withstand and facilitate thorough cleaning and minimise contamination of product, either through pests, harbouring of dirt or other physical, chemical or microbiological hazards.</i>
3.1.2	Access to the production site must be controlled.	<i>Access to the production site must prevent any unauthorised access to ensure the risk of product contamination is minimised.</i>
3.1.3	All staff facilities must be designed and operated so as to minimise the risk of product contamination.	<i>Staff facilities include toilets, showers and rest areas including eating, drinking and smoking areas; specifically wash basins, hand drying facilities and waste bins.</i>

3.2 Product Transport

3.2.1	All vehicles must be suitable for the purpose.	<i>Vehicles must be maintained in good repair and in hygienic conditions.</i> <ul style="list-style-type: none">• <i>Vehicles used for transport of meat must be refrigerated, clean, purpose built vehicles and constructed so as to be easily cleaned and prevent cross contamination of product.</i>
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3.2.2	Transport must be able to keep the product in conditions specific to the control of food safety and hygiene	<p><i>Conditions must be specific to the product and must include the internal environment (cleanliness and hygiene), temperature, and other products on the same vehicle to minimise the risk of cross contamination and maintain product safety and quality.</i></p> <ul style="list-style-type: none"> • <i>Carcases or cuts must not be allowed to touch the floor of the transport vehicle at any time, and boxed product must not be placed directly on the floor.</i> • <i>Boxed meat that is transported on the same vehicle as carcasses or cuts must be protected from contamination, and not placed directly on the floor (e.g. clean polythene sheeting may be OK in some instances)</i>
3.2.3	Refrigerated vehicles must be pre-chilled to a temperature before loading.	<p><i>The vehicles must be pre-chilled in order to maintain the core temperature of the product during transportation.</i></p> <ul style="list-style-type: none"> ▪ <i>The core temperature must not be allowed to rise above +7 degrees C for fresh meat, +3 degrees C for offal or -12 degrees C for frozen meat except where allowed under legislation to meet other customer requirements</i>
3.2.4	The transport temperatures for each load must be recorded	<i>Records can either be kept manually or via the vehicle being fitted with an automatic temperature-recording device and as required by HACCP.</i>

3.3 Water Supply

3.3.1	Potable water must be used for all operations throughout the plant.	<i>All water must comply with the EC Drinking Water Directive 98/83/EC (3rd November 1998) as required by HACCP.</i>
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3.4 Cleaning and Sanitation

3.4.1	The company must have a documented cleaning procedure which is regularly monitored.	<i>The cleaning procedure must relate to all sections of the site and include both equipment and the factory environment and ensure consistent hygienic standards throughout the site as required by HACCP</i>
3.4.2	The frequency of cleaning must prevent the build up of micro-organisms and contamination of products.	<i>During production periods a 'clean as you go' policy must be adopted and must include equipment, tools and utensils.</i>
3.4.3	The company must keep up-to-date records of all cleaning undertaken.	<i>The cleaning record must be kept in line with the cleaning procedure in 3.4.1 and as required by HACCP.</i>

3.5 Personal Hygiene

- The personal hygiene standards must be formulated with due regard for product contamination and safety.

3.5.1	Staff must maintain a high standard of personnel cleanliness and take all necessary precautions to prevent contamination of the meat and all materials used in the processing of this meat	<p><i>The personal hygiene standards must include:</i></p> <ul style="list-style-type: none"> • <i>A valid medical certificate must be held or each operative who may be assigned to handle fresh meat.</i> ▪ <i>Fingernails must be short, clean and free of nail varnish.</i> ▪ <i>Jewellery/Watches are not allowed with the exception of a plain wedding band and sleep earrings.</i> ▪ <i>Cuts and Sores must be covered with blue, waterproof, metal detectable dressings.</i> ▪ <i>Smoking, Eating and drinking must be carried out in designated areas which must not include the toilets or changing facilities.</i> ▪ <i>Hands and captive footwear are to be washed and disinfected on entrance to all production areas, or transferring from one area to another, where food or food products are being handled.</i> ▪ <i>Hands and tools are to be washed and disinfected as required to maintain product safety throughout the work period.</i> ▪ <i>Hand washing procedures must be in place to ensure effective hand washing.</i> ▪ <i>All illness of public health significance including symptoms such as diarrhoea and/or vomiting must be reported and recorded.</i> ▪ <i>Staff and visitors who have suffered from stomach disorders or any condition that may cause food borne infection within the previous 7 days must not be allowed to work or handle meat or meat products.</i> ▪ <i>Correct wearing of protective clothing including hairnets must cover all hair and ears, snoods for beards.</i> ▪ <i>Personnel moving between "clean" and "dirty" areas or the plant must change into clean protective clothing between areas.</i> <p><i>And be signed by all staff as agreement of adoption.</i></p>
3.5.2	Personal hygiene standards must be documented and adopted by all personnel including visitors.	
3.5.3	All visitors and contractors must complete and sign a Medical Questionnaire before entering production areas.	<p><i>Examples of a medical questionnaire are shown in appendix 8.</i></p>

3.6 Maintenance

- All maintenance must be carried out with due regard for product safety, legality and quality

3.6.1	A documented record of all maintenance carried out on the site must be kept.	<i>This includes routine maintenance to equipment including any manufacturers recommendations, and general site maintenance</i>
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3.7 Foreign Body Control

3.7.1	The company must take all necessary steps to identify, avoid, eliminate or minimise the risk of foreign body contamination.	<i>All systems for foreign body control must be regularly monitored and tested to ensure product safety, legality and quality. This may include metal detection where required and other control measures taken as part of the HACCP plan.</i>
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3.8 Pest Control

3.8.1	The company must have a documented procedure for the control of pests on site.	<i>The procedure must include the name of the trained person with responsibility for pest control and/or the name of the external pest control contractor, inspection dates and action taken as required by HACCP Appendix 6 provides further information on pests and pest control.</i>
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3.9 Temperature Control

- Temperature control must comply with current legislation at all times

3.9.1	The temperature of storage rooms and product must be monitored regularly and recorded.	<i>The monitoring system can either be manually recorded or automated, but must ensure that specified temperatures are maintained to confirm that product safety and quality are not compromised. Temperatures must be recorded at least twice a day.</i>
3.9.2	Meat and meat products must not be kept at temperatures above the legal limit.	<i>The core temperature must not be allowed to rise above +7 degrees C for fresh meat, +3 degrees C for offal or -12 degrees C for frozen meat except where allowed under legislation to meet other customer requirements.</i> <ul style="list-style-type: none">• <i>ABM recommends that Chilling procedures ensure that cold shortening is avoided.</i>

3.10 Handling and Storage

3.10.1	All product must be handled and stored with due regard for product safety, quality and legality.	<p><i>All product includes raw material and packaging and all product at all stages of the process from intake to removal from site. All packaging must be stored off the floor.</i></p> <ul style="list-style-type: none"> <i>All cut / packaged meat must be stored off the floor, in clean hygienic conditions.</i> <i>Wooden storage racks or pallets must not be used to store 'open' meat, and should be avoided whenever possible when storing packaged meat.</i> <i>Detergents, disinfectants sanitizers and other products approved for use in food premises must be stored in a separate chemical store away from all food products that they may contaminate.</i>
3.10.2	The Company must have a planned stock rotation programme.	<i>The Stock Rotation Programme must be monitored to ensure that product is not out-of-date or kept for periods that may have a detrimental effect on product quality and safety.</i>

3.11 Hygienic Production

3.11.1	Meat cutting and packaging must be carried out in clean hygienic conditions	<i>Production must be carried out at sufficient speed to minimize microbial growth or spoilage</i>
3.11.2	Suitable clean protective clothing is to be supplied and worn at all times whilst in production areas.	<i>Clean protective clothing, in the form of light coloured coats, headwear and footwear (overshoes are permitted), must be available for both staff and visitors / contractors and must be changed at least daily or more frequently as the job demands</i>

3.12 Labelling

3.12.1	All product must be labelled in accordance with current legislation and other voluntary Scheme licence requirements.	<i>Current legislation is listed in appendix A. Voluntary Scheme Licence requirements must be demonstrated and verifiable.</i>
3.12.2	All product must be clearly labelled in order to facilitate the traceability process.	

3.13 Waste Management

- All waste product must be disposed of in accordance with current legislation.

3.13.1	Waste and waste material must not be allowed to accumulate within the confines of the site.	<i>Waste must not be allowed to build up in production areas or outside the production facility, and must be removed at regular, pre-determined, intervals so as to potential contamination and/or attraction and harbourage of pests.</i>
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3.13.2	The Company must have procedures in place to allow for the safe collection, storage and disposal of all waste material.	<i>The Company must have due regard for the surrounding area and environmental risks associated with some forms of waste.</i>
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3.14 Contingency Plans

3.14.1	The Company must have documented contingency plans which are easily accessible to all members of staff.	<i>Contingency plans should include what to do in the case of a fire, line breakdown, accidents, vehicle breakdowns, and equipment failure.</i>
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MODULE A (ALL ABATTOIRS)

Scope:

- All Abattoirs must comply with the Core Standards and Module A of the ABM Standard **or** hold BRC Certification and be inspected against Module A of the ABM Abattoir Standards
- At all times food safety, animal welfare and traceability are of high importance.
- The Company must be fully compliant with all current relevant legislation.
- Only livestock purchased from an 'Assured Farm' and transported on 'Assured Transport' and slaughtered in an 'Assured Abattoir' can carry the Red Tractor Logo.

Objectives:

- The Company must have procedures in place to safeguard the welfare of animals at all times as well as food safety and traceability.
- The Company must be fully compliant with relevant SRM regulations
- The Company must have, and be guided by, the Humane Slaughter Association (HSA) Best Practice Guidelines for the Welfare of Cattle, Sheep and Goats, and Pigs in Abattoirs as well as MHS advice and instructions

4.0 Animal Welfare Policy

4.1	The Company must have an Animal Welfare Policy which is communicated to all relevant staff.	<i>The Animal Welfare Policy must include the written procedures with regard to maintaining animal welfare including the responsibilities and duties of staff and emergency procedures. This policy must be regularly reviewed, updated and conform to current legislation. An example of an Animal Welfare Policy is Shown in Appendix 7.</i>
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5.0 Design and Facilities

- Abattoirs and cutting plants must comply with the requirements of the Council Directive 64/433/EEC, June 1964 and all subsequent amendments.

5.1	The lairage must be designed so as not to cause distress or harm to the livestock.	<i>The design must encompass walls, flooring and pen construction. Pens, gates and races must be designed, constructed and maintained in such a manner that stress or injury to animals is minimized, and also be secure as to prevent livestock from escaping.</i>
5.2	The unloading bays must be designed to facilitate ease of unloading of all species.	<i>The angle between the tail ramps and the unloading facilities must be no greater than 29°. (Ramp angles must be measured from the floor to the top of the ramp.)</i> <ul style="list-style-type: none">• <i>Unloading docks should be provided to facilitate ease of unloading of all livestock.</i>
5.3	The lairage must provide access to clean drinking water for all livestock at all times.	<i>Drinkers must be positioned so that all classes of livestock can have access to them.</i>
5.4	The lairage must have adequate ventilation, lighting and shelter from adverse conditions.	

5.5	There must be suitable and sufficient bedding available for animals which are lairaged overnight.	<i>This standard applies to all livestock arriving at the abattoir before midnight the day prior to the day of kill.</i>
5.6	There must be suitable and sufficient feed available for animals which are lairaged overnight.	<i>This standard applies to all livestock arriving at the abattoir before midnight the day prior to the day of kill.</i>
5.7	There must be means to identify an animal in isolation.	<p><i>The company must have access to signs or other means of indication that the animal within the pen is in isolation.</i></p> <ul style="list-style-type: none"> <i>• Ideally there should also be a dedicated isolation pen available and ready for use at all times and ideally situated close to the unloading bay, easily accessible and identifiable.</i> <i>• All animals requiring this facility should be dealt with as a matter of urgency with due care for animal health and welfare.</i>
5.8	Stunning equipment must be maintained to ensure consistent, effective stunning.	<i>This must ensure that the equipment is checked and maintained in line with manufactures recommendations and current legislation.</i>
5.9	Provisions for vehicle washout and disinfection facilities must be available	<i>All vehicles must be able to clean and disinfect on site or sign a declaration as to off-site cleansing and disinfection as per the current regulations as listed in appendix A.</i>

6.0 Livestock Transport

- All livestock must be transported according to the current legislation.

6.1	All livestock being purchased as 'Assured' must be transported to the abattoir on 'Assured' Transport.	<i>The Assured Schemes are the ABM Farm members 'own' transport (for their own stock only) ABM Livestock Transport Scheme, the Specially Select Scottish Transport Scheme or equivalent in order to maintain the products assured status.</i>
6.2	Livestock vehicles must be unloaded promptly on arrival.	<p><i>There should be a pre-planned arrival system, where practicable communicated to hauliers to minimise waiting times of livestock on vehicles.</i></p> <ul style="list-style-type: none"> <i>▪ Hauliers should arrive within 30 mins of the planned arrival time.</i>
6.3	There must be procedures in place to report welfare-related issues to the AWO, lairage staff and management.	<i>Serious concerns over the vehicle or haulier should be reported directly to the Scheme owners.</i>
6.4	There must be procedures in place to report welfare issues back to the haulier and or farmer.	

7.0 Management

7.1	There must be a trained Animal Welfare Officer on the premises on duty at all times during operational hours.	<p><i>The AWO must be responsible for the welfare of livestock on the site. The duties must cover the arrival of livestock to the abattoir and welfare of the livestock up to the point of slaughter.</i></p> <ul style="list-style-type: none"> <i>The trained AWO must have undertaken an External AWO Training Course, or AWO Training course run by an External Trainer/Welfare Consultant.</i>
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8.0 Training

8.1	All persons involved with the handling of livestock must be suitably trained.	<p><i>All staff must have undertaken Animal Welfare training before handling livestock. This training can be under the instruction of the Animal Welfare Officer. Ideally all staff handling livestock should have completed an Animal Welfare Officer training course.</i></p>
8.2	All staff involved with the handling of livestock must have access to the HSA Best Practice Guidelines for the relevant species.	
8.3	All staff involved with the slaughter or killing of livestock must be licensed and trained in the method used.	<i>Staff must be able to recognise signs of an effective/ineffective stun/kill. This also applies to emergency slaughter procedures.</i>

9.0 Traceability

9.1	All incoming livestock must be identified in line with current legislation.	<p><i>The current legislation is listed in appendix A. In the case of Cattle, all movements must be registered with the British Cattle Movement Service (BCMS) or relevant authority.</i></p> <p><i>All sheep must be double tagged with a unique ID unless they are under 12 months of age where 1 tag is acceptable.</i></p> <p><i>All pigs must be slap marked.</i></p>
9.2	Records of all livestock must be maintained to ensure full traceability in line with current legislation	<ul style="list-style-type: none"> <i>This may form part of the Food Chain Information required as part of the Food Hygiene Regulations coming into force January 1st 2006.</i>
9.3	Livestock and carcasses must be handled in such a way to ensure full traceability.	<p><i>All livestock must be slaughtered in controlled batches</i></p> <p><i>Farm Assured and Non-farm assured livestock must be slaughtered in separate batches and identified as such.</i></p>
9.4	All abattoirs must have procedures, which accurately identify the carcass's slaughter number with its unique animal number, alphanumeric tag, batch number and/or slap mark	<i>Cattle ear tags may be checked after stun/bleed, depending on the individual plant systems providing this does not delay the stun to stick times and compromise animal welfare.</i>

9.5	All carcasses must be clearly marked with the slaughter number.	<i>The identification mark must be applied before the product leaves the site and must indicate the name of the country in which the site is base i.e. UK. The mark can be applied directly to the surface of the carcase or via a printed label affixed to the carcase or other means as determined by current legislation.</i>
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10.0 Purchasing

10.1	All livestock must be accompanied by a Delivery Note, Passport or Animal Movement Licence.	<i>The documents must relate to transport used and farm/market of departure to allow for farm assurance verification and traceability</i>
10.2	Assurance status of livestock, markets and transport must be verified.	<p><i>Any claims of origin (e.g. English) or Farm Assurance must be identified, documented, independently audited. This includes ensuring that the full residency period (90 days cattle and 60 days sheep) has been completed on the last holding (s) and that any movement during this period through a livestock market and/or collection centre has taken place at an assured premises approved under the ABM Livestock Market and Collection Centre Scheme or QMS Market Scheme.</i></p> <ul style="list-style-type: none"> <i>Verification of Assurance can be done either via the ABM website or other on-line verification system, or other means which can ensure the validity of a producers/hauliers/markets assured status.</i>
10.3	All markets and collection centres used to purchase/move assured livestock must be assured.	<p><i>This applies to all markets or collection centres used during the livestock residency period (90 days for cattle and 60 days for sheep). Eligible schemes are the ABM Livestock Market and Collection Centre scheme or the QMS Market Scheme. Some collection centres that only collect livestock for direct onward movement to slaughter may be assured under a Red tractor Approved Farm scheme.</i></p> <ul style="list-style-type: none"> <i>Verification of assurance status can be done through the ABM website or QMS website.</i>

11.0 Lairage

11.1	All livestock must be penned in clean, dry pens.	
11.2	Livestock must not be penned with stock of different species, or with stock from a different holding/market.	<i>Males and females and horned and non-horned animals, must also be kept separate unless they have been reared together.</i>

12.0 Casualty Animals

- ABM Recommends the DEFRA Guidance on the Transport of Casualty Farm Animals for further information on the section.

12.1	Casualty animals must be accompanied by the appropriate documentation.	<i>Casualty animals must be transported in line with schedule 18 of the Fresh Meat (Hygiene and Inspection) Regulations 1995 as shown in appendix 9</i>
12.2	Casualty animals must be treated as a priority.	<i>Procedures must be in place to allow the slaughter of a casualty animal in situ either on the vehicle or in the pen if necessary.</i>

13.0 Clean Livestock Policy

13.1	All livestock must be subject to the criteria laid down in the MHS Clean Livestock Policy.	<i>Ideally only animal in category 1 and 2 can be slaughtered as required by HACCP. Animals outside category 1 or 2 must follow the guidelines set out in the MHS Clean Livestock Policy and/or advice and instructions given by the OVS.</i>
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14.0 Cleaning and Sanitisation

14.1	Pens must be thoroughly cleaned and washed out at the end of each days kill.	
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15.0 Maintenance

15.1	All maintenance must be carried out with due regard for animal welfare.	<i>Maintenance must not cause distress or harm to livestock.</i>
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16.0 Temperature Control

16.1	Meat and meat products must not be kept at temperatures above the legal limit.	<i>The core temperature must not be allowed to rise above +7 degrees C for fresh meat, +3 degrees C for offal or -12 degrees C for frozen meat except where allowed under legislation to meet other customer requirements.</i> <ul style="list-style-type: none"><i>ABM recommends that Chilling procedures ensure that cold shortening is avoided.</i>
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17.0 Handling and Storage

17.1	Carcasses must be dressed in accordance with agreed dressing specifications.	<i>ABM Recommends that a two-knife system be used in all high-risk areas.</i>
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18.0 Welfare at Slaughter

- Stunning and Killing, including slaughter must only be carried out in accordance with current legislation.
- Stunning and killing, including slaughter must minimise the risk of causing pain, fear or distress to the animal and must render the animal unconscious and insensible to pain.
- Stunning and Killing, including slaughter can be carried out using a number of different methods. ABM recommends that the Humane Slaughter Association (HSA) Best Practice Guidelines for the Welfare of Cattle / Sheep / Pigs in Abattoirs be followed.

18.1	Animals must be handled calmly and quietly at all times.	<i>All animals must be treated humanely with a minimum of stress, in conditions that reflect proper care for the welfare of the animals and in compliance with all relevant legislation and codes of practice.</i>
18.2	The use of goads is not permitted, unless under veterinary direction in exceptional circumstances.	<i>Electric goads must not be used on sheep. Electric goads can only be used on adult cattle and pigs and when used, must only be applied for not more than 2 seconds to the hindquarters, and only when the way forward is clear for them to move, providing they have been asked to move, have been given time to move and still refuse to go forward.</i>
18.3	Stun to stick times for livestock must be within the time limits set out in the HSA Guidelines	<i>Stun to stick times for sheep and pigs must not exceed 15 second. Stun to stick times for cattle must not exceed 60 seconds for penetrative captive bolt stunning, 30 seconds for non-penetrative captive bolt stunning and 10 seconds for electrical head only stun.</i>
18.4	Bleeding times for livestock must not be less than the limits set out in the HSA Guidelines	<i>Bleeding times for sheep and pigs must not be less than 20 seconds. Bleeding times for cattle must not be less than 30 seconds.</i>

MODULE B (ALL CUTTING / PACKING PLANTS)

Scope:

- All Cutting plants must comply with the Core Standards and Module B of the ABM Standard **or** hold BRC Certification and be inspected against Module B of the ABM Abattoir Standards
- At all times food safety and traceability are of high importance.
- The Company must be fully compliant with all current relevant legislation.
- Incoming meat and meat products can only be derived from livestock purchased from an 'Assured Farm' and transported on 'Assured Transport' and slaughtered in an 'Assured Abattoir' and be able to carry the Red Tractor Logo.

Objectives:

- Food safety and traceability are of high importance.
- The Company must be fully complaint with all current relevant legislation.
- The Company must be fully compliant with relevant SRM regulations.

19.0 Labelling

- Finished product must be labelled in accordance with current legislation.

19.1	All product must be labelled in accordance with current legislation and other voluntary Scheme licence requirements where applicable.	<i>Current legislation is listed in appendix A. Voluntary Scheme Licence requirements must be demonstrated and verifiable.</i> <ul style="list-style-type: none">• Sealed containers containing product packed in Modified Atmosphere Packaging (MAP) or vacuum-packed product must be labelled as such in accordance with current legislation.
19.2	Outer cases must be printed to identify the name and address of the packer.	<i>The EEC plant code will generally be used and will satisfy the requirements of this standard.</i>
19.3	Each outer case must be marked or labelled with the following information: i) the pack contents; ii) the pack weight; iii) the slaughter or production code/date; iv) the packer's EC number.	
19.6	Packaging must protect the meat and ensure its hygiene and safety during handling and transport.	
19.7	All packs must contain product which has been processed under the same conditions.	<i>Where packs contain more than one joint, cut or product, care must be taken to ensure pack contents have been processed under the same conditions.</i>

20.0 Product Transport

20.1	The transport must be able to keep the product in conditions specific to the control of food safety and hygiene.	<i>Conditions must be specific to the product and must include the internal environment (cleanliness and hygiene), temperature, and other products on the same vehicle to minimise the risk of cross contamination and maintain product safety and quality</i> <ul style="list-style-type: none">• <i>Carcases or cuts must not be allowed to touch the floor of the transport vehicle at any time, and boxed product must not be placed directly on the floor.</i>• <i>Boxed meat that is transported on the same vehicle as carcasses or cuts must be protected from contamination, and not placed directly on the floor (e.g. clean polythene sheeting may be OK in some instances)</i>
20.2	Refrigerated vehicles must be pre-chilled to a temperature before loading.	<i>The vehicles must be pre-chilled in order to maintain the core temperature of the product during transportation.</i> <ul style="list-style-type: none">▪ <i>The core temperature must not be allowed to rise above +7 degrees C for fresh meat, +3 degrees C for offal or -12 degrees C for frozen meat.</i>
20.3	The transport temperatures for each load must be recorded	<i>Records can either be kept manually or via the vehicle being fitted with an automatic temperature-recording device and as required by HACCP.</i>

21.0 Temperature Control

21.1	Meat and meat products must not be kept at temperatures above the legal limit.	<i>The core temperature must not be allowed to rise above +7 degrees C for fresh meat, +3 degrees C for offal or -12 degrees C for frozen meat.</i>
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22.0 Contingency Plans

22.1	The Company must have contingency plans, which are easily accessible to all members of staff.	<i>Contingency plans must include what to do in the case of a fire, line breakdown, accidents, vehicle breakdowns, and equipment failure.</i>
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Abattoir, Cutting and Packing Plants

APPENDIX A:

GUIDE TO SOURCES OF INFORMATION ON CURRENT RELEVANT LEGISLATION AND CODES OF PRACTICE

The following is a guide for processors to sources of information on current relevant legislation and Codes of Practice. It is not an exhaustive list. Legislation should be consulted and legal advice sought when particular points in the law need to be considered.

The Welfare of Animals (Slaughter or Killing) Regulations 1995 (and amendment 1999)

The Plastic Materials and Articles in Contact with Food Regulations 1998

The Animals and Fresh Meat (Examination for Residues) Regulations 1988

The Animals, Meat and Meat Products (Examination for Residues and Maximum Residue Limits) (Amendment) Regulations 1993/4/6

The Minced Meat and Meat Preparations (Hygiene) Regulations 1995

The Food Safety Act 1990

Food Safety (General Food Hygiene) Regulations 1995

The Food Safety (Temperature Control) Regulations 1995

The Animals and Fresh Meat (Hygiene and Inspection) Regulations 1995

The Cattle Identification Regulations 1998

The Sheep and Goats (Records, Identification and Movement (England) Order 2007

The Welfare of Animals (Transport) Order 1997

Health and Safety at Work Act 1974

The Control of Substances Hazardous to Health Regulations 1988

Meat Products (Hygiene) Regulations 1994

Food Labeling Regulations 1996 and The Food Labeling (Amendment) Regulations 1998

The Fresh Meat (Import Conditions) Regulations 1996

As from January 1st 2006 the following regulations will apply and will revoke those in *red italics* regulations listed above:

The Food Hygiene (England) Regulations 2005 (or appropriate to each region)

The above legislation is available from The Stationery Office, London

Information on Slaughter and Welfare	available from DEFRA
Information on Carcass Production and Authentication	available from MLC



Abattoir, Cutting and Packing Plants

Appendix 1: Hazard Analysis and Critical Control Points

The Meat (Hazard Analysis and Critical Control Point) Regulations 2002 require meat plant operators to introduce hygiene procedures based on HACCP principles and to undertake microbiological checks in red meat plants.

HACCP

The Hazard Analysis and Critical Control Point (HACCP) system is internationally accepted as the system of choice for food safety management. It is a preventative approach to food safety based on the following 7 principles:

- 1. Identify any hazards that must be prevented eliminated or reduced;
- 2. Identify the critical control points (CCPs) at the steps at which control is essential;
- 3. Establish critical limits at CCPs;
- 4. Establish procedures to monitor the CCPs;
- 5. Establish corrective actions to be taken if a CCP is not under control;
- 6. Establish procedures to verify whether the above procedures are working effectively; and
- 7. Establish documents and records to demonstrate the effective application of the above measures.

The 7 principles aim to focus attention on the identification and control of microbiological, chemical and physical food safety hazards during production. The hazard assessment and the regular monitoring of critical control measures must be documented to provide the basis for audit checks and may provide evidence of due diligence in the event of legal action.

In meat plants HACCP plans will focus on control measures that can reduce the likelihood of contamination of meat from microbiological hazards, such as Salmonella, E.coli O157 and Campylobacter, during production. These meat-borne pathogens can be carried by healthy animals and cannot be detected by sight or smell.

Although thorough cooking kills most bacteria, meat may be handled by lots of people before it is cooked and the bacteria will spread to other foods that may not be cooked. Bacteria multiply very quickly, especially in warm conditions. Retailers and consumers need to take precautions, including temperature controls and keeping raw meat and cooked meat and other ready to eat foods separate.

Conscientious implementation of HACCP principles by plant operators demonstrates their commitment to food safety; improves employee awareness of their role in protecting consumers, and emphasises management's responsibility for the safe production of meat.

Compliance with the Meat (HACCP) Regulations 2002

Compliance with the requirement to apply HACCP principles should be achieved if operators:

PLAN IT:

- Prepare a HACCP Plan for each product

SAY WHAT YOU DO

USE IT:

- Put in place the control and monitoring procedures set out in the Plan, and explain them to staff · Make sure staff take action if something goes wrong

DO WHAT YOU SAY

PROVE IT:

- Keep some records to show that the right action are being taken at the right time · Check to see that procedures are working · Review procedures at least once a year

PROVE IT WITH RECORDS

Records need to match the nature and size of the business. They should be as simple as possible so that they are easy to keep up to date.



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Appendix 2: Documentation and Record Keeping

DOCUMENTATION:

Documents, procedures, record and data critical to the management and control of product safety, legality and quality are listed below:

1. HACCP Plan
2. Annual Audit Records (undertaken as part of HACCP and ABM audits)
3. Management Structure
4. Product Specifications
5. Cleaning Procedures and Records
6. Contingency Plans
7. Daily Internal Audit results
8. Microbial Testing and Inspection Records
9. Transportation Temperatures
10. Storage Room Temperatures
11. Training records
12. Traceability records
13. Personnel Adoption of Company Hygiene Standards
14. Medical Questionnaires
15. Reported Illness of Public Health Significance
16. Maintenance Record
17. Pest Control
18. Complaints and Corrective Action
19. Supplier List
20. Calibration Record

Records relating to Module A Only:

21. Livestock Movement Record
22. Casualty Animals Record



Abattoir, Cutting and Packing Plants

Appendix 3: Control of Rejected or “Non-Conforming” Product

Non-conforming product is “*product not of the nature, substance or quality demanded by the purchaser*” (Section 14 of the Food Safety Act 1995).

Non-conforming Product is a product that may be:

- Potentially hazardous to consumers, or
- Defective but not hazardous

Examples of these are:

1. product which does not comply to specification
2. product is damaged
3. product has deteriorated, e.g. enzymic spoilage, stored improperly
4. contaminated product – potential spoilage
5. contaminated product – actual spoilage
6. accidental contamination – hazardous product
- 7.

Non-Conforming Product must be dealt with immediately to ensure food safety is not compromised.



Abattoir, Cutting and Packing Plants

Appendix 4: Calibration

Calibration ensures that equipment and measurements correspond to universal standards. Calibration is the process of comparing an instrument or device against a standard to determine instrument/equipment accuracy.

Equipment that must be calibrated includes:

- Metal detectors
- Scales / weighing devices
- Labelling equipment
- Temperature monitoring equipment
- Gas analyzing equipment

Abattoir Specific items:

- Stunning equipment



Abattoir, Cutting and Packing Plants

Appendix 5: Services

An Abattoir, Cutting and Packing Plant must have contact details and agreements with a number of external services in order to ensure that the standards within the manual are upheld.

It is required by ABM that the site have provision arrangements with the following services:

- Electrician
- Plumber
- I.T (Information Technology) Supplier (where applicable)

ABM recommends that the site also have provision arrangements with the following services:

- Pest Control
- Site Maintenance
- Security
- Laundry

This is a recommended list and is not exhaustive. It is accepted that this may not apply if there is sufficient in-house expertise to carry out these roles.



Abattoir, Cutting and Packing Plants

Appendix 6: Pest Control

Pests are a source of foodborne pathogens, and pest control is usually considered a pre-requisite for HACCP.

The common pests found in the food industry include:

- Rodents: rats and mice
- Insects: flies, wasps, cockroaches, psocids, silverfish, stored product insects and ants
- Birds: mainly feral pigeons and sparrows; seagulls and starlings
- Mites.

Reasons for pest control:

- To prevent the spread of disease;
- To prevent the wastage of food;
- To prevent damage;
- To comply with the law and
- To avoid losing business, staff and profit.

Pest control programmes should encompass an integrated approach to pest control. The strategies for integrated pest control, implementation of prevention and eradication strategies, should be based on the biology of the pests and should include the following elements:

- Early detection and identification of pest species;
- The application of environmental management – improvements in hygiene, exclusion and proofing;
- The application of chemical and physical control. Undertaken with due regard to safety and the environment.
- The development of an effective monitoring strategy that will monitor the progress of any control operations.

All food business proprietors and staff must be vigilant and look regularly for evidence of pests.

However good the business sooner or later an insect or rodent will be a threat.

Consideration should be given to a pest control contract with a reputable pest control company. This may assist in providing long term control of pests and advice regarding any pest proofing work which may be necessary.

If pests are discovered on the premises immediate corrective action must be taken to rectify the problem with due regard for product safety and risk of contamination.

All pest control measures must be undertaken in line with current legislative requirements and documented.



Abattoir, Cutting and Packing Plants

Appendix 7: Animal Welfare Policy

The “Company” Animal Welfare Policy

The “COMPANY” endeavours to maintain high standards of animal welfare throughout its entire operation. All staff involved with the handling and slaughter and or killing of animals will be appropriately trained to the highest standards in junction with the legislative, company and customer requirements.

Our aim is to handle all stock as quietly and calmly as possible to minimise stress experienced by the animals. Respect will be shown to animals at all times.

All procedures involving live or stunned animals are available from the Abattoir Manager (or other person with significant authority for the area). Contingency plans can also be found in the relevant sections of the manual.

These procedures are understood and followed by the relevant staff. Where procedures are changed, this change will be reflected immediately in any manuals or procedures relating to this area.

All unloading of animals will take place under the supervision of our staff and remedial action taken where necessary.

It is our policy to slaughter/kill casualty animals in situ, if they cannot be moved without causing them unnecessary pain or suffering.

The “COMPANY” lairage has been designed and developed with animal welfare and natural behaviour in mind and constructed to a high standard. All animals are held securely and comfortably at all times within the lairage. Any problems arising within the lairage relating to the facilities will be recorded on feedback form ## and passed to the AWO for further investigation.

All stunning/killing equipment used by the staff will be maintained and cleaned regularly to ensure effective operation.

The company guarantees that every effort is made to keep all equipment, practices and training up-to-date, to ensure consistently high standards of animal welfare. Training of all staff is ongoing and part of a structured training programme including both internal and external courses.

All of the above efforts are of significant importance to everybody involved with livestock and will be consistently followed and improved where necessary.

Signed:

Chief ExecutiveOVS


Slaughterhall Manager Animal Welfare Officer

Date:

Review Date:

BY KIND PERMISSION OF THE HUMANE SLAUGHTER ASSOCIATION

Appendix 8: Medical Questionnaires

		PERSONAL HYGIENE STANDARDS	
Medical Questionnaire		Section:	
Issue Status:		Page 1 of 1	

PLEASE READ THE FOLLOWING – REMEMBER YOU ARE ENTERING A FOOD FACTORY AND MUST ABIDE BY THE SITE RULES

- Persons suffering from any symptoms of diarrhoea, stomach ache or sickness must notify the company prior to entering production areas.
- No jewellery, including wristwatches, may be worn in production areas with exception of a plain wedding band.
- Smoking is forbidden on site except in the designated smoking area
- Protective clothing existing of a hairnet, light coloured coat and footwear (over shoes are permitted) will be worn when visiting the food preparation areas.
- Overalls, coats and hair/head protection must be removed before entering the canteen, toilets or designated smoking area.
- No eating, drinking or chewing is allowed in the factory except in designated areas.
- Please ensure that you do not leave any articles behind you when you have finished your business.
- Ensure you are aware of company contingency plans in case of fires or emergencies.
- All visitors are subject to the current Health and Safety at Work Act 1974.

If during your visit you intend to enter any production areas you must complete the following questionnaire.

1. Within the last three days have you suffered from vomiting or diarrhoea? YES/NO*
2. Have you been diagnosed with food poisoning within the last month? YES/NO*
3. If the answer to 2 is yes, do you have a clean health certificate from your doctor? YES/NO*
4. Do you at present have a serious cough or diagnosed chest infection? YES/NO*
5. Are you suffering from discharging ears? YES/NO*
6. Are you at present suffering from any skin conditions affecting the hands, forearms, face or neck? YES/NO*
7. Have you suffered from typhoid, paratyphoid, any Salmonella infection, amoebic or bacillary dysentery or any Staphylococcal infection? YES/NO*

*Delete if inappropriate

Unless you have a medical certificate from your doctor and if the answer to any of the above questions is yes, other than question 2, then entrance to the production areas may be denied.

I have read the above and understand my responsibilities as a visitor. The questions I have answered are true and correct

Visitors name:

Visiting:

Company: Date:

Issued By	Approved By	Date	Reference



Abattoir, Cutting and Packing Plants

Appendix 9: Casualty Animal Movements

SCHEDULE 18

Statutory instrument 1005 No 539

The Fresh Meat (Hygiene and Inspection) Regulations 1995

Regulation 17(2)(a)

MODEL DECLARATION TO ACCOMPANY AN ANIMAL FOR SLAUGHTER KNOWN OR SUSPECTED TO BE DISEASED OR IN JURED

Name and address of owner/person in charge

Telephone No. (if any)

Name and Address of owner's veterinary surgeon

Animal:

Species

Breed

Age

Sex

Identifying marks (e.g. ear tag number)

*(a) The above animal has received no treatment within the last 28 days.

*(b) The withdrawal period for any treatment administered to this animal has been observed.

*delete where not applicable

Describe the signs of disease or injury the animal has exhibited or, if a veterinary surgeon has seen the animal, his diagnosis

.....
.....
.....

Signature

Name

Status

Time and Date am/pm20.....

Remember

It is an offence to transport a sick or injured animal if this is likely to cause it unnecessary suffering. If in doubt you should consult a veterinary surgeon.

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