**Facility: (INSERT COMPANY NAME AND ADDRESS)**

**Other retail facilities, farmer markets, etc.: (INSERT NAME)**

**Purpose:**

This HACCP plan describes products and process used for Reduce Oxygen Packaging of Raw Frozen Meat, Poultry, and Farm Raised Game products. The establishment has a Specialized Meat Processing at Retail Food Establishment Variance that contains Good Manufacturing Practices (GMPs) and Standard Operating Procedures (SOPs) which are followed.

**Type of food(s):** Frozen Raw Products:

* Beef (Beef and Veal): roasts, steaks, cuts, diced, ground
* Pork: Roasts, chops, cuts, ground,
* Poultry (Turkey, Chicken, Game Birds): whole, parts, cuts, ground
* Farm Raised Game (Bison / Buffalo, Elk, etc.): roasts, steaks, cuts, ground
* Meat or Poultry further processed items, with or without non-meat ingredients\*
* Sausage\* (meat or poultry) bulk, patties, links

\*ingredients available in Food Label section

**Process Flow diagram:** see below

**Facility Layout:** see attached

**Equipment used:**

* Coolers and Freezers
* Mixer
* Stuffer linker
* Grinder
* Raw Meat Slicer
* Vacuum packaging machine (INSERT TYPE)

**Food employee and supervisory training plan addressing food safety issues of concern:** Employees are trained in proper food safety issues associated with reduced oxygen packaging of raw and cooked foods. This includes preventing cross-contamination throughout processing and packaging by doing cooked foods before raw food, properly cooling cooked foods, and freezing all reduced oxygen packages after packaging. Employees will be observed to make sure they follow practices.

**Standard Operating Procedures (SOP)**

U.S. Department of Agriculture inspected or authorized raw whole muscle cuts are utilized.

Whole muscle/carcass, roasts, steaks, chops, parts, cuts, fillets processing:

* Removed from package,
* Evaluate and trim as necessary,
* Cut into individual portions as necessary,
* Reduced oxygen packaged (vacuum packaged),
* Labeled, placed on trays or containers, frozen, and
* Held at frozen temperature until sale.

Ground and sausage processing:

* Removed from packaging,
* Reduced in size as needed,
* Ground,
* Mixed/blended with or without non-meat ingredients per formulation/recipe if needed,
* Stuffed into casings or formed per product design,
* Reduced oxygen packaged (vacuum packaged),
* Labeled, placed on trays or containers, frozen, and
* Held at frozen temperature until sale.

Note: If multiple species of ground product is processed on the same shift, grinder, mixer/blender is cleaned between species.

There will be no cross contamination between ready to eat (RTE) food products and raw food products.

Vacuum package machine (reduced oxygen packaging) is cleaned at the end of each processing shift or more frequently as needed according to our Specialized Retail Meat Processing Variance written Sanitation Standard Operating Procedure (SSOP).

Each package or unit will be appropriately labeled including a traceable lot code.

Product transport from processing facility to other company owned facility or farmer’s markets under refrigerated and/or frozen transportation. Product remains frozen during transportation and through sale. Product label includes “Safe Handling Instructions”.

**Each Critical Control Point (CCP)**

Temperature monitoring of food products in frozen storage

**Critical Limits for each Critical Control Point**

Food product temperature is less than or equal to 26°F or “firm to touch”.

**Method and frequency for monitoring and controlling each CCP and who**

Contact tip or equivalent calibrated thermometer used to measure food product temperature of a food package. Frozen product exterior of the package should be “firm” when “touched” by hand with a slight amount of force in frozen storage. Monitoring will be done to a package in the warmest part of the freezer a minimum of once per day of operation day by designated employee.

**Corrective actions**

* If the product temperature is greater than 26°F, determination of the cause of freezer malfunction will be found, corrected, or repaired.
* Product temperature is measured and action as followed:

|  |  |
| --- | --- |
| Product Temperature | Actions |
| > 26°F ≤ 31°F | Restore power supply, move to another freezer, place in insulated container with dry ice, or other appropriate actions to maintain frozen product temperature. |
| > 31°F ≤ 41°F | Re-freeze product.  Refrigerate product and utilize or sale within 7 days. |
| > 41°F ≤ 70°F | Thermal processed if within 6 hours from product temperature reaching 41°F. If greater than 6 hours, hold and dispose product (FC 3-501.19). |
| > 70°F | Hold and dispose product. |

**Records:** Food temperature log (see attached)

*Process Flow Diagram*

***Process Category: Raw Meat and Poultry Reduced Oxygen Packaging***

***2.*** *Receiving*

*Raw Meat/Poultry/Game*

***4.*** *Storage (Frozen/Refrigerated)*

*Raw Meat/Poultry/Game*

***5.*** *Tempering*

*Frozen Meat/Poultry*

***7.*** *Cut*

*Raw Meat/Poultry*

***8.*** *Grinding (if needed)*

***10.*** *Mixing/blending (if needed)*

***13.*** *Package / Labeling*

***15.*** *Finished product storage*

***1.*** *Receiving Packaging Materials*

***12.*** *Storage of Packaging Materials, incl. collagen or synthetic casings*

***3.*** *Receiving and*

***6.*** *Storage of Non-Meat/Non-Poultry Food Ingredients and Water*

***16.*** *Retail sales or transfer to other company locations*

14. Place on tray or container

***11.*** *Stuffing or forming (if needed)*

CCP < 26°F or firm to touch

***9.*** *Weighing of Non-meat/Non-poultry Food Ingredients and Water*

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **(Facility Name)** |  | **Frozen Food Temperature Log** | | | |
| **(Facility Address)** |  |
|  |  |  |  |  |  |
| **Product Name** | **Date / Time** | **Temperature (°F) Max. 26°F or firm to touch** | **Initials** |  |  |
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**Additional scientific data / supporting documentation as required**

**Tompkin paper**, Table 1, minimum temperatures for growth of bacteria of concern

Bruce Tompkin Ph.D. Armour Swift-Eckrich

Table 1. Minimum growth temperatures for selected foodborne pathogens.

Minimum Growth

Temperatures\_\_\_\_\_\_

|  |  |  |
| --- | --- | --- |
| Salmonellae1 | 7C | 44.6F |
| Pathogenic *E. coli* | 7-8C | 44.6-46.4F |
| *L. monocytogenes* | -0.4C | 31.3F |
| *Y. enterocolitica* | -1.3C | 29.7F |
| *Campylobacter jejuni* | 32C | 89.6F |
| *Staphylococcus aureus* | 7C | 44.6F |
| *Bacillus cereus*2 | | |
| psychrotrophic strains | 4C | 39.2F |
| *Clostridium perfringens* | 12C | 53.6F |
| *Clostridium botulinum* | | |
| nonproteolytic | 3.3C | 38F |
| proteolytic | 10C | 50F |

• 1One report of initial growth on bacon at 5C but then the population decreased.

• 2While growth of *B. cereus* occurs in milk at refrigeration temperatures (e.g., <7C), there is no evidence for this in meat and poultry. One study reported death of vegetative cells in ground beef at 12.5C (54.5F) and below.

• Parasites (e.g., *Trichinella spiralis*, *Taenia* spp., *Toxoplasma gondii*) and viruses do not multiply in meat or poultry products.

Source: International Commission on Microbiological Specifications for Foods. 1996.

Microorganisms in Foods: Microbiological Specifications of Food Pathogens. Blackie

Academic & Professional, New York.

**USDA Meat and Poultry Labeling Terms**

**FRESH POULTRY:**  
"Fresh" means whole poultry and cuts have never been below 26 °F (the temperature at which poultry freezes). This is consistent with consumer expectations of "fresh" poultry, i.e., not hard to the touch or frozen solid.

In 1997, FSIS began enforcing a final rule prohibiting the use of the term "fresh" on the labeling of raw poultry products whose internal temperature has ever been below 26 °F.

The temperature of individual packages of raw poultry products labeled "fresh" can vary as much as 1 °F below 26 °F within inspected establishments or 2 °F below 26 °F in commerce.

Fresh poultry should always bear a "keep refrigerated" statement.