



DID YOU KNOW?

- All establishments that slaughter swine must develop, implement, and maintain written procedures in their HACCP systems to prevent contamination of carcasses.
- Plants that slaughter swine as their predominant species are required to conduct pathogen reduction testing.



DEPARTMENT OF
AGRICULTURE

Swine Slaughter Sanitary Dressing Procedures and Microbiological Sampling Plan

All Minnesota “Equal To” establishments that slaughter swine must have written procedures to prevent contamination during the sanitary dressing process. In addition, if swine is the predominant species slaughtered at the plant, the establishment must also have a written sampling plan and conduct sampling to assess the effectiveness of those procedures. This document provides step-based guidance on how to implement these requirements in your establishment.

Step 1: Determine which requirements apply to your establishment.

All swine slaughter establishments must have written sanitary dressing procedures. Some establishments are also required to conduct microbiological sampling to assess pathogen control as well. Use the flowchart in Figure 1 to help you determine whether you must have a sampling program.

Step 2: Review your written procedures to ensure they contain measures to prevent contamination.

Establishments that slaughter swine must have written procedures to prevent contamination during the slaughter process. These procedures may be written separately or included as a part of your HACCP plan and other food safety documentation. You may already have written procedures, such as zero fecal checks or sanitation procedures, that may satisfy this requirement. Please consult with your inspector if you are unsure whether your current procedures will be sufficient.

The following is an example of the kinds of written procedures that can be used to satisfy this requirement:

To prevent contamination of carcasses and parts by enteric pathogens, feces, ingesta, and milk throughout the entire slaughter and dressing operation we have implemented the following steps:

1. Conducting a zero-tolerance check of feces, ingesta, and milk as a CCP
2. Washing the carcasses after the final inspection step
3. Sanitize knives after skinning or after contamination at any process step
4. Using antimicrobial spray on swine, see SOP and monitoring records
5. Hand trimming any signs of visible contamination

Note, each establishment must also have records associated with these procedures to document they have occurred and/or are monitoring implementation. Other procedures may also be appropriate; remember, these procedures must be specific to your establishment’s operation.

Step 3: If applicable, develop and implement a microbial sampling plan for carcasses

Establishments that slaughter swine as their predominant species must also conduct microbiological sampling to assess their pathogen control and sanitary dressing procedures. Previously, this was known as generic E. coli sampling; the

new rules removed the specific reference to generic E. coli testing and allows an establishment to develop a different plan.

To develop and implement your plan, do the following:

1. Determine which organism you will use to assess control of your sanitary dressing procedures. Establishments may use generic E. Coli sampling to satisfy this requirement or may choose to use another sampling scheme that is more appropriate for their process.
2. Write procedures that describe your plan; use the following checklist to ensure your plan has all the necessary components.
 - Sample collection procedures, including:
 - Procedure for random selection of carcasses for sampling
 - Location within the slaughter process where samples are collected (must be post-chill)
 - Frequency of sample collection
 - Description of the sample collection procedure, including the techniques used for ensuring samples are collected aseptically
 - Designation of sampling to a trained employee (who will collect the sample)
 - Procedures for handling and shipping samples, including:
 - Procedure for identifying samples
 - Process for holding samples under refrigeration/ not frozen
 - Packing process, including use of an insulated shipping container with cold packs
 - Shipment to the laboratory on the same day as collected
 - Name of person or service used to transport samples
 - Chain of custody documentation that will be used (such as a tracking number)
 - Testing method and procedures for reporting results
 - Description of the testing method used by the laboratory
 - Microbiological testing results reports
 - Process used to assess results, including use of a control chart/moving window format and criteria for determining acceptable or unacceptable results
 - Actions that will be taken in response to results

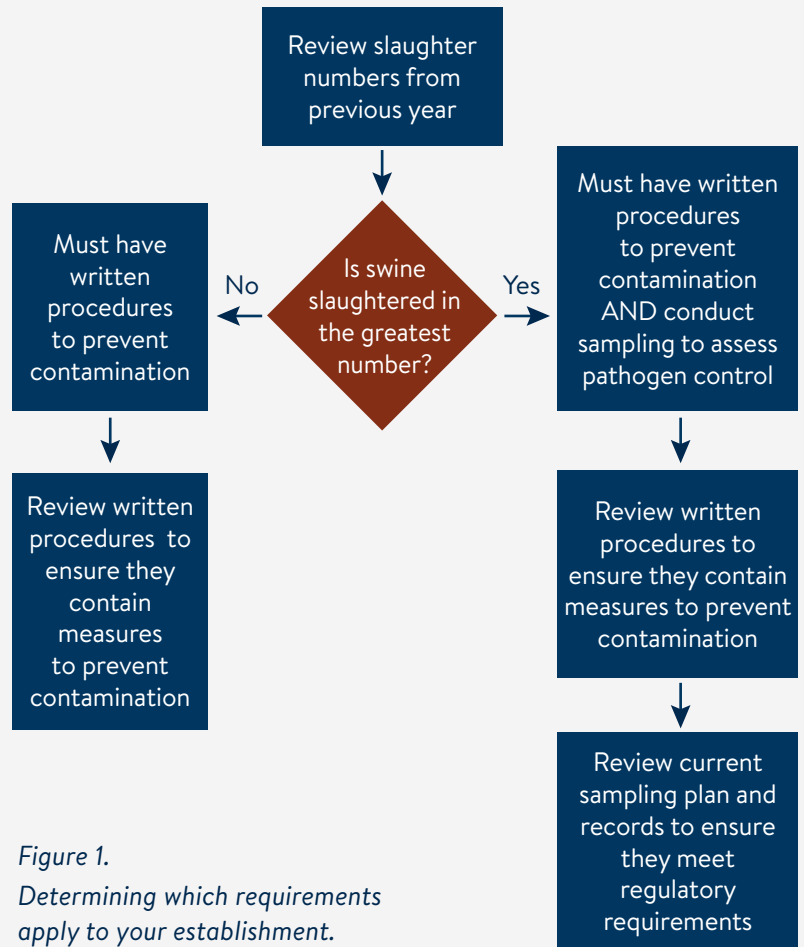


Figure 1. Determining which requirements apply to your establishment.

3. Begin collecting samples, documenting results and assessing compliance
 - Testing must begin on June of every year, with samples collected at least once each week of operation. If after 13 samples are collected and analyzed, you can demonstrate you are not exceeding your upper process control limit, you may discontinue sampling until the following year.
 - Sample results must be available for review by your inspector and plotted on a control chart to assess compliance.

Additional resources for pathogen reduction sampling and sanitary dressing control programs have been developed by USDA Food Safety Inspection Service and they can be found here:

Developing Microbiological Sampling Programs in Swine Slaughter Establishments:
www.fsis.usda.gov/wps/wcm/connect/6bfab330-1c93-4a44-b95a-67e37ebc753e/modernization-swine-slaughter-microbiological-sampling.pdf?MOD=AJPERES