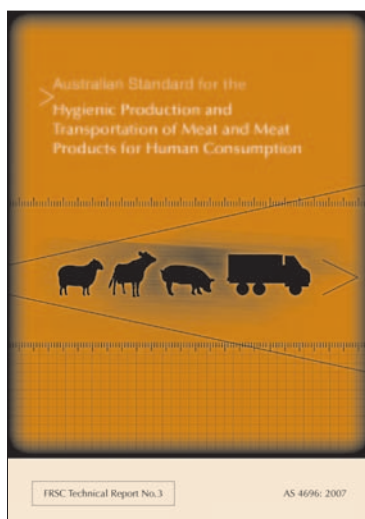


Australian standard for the hygienic production and transportation of meat and meat products for human consumption

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AS 4696:2007



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**Australian Standard for
the Hygienic Production
and Transportation of
Meat and Meat Products
for Human Consumption**

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PREFACE

The Standard

This Standard has been approved by the Australia and New Zealand Food Regulation Ministerial Council (ANZFRMC).

This Standard harmonises standards for the production and transportation within Australia of meat and meat products regardless of whether the meat or meat products are for domestic use or for export. The Standard results from a review of domestic and export requirements undertaken as part of the assessment of meat regulation in accordance with the National Competition Policy Principles.

The focus is on essential health and hygiene issues and provides for standards that are consistent with the principles and objectives of the world standards contained in *Codex Alimentarius, Volume 10* (1994).

Importing requirements set by overseas governments for access to their individual markets are not dealt with in this Standard but are dealt with under Commonwealth legislation dealing with export certification. Similarly, special requirements set by government or industry for all exporters of a particular product to a particular market are beyond the scope of, and in addition to, the requirements specified in this Standard.

Objectives

The prime objective of this Standard is to ensure meat and meat products for human consumption comply with food safety requirements and are wholesome. The food safety outcomes for each stage of production are specified in this Standard together with requirements to ensure meat and meat products are wholesome or else are removed from the food chain and dealt with separately. The Standard reflects the fact that food safety risks extend through the food preparation chain and are not confined to the preparation, handling and storage of end products.

This Standard incorporates other objectives so that wholesomeness can be assured. These objectives include the need for systems to be in place for the accurate identification, traceability, effective recall and integrity of meat and meat products. They also include animal welfare objectives as they impact on food safety and on public expectations as to wholesomeness.

The Standard reflects the shared responsibility between industry and governments for food safety. Management and production practices underpin the Standard as do process controls based on the hazard analysis critical control point (HACCP) approach with its emphasis on risk assessment and risk management.

Scope

This Standard sets out the outcomes required for the receipt and slaughter of animals, the dressing of carcasses, and the processing (including further processing), packaging, handling and storage of meat or meat products. It also consolidates, in the one Standard, rules for the construction of premises and transportation of meat and meat products.

This Standard potentially applies to meat and meat products derived from any animal belonging to a species set out in clause 2.1. Commonwealth, state and territory laws enable permission to

be given for the production of meat derived only from certain specified animals within these species. In this manner it is the Commonwealth, state and territory laws that limit in a practical way the animals to which this Standard applies.

Similarly, this Standard is broad enough in scope to apply to retailers who store or prepare meat and meat products and to the transportation of meat and meat products from the retailer to the consumer. However, the question of when meat and meat products cease to fall within this Standard and are to be covered under food laws applying to retailers is left to be dealt with under Commonwealth, state and territory laws governing the adoption of this Standard.

This Standard is in addition to other requirements under Commonwealth, state and territory legislation and the standards and codes that also apply to the production of meat and meat products. These include animal health and welfare requirements and construction requirements. They also include requirements in the *Australia New Zealand Food Standards Code* such as those relating to additives, contaminants, labelling and fermentation.

Guidelines

This Standard should be read in conjunction with guidelines as periodically developed by the Meat Standards Committee.

Equivalence

Where a meat business proposes a technique different from one detailed in this Australian Standard the assessment of equivalence is to be determined by the relevant controlling authority. This committee will establish methodology for determining the equivalence of benchmarks or standards. The proposer of the alternative technique is to supply sufficient supporting information to validate the procedure to the relevant controlling authority who will advise the Meat Standards Committee. The submission must include a HACCP plan that ensures equivalence is maintained. Where the Meat Standards Committee cannot reach agreement on the approval of an alternative technique the final decision shall be made by the relevant Ministerial Council.

Standards replaced

This Standard replaces each edition of the following Australian Standards:

- AS 4460:1997 *Australian Standard for the Construction of Premises for Processing Meat for Human Consumption* (SCARM Report No. 53)
- AS 4461:1997 *Australian Standard for the Hygienic Production of Meat for Human Consumption* (SCARM Report No. 54)
- AS 4462:1997 *Australian Standard for the Construction of Premises for Processing Animals for Human Consumption* (SCARM Report No. 55)
- AS 4463:1997 *Australian Standard for the Transportation of Meat for Human Consumption* (SCARM Report No. 56)
- AS 4696:2002 *Australian Standard for the Hygienic Production and Transportation of Meat and Meat Products for Human Consumption* (PISC Report No. 80).

Australia New Zealand Food Regulation Ministerial Council

The Australia New Zealand Food Regulation Ministerial Council (ANZFRMC) comprises Australian Commonwealth, state and territory health and agriculture ministers responsible for food safety and food standards, and their New Zealand counterparts. The objective of the council is to develop food safety and food standard management policies, strategies and practices for the benefit of the community.

ANZFRMC is supported by a permanent Food Regulation Standing Committee (FRSC) and Food Regulation Secretariat within the Commonwealth Department of Health and Ageing. Membership of FRSC comprises relevant departmental heads and chief executive officers of Australian Commonwealth, state, territory and New Zealand food safety regulatory agencies.

ANZFRMC was created on 3 November 2000 following endorsement by the Council of Australian Governments (COAG) of the Senior Officials Working Group's response to the Blair Review including the drafting of a Food Regulation Inter-Government Agreement.

In June 2001 the Australian Commonwealth, state and territory governments created several new ministerial councils by amalgamating and redirecting the work of several existing councils. These changes included the disbandment of the Agriculture and Resource Management Council of Australia and New Zealand (ARMCANZ) and the establishment of the Primary Industries Ministerial Council (PIMC), which is responsible for non-food industry issues.

The objective of PIMC is to develop and promote sustainable, innovative and profitable agriculture, fisheries/aquaculture, and food and forestry industries. The primary source of policy advice for PIMC is the Primary Industries Standing Committee (PISC).

Food Standards Australia New Zealand

Food Standards Australia New Zealand (FSANZ) was established as an independent science-based food standard setting body by the *Food Standards Australia New Zealand (FSANZ) Act* 2001. It was created as an outcome of the Food Regulation Agreement (Inter-Government Agreement) signed in November 2000 by departmental heads and chief executive officers of Australian Commonwealth, state, territory and New Zealand food safety regulatory agencies. The Food Regulation Agreement provides a national approach to food regulation.

PART 1 – INTRODUCTION

1 PRELIMINARY

Name of Standard

- 1.1 This Standard is the *Australian Standard for the Hygienic Production and Transportation of Meat and Meat Products for Human Consumption*.

Objectives

- 1.2 The objectives of this Standard are to ensure:
- (a) meat and meat products for human consumption are wholesome; and
 - (b) meat and meat products that are not fit for human consumption or not intended for human consumption are dealt with separately; and
 - (c) the accurate identification, traceability and recall of meat and meat products; and
 - (d) any statement made in relation to the condition of meat and meat products or their production is accurate; and
 - (e) an accurate assessment can be made as to whether the objectives identified in paragraphs (a) to (d) are met.

Interpretation

- 1.3 In this Standard, unless the contrary intention appears:

animal	means an animal of a kind referred to in clause 2.1 but does not include a work animal.
animal food	means: <ul style="list-style-type: none">(a) a part of any animal or a meat product to which a disposition has been applied enabling it to be recovered for animal food; and(b) inedible material for use for food for animals.
approval	includes registration, licence, accreditation, appointment or other authorisation (however this is expressed).
approved arrangement	when used in relation to a provision of this Standard applying to a meat business or meat transport business, means the arrangement for the business that is approved by the controlling authority.
batch	means an identifiable quantity of a commodity produced under essentially the same conditions and during the same period of time not exceeding 24 hours.
boning	means a procedure (other than mechanical separation or rendering to produce meat fractions) for: <ul style="list-style-type: none">(a) the removal of the meat from the bones of a carcass or carcass part; or(b) the production of bone-in or boneless meat cuts.
canning	when used in relation to meat, means the application of a heat process to meat after it is packed in an airtight container.
carcass	means the body of a slaughtered animal after bleeding.

carcase part	means any tissue or structure removed from a carcase and includes, for example, the head, viscera, offal and blood.
clean	when used in relation to premises, meat transport vehicles and equipment, means clean to touch and free of extraneous visible matter and objectionable odour.
commercially sterile	when used in relation to canned goods, means free of micro-organisms that are capable of growing under the conditions the goods are likely to encounter during storage, transport, distribution and sale.
comminuting	means chopping or mincing.
condemned material	means an animal, carcase, carcase part, meat or meat product (including part of a carcase or carcase part): (a) that is condemned under a provision of this Standard; or (b) to which one of the following dispositions is applied: (i) unfit for human consumption and may be recovered for animal food; (ii) unfit for human consumption and may be recovered for pharmaceutical material; (iii) condemned.
construction	includes the design, layout, installation and assembly of the premises, equipment and vehicles and the materials of which they are made.
contaminate	when used in relation to a meat or meat product, means to directly or indirectly transmit objectionable matter to the meat or meat product and includes to transmit the matter to any animal from which meat and meat products are derived or to any surface that may directly or indirectly come into contact with meat and meat products.
contamination	means the presence of objectionable matter (including residues, micro-organisms or matter that has been subjected to ionising radiation contrary to the <i>Food Standards Code</i>) or any substance which may compromise food safety or wholesomeness.
controlling authority	when used in relation to: (a) the production of meat or meat products, means the Commonwealth, state or territory authority that is responsible for the enforcement of this Standard as it applies to the meat or meat products; and (b) the transport of meat or meat products, means the Commonwealth, state or territory authority responsible for the enforcement of this Standard as it applies to and in relation to the transportation of the meat or meat products.
critical control point	means a point, procedure or operation or stage in the food chain, including raw materials, at which control can be applied and is essential to prevent or eliminate a hazard or reduce it to an acceptable level.
critical limit	means the limit to which a hazard must be controlled at a critical control point to prevent or reduce to an acceptable level the occurrence of the identified food safety hazard.
date of packaging	means: (a) for further processed meat and meat products (other than canned meat and meat products), the date on which the further processing was completed; and

	(b) for canned meat and meat products, the date on which the can was closed; and
	(c) in any other case, the date the meat and meat products were first packaged.
document	includes a record.
dressing	means the progressive separation of the body of an animal into a carcass (or sides of a carcass), offal and inedible material. Examples of dressing include the removal of the head, hide or skin, genital organs, urinary bladder, feet, viscera and in lactating animals, the removal of the udder.
dried meat	means meat that has been dried to a water activity of no more than 0.85, but does not include slow dried cured meat.
dry clean	means the removal of extraneous visible matter without the use of water.
edible material	means: (a) meat that is normally regarded as of a kind that is fit for human consumption and to which a disposition has not been applied; and (b) meat and meat products to which a disposition passing them for human consumption has been applied.
emergency slaughter	means slaughter by necessity of any animal that: (a) has recently suffered traumatic injury or is affected or suspected of being affected by a disease or other abnormality; and (b) is in pain or is likely to deteriorate unless it is killed immediately.
equipment	means a machine, instrument, apparatus, utensil, container or other thing used or for use in connection with the production and transportation of meat and meat products (including any thing used or for use for inspection, maintenance and cleaning), but does not include a meat transport vehicle.
essential services	include the provision of drainage, waste disposal, lighting, water and electricity.
established limits	when used in relation to: (a) a contaminant, means the maximum level listed for that contaminant in the <i>Food Standards Code</i> ; and (b) a chemical, means the maximum residue limits permitted for the chemical under the <i>Food Standards Code</i> .
evisceration	means the removal of the viscera from a carcass.
food-borne disease	means a disease that is capable of being transmitted through the consumption of contaminated meat and meat products.
food safety	means food will not cause harm to the consumer when it is prepared or eaten according to its intended use.
Food Standards Code	means the <i>Australia New Zealand Food Standards Code</i> as defined in section 3 of the <i>Australia New Zealand Food Authority Act 1991</i> .
further process	means a process (such as curing, heat treatment, drying, canning, fermenting or rendering) applied to meat or meat products to form essentially a new product with different characteristics and flavour.
HACCP	means hazard analysis critical control point, a system that identifies, evaluates and controls hazards that are significant for food safety.

handle	includes to hold, move, load, unload or touch.
hazard	means a biological, chemical or physical agent in, or condition of, food with the potential to cause an adverse effect in humans.
hazard analysis	means the process of collecting and evaluating information on hazards and conditions leading to their presence to decide which are significant for food safety.
holding	in relation to the sourcing of an animal that is to be slaughtered at meat premises, means the run, station, feedlot, farm or place where the animal is fed, pastured or grazed before it arrives at the premises.
holding pen	means a pen used or to be used to hold animals in preparation for their slaughter.
hot boning	means the boning of a carcass before the temperature at the thermal centre of the carcass is reduced to 20°C.
human consumption	means consumption as food by humans.
inedible material ingredient	means meat that is normally regarded as of a kind that is not fit for human consumption and to which a disposition has not been applied.
meat	means any substance (including a food additive) that is used in the preparation, manufacture or handling of meat and meat products.
meat business	means the dressed carcass and carcass parts of an animal.
meat handler	means a business that is engaged in the production of meat or meat products for human consumption.
meat handler	means an individual who: (a) directly engages in the handling of meat and meat products; or (b) handles surfaces likely to come into contact with meat or meat products; for a meat business or a meat transport business.
meat premises	means premises used for the production of meat or meat products for human consumption.
meat product	means a product containing meat.
meat safety inspector	means an individual who: (a) is given approval by the controlling authority to inspect animals, meat and meat products, and to apply dispositions; and (b) holds qualifications that are approved by the controlling authority as being qualifications required for the purpose of the inspection of animals, meat and meat products, the making of dispositions and the control of hygiene.
meat transport business	means a business that is engaged in the transportation of meat or meat products for human consumption.
meat transport vehicle	means a vehicle used or to be used to transport meat and meat products for human consumption and includes the meat carrying compartment of the vehicle.
monitor	when used in relation to the monitoring of a critical control point, means to conduct a planned sequence of observations or measurements to assess whether the critical control point is under control.

notifiable disease	when used in relation to a disease of animals, means a disease, the presence or suspected presence of, that must be notified or reported (however this is expressed) under a law of the state or territory in which the disease is present or suspected of being present.
packaging	includes wrapping and containers, such as cartons and boxes.
pharmaceutical material	means: (a) a part of any animal or a meat product to which a disposition has been applied enabling it to be recovered for pharmaceutical material; and (b) inedible material for pharmaceutical use.
place of destruction or other disposal	means a place specified in the approved arrangement as a place of destruction or other place of disposal of carcasses and carcase parts.
place of production	in relation to an animal at a meat premises or a holding, means the place of husbandry for the animal immediately before it arrives at the premises or holding.
potable	when used in relation to water, means water that is acceptable for human consumption.
premises	means a place where operations to produce meat or meat products are carried out and includes: (a) any area (whether enclosed, or built on, or not), building, facility, fixture and fitting at the place; and (b) a part of an area, building, facility, fixture or fitting referred to in paragraph (a).
primary bleeding	means the initial and major part of bleeding that follows incisions made to initiate exsanguinations and that is characterised by a continuous flow of blood.
processing	when used in relation to a thing, means applying a treatment to it (including cooling or warming it).
production	of meat or meat products, means: (a) the admission of animals for slaughter for meat and meat products; and (b) the slaughter and dressing of animals from which meat and meat products are derived; and (c) the preparation of meat and meat products; and (d) the storage, processing and packaging of meat and meat products.
proprietor	of a meat business (or meat transport business) means: (a) the person to whom the controlling authority has given approval for the production (or transportation) of meat and meat products (however this is expressed); or (b) if the approval referred to in paragraph (a) is not required to be given under the laws of the Commonwealth, state or territory that apply to the production (or transportation), the person carrying on the business.
protective clothing	means clothing that protects carcasses, carcase parts, meat and meat products from contamination and includes head coverings, footwear, gloves, aprons and boots.
raw meat	means meat that has not undergone a further process.

ready-to-eat	when used in relation to meat and meat products, means meat and meat products that are ordinarily consumed in the same state as that in which they are sold.
refrigeration index	means the value obtained by using a recognised predictive model to calculate the potential growth of <i>E. coli</i> at the site of microbiological concern.
refrigeration index criteria	means the criteria applied to the refrigeration indices to assess a chilling process.
rendering station	means a place specified in an applicable approved arrangement as a place for rendering meat and meat products.
residues	means residues of chemicals and contaminants.
risk assessment	when used in relation to a hazard, means an evaluation of: <ul style="list-style-type: none"> (a) the likelihood that a hazard will occur; and (b) the likelihood of the hazard affecting food safety; and (c) the likely extent of the harm that could result if food safety was so affected.
ritual slaughter	means the slaughter of animals: <ul style="list-style-type: none"> (a) in accordance with Islamic rites in order to produce Halal meat; or (b) in accordance with Judaic rites in order to produce Kosher meat.
sanitise	means to apply heat, chemicals or other processes to a surface so that the number of micro-organisms on the surface is reduced to a level that: <ul style="list-style-type: none"> (a) does not compromise the safety of meat or meat products that may directly or indirectly come into contact with the surface; and (b) does not permit the transmission of infectious disease.
shelf-stable	means will not deteriorate when stored and handled at ambient temperature.
site of microbiological concern	when used in relation to meat or a meat product, means: <ul style="list-style-type: none"> (a) if the site on the meat or meat product where micro-organisms of concern are likely to be located is known, that site; and (b) in any other case, the thermal centre of the meat or meat product.
slaughter	means the killing of an animal and includes stunning, sticking and bleeding.
sticking	means the severing of the large blood vessels to induce effective bleeding.
stunning	means a procedure for rendering an animal unconscious and insensible to pain.
tempering	means warming to a temperature of not warmer than -2°C .
thawing	means warming to a temperature warmer than -2°C .
thermal centre	when used in relation to meat or meat products or a carton containing meat or meat products, means the last point in the meat or product or the carton at which a change in temperature occurs.
transport	includes loading and unloading.
validate	means obtaining evidence to demonstrate the effectiveness of a system of controls.
verify	means apply methods, procedures, tests and other evaluations in addition to monitoring to determine whether a requirement is complied with or a matter is met.

viscera	means the organs of the thoracic and abdominal cavity and includes the kidneys.
waste	includes liquid and solid waste.
wholesome	when used in relation to meat and meat products, means that the meat and meat products may be passed for human consumption on the basis that they: (a) are not likely to cause food-borne disease or intoxication when properly stored, handled and prepared for their intended use; and (b) do not contain residues in excess of established limits; and (c) are free of obvious contamination; and (d) are free of defects that are generally recognised as objectionable to consumers; and (e) have been produced and transported under adequate hygiene and temperature controls; and (f) do not contain additives other than those permitted under the <i>Food Standards Code</i> ; and (g) have not been irradiated contrary to the <i>Food Standards Code</i> ; and (h) have not been treated with a substance contrary to a law of the Commonwealth or a law of the state or territory in which the treatment takes place.
withholding period	when used in relation to a chemical, means the period that is specified on the label approved for the container of the chemical under the <i>Agricultural and Veterinary Chemicals Code Act 1994 (Cwlth)</i> as being the minimum recommended period that must elapse between the last treatment or exposure of an animal to the chemical and its slaughter for meat or meat products for human consumption.
work animal	means: (a) a leader animal and a horse or dog used or to be used to assist in moving and handling slaughter animals; and (b) a dog used or to be used for security.
work implement	means a pouch, belt, steel or knife or other implement of a similar kind used or to be used to produce or transport meat or meat products.

1.4 In this Standard a reference to an Act includes any regulations made under that Act.

Effect of the notes

1.5 A note in this Standard or an outcome described at the head of a section is for information or guidance only and does not form part of this Standard.

2 APPLICATION

Application

2.1 This Standard applies to, and is in relation to, meat and meat products for human consumption that are derived from animals of the bovine, bubaline, camelidae, caprine, cervidae, ovine, porcine and soliped species slaughtered other than in a wild state.

Note For the meaning of *animals*, *human consumption*, *meat*, *meat products* and *slaughter* see clause 1.3.

2.2 This Standard applies to and is in relation to:

- (a) the production, segregation, identification and transportation of meat and meat products for human consumption; and
- (b) the segregation and identification of animal food and pharmaceutical material derived from animals slaughtered to produce meat or meat products for human consumption; and
- (c) the premises, equipment and essential services and meat transport vehicles used or to be used for their production and transportation.

Note For the meaning of *animal food*, *equipment*, *essential services*, *meat transport vehicle*, *pharmaceutical material*, *premises*, *production* and *transport* see clause 1.3.

2.3 The proprietor of a meat business must ensure each of the matters specified in Parts 2 to 7 of this Standard that apply to or are in relation to:

- (a) the production of meat and meat products by the business; and
- (b) the premises, equipment, vehicles and essential services used or to be used by the business for and in relation to the production; are met.

Note For the meaning of *meat business* and *proprietor* see clause 1.3.

2.4 The proprietor of a meat transport business must ensure each of the matters specified in Part 8 of this Standard that apply to or are in relation to:

- (a) the transportation of meat and meat products by the business; and
- (b) the meat transport vehicles and equipment used or to be used by the business for and in relation to the transportation; are met.

Note For the meaning of *meat transport business* see clause 1.3.

PART 2 – WHOLESOMENESS AND OPERATIONAL HYGIENE

3 MANAGEMENT OF WHOLESOMENESS

OUTCOME

Management and production practices and the implementation of HACCP ensure the production of meat and meat products that are wholesome.

Approved arrangement for the production of meat and meat products

- 3.1 The proprietor of a meat business has an approved arrangement that:
- (a) covers each stage of the production of all meat and meat products produced by the business at the premises at which the meat and meat products are produced; and
 - (b) contains controls to ensure meat and meat products for human consumption do not leave the premises unless they are wholesome and accurately identified in accordance with this Standard; and
 - (c) contains controls to ensure meat and meat products unfit for human consumption and meat and meat products not intended for human consumption are removed from the food chain and dealt with separately from meat and meat products for human consumption; and
 - (d) specifies how each of the matters specified in this Standard that apply in relation to the operations for the production undertaken at the premises will be met by the proprietor; and
 - (e) provides for the implementation of a HACCP plan for each stage of the production at the premises.

Note For the meaning of *approved arrangement*, *HACCP* and *wholesome* see clause 1.3.

- 3.2 The provisions of the approved arrangement that relate to each of the matters set out in paragraphs 3.1(a) to (e) are complied with.

Management and production practices at meat premises

- 3.3 The management and production practices of the meat business ensure the matters specified in clauses 3.4 to 3.15 are met in relation to the production of meat and meat products by the business.
- 3.4 The policy objectives of the meat business for the production of meat and meat products that are wholesome and the commitment of the proprietor of the business to these objectives are clearly stated.
- 3.5 The organisational structure, the provision of resources and the provision and training of personnel are documented and are appropriate to the operations undertaken.

Note For the meaning of *document* see clause 1.3.

- 3.6 A system is in place at the premises to verify whether the matters specified in this Standard that apply to the operations are met by the proprietor and the results of the verification are documented.
- Note* For the meaning of *verify* see clause 1.3.
- 3.7 If a matter specified in this Standard is not being met:
- (a) action is taken to address the fact the matter specified is not being met; and
 - (b) action is taken to ensure the failure to meet the matter specified does not recur; and
 - (c) the effectiveness of the action referred to in paragraphs (a) and (b) is assessed.
- 3.8 The effectiveness of the action taken under clauses 3.6 and 3.7 is reviewed regularly and further action is taken if necessary and the results of this review are documented.
- 3.9 Internal audits and management reviews are conducted of steps taken under clauses 3.6 to 3.8 and of management's delivery of the meat business' policy objectives, and the results of these reviews, the decisions to take action as a result of the reviews and the action taken are documented.
- 3.10 For a meat business employing less than three people clauses 3.8 and 3.9 are satisfied if the business conducts a management review.

The HACCP plan

- 3.11 The HACCP plan:
- (a) lists the potential hazards associated with all stages of the production of meat and meat products undertaken by a meat business that may reasonably be expected to occur and that have been identified as a result of a hazard analysis and a risk assessment of each hazard; and
 - (b) specifies the preventative measures that can be applied to control each hazard; and
 - (c) lists the critical control points for each hazard identified; and
 - (d) lists the critical limits that must be met at each of the critical control points; and
 - (e) documents:
 - (i) the procedures that will be used to monitor each of the critical control points to ensure compliance with the critical limits; and
 - (ii) the frequency with which these procedures will be performed; and
 - (iii) the person, or persons included in a class of persons, who will carry out these procedures.
 - (f) documents all corrective action to be taken when monitoring indicates that a critical control point is not under control; and
 - (g) documents the procedures that the business will use to:
 - (i) validate the HACCP plan is working effectively;
 - (ii) verify compliance with the HACCP plan by the business; and lists the frequency with which these procedures will be performed; and

- (h) provides for a system for keeping the documents that contains all matters relevant to the effectiveness of the implementation of the HACCP plan.

Note 1 For the meaning of *critical control point*, *critical limit*, *hazard*, *hazard analysis*, *monitor*, *risk assessment* and *validate* see clause 1.3.

Note 2 For requirements to comply with the provisions of the approved arrangement, including with the HACCP plan, see clause 3.2.

Surveillance, sampling, monitoring and testing programs

- 3.12 The meat business complies with surveillance (targeted), sampling, monitoring and testing programs applying to the business that:

- (a) are endorsed by the relevant Council of Commonwealth, state or territory ministers; or
- (b) are programs that the controlling authority requires the meat business to comply with for the purposes of this provision.

Note For the meaning of *controlling authority* see clause 1.3.

- 3.13 The meat business records the surveillance (targeted), sampling, monitoring and testing performed under programs referred to in clause 3.12 and the available results of surveillance, sampling, monitoring and testing.

Note For general requirements to make and keep documents, see clauses 3.6 and 18.1.

Notifiable diseases

- 3.14 If an animal at a meat premises is affected by, or is suspected of being affected by, a notifiable disease or a carcass or carcass part at the premises displays evidence of an animal having been so affected, the operator must without delay advise the authority in the state or territory in which the premises is located that is charged by the government of that state or territory with the responsibility for animal health.

Note 1 See clauses 6.12 and 10.22.

Note 2 For the meaning of *meat premises*, *carcass* and *carcass part* see clause 1.3.

- 3.15 There is a system in place for the handling of animals, carcasses and carcass parts, and other measures, including traceback, to control the spread of a notifiable disease.

4 OPERATIONAL HYGIENE

OUTCOME

Operational hygiene process controls ensure the production of meat and meat products that are wholesome.

General

- 4.1 The proprietor of a meat business follows a system of operational hygiene process controls that is effective in ensuring meat and meat products produced by the business are wholesome.

Cleaning and maintenance of premises and equipment

- 4.2 Meat premises (other than external areas) and equipment:
- (a) are clean before operations commence each day; and
 - (b) are cleaned at the end of operations each day; and
 - (c) if there is more than one shift in a day, are dry cleaned at the end of each shift; and
 - (d) are cleaned and sanitised whenever it is necessary to do so to prevent the contamination of meat and meat products.

Note For the meaning of *clean*, *contamination*, *dry clean* and *sanitise* see clause 1.3.

- 4.3 At the end of operations each day holding pens are cleaned to the extent necessary to ensure:
- (a) contamination is not transferred from the pens to areas used for slaughter and dressing animals; and
 - (b) pests are not attracted to the pens.

Note For the meaning of *holding pen* see clause 1.3.

- 4.4 If any part of the premises or any thing:
- (a) comes into contact with a carcass or carcass part that has not been given a post-mortem disposition; and
 - (b) there is a risk it could contaminate a carcass or carcass part intended for human consumption of any other animal; it is cleaned and sanitised before it comes into contact with a carcass or carcass part of any other animal.

Note For the meaning of *contaminate* see clause 1.3.

- 4.5 Meat premises and equipment are maintained in a good state of repair and working order having regard to their use.

- 4.6 Ingredients for meat and meat products:
- (a) are fit for the purpose for which they are to be used; and
 - (b) are labelled, stored and handled in a way that ensures their identity can be ascertained.

Note For the meaning of *ingredient* and *handle* see clause 1.3.

- 4.7 The accumulation of material likely to cause contamination of meat and meat products at meat premises is prevented.

Hazardous materials and chemicals

- 4.8 Hazardous materials (such as cleaning compounds, pesticides, detergents and sanitisers) and other chemicals:
- (a) are fit for the purpose for which they are to be used; and
 - (b) do not contaminate animals, meat and meat products and are not used if their use could cause contamination; and
 - (c) do not become contaminated during storage and handling; and
 - (d) are labelled, stored and handled in a way that ensures their identity can be ascertained; and
 - (e) are identified and stored in a manner that prevents their misuse and the contamination of meat and meat products; and
 - (f) are fit for use in connection with the operations undertaken to produce meat and meat products.
- 4.9 Containers used for storing, mixing and distributing hazardous material are identified for use for hazardous material and are used only for that purpose.

Pest control

- 4.10 There is an effective and continuous program for the control of pests.

Animals

- 4.11 Only the following animals are present at meat premises:
- (a) animals of a kind specified in the approved arrangement that are to be slaughtered at the premises; and
 - (b) work animals used or to be used at the premises.
- Note* For the meaning of *work animal* see clause 1.3.
- 4.12 Animals are not removed from meat premises except in accordance with requirements for their removal specified in the approved arrangement.
- 4.13 Work animals used or to be used to assist in handling animals to be slaughtered are kept outside any buildings used to produce meat or meat products or are restricted to lairages.
- 4.14 Work animals used or to be used for security are restricted to perimeter areas and do not enter buildings used to produce meat or meat products.
- 4.15 Work animals are maintained in sound health and do not contaminate animals, meat or meat products.

Personal hygiene

- 4.16 Persons at premises where meat and meat products are produced exercise personal hygiene practices that do not jeopardise the wholesomeness of meat and meat products.
- 4.17 Each of the applicable matters specified in Schedule 1 are met.

5 CROSS-CONTAMINATION

OUTCOME

Meat and meat products are not contaminated.

Meat and meat products are not contaminated

- 5.1 Meat and meat products at meat premises are not contaminated by:
- (a) airflow; and
 - (b) steam, smoke, condensation, splash, the emission of heat or other contaminants; and
 - (c) the movement of persons or things between areas; and
 - (d) the slaughter and dressing of animals; and
 - (e) the storage, handling, processing or packaging of meat or meat products; and
 - (f) the cleaning, sanitising and maintenance of meat premises, equipment or meat transport vehicles; and
 - (g) the assembly, storage, handling or use of equipment, packaging or ingredients; and
 - (h) any other thing or activity at the premises.

Note For the meaning of *packaging* and *processing* see clause 1.3.

- 5.2 During production meat and meat products do not come into contact with any surface that is not designed for contact with the meat or meat products.

Cross-contamination of meat and meat products and other materials

- 5.3 Edible material is not contaminated by animals, inedible material, condemned material, animal food or pharmaceutical material.

Note For the meaning of *condemned material*, *edible material* and *inedible material* see clause 1.3.

- 5.4 There is physical separation between areas used for edible material and areas where animals are held.

- 5.5 Areas used for inedible material and condemned material are, to the extent necessary to prevent contamination of edible material, physically separate from areas used for edible material.

Note For the segregation of animal food and pharmaceutical material see clause 17.

- 5.6 To the extent necessary to prevent contamination of other meat and meat products, separate rooms and separate equipment are used for the emptying, cleansing and processing of alimentary tracts for human consumption.

- 5.7 The alimentary tract and inedible material are removed from the slaughtering and dressing area as soon as inspection permits and in a manner that prevents contamination of the area and of meat and meat products for human consumption.

- 5.8 Alimentary tracts not for human consumption and inedible material are processed in parts of the premises intended for the purpose of treating inedible material and in a way that does not risk contamination of meat and meat products for human consumption.
- 5.9 Each of the areas, rooms or parts of premises referred to in clauses 5.4 to 5.8 are identified so as to indicate the material that may be stored, handled, processed or packaged in that area, room or part of the premises.
- 5.10 Equipment used in an area, room or part of a premises referred to in clauses 5.4 to 5.8 is not taken into any other area, room or part of a premises (as the case may be) unless the equipment:
- (a) is used to take edible material to an area used for inedible or condemned material; and
 - (b) is sanitised before re-entering an area used for edible material.
- 5.11 Persons in areas (including rooms or parts of a premises) used for inedible material, rendered material or animal food do not enter areas used for edible material unless they:
- (a) have thoroughly washed; and
 - (b) have changed their outer clothing; and
 - (c) are free from contamination originating in the area used for the inedible material, rendered material or animal food.
- 5.12 Carcase parts that under clause 10.4 need not be inspected are removed from the slaughter floor as soon as possible after dressing.
- 5.13 Inedible material and condemned material:
- (a) are clearly identified as inedible or as condemned as the case may be; and
 - (b) are secured and handled in a manner that ensures they do not contaminate edible material.
- 5.14 Inedible material (other than inedible material for use as animal food or for use for pharmaceuticals) and condemned material:
- (a) are moved to a rendering station or place of destruction or other disposal at the premises and are destroyed or otherwise disposed of so that they cannot be used for human consumption; or
 - (b) are removed from the premises to a rendering station or place for destruction or other disposal in order to be rendered, destroyed or otherwise disposed of so that they cannot be used for human consumption.
- Note 1* For the meaning of *place of destruction or other disposal* and *rendering station* see clause 1.3.
- Note 2* For inedible material for use for animal food or for pharmaceutical material see section 17.
- 5.15 Meat and meat products that come in contact with or are contaminated by inedible material, animal food, pharmaceutical material or condemned material:
- (a) are condemned; or
 - (b) are separately identified and held separately under conditions of security until a meat safety inspector applies a disposition to them.

Note For the meaning of *meat safety inspector* see clause 1.3.

- 5.16 Inedible material is not received by a meat business for rendering for meat and meat products for human consumption unless the approved arrangement provides for the receipt and processing of the material.
- 5.17 Before rendering, the inedible material referred to in clause 5.16:
 - (a) is kept separate from edible material; and
 - (b) is stored in facilities and containers that are not used for any other purpose and are clearly identified as being for use for the inedible material.
- 5.18 Meat that is diseased or suspected of being diseased is handled in a manner that ensures meat and meat products are not contaminated.
- 5.19 Meat and meat products that are required to be retained awaiting treatment, the results of tests or other examination or the application of a disposition are identified as retained for that purpose and are held separately from meat and meat products not required to be retained.

Processing

- 5.20 The process flow of meat awaiting processing ensures uniform turnover of accumulated product.
- 5.21 Processing activities likely to cause contamination are undertaken so that there is physical separation from other activities.

Additional requirements for ready-to-eat and cooked product

- 5.22 Ready-to-eat meat and meat products are not contaminated by meat and meat products that are not ready-to-eat.
Note For the meaning of *ready-to-eat* see clause 1.3.
- 5.23 Cooked meat is not contaminated by raw meat.
- 5.24 The storage, handling, processing and packaging of raw meat takes place in areas that are used for raw meat only and are clearly identified as being for use for raw meat only.
- 5.25 The manual handling of cooked meat does not jeopardise its wholesomeness.
- 5.26 The storage, handling, processing and packaging of cooked meat takes place in areas that are used for cooked meat only and are clearly identified as being for use for cooked meat only.
- 5.27 The further processing of meat and meat products takes place in areas that:
 - (a) are only used for further processing of the kind undertaken; and
 - (b) are clearly identified as being for use only for the further processing of the kind undertaken.

Note For the meaning of *further process* see clause 1.3.

- 5.28 Persons in areas used for uncooked meat and meat products do not enter areas used for cooked meat and meat products until they:
- (a) have thoroughly washed; and
 - (b) have changed their outer clothing; and
 - (c) are free from contamination originating in the area used for uncooked meat and meat products.

PART 3 – SLAUGHTER AND DRESSING OF ANIMALS

6 THE SUPPLY AND ADMISSION OF ANIMALS FOR SLAUGHTER

OUTCOMES

Animals are sourced from holdings where the management of animals ensures the wholesomeness of meat and meat products derived from the animals is not jeopardised. Animals affected by a disease or other abnormality do not contaminate other animals or jeopardise the wholesomeness of meat and meat products.

Source of supply

- 6.1 Animals for slaughter for meat and meat products for human consumption (other than animals captured in the wild) are sourced only from a holding:
- (a) where animals are raised according to good animal husbandry practices and are not fed feedstuffs that could jeopardise the wholesomeness of meat and meat products derived from the animals; and
 - (b) that has a system in place that is capable of reliably identifying any disease, other abnormality or treatment of animals that could affect their fitness for slaughter; and
 - (c) that complies with surveillance (targeted), sampling, monitoring and testing programs (including the National Residue Survey monitoring programs) that:
 - (i) are endorsed by a Commonwealth, state or territory authority; and
 - (ii) apply to the holding.

Note For the meaning of *holding* and *place of production* see clause 1.3.

- 6.2 Animals for slaughter for meat and meat products for human consumption are sourced only from a holding that has a system in place that is capable of:
- (a) for ovines, caprines and cervidae admitted by a meat business as part of a consignment of animals, reliably providing a list of:
 - (i) the places of production or the saleyards of the animals in the consignment; or
 - (ii) if the animals are captured in the wild, all the areas from which the animals in the consignment were captured; and
 - (b) for other animals, identifying:
 - (i) the place of production of each animal; or
 - (ii) if the animals are captured in the wild, the area from which each animal was captured.

Admission of animals

- 6.3 As soon as practical after animals for slaughter arrive at a meat premises a determination is made about their admission.
- 6.4 Animals suspected to have a disease or defect that could affect their fitness for slaughter are referred to a meat safety inspector for a decision about their admission.
- 6.5 A decision that an animal is not to be admitted or is to be admitted only under conditions that ensure the wholesomeness of meat and meat products is not jeopardised is the responsibility of the meat safety inspector.
- 6.6 Animals are not admitted or are admitted subject to conditions specified by the meat safety inspector if they are animals in relation to which at the time of their admission:
- (a) the meat business does not have:
 - (i) information indicating whether or not they are animals of the kind referred to in clauses 6.7 to 6.9; or
 - (ii) the information about them that is referred to in paragraphs 6.2(a) and 6.2(b); or
 - (b) the animals are not identified in accordance with any requirements applying to the animals under a law of the Commonwealth or a state or a territory, or under a program referred to in clause 3.12.
- 6.7 Animals are not admitted or are admitted subject to conditions specified by the meat safety inspector if there is a risk that the animals:
- (a) are subject to, or have been at an area that is subject to, requirements for the control of animal health under a law of a state or territory; or
 - (b) are subject to requirements for the controls of a disease of animals under a law of the Commonwealth; or
 - (c) are delivered subject to animal health controls under a law of a state or territory; or
 - (d) have been fed foodstuffs capable of recycling human or animal pathogens and all necessary precautions have not been taken to remove the risk of recycling the pathogens; or
 - (e) have been grazed on areas treated with sewerage; or
 - (f) are affected by or suspected of being affected by a contagious or notifiable disease.
- Note* For the meaning of *notifiable disease* see clause 1.3.
- 6.8 (1) Animals are not admitted or are admitted subject to conditions specified by the meat safety inspector if they have been or there is a risk that they have been exposed to a dangerous substance.
- (2) Animals are taken to be exposed to a dangerous substance if they have been:
- (a) used for trials or experiments to evaluate drugs, chemicals, biological substances or processes of genetic manipulation; or
 - (b) treated with or exposed to a new or unidentified drug, chemical or biological substance or treated with or exposed to a chemical and the withholding period for the chemical has not elapsed; or

- (c) treated or exposed to a chemical likely to present a risk of a residue in excess of established limits; or
- (d) exposed to ionising radiation contrary to the *Food Standards Code*.

Note For the meaning of *established limits*, *Food Standards Code*, *residues* and *withholding period* see clause 1.3.

- 6.9 Animals are not admitted or are admitted subject to conditions specified by the meat safety inspector if the animals are affected by or are suspected of being affected by any disease or other abnormality that:
- (a) could result in contamination of other animals or of meat or meat products; or
 - (b) could jeopardise the wholesomeness of meat and meat products derived from the animal.
- 6.10 If an animal is admitted subject to conditions, the conditions specified by the meat safety inspector are complied with.
- 6.11 If an animal is admitted subject to conditions or if an animal is found after admission to be an animal of a kind referred to in clauses 6.6 to 6.9 the animal:
- (a) is separately identified and segregated from other animals until a decision is made by a meat safety inspector about its suitability for slaughter; and
 - (b) does not contaminate other animals, meat and meat products.
- 6.12 (1) If an animal is affected by or is suspected of being affected by a contagious or a notifiable disease, associated animals, carcasses and carcase parts are also separately identified and segregated from animals, carcasses and carcase parts not so affected or suspected of being affected until a disposition is applied to them by a meat safety inspector.
- (2) For the purposes of sub-clause (1): *associated animals*, *carcasses* and *carcase parts* means any animals and the carcasses and carcase parts of any animals for which there is a risk that they are affected by the disease.

Note For contagious or notifiable diseases discovered in carcasses and carcase parts see clause 10.22 and see further clause 3.14.

Identification and handling of animals

- 6.13 There is a system in place for the identification and handling of animals to be slaughtered so that until the post-mortem disposition is applied to the carcase of each animal and each of its carcase parts:
- (a) the ability to identify the place of production of the animal is retained; and
 - (b) information about the condition, treatment, exposure and slaughter of the animal that is necessary to assess the wholesomeness of meat and meat products derived from the carcase or carcase part of each animal can be ascertained.

7 ANIMAL WELFARE

OUTCOME

The minimisation of the risk of injury, pain and suffering and the least practical disturbance to animals.

Handling of animals

- 7.1 Premises and equipment:
- (a) are used in a way; and
 - (b) are maintained in a condition; that minimises risk of injury, pain and suffering to animals and causes them the least practicable disturbance.
- 7.2 Animals are handled at meat premises in a way that minimises the risk of injury, pain and suffering and causes the least practicable disturbance to them and to other animals at the premises.
- 7.3 The separation of animals of different species or different sexes or of animals of the same species is provided to the extent necessary to minimise the risk of injury, pain and suffering to them and causes them the least practicable disturbance.
- 7.4 Animals are provided with feed (where appropriate), water, shade, shelter, space and ventilation that is sufficient to minimise stress to the animals.
- 7.5 If it is necessary to minimise the stress to the animals, water sprays are provided.

Young, injured, sick or stress susceptible animals

- 7.6 Special provision is made for the handling and slaughter of:
- (a) animals that are not weaned or are stressed, injured or diseased; and
 - (b) animals of a species that is particularly susceptible to stress.
- 7.7 Injured and sick animals are examined and given appropriate treatment and are segregated from other animals.
- 7.8 Animals identified as requiring emergency slaughter are not moved more than is necessary and are slaughtered or killed humanely as soon as possible after being so identified.
- Note* For the meaning of *emergency slaughter* see clause 1.3.

Slaughter

- 7.9 Animals are slaughtered in a way that prevents unnecessary injury, pain and suffering to them and causes them the least practicable disturbance.
- 7.10 Before sticking commences, animals are stunned in a way that ensures the animals are unconscious and insensible to pain before sticking occurs and do not regain consciousness or sensibility before dying.
- Note* For the meaning of *sticking* and *stunning* see clause 1.3.

- 7.11 Before stunning commences, animals are restrained in a way that ensures stunning is effective.

Ritual slaughter

- 7.12 (1) This provision only applies to animals killed under an approved arrangement that provides for their ritual slaughter involving sticking without prior stunning.
(2) An animal that is stuck without first being stunned and is not rendered unconscious as part of its ritual slaughter is stunned without delay after it is stuck to ensure it is rendered unconscious.

Note For the meaning of *ritual slaughter* see clause 1.3.

Work animals

- 7.13 Work animals are kept under control and are handled, restrained and accommodated in a way that minimises risk of injury and stress and causes the least practicable disturbance to the animals that are to be slaughtered and to other work animals.
- 7.14 Work animals (other than leader animals) are accommodated separately from slaughter animals.
- 7.15 Dogs used or to be used to facilitate the handling of slaughter animals:
(a) are effectively muzzled when working; and
(b) are restrained when not working.

8 ANTE-MORTEM INSPECTION AND DISPOSITION

OUTCOME

Only animals fit for slaughter for the purpose of producing meat and meat products for human consumption are slaughtered.

Role of meat safety inspector

- 8.1 Animals are not slaughtered unless a meat safety inspector:
- (a) has carried out an ante-mortem inspection in accordance with the approved arrangement; and
 - (b) has passed the animals for slaughter.

Ante-mortem inspection

- 8.2 An ante-mortem inspection of animals is carried out within 24 hours before they are slaughtered.
- 8.3 A further inspection of the animals is carried out if after the initial inspection any of them are found to be or are suspected of being affected with a disease or other abnormality.
- 8.4 Reasonable steps are taken to present animals for inspection in a clean condition.
- 8.5 Animals that are not clean are not passed for slaughter or are passed for slaughter subject to conditions that ensure they do not contaminate animals, carcasses and carcase parts during slaughter, dressing, post-mortem inspection and disposition.
- 8.6
- (1) The meat safety inspector is given all relevant information known to the meat business about the animals slaughtered or to be slaughtered.
 - (2) For the purposes of sub-clause (1), relevant information means:
 - (a) information identifying any place (including a run, station, feedlot, farm or other place where animals are fed, pastured or grazed) where the animals have been present before arriving at the meat business; and
 - (b) information indicating whether the animals may have been in contact with an animal affected or suspected of being affected by a disease or other abnormality that could affect the disposition to be applied to them; and
 - (c) information about the treatment and health of the animals that could affect the disposition to be applied to them including the results of any sampling, monitoring or testing of the animals under any program referred to in clause 3.12; and
 - (d) any other information that is relevant to whether the animals are or are suspected to be affected with a disease or other abnormality that could affect the disposition to be applied to them.
- 8.7 Animals are inspected to the extent necessary to determine the disposition to be applied to them.

Ante-mortem disposition

- 8.8 In deciding the disposition that is to be applied to animals the meat safety inspector takes into account:
- all relevant information about the animals described in sub-clause 8.6; and
 - the results of inspection of the animals.
- 8.9 One of the following dispositions is applied to the animals:
- passed for unconditional slaughter; or
 - passed for slaughter subject to conditions specified by the meat safety inspector; or
 - withheld from slaughter; or
 - condemned.
- 8.10 (1) An animal (other than an animal referred to in sub-clause (2)) is passed for slaughter only if the meat safety inspector knows:
- the place of production of the animal; or
 - for an animal captured in the wild, the area from which the animal was captured.
- (2) An animal of the ovine, caprine and cervidae species admitted by a meat business as part of a consignment of animals is passed for slaughter only if the meat safety inspector has a list of:
- all the places of production or the saleyards of the animals in the consignment; or
 - for an animal captured in the wild, all the areas from which the animals in the consignment were captured.
- 8.11 An animal is not passed for unconditional slaughter if the animal is or is suspected of being affected by a disease or other abnormality that:
- could result in contamination of animals, carcasses or carcase parts during slaughter, dressing, post-mortem inspection or disposition; or
 - could jeopardise the wholesomeness of meat and meat products derived from the animal.
- Note* For animals affected or suspected of being affected by a notifiable disease see clause 6.12.
- 8.12 An animal affected or suspected of being affected in a way described in clause 8.5 or clause 8.11 is passed for slaughter subject to conditions specified by the meat safety inspector only if compliance with the conditions would ensure the disease or other abnormality does not result in the contamination referred to in paragraph 8.11(a) and that the wholesomeness of meat and meat products is not jeopardised.
- 8.13 An animal passed for slaughter subject to conditions specified by the meat safety inspector:
- is identified as passed subject to conditions; and
 - is segregated from animals not passed subject to conditions.

- 8.14 An animal is not passed for slaughter if the animal is or is suspected of being treated with or exposed to a drug, chemical or biological substance:
- (a) contrary to a law of the Commonwealth or a law of the state or territory in which the treatment or exposure takes place; or
 - (b) for which the withholding period has not expired.
- 8.15 An animal affected, or suspected of being affected, with a disease or other abnormality is withheld from slaughter if to do so would enable:
- (a) the disease or abnormality to be identified (including symptoms of the disease to develop and results of tests to be obtained and examinations to be conducted); or
 - (b) the disease or abnormality to be treated; or
 - (c) the animal to recover from the disease or abnormality.
- 8.16 An animal required to be withheld from slaughter:
- (a) is identified and segregated from animals not required to be withheld from slaughter; and
 - (b) is submitted for ante-mortem inspection and disposition before slaughter.
- 8.17 If an animal is affected or suspected of being affected by a disease or other abnormality specified for animals of that kind in column 1 of Schedule 3, the disposition (if any) that is specified, in column 2 of Schedule 3 as applying to the disease or abnormality for animals of that kind, is applied to the animal.
- 8.18 An animal is condemned if it is affected with or suspected of being affected with a disease or other abnormality for animals of that kind described in column 1 of Schedule 3 for which the disposition specified in column 2 of Schedule 3 is the condemnation of the carcass and all its carcass parts.
- Note* If column 2 of Schedule 3 specifies condemnation of the animal itself then clause 8.17 applies.
- 8.19 An animal is condemned if necessary to prevent or reduce the risk of the spread of a disease or to prevent or reduce any other risk to human or animal health.
- 8.20 A record is kept of the ante-mortem disposition applied to animals (other than a disposition applied to animals passing them for unconditional slaughter).
- 8.21 The disposition applied to each animal can be matched:
- (a) with the animal until it is slaughtered; and
 - (b) with its carcass and carcass parts until the post-mortem inspection of its carcass and all its carcass parts is completed.
- 8.22 The conditions and other requirements specified in the ante-mortem disposition applied to the animals are complied with.
- 8.23 Animals that have been condemned are humanely killed and removed expeditiously to a place for the rendering, disposal or destruction of carcasses that is specified in the approved arrangement.
- 8.24 Animals that have died prior to slaughter are removed expeditiously to a place referred to in clause 8.23.

9 SLAUGHTER AND DRESSING

OUTCOME

Slaughter and dressing is to be done in a way that:

- (a) reduces the risk of contamination of carcasses and carcase parts to a level that ensures the wholesomeness of meat and meat products is not jeopardised; and
- (b) ensures an accurate post-mortem disposition can be applied to carcasses and carcase parts.

General

9.1 The slaughter of an animal and the dressing of its body and the trimming and washing of its carcase and its carcase parts is done in a way that:

- (a) reduces the risk of contamination of the carcase and its carcase parts to a level that ensures their wholesomeness and the wholesomeness of other meat and meat products at the premises is not jeopardised; and
- (b) ensures an accurate post-mortem disposition can be applied to the carcase and each of its carcase parts.

Note For the meaning of *dressing* see clause 1.3.

9.2 Different species of animals that:

- (a) are killed on a common slaughter chain are segregated by sufficient interval so that mixing of species does not occur; and
- (b) are killed on a common slaughter floor but on different slaughter chains are segregated by sufficient space so that mixing of species does not occur.

9.3 A meat safety inspector is present during the slaughter and dressing of each animal.

Slaughter

9.4 Stunning proceeds at a rate that allows:

- (a) carcasses to be promptly accepted for dressing; and
- (b) carcasses to be dressed in a hygienic and orderly manner; and
- (c) for the post-mortem inspection and chilling and freezing of carcasses and their parts to be carried out effectively.

Dressing – general

9.5 Animals are unconscious and primary bleeding is completed before dressing commences.

Note For the meaning of *primary bleeding* see clause 1.3.

9.6 Once dressing has commenced, carcasses are kept separate so that there is no contact between them until they have been examined and passed by a meat safety inspector.

- 9.7 Skinning of the carcass is completed before evisceration unless the skin is intended to remain on the carcass after dressing.

Note For the meaning of *evisceration* see clause 1.3.

- 9.8 If the skin is intended to remain on the carcass of an animal:
- (a) any incisions of the carcass are minimised so that there is no contamination of the carcass by the hair, bristles and any other objectionable matter; and
 - (b) before the first incision resulting in the opening of a body cavity the carcass is scalded, flamed, washed or similarly treated so as to be thoroughly cleansed of hair, bristles and any other objectionable matter.
- 9.9 Water does not enter the abdominal or thoracic cavities during the washing of uneviscerated carcasses.

Dressing – removal of parts

- 9.10 The discharge of any material from the oesophagus, stomach, intestines, rectum, gall bladder, urinary bladder and uterus is prevented.
- 9.11 Unless the skin is intended to remain on the carcass after dressing, the head of a carcass:
- (a) that is to be inspected under clause 10.4 is skinned to the extent necessary to enable inspection of the head to be performed effectively; and
 - (b) from which the brain is to be removed is skinned to the extent necessary to facilitate the hygienic removal of the brain; and
 - (c) from which meat for human consumption is to be removed is completely skinned, dehorned and washed.
- 9.12 The nasal, buccal and oral cavities of animals of the bovine, bubaline, camelidae and soliped species are thoroughly cleansed by flushing with water before the tongue is partially detached or removed.
- 9.13 The tongue is partially detached or removed without cutting the tonsils.
- 9.14 All tonsillar tissue is removed intact from the tongue before washing.
- 9.15 Udders are removed in such a manner that:
- (a) teat and udder substances remain intact and milk ducts and sinuses are not opened; and
 - (b) associated lymph nodes are left in place; and
 - (c) the discharge of any material from the udders does not cause contamination to meat and meat products.
- 9.16 Pizzles are removed as completely as possible.
- 9.17 Meat other than brains recovered from heads is individually washed in potable running water and immediately drained.

Note For the meaning of *potable* see clause 1.3.

- 9.18 The following are removed from the carcass before washing if the approved arrangement specifies that they may be removed or if their removal is approved by a meat safety inspector:
- (a) evidence of visible contamination including faecal material, urine, milk and other excreta and secretions; and
 - (b) exudate from a lesion and any other defect likely to contaminate a carcass during washing.
- 9.19 Before the post-mortem inspection of a carcass and each of its carcass parts is completed the following are removed or modified only with the approval of a meat safety inspector:
- (a) any defects other than those referred to in clause 9.18; and
 - (b) any other indication of a disease or other abnormality or evidence of contamination.
- Note* For the meaning of *approval* see clause 1.3.
- 9.20 The following are condemned:
- (a) all material that is likely to be affected by contamination or pathological conditions trimmed from a carcass or carcass part; and
 - (b) the heads of animals stunned using a firearm.

10 POST-MORTEM INSPECTION AND DISPOSITION

OUTCOME

Unwholesome meat is excluded from the human food chain and disposed of separately.

Post-mortem inspection

- 10.1 Post-mortem inspection of each carcase and its carcase parts is carried out by a meat safety inspector.
- 10.2 Before the post-mortem inspection commences, the meat business gives the meat safety inspector:
- (a) details of the inspection of and disposition applied to the animal from which the carcase and its carcase parts are derived; and
 - (b) all information known to the meat business about any disease or other abnormality affecting or suspected of affecting the carcase and its carcase parts and the animal from which the carcase and its carcase parts are derived.
- 10.3 Any information including identification that is applied to an animal or to its carcase or carcase part is not removed or modified before the post-mortem inspection of the carcase of the animal and all its parts unless a meat safety inspector has approved the removal or modification.
- 10.4 The following are inspected:
- (a) carcasses; and
 - (b) carcase parts for human consumption; and
 - (c) carcase parts of a kind the inspection of which is necessary in order to establish whether a carcase or carcase part for human consumption may be affected by a disease or other abnormality.
- Note* For carcasses and carcase parts not required to be inspected see clause 5.12.
- 10.5 The inspection procedures specified in Schedule 2 are followed.
- 10.6 Carcasses and carcase parts to be inspected under clause 10.4 are presented for inspection in a manner and condition that enables the inspection to be performed effectively.
- 10.7 Procedures for the inspection of carcasses and carcase parts enable any disease or other abnormality of a kind that can be detected by physical observation such as sight, touch and smell to be detected.
- 10.8 Meat businesses comply with additional procedures for the inspection of carcasses and carcase parts that apply to the meat business under programs referred to in clause 3.12.
- Note* This provision picks up the additional inspection procedures that may be required for animals under a targeted surveillance program.

Correlation

- 10.9 Carcasses and carcass parts to be inspected under clause 10.4 do not leave the slaughter floor until a post-mortem disposition is applied to the carcass and all its parts.
- 10.10 Carcass parts to be inspected under clause 10.4 are correlated with the carcass from which the parts are removed until the post-mortem disposition is applied to the carcass and all its parts.

Post-mortem disposition

- 10.11 In deciding the disposition that is to be applied to a carcass and its parts the meat safety inspector takes into account:
 - (a) information known to the meat safety inspector about any disease or other abnormality affecting or suspected of affecting the carcass, its carcass parts or the animal from which the carcass and its carcass parts are derived; and
 - (b) the results of the inspection of the carcass and its carcass parts.
- 10.12 One of the following dispositions is applied:
 - (a) for carcasses and carcass parts:
 - (i) passed for human consumption;
 - (ii) retained for final disposition;
 - (iii) unfit for human consumption and may be recovered for animal food;
 - (iv) unfit for human consumption and may be recovered for pharmaceutical material; or
 - (v) condemned; and
 - (b) for carcass parts, derived from an animal the carcass of which is passed for human consumption and the carcass parts require further treatment to be fit for human consumption.
- 10.13 Carcasses and carcass parts affected or suspected of being affected with a disease or other abnormality that could affect the wholesomeness of meat and meat products are not passed for human consumption.
- 10.14 If a carcass part is derived from an animal the carcass of which is passed for human consumption and the carcass part requires further treatment, the carcass part is stored, handled, processed and packaged by a meat business under conditions of security specified in the approved arrangement until the further treatment is completed.
- 10.15 If a carcass part of an animal has been aggregated with a part derived from another animal, then the disposition applied to all the aggregated parts is the most restrictive of the dispositions applied to the following:
 - (a) any of the carcasses from which the aggregation parts are derived; and
 - (b) any of the carcass parts forming part of the aggregation.
- 10.16 Edible fat for food is derived only from carcasses and carcass parts passed for human consumption.

- 10.17 Carcasses and carcase parts requiring treatment or awaiting the results of tests or other examination before final disposition are retained pending the treatment or the results or examination or are condemned as unfit for human consumption.

Note For meat and meat products that are retained see clause 5.19.

- 10.18 If a carcase or carcase part of an animal is affected or suspected of being affected with a disease or other abnormality described in column 1 of Schedule 3 for an animal of that kind, a disposition for the carcase and carcase part specified for that disease or other abnormality in animals of that kind in column 2 of Schedule 3 is applied to the carcase and carcase part.

- 10.19 Carcasses and carcase parts are condemned as unfit for human consumption if necessary to prevent or reduce the risk of the spread of a disease or to prevent or reduce any other risk to human or animal health.

- 10.20 A record is kept of:

- (a) carcasses and carcase parts to which a disposition described in sub-paragraphs 10.12 (a)(iii), (iv) and (v) is applied; and
- (b) carcasses and carcase parts affected or suspected of being affected with a disease or other abnormality presenting a risk to public health and of the nature of the risk presented.

- 10.21 The conditions and other requirements specified in the post-mortem disposition applied to the carcasses or carcase parts are complied with.

Note For related requirements see clauses 5.13 and 5.14 (inedible material and condemned material), clause 5.19 (meat and meat products required to be retained) and clauses 17.1 to 17.11 (animal food and pharmaceutical material).

- 10.22 (1) If the carcase or carcase part of an animal is affected by or is suspected of being affected by a contagious or notifiable disease of animals:

- (a) the animal's carcase and all its carcase parts (including the head if still available) are separately identified and segregated from other carcasses and carcase parts not affected or suspected of being affected by the disease; and
- (b) associated animals, carcasses and carcase parts are separately identified and segregated from animals, carcasses and carcase parts not so affected or suspected of being affected until a disposition is applied to them by a meat safety inspector.

(2) For the purposes of sub-clause (1): *associated animals, carcasses and carcase parts* means any animals and the carcasses and carcase parts of any animals for which there is a risk that they are affected by the disease.

Note For contagious or notifiable diseases discovered in animals see clause 6.12 and see further clauses 3.14 and 3.15.

PART 4 – PROCESSING

11 CHILLING AND FREEZING

OUTCOME

The chilling and freezing of meat maintains and does not jeopardise its wholesomeness.

- 11.1 The chilling and freezing of meat ensures its wholesomeness is maintained.
- 11.2 During its chilling and freezing the wholesomeness of meat is not jeopardised.
- 11.3 All carcasses and carcase parts are placed under refrigeration for chilling or freezing within two hours of stunning.
- 11.4 During primary chilling carcasses, sides and quarters do not come into contact with each other.
- Note* For requirements that carcasses and carcase parts do not come into contact with other surfaces see clause 5.2.
- 11.5 The loading of hot carcasses into chillers containing chilled carcasses does not result in the warming of the chilled carcasses or their contamination with condensed moisture.
- 11.6 Refrigeration for the chilling and freezing applied to carcasses and carcase parts achieves:
- chilling with continuous temperature reduction within 24 hours after the stunning of the animal from which the carcase or part is derived:
 - for a carcase, side, quarter or bone-in major separated cut, a temperature of no warmer than 7°C on all its surfaces; and
 - for any other carcase part, a temperature of no warmer than 5°C at the site of microbiological concern; or
 - chilling of hot boned carcasses and carcase parts in accordance with the requirements for hot boning specified in the approved arrangement and within the following refrigeration index criteria:
 - the refrigeration index average is to be no more than 1.5; and
 - 80% of refrigeration indices are to be no more than 2.0; and
 - no refrigeration index above 2.5; or
 - the alternative time and temperature controls for chilling the carcase or carcase parts that are specified in the approved arrangement; and
 - if the carcase or carcase parts are to be frozen, the refrigeration controls for freezing:
 - ensure the carcasses or carcase parts are hard frozen without delay after compliance with requirements for chilling in paragraphs 11.6(a) to (c); and

(ii) achieve the controls that are specified in the approved arrangement.

Note For the meaning of *hot boning*, *site of microbiological concern*, *refrigeration index* and *refrigeration index criteria* see clause 1.3.

- 11.7 If paragraph 11.6(c) applies, the meat business demonstrates in the approved arrangement that achieving the alternative time and temperature controls for the chilling and the way in which this will be done will not adversely affect the microbiological safety of the carcasses and carcass parts.
- 11.8 Other than when a process is being applied to them, carcasses and carcass parts are maintained at:
- (a) the temperature specified for the carcass or carcass parts in paragraph 11.6(a); or
 - (b) the alternative temperature specified for the carcass and carcass parts in the approved arrangement.
- 11.9 If paragraph 11.8(b) applies, the meat business demonstrates in the approved arrangement that maintaining the carcasses and carcass parts at the alternative temperature and the way in which this will be done will not adversely affect the microbiological safety of the carcasses and carcass parts.

12 THAWING, TEMPERING, BONING AND OTHER PROCESSING OF RAW MEAT

OUTCOME

The thawing, tempering, boning and other processing of raw meat does not jeopardise its wholesomeness.

General

- 12.1 (1) Clause 12 applies to raw meat.
(2) In clause 12, processing means:
- (a) thawing and tempering; and
 - (b) boning, comminuting, slicing, stuffing, filling, massaging and tumbling; and
 - (c) producing meat mechanically using the controlled application of compressive force; and
 - (d) any other similar process (other than chilling, freezing or a further process).

Note For the meaning of *boning*, *comminuting*, *raw meat*, *tempering* and *thawing* see clause 1.3.

- 12.2 The processing of meat is done in a way that ensures its wholesomeness is maintained and is not jeopardised.
- 12.3 During the time the processing of the meat occurs the time and temperature requirements specified for its processing or packaging in the approved arrangement are complied with.
- 12.4 If the processing of meat removed from refrigeration is likely to result in a temperature of warmer than:
- (a) for a carcass, side, quarter or bone-in major separated cut, 7°C on any of its surfaces; and
 - (b) for any other meat, 5°C at the site of microbiological concern; then the processing takes place in a temperature controlled environment of no warmer than 10°C.
- 12.5 After the process is completed the meat:
- (a) undergoes a further process without delay; or
 - (b) is placed under refrigeration without delay and is rapidly chilled until it reaches a temperature of no warmer than:
 - (i) for a carcass, side, quarter or bone-in major separated cut, 7°C on any of its surfaces; and
 - (ii) for any other meat, 5°C on any of its surfaces; or
 - (c) achieves the alternative time and temperature controls for chilling the meat that are specified in the approved arrangement; and

- (d) if it is to be frozen, the refrigeration controls for freezing:
 - (i) ensure the meat is hard frozen without delay after compliance with requirements for chilling in paragraphs 12.5(b) and 12.5(c); and
 - (ii) achieve the controls that are specified in the approved arrangement.
- 12.6 If paragraph 12.5(c) applies, the meat business demonstrates in the approved arrangement that achieving the alternative time and temperature controls for the chilling and the way in which this will be done will not adversely affect the microbiological safety of the meat.
- 12.7 The chilling of the meat maintains and does not jeopardise its wholesomeness.

Additional requirements for air thawing and tempering

- 12.8 The thawing and tempering of meat is undertaken under refrigerated conditions.
- 12.9 If during air thawing of meat the presence of the packaging of the meat could cause contamination it is removed before the air thawing commences.
- 12.10 If meat is thawed by immersion in water:
 - (a) all packaging is removed from the meat before immersion; and
 - (b) during immersion thawing the water discharge rate on an hourly basis is greater than the volume of the meat in the vessel; and
 - (c) the water temperature is no warmer than 10°C.
- 12.11 The thawing of the meat:
 - (a) results in a temperature of no warmer than:
 - (i) for a carcass, side, quarter or bone-in major separated cut, 7°C on any of its surfaces; and
 - (ii) for any other meat, 5°C at the site of microbiological concern; or
 - (b) achieves the alternative time and temperature controls for thawing the meat that are specified in the approved arrangement.
- 12.12 If paragraph 12.11(b) applies, the meat business demonstrates in the approved arrangement that achieving the alternative time and temperature controls for the thawing and the way in which this will be done will not adversely affect the microbiological safety of the meat.

13 FURTHER PROCESSING

OUTCOME

The further processing of meat and meat products ensures and does not jeopardise their wholesomeness.

General

- 13.1 The further processing of meat and meat products ensures the wholesomeness of the meat and meat products by destroying pathogens or by preventing pathogenic growth or by reducing pathogenic growth to a level that does not jeopardise the wholesomeness of the meat or meat products.

Curing

- 13.2 The curing of meat and meat products takes place under controlled time and temperature conditions specified for the curing in the approved arrangement and which reduces pathogenic growth to a level that does not jeopardise wholesomeness of the meat or meat products.
- 13.3 The curing liquid is stored at 5°C or colder.
- 13.4 Saline, nitrite and nitrate levels are maintained at concentrations that minimise food safety hazards and preserve the wholesomeness of the meat and meat products.

Note For the meaning of *food safety* see clause 1.3.

Cooking

- 13.5 The heat treatment delivered to meat or meat products:
- (a) ensures the temperature at the site of microbiological concern is maintained at a temperature of 65°C for at least 10 minutes; or
 - (b) achieves the alternative time and temperature controls for cooking the meat and meat products that are specified in the approved arrangement.
- 13.6 If paragraph 13.5(b) applies, the meat business demonstrates in the approved arrangement that achieving the alternative time and temperature controls for the cooking and the way in which this will be done will reduce pathogenic growth to a level that does not jeopardise wholesomeness of the meat or meat products.
- 13.7 Cooked meat and meat products:
- (a) are cooled to reduce the temperature at the site of microbiological concern in a way which prevents pathogenic growth or reduces pathogenic growth to a level that does not jeopardise the wholesomeness of the meat or meat products; or
 - (b) are further processed; without delay after the heat treatment is applied.

Note For the temperature controls required for cooling cooked meat and meat products see further clauses 13.16 and 13.17.

- 13.8 Clauses 13.5 to 13.7 do not apply to the heat treatment of meat products that have been fermented.

Fermenting

- 13.9 The fermentation of the meat products and the heat treatment of fermented products comply with the requirements for fermenting and for heat treatment (as the case may be) in Division 3 of Standard 4.2.3 of the *Food Standards Code*.

Canned meat

- 13.10 The canning process (which may be enhanced by the addition of chemical agents such as nitrite) results in shelf-stable goods that are commercially sterile.
Note For the meaning of *canning*, *commercially sterile* and *shelf-stable* see clause 1.3.
- 13.11 The heat treatment is applied under pressure using a retort.
- 13.12 The cans are:
- (a) sealed and handled in a manner that prevents the introduction of micro-organisms that could affect the commercial sterility of the contents of the can; and
 - (b) cooled in a manner that prevents contamination of meat products or the growth of surviving micro-organisms.
- 13.13 The cans do not leave the meat premises at which they are canned until the procedures necessary to establish whether the products are shelf-stable and commercially sterile are completed.

Dried meat

- 13.14 The drying of meat, for the production of dried meat, achieves a water activity of no more than 0.85.
Note For the meaning of *dried meat* see clause 1.3.

Rendering

- 13.15 Rendering of meat and meat products for human consumption:
- (a) achieves the destruction of target contaminant micro-organisms in the rendered product; and
 - (b) ensures viable *Clostridium perfringens* spores are not present in the rendered product immediately on completion of rendering.

Temperature requirements for cooling meat products

- 13.16 After cooking, meat products that are cured:
- (a) are cooled so that the temperature of the meat products at the site of microbiological concern:
 - (i) is reduced from 52°C to 12°C within 7.5 hours; and
 - (ii) is reduced to 5°C within 24 hours of completion of cooking; or

- (b) are cooled in accordance with the time and temperature controls specified for their cooling in the approved arrangement.
- 13.17 After cooking, meat products that are uncured:
 - (a) are cooled so that the temperature of the meat products at the site of microbiological concern:
 - (i) is reduced from 52°C to 12°C within six hours; and
 - (ii) is reduced to 5°C within 24 hours of completion of cooking; or
 - (b) are cooled in accordance with the time and temperature controls specified for their cooling in the approved arrangement.
- 13.18 For the purposes of clauses 13.16 and 13.17 a product is cured if curing salts have been added at a level which preserves the product, being a minimum 2.5% salt on water phase and 100 ppm nitrite in-going.
- 13.19 Clauses 13.16 and 13.17 do not apply to the heat treatment of meat products that have been fermented.
- 13.20 After the further processing (other than cooking) of meat products is completed, non-shelf-stable meat products are cooled as soon as possible:
 - (a) to a temperature of no warmer than 5°C; or
 - (b) in accordance with the alternative time and temperature controls for cooling non-shelf-stable meat products that are specified in the approved arrangement.
- 13.21 If paragraph 13.16(b), 13.17(b) or 13.20(b) applies, the meat business demonstrates in the approved arrangement that achieving the time and temperature controls for the cooling specified in the approved arrangement and the way in which this will be done will not adversely affect the microbiological safety of the meat products.
- 13.22 If the cutting, shaving and any other similar process or packaging applied to non-shelf-stable meat products is likely to result in an increase in their surface temperature they:
 - (a) undergo a further process without delay; or
 - (b) are placed under refrigeration without delay and cooled in accordance with clause 13.20.
- 13.23 The cooling process achieves the reduction of temperature at the site of microbiological concern in a manner that prevents the growth of micro-organisms to a level that does not adversely affect the wholesomeness of the meat products.
- 13.24 The cooling of the meat and meat products maintains and does not jeopardise their wholesomeness.

PART 5 – PACKAGING, STORAGE AND HANDLING

14 PACKAGING

OUTCOME

During packaging the wholesomeness of meat and meat products is not jeopardised and all packaging and labelling comply with the requirements of the *Food Standards Code*

- 14.1 The packaging, inks, tags and labels used to package meat and meat products:
- (a) do not contaminate meat and meat products; and
 - (b) are free from substances that are capable of contaminating meat and meat products.
- 14.2 The packaging, tags and labels used are sufficiently strong and are fit for:
- (a) the purpose for which they are used; and
 - (b) the conditions under which the meat and meat products are to be stored, handled and transported; and
 - (c) meat and meat products of the kind for which they are used.
- 14.3 The manner in which meat and meat products are packaged and the material used for their packaging:
- (a) ensures their wholesomeness is not jeopardised during packaging; and
 - (b) effectively protects them from contamination and deterioration in the conditions under which they are to be stored, handled and transported.
- 14.4 The packaging of raw meat meets the time and temperature controls specified for processing raw meat in clauses 12.3 to 12.7.
- 14.5 Meat products are packaged in accordance with the time and temperature controls specified for their packaging in the approved arrangement.
- Note* For cooling non-shelf-stable meat products after packaging see clauses 13.20 to 13.24.

15 STORAGE AND HANDLING

OUTCOME

During storage and handling meat and meat products are not contaminated and their wholesomeness is not jeopardised.

General

- 15.1 Meat and meat products are stored and handled under conditions that prevent their contamination and ensure their wholesomeness is not jeopardised.
- 15.2 Other than when they are being processed or packaged, meat and meat products (other than shelf-stable meat products) are stored and handled:
- (a) at a temperature of no warmer than:
 - (i) for a carcass, side, quarter and bone-in major separated cut, 7°C on any of its surfaces; and
 - (ii) for any other meat or meat products, 5°C at the site of microbiological concern; or
 - (b) in accordance with the alternative time and temperature controls for storing and handling the meat or meat products that are specified in the approved arrangement.
- 15.3 Other than when they are being processed or packaged, shelf-stable meat products are stored and handled in accordance with the time and temperature controls specified for their storage and handling in the approved arrangement.
- 15.4 If paragraph 15.2(b) or clause 15.3 applies, the meat business demonstrates in the approved arrangement that achieving the alternative time and temperature controls for the storage and handling and the way in which this will be done will not adversely affect the microbiological safety of the meat or meat products.
- 15.5 Finished meat and meat products awaiting test results for release are identified and held separately from other meat and meat products.
- 15.6 Meat and meat products are not removed from a chiller for transport unless all their surfaces are visibly dry.
- 15.7 Meat and meat products (other than shelf-stable meat products) are not removed from a chiller for transport unless:
- (a) they are at a temperature no warmer than that specified in clause 15.2(a); or
 - (b) the alternative temperature controls for removing the meat or meat products that are specified in the approved arrangement are complied with.
- 15.8 Shelf-stable meat products are removed from a chiller for transport in accordance with the time and temperature controls specified for their removal in the approved arrangement.

- 15.9 If paragraph 15.7(b) or clause 15.8 applies, the meat business demonstrates in the approved arrangement that complying with the time and temperature controls for removing the meat or meat products specified in the approved arrangement and the way in which this will be done will not adversely affect the microbiological safety of the meat or meat products.
- 15.10 Meat and meat products are not loaded onto a meat transport vehicle unless the vehicle, the equipment to be used in the meat carrying compartment and the equipment to be used for the loading of the meat and meat products meet the matters specified for them in this Standard.

Product that is not wholesome

- 15.11 Meat businesses have a system in place for the evaluation of the wholesomeness of:
- (a) all meat and meat products received by the meat business; and
 - (b) all meat and meat products produced by the meat business.
- 15.12 Whether or not meat and meat products that are returned to a meat business are wholesome is established by the business at the time of their return.
- 15.13 Meat and meat products suspected of not being wholesome:
- (a) are condemned; or
 - (b) are separately identified and held separately under conditions of security until a meat safety inspector applies a disposition to them.

PART 6 – IDENTIFICATION, TRACEABILITY, INTEGRITY AND RECORD KEEPING

16 IDENTIFICATION, TRACEABILITY AND INTEGRITY

OUTCOME

Meat and meat products are accurately identified. Meat and meat products that should be recalled can be recalled.

General

- 16.1 Meat businesses have a documented system that provides for the accurate identification of, and the ability to trace and recall, meat and meat products produced by the business.

Slaughter and dressing

- 16.2 The following can be ascertained in relation to animals slaughtered by a meat business:
- (a) the date of slaughter; and
 - (b) the species of animals slaughtered.
- 16.3 The following can be ascertained in relation to animals slaughtered by a meat business:
- (a) for ovines, caprines and cervidae admitted by a meat business as part of a consignment of animals:
 - (i) a list of the places of production or the saleyards of the animals in the consignment; or
 - (ii) if the animals are captured in the wild, all the areas from which the animals in the consignment were captured; and
 - (b) for other animals:
 - (i) the place of production of each animal; or
 - (ii) if the animals are captured in the wild, the area from which each animal was captured.

Production of meat and meat products

- 16.4 Each of the following that apply to meat and meat products at meat premises can be ascertained:
- (a) the identity of the meat business from which they are received;
 - (b) the batch in which they are processed, the date of processing, the total size of the batch and the identity of the meat business that processed them and of the meat businesses from which all other meat and meat products in the batch are derived;
 - (c) their location at the premises;
 - (d) all other information that is necessary to identify whether or not they should be recalled;

- (e) the name and address of the person to whom the meat business consigns the meat and meat products and the date of consignment.

Note For the meaning of *batch* see clause 1.3.

- 16.5 The information specified in paragraph 16.4(e) need not be able to be ascertained if the consignee is the consumer of the meat or meat products.
- 16.6 The meat and meat products are identified either uniquely or in the batch in which they are processed or packaged.
- 16.7 Packaged meat and meat products are identified with the following information no later than at the time they are packed:
 - (a) the species of animal from which they are derived;
 - (b) the date of packaging;
 - (c) the identity of the meat business at which they are packaged.

Note For the meaning of *date of packaging* see clause 1.3.
- 16.8 There is a system of document keeping in place that ensures:
 - (a) trace-back to the individual production batch; and
 - (b) all raw ingredients used in each individual production batch of meat products can be ascertained.
- 16.9 If any meat or meat products produced by a meat business are required to be recalled, the documents kept by the business are comprehensive enough to identify all of the meat and meat products that should be recalled.
- 16.10 If:
 - (a) meat or meat products produced by a meat business; or
 - (b) raw material used or for use at an establishment; are suspected to present a public health and safety risk, the notification specified for the risk in the approved arrangement is given.

17 ANIMAL FOOD AND PHARMACEUTICAL MATERIAL

OUTCOME

Animal food is identified as animal food and segregated from other meat and meat products. Pharmaceutical material is identified as pharmaceutical material and segregated from other meat and meat products. Animal food and pharmaceutical material that should be recalled can be recalled.

Animal food

- 17.1 Animal food:
- (a) is identified as animal food and segregated from other meat and meat products; and
 - (b) is stored and handled in a separate room that is used exclusively for animal food until the animal food is packaged, sealed and labelled; and
 - (c) is stored and handled in a way that ensures meat and meat products for human consumption are not contaminated.
- 17.2 Immediately after the post-mortem disposition is applied to animal food that is to be heat treated, the animal food:
- (a) is placed in a container or is packaged and moved to the room referred to in paragraph 17.1(b); or
 - (b) is moved from the slaughter floor to the room under conditions of security.
- Note* For when animal food requires heat treatment see Schedule 3.
- 17.3 A container or package containing animal food that is to be heat treated:
- (a) has a continuous red band of at least 50 mm in width around the lesser circumference of the container or package; and
 - (b) is identified as containing animal food that is unfit for human consumption and requires sterilisation by heat treatment.
- 17.4 A container or package containing animal food at meat premises that is to be heat treated is stored and handled under conditions of security until it:
- (a) is heat sterilised at a place located at the premises and nominated in the approved arrangement as a place for heat sterilising animal food; or
 - (b) is despatched to a place nominated in the approved arrangement as a place for heat sterilising animal food in order to be rendered for animal food.
- 17.5 Animal food (other than blood) that is not to be heat treated is stained with a brilliant blue dye (being FCF CI 42090 diluted at one part dye to 500 parts of water) immediately after the post-mortem disposition is applied to the animal food and before primary chilling.
- Note* For when animal food need not be heat treated see Schedule 3.
- 17.6 The stain is easily detectable and in the case of comminuted animal food is visible throughout the food.

- 17.7 A package or container containing animal food referred to in clause 17.5:
- (a) has a continuous yellow band of at least 50 mm in width around the lesser circumference of the covering or packaging; and
 - (b) is conspicuously identified as containing meat that is animal food and is not for human consumption.
- 17.8 Immediately after collection, blood for animal food:
- (a) is placed in a container identified in accordance with clause 17.7; and
 - (b) is moved to and stored and handled in a room referred to in paragraph 17.1(b) under conditions of security.
- 17.9 The room referred to in paragraph 17.1(b) is identified as a room that is to be used exclusively for animal food.

Pharmaceutical material

- 17.10 Pharmaceutical material is separately identified and segregated from:
- (a) meat and meat products for human consumption, inedible material and animal food; and
 - (b) condemned material (unless the approved arrangement allows pharmaceutical material to be made using the condemned material).
- 17.11 Before pharmaceutical material leaves the area in which it is packed, it is identified with a conspicuous indication that the product is for use as pharmaceutical material only.

Identification, traceability and recall of animal food and pharmaceutical material

- 17.12 A meat business has a documented system that provides for the identification, traceability and recall of animal food and pharmaceutical material produced from animals slaughtered at the premises.
- 17.13 Packaged animal food and pharmaceutical material are identified with the following information no later than at the time they are packed:
- (a) the date of packaging;
 - (b) the identity of the meat business at which they are packed.
- 17.14 Each of the following that apply to the animal food and pharmaceutical material at meat premises can be ascertained:
- (a) the date of slaughter and species of the animals from which the animal food or pharmaceutical material is derived;
 - (b) the location of the animal food or pharmaceutical material at the premises;
 - (c) all other information that is necessary to identify whether or not the animal food or pharmaceutical material should be recalled;
 - (d) the name and address of the person to whom the meat business consigns the animal food or pharmaceutical material and the date of consignment.

18 RECORD KEEPING

OUTCOME

Documents are kept so as to ascertain whether:

- (a) meat and meat products are wholesome; and
- (b) the matters specified in this Standard are met.

- 18.1 The proprietor of a meat business keeps each document made or received by the business that is relevant to any of the following:
 - (a) the ante-mortem disposition applied to the animals slaughtered by the business;
or
 - (b) the wholesomeness of meat and meat products produced by the business (including any post-mortem disposition applied to the carcasses and carcase parts from which the meat and meat products are derived); or
 - (c) whether each of the applicable matters specified in this Standard are met by the business.
- 18.2 A document referred to in clause 18.1 is kept for a period of two years after it is made or received by the business.

PART 7 – PREMISES, EQUIPMENT AND ESSENTIAL SERVICES

19 PREMISES AND EQUIPMENT

OUTCOMES

Premises and equipment facilitate the production of meat and meat products that are wholesome and that do not jeopardise their wholesomeness. Premises and equipment minimise risk of injury, pain and suffering and cause the least practicable disturbance to animals.

General

- 19.1 Premises and equipment are provided that are necessary to ensure that each of the matters specified in this Standard that apply to the meat business are met.
- 19.2 The premises and equipment:
- (a) are not a source of contamination of animals, meat and meat products and do not jeopardise the wholesomeness of meat and meat products; and
 - (b) facilitate hygienic production; and
 - (c) can be effectively inspected and monitored.
- 19.3 The premises and equipment (other than equipment that is disposable and is not re-used) can be effectively cleaned and maintained.
- Note* The definition of premises includes any outdoor areas such as lairages; see clause 1.3.
- 19.4 The premises and equipment are constructed, located, cleaned, maintained and used in a way which minimises risk of injury, pain and suffering and causes the least practicable disturbance to animals.
- 19.5 The premises and equipment are fit for the purpose for which they are used.
- 19.6 The wholesomeness of meat and meat products is not jeopardised by external environmental conditions.
- 19.7 The entry of odours, smoke, dust and other environmental contamination into areas where meat and meat products are produced is effectively prevented.
- 19.8 The entry of animals not intended to be slaughtered and of pests into, and their harbourage in, meat premises and equipment is prevented.
- 19.9 The premises must have sufficient natural or mechanical ventilation to:
- (a) minimise airborne contamination; and
 - (b) remove excessive heat and steam and minimise condensation; and
 - (c) facilitate the control of temperatures; and
 - (d) facilitate the control of humidity where this is necessary to ensure the wholesomeness of meat and meat products.

- 19.10 The premises, equipment and services that are necessary to enable the effective supervision and inspection of animals and meat hygiene, including the carrying out of audits, are provided.
- 19.11 The premises and equipment have sufficient capacity to store, handle and process the maximum quantity of meat and meat products produced at the premises at any one time.

Construction of premises and equipment

- 19.12 The premises and the equipment are constructed in a way that is necessary to enable the matters specified in this Standard that apply to the meat business to be met.

Note For the meaning of *construction* see clause 1.3.

- 19.13 The surfaces of the interiors of buildings, including floors, and the surfaces of equipment:
 - (a) are durable; and
 - (b) are smooth, impervious and corrosion resistant; and
 - (c) are non-toxic, inert to the food and to detergents and sanitising agents under normal operating conditions; and
 - (d) do not transmit odour or taste; and
 - (e) are capable of withstanding repeated cleaning and sanitising; and
 - (f) allow visible contamination to be easily seen.
- 19.14 Internal floors and paved areas have an impervious surface and are effectively drained.
- 19.15 Raceways and holding pens:
 - (a) if used for small stock, are paved or have mesh or slatted floors; and
 - (b) in any other case, are paved.
- 19.16 Dead stock handling areas and areas where animals are inspected or cleaned are paved and can be effectively cleaned.
- 19.17 Pens for holding animals affected by or suspected of being affected by a disease or other abnormality:
 - (a) are constructed so as to minimise the risk of spread of contamination from the pens to other areas; and
 - (b) are drained.
- 19.18 Load-out and load-in areas:
 - (a) are constructed in a way that prevents contamination of meat and meat products during loading and unloading; and
 - (b) if used for chillers and freezers, are paved.
- 19.19 Floors in the areas used for cleaning meat transport vehicles are drained.

20 HYGIENE AND SANITATION FACILITIES

OUTCOME

The provision of hygiene and sanitation facilities that enable the hygienic production of meat and meat products.

Hygiene and sanitation facilities

- 20.1 Facilities that enable the effective cleaning and sanitising of premises and equipment and protective clothing are provided at meat premises.
Note For the meaning of *protective clothing* see clause 1.3.
- 20.2 Meat premises at which animals are slaughtered for meat for human consumption are provided with facilities that enable the cleaning of animals before slaughter.
- 20.3 The location of sanitation facilities does not jeopardise the hygienic processing of meat and meat products.
- 20.4 Areas where implements are used on slaughter animals or on unpackaged meat or meat products have facilities for cleaning and sanitising the implements.
- 20.5 The facilities for cleaning and sanitising implements:
- (a) are used only for the purpose of cleaning and sanitising the implements; and
 - (b) are conveniently located for the use of personnel during operations; and
 - (c) are provided with an adequate supply of hot potable water at no less than 82°C or an equivalent method of sanitising; and
 - (d) overflow directly to the drainage system.
- 20.6 Hand wash facilities are accessible and conveniently located.
Note For hand washing requirements see Schedule 1.
- 20.7 The hand wash facilities are provided with:
- (a) warm water between 35°C and 46°C from a central outlet; and
 - (b) taps of a non-hand operable type; and
 - (c) a suitable hand cleaning agent; and
 - (d) suitable hand drying facilities (other than on the slaughter floor).
- 20.8 If meat transport vehicles are cleaned at a meat business the cleaning takes place in areas that are separate from areas where meat or meat products are produced.

Amenities

- 20.9 Suitable and conveniently located toilets, hand wash and changing facilities and a separate area for eating meals that are adequate for the number of persons at the meat premises are provided.

- 20.10 The hand wash facilities:
 - (a) meet the matters specified in clause 20.7; and
 - (b) have a suitable hygienic means of drying hands; and
 - (c) are for the exclusive use of washing hands, arms and faces.
- 20.11 The location of the amenities does not jeopardise the hygienic production of meat and meat products.
- 20.12 Toilets do not open directly onto areas where meat or meat products are produced.
- 20.13 Other amenities are physically separate from areas where meat or meat products are produced.
- 20.14 Access between the amenities and areas where meat and meat products are produced is achieved without:
 - (a) persons in areas used for edible material passing through areas used for inedible or condemned material; and
 - (b) persons in areas used for condemned or inedible material passing through areas used for edible material.
- 20.15 Paved walkways are provided between the workplace and the amenities.

21 ESSENTIAL SERVICES

OUTCOME

The essential services provided:

- (a) enable operations to be carried out effectively; and
- (b) maintain and do not jeopardise the wholesomeness of meat and meat products.

General

- 21.1 Essential services are provided to enable:
- (a) the operations to produce meat and meat products to be carried out effectively by the meat business; and
 - (b) the matters specified in this Standard that apply to the operations to be met by the meat business; and
 - (c) the effective supervision at the premises of meat hygiene (including inspection and audit).
- 21.2 A system of operational hygiene process controls is followed that ensures the essential services maintain and do not jeopardise the wholesomeness of meat and meat products.

Energy

- 21.3 There is a reliable energy supply that is sufficient and appropriate to the operations undertaken.

Water

- 21.4 There is an effective program in place for the supply of water that is sufficient and appropriate to the operations undertaken.
- 21.5 There is a continuous supply of hot and cold potable water at a volume and pressure that enables hygienic practices for the production of meat and meat products to be met.
- 21.6 Only potable water is used for the production of meat and meat products unless:
- (a) the water is only used:
 - (i) for steam production (other than steam used or to be used in direct or indirect contact with meat and meat products), fire control, the cleaning of yards, the washing of animals (other than the final wash) and other similar purposes not connected with meat and meat products; or
 - (ii) in other circumstances where there is no risk of the water coming into contact with or contaminating meat and meat products; and
 - (b) the approved arrangement expressly provides for the use of the non-potable water in the circumstances in which it is used.

- 21.7 The potable water supply (including storage tanks) is protected from contamination.
- 21.8 Potable water is supplied in lines that:
 - (a) are used only for potable water; and
 - (b) are physically separate from the supply of non-potable water; and
 - (c) are identified for use for potable water if any non-potable water is used at the business.
- 21.9 Non-potable water is supplied in lines that:
 - (a) are used only for non potable water; and
 - (b) are identified for use for non-potable water.
- 21.10 The reticulation system prevents the back siphonage of used or contaminated water.
- 21.11 Ice is made from potable water and is protected from contamination during its making, storage and handling.
- 21.12 Steam used or to be used in direct or indirect contact with meat and meat products is produced from potable water and does not contain substances that may create a food safety hazard or jeopardise the wholesomeness of meat and meat products.
- 21.13 Only potable running water that is not recycled is used for immersion thawing or cooling.

Waste disposal system and drainage

- 21.14 The meat business has an effective waste disposal program for the storage, handling and removal of waste that does not jeopardise the wholesomeness of meat and meat products.

Note For the meaning of *waste* see clause 1.3.
- 21.15 The waste disposal system provided:
 - (a) is sufficient to handle, and where necessary treat, all waste produced at the premises; and
 - (b) ensures waste can be disposed of with no risk of contamination of meat and meat products or the potable water supply at the premises; and
 - (c) is not a source of contamination; and
 - (d) does not permit pests or material capable of causing contamination to enter via the drainage system; and
 - (e) ensures discharge is contained and directed to the drainage system.
- 21.16 Catch basins, traps save-alls and sumps are separate from any area in which meat and meat products are produced.
- 21.17 Untreated waste from toilets is treated separately from other waste at the plant and does not discharge into the plant's waste system.

Lighting

- 21.18 Meat premises have a lighting system that provides sufficient natural or artificial lighting for the activities conducted at the premises.
- 21.19 The lighting does not result in distortions, including colour.
- 21.20 The lighting system is not a source of contamination and light bulbs and fixtures suspended over meat are protected so as to prevent contamination of meat and meat products.

PART 8 – TRANSPORTATION OF MEAT AND MEAT PRODUCTS

22 MANAGEMENT OF WHOLESOMENESS

OUTCOME

Management and handling practices ensure the wholesomeness of meat and meat products is maintained during transport.

Approved arrangement for the transport of meat and meat products

- 22.1 The proprietor of a meat transport business has an approved arrangement that:
- (a) covers the transport of all meat and meat products for human consumption undertaken by the business; and
 - (b) specifies how each of the matters specified in this Standard that apply in relation to the transport will be met by the business.
- 22.2 The provisions of the approved arrangement relating to each of the matters set out in paragraph 22.1(a) and (b) are complied with.

Management and handling practices for transport

- 22.3 The management and handling practices of a meat transport business ensure the matters specified in clauses 3.5 to 3.9 are met in relation to the transport of meat and meat products by the business.
- 22.4 The policy objectives of the meat transport business for maintaining the wholesomeness of meat and meat products during transport and the commitment of the proprietor of the business to these objectives are clearly stated.

23 OPERATIONAL HYGIENE

OUTCOME

Operational hygiene process controls result in the transportation of meat and meat products that are wholesome.

General

- 23.1 The proprietor of a meat transport business follows a system of operational hygiene process controls for the transportation of meat and meat products that is effective in ensuring the wholesomeness of the meat and meat products.
- 23.2 The meat carrying compartment of a meat transport vehicle, the equipment to be used in the meat carrying compartment and the equipment to be used for the loading of meat and meat products:
- (a) are not a source of contamination of meat and meat products; and
 - (b) are clean before operations commence each day and are cleaned at the end of operations each day; or
 - (c) if the compartment and equipment are being used to transport a consignment of meat for a period greater than a day, are clean before the meat and meat products are loaded onto the vehicle and are cleaned as soon as practicable after the vehicle has been unloaded.
- 23.3 Water used to clean the meat carrying compartment is potable.
- 23.4 Meat transport vehicles are maintained in a good state of repair and working order having regard to their use.
- 23.5 The accumulation of material likely to cause contamination of meat and meat products during transportation is prevented.

Hazardous materials

- 23.6 Hazardous materials and other chemicals used or to be used by a meat transport business are fit for use in operations for the transportation of meat and meat products.
- 23.7 Each of the matters specified in paragraphs 4.8(a) to (e) and clause 4.10 are met.

Pests and animals

- 23.8 An effective and continuous program to prevent the entry of pests into, and their harbourage in, meat transport vehicles is followed.

Personal hygiene

- 23.9 Persons transporting meat and meat products exercise personal hygiene practices that do not jeopardise the wholesomeness of the meat and meat products.
- 23.10 Each of the applicable matters specified in Schedule 1 are met.

24 WHOLESOMENESS AND IDENTIFICATION DURING TRANSPORT

OUTCOME

During transport:

- (a) the wholesomeness of meat and meat products is maintained and not jeopardised; and
- (b) the identification of meat and meat products is retained.

- 24.1 Meat and meat products are transported under conditions that maintain their wholesomeness and ensure that during transport their wholesomeness is not jeopardised.
- 24.2 During the transport of meat and meat products:
 - (a) exposed meat and meat products do not come into contact with any surfaces that may cause contamination; and
 - (b) unwrapped carcase and carcase parts (other than hanging carcase and carcase parts) are carried in closed containers and do not contaminate other meat and meat products; and
 - (c) there is adequate airflow; and
 - (d) the introduction into the cans of canned meat products of micro-organisms that could affect the commercial sterility of the contents of the cans is prevented; and
 - (e) the means of identifying the meat or meat products is not lost.
- 24.3 Meat and meat products (other than shelf-stable meat products) are transported:
 - (a) at a temperature of no warmer than:
 - (i) for a carcase, side, quarter and bone-in major separated cut, 7°C; and
 - (ii) for any other meat or meat products, 5°C at the site of microbiological concern; or
 - (b) in accordance with the alternative time and temperature controls for their transport that are specified in the approved arrangement of the meat business that stores and handles them.
- 24.4 Shelf-stable meat products are transported in accordance with the time and temperature controls specified for their transport in the approved arrangement of the meat business that stores and handles them.
- 24.5 If paragraph 24.3(b) or clause 24.4 applies, the meat transport business demonstrates in the approved arrangement that achieving the time and temperature controls for the transportation specified in the approved arrangement and the way in which this will be done will not adversely affect the microbiological safety of the meat and meat products.
- 24.6 The transport of meat and meat products for human consumption in the same meat transport vehicle as other things does not jeopardise the wholesomeness of the meat or meat products.

- 24.7 Animals, inedible material and condemned material are not transported in a meat transport vehicle.
- 24.8 During transport:
- (a) ready-to-eat meat products are not contaminated by meat and meat products that are not ready-to-eat; and
 - (b) cooked meat is not contaminated by raw meat.
- 24.9 Meat and meat products are not loaded onto a meat transport vehicle unless the vehicle, the equipment to be used in the meat carrying compartment and the equipment to be used for the loading meet the applicable matters specified in this Standard.
- 24.10 If the proprietor of a meat transport business becomes aware that meat or meat products transported by the business are exposed to conditions that may have jeopardised the wholesomeness of the meat and meat products, the proprietor notifies without delay the proprietor of the meat business that receives the meat or meat products.

25 MEAT TRANSPORT VEHICLES AND EQUIPMENT

OUTCOME

Meat transport vehicles and equipment facilitate and do not jeopardise the wholesomeness of meat and meat products.

General

- 25.1 The meat transport vehicles and equipment that are necessary to enable the applicable matters specified in this Standard to be met are provided.
- 25.2 The meat transport vehicles and equipment:
- (a) are not themselves a source of contamination of animals, meat and meat products and do not jeopardise the wholesomeness of meat and meat products; and
 - (b) are fit for the purpose for which they are used; and
 - (c) facilitate hygienic transportation and can be effectively inspected and monitored.
- 25.3 The meat transport vehicles and equipment (other than equipment that is disposable and is not re-used) can be effectively cleaned and maintained.
- 25.4 The entry into meat transport vehicles of odours, smoke, dust and other environmental contamination is effectively prevented during transportation.
- 25.5 Meat transport vehicles are able to transport under controlled conditions the maximum quantity of meat and meat products to be transported at any one time.
- 25.6 The construction of vehicles and equipment used to transport meat and meat products for human consumption enables the matters specified in clauses 22 to 25 of this Standard that apply in relation to the transportation to be met.
- 25.7 The meat carrying compartment of a meat transport vehicle is separate from the rest of the vehicle.
- 25.8 The surfaces of the meat carrying compartment of meat transport vehicles and equipment used to transport meat and meat products:
- (a) are durable; and
 - (b) are smooth, impervious and corrosion resistant; and
 - (c) are non-toxic, inert to the food and to detergents and sanitising agents under normal operating conditions; and
 - (d) do not transmit odour or taste; and
 - (e) are capable of withstanding repeated cleaning and sanitising; and
 - (f) allow visible contamination to be easily seen.
- 25.9 The meat carrying compartments of meat transport vehicles are adequately insulated and supplied with operating refrigeration equipment.
- 25.10 The cooling unit discharge is contained and directed to the outside of the vehicle.

SCHEDULE 1 – PERSONAL HYGIENE

General

1. The proprietor of a meat business and a meat transport business informs all meat handlers employed by the business of the proprietor's obligation to ensure each of the matters specified in this Schedule are met.

Note For the meaning of *meat handler* see clause 1.3.

Hygiene obligations

2. Meat handlers and persons in areas of a meat business where meat and meat products are produced:
 - (a) maintain a high degree of personal cleanliness and take all practicable measures to ensure their body, anything from their body and anything they are wearing (including cosmetics) does not contaminate meat or meat products; and
 - (b) do not wear jewellery where it could contaminate meat or meat products; and
 - (c) if in areas where exposed meat and meat products are produced, wear washable (or disposable), protective clothing including enclosed footwear, a head covering enclosing their hair and a covering enclosing any beard or moustache; and
 - (d) ensure their outer clothing is of a level of cleanliness that is appropriate for the handling of meat and meat products that is being conducted; and
 - (e) take all practicable measures to prevent unnecessary contact with ready-to-eat meat and meat products; and
 - (f) ensure that open cuts, wounds and sores are completely protected by a detectable bandage or dressing and that bandages and dressings used on exposed parts of the person's body are completely covered with a detectable waterproofed covering.
3. Meat handlers and persons in areas of a meat business where meat and meat products are produced:
 - (a) do not eat or drink in areas where meat and meat products are produced; and
 - (b) do not sneeze, blow or cough over exposed meat or meat products or surfaces likely to come into contact with meat or meat products; and
 - (c) do not spit, smoke or use tobacco or similar preparations in areas in which meat or meat products are produced; and
 - (d) do not urinate or defecate except in a toilet.
4. Meat handlers and persons at meat premises wash their hands:
 - (a) whenever their hands are likely to be a source of contamination of meat or meat products; and
 - (b) immediately before handling ready-to-eat meat or meat products after handling raw meat; and
 - (c) immediately after using the toilet.

5. Persons when engaging in any activity involving the handling of exposed meat and meat products or surfaces likely to come into contact with meat or meat products wash their hands:
 - (a) before commencing or recommencing the handling of meat or meat products; and
 - (b) immediately after smoking, coughing, sneezing, using a handkerchief or tissue, eating, drinking, using tobacco or similar substances and after touching their hair, scalp or a body opening.

Note For obligations that apply to persons entering areas used for edible material or cooked meat and meat products see clauses 5.11 and 5.28.
6. The wearing of gloves does not exempt a person from complying with requirements for hand washing.

Clothing, work implements and personal effects

7. Meat handlers clean and sanitise their protective clothing and work implements (other than clothing and implements that are disposed of and not re-used):
 - (a) at the commencement of operations and at the end of each shift; and
 - (b) whenever the clothing or implements come into contact with diseased or suspect material or become contaminated; and
 - (c) whenever else it is necessary to prevent contamination of meat and meat products.

Note For the meaning of *work implements* see clause 1.3.
8. Protective clothing and implements are cleaned in designated areas and in a way that ensures they do not contaminate the meat or meat products.
9. Meat handlers:
 - (a) change their protective clothing if it becomes excessively soiled; and
 - (b) maintain their protective clothing and work implements in good repair and working order having regard to their use or replace them.
10. Meat handlers wear protective clothing and use work implements that are fit for the purpose for which they are worn or used.
11. Meat handlers wear outer clothing (including protective clothing):
 - (a) the material and design of which is not likely to cause contamination; and
 - (b) the colour of which allows detection of visible contamination; and
 - (c) that is suitable for the work being undertaken.
12. Meat handlers store personal effects, clothing (including protective clothing) and work implements when not in use to ensure they do not contaminate meat and meat products.
13. Meat handlers do not take protective clothing and work implements into the amenities.

Health obligations

14. A meat handler who is given a request in writing or electronically by the proprietor of a meat business or a meat transport business to have a medical examination does not work for the meat business or meat transport business in any capacity where the person could contaminate meat or meat products with pathogenic micro-organisms until the person complies with the request.
15. A person employed by a meat business or a meat transport business who:
 - (a) is known or suspected to be suffering from, or is a carrier of, a food-borne disease; or
 - (b) is known or suspected to have a symptom that may indicate he or she is suffering from, or is a carrier of, a food-borne disease; or
 - (c) is afflicted with infected wounds or sores; does not work for the meat business or meat transport business in any capacity where the person could contaminate meat or meat products with pathogenic micro-organisms.

Note For the meaning of *food-borne disease* see clause 1.3.
16. A person who knows or suspects that he or she is a person to whom clause 15 applies immediately notifies the person in charge of operations at the business.

SCHEDULE 2 – PROCEDURES FOR POST-MORTEM INSPECTION

In this Schedule:

- *buffalo* means any bubaline greater than 50 kg dressed weight; and
- *calf* means a young bovine or bubaline no greater than 50 kg dressed weight; and
- *cattle* means any bovine greater than 50 kg dressed weight; and
- *incise* means to examine by observation and multiple slicing; and
- *palpate* means to examine by observation and palpation.

Table 1. Procedure for post-mortem inspection of carcasses

	Cattle and buffalo	Calves	Sheep and goats	Lambs	Pigs	Horses	Deer
All carcasses	Observe internal and external surfaces of carcase (including tail, musculature, exposed bone, joints, serous membranes).						
Lymph nodes							
Superficial inguinal	See Note #1	Observe	See Note #2	Observe	See Note #3	Incise	Observe
Internal iliac	See Note #1	Observe	Palpate	Observe	Observe	Observe	Observe
Lumbar	—	—	Palpate	Observe	Observe	—	—
Ischiatic	—	—	Palpate	Observe	—	—	—
Precurral	—	—	See Note #2	Observe	—	Palpate	—
Superficial cervical	—	—	See Note #2	Observe	—	Palpate	—
Popliteal	—	—	Palpate	Observe	—	—	—
Prepectoral	—	—	—	—	—	Incise	—

Equivalent procedures

Note #1 **Cattle and buffalo** – Palpate the superficial inguinal and internal iliac lymph nodes or, for animals in an area in relation to which the relevant Commonwealth, state or territory controlling authority requires minimal risk inspection for tuberculosis (other than animals subject to conditional slaughter or emergency slaughter), an equivalent procedure is to observe the nodes (other than in bulls and mature females).

Note #2 **Sheep and goats** – Palpate the superficial cervical, precrural and superficial inguinal lymph nodes or, other than animals subject to conditional slaughter or emergency slaughter, an equivalent procedure is to excise and discard these nodes without inspection.

Note #3 **Pigs** – Observe the superficial inguinal lymph nodes or, other than animals subject to conditional slaughter or emergency slaughter, an equivalent procedure is to excise and discard these nodes without inspection.

Table 2. Procedure for post-mortem inspection of viscera

	Cattle and buffalo	Calves	Sheep and goats	Lambs	Pigs	Horses	Deer
Lymph nodes							
Bronchial and mediastinal	See Note #1	Palpate	Palpate	Observe	Palpate	Incise	Palpate
Portal	Palpate	Palpate	Observe	Observe	Palpate	Palpate	Observe
Mesenteric	Observe	Observe	Observe	Observe	Observe	Observe	Observe
Lungs	Palpate, except in lambs where observe. Additionally, bronchi opened and internal surfaces observed when saved for human consumption.						
Heart	Palpate. Incise internal musculature three to four times in cattle and buffalo.						
Liver	Palpate, except in lambs where observe. Incise main bile ducts transversely and observe contents, except in pigs where inspection of bile ducts not required (see Note #2 for option).						
Gastrointestinal tract	Observe, though observation of oesophagus not required in cattle, buffalo, calves or deer unless recovered for human consumption.						
Spleen	Observe	Observe	Palpate	Observe	Observe	Palpate	Observe
Kidney (enucleated)	Palpate	Palpate	Observe	Observe	Palpate	Palpate	Palpate
Other tissues and organs	Thymus, pancreas, non-gravid uterus, bladder, testicles and penis observed when recovered for human consumption.						

Equivalent procedures

Note #1 **Cattle and buffalo** – Incise bronchial and mediastinal lymph nodes or, for animals in an area in relation to which the relevant Commonwealth, state or territory controlling authority requires minimal risk inspection for tuberculosis (other than animals subject to conditional slaughter or emergency slaughter), an equivalent procedure is to observe the nodes.

Note #2 **All animals** – Procedures for the incision of main bile ducts and observation of contents may not be required at a meat business by the controlling authority.

Table 3. Procedure for post-mortem inspection of heads

	Cattle and buffalo (Note #3)	Calves (Note #1)	Sheep and goats (Note #1)	Lambs (Note #1)	Pigs (Note #1)	Horses (Note #1)	Deer (Note #1)
All carcasses	Observe external surfaces. For cattle, buffalo and horses observe the oral, buccal and nasal cavities.						
Lymph nodes							
Submaxillary	See Note #2	—	—	—	See Note #4	Incise	—
Parotid	See Note #2	—	—	—	—	Incise	—
Retro-pharyngeal	See Note #2	—	—	—	—	Incise	—
Cervical	—	—	—	—	See Note #4	—	—
Masticatory muscles (internal and external)	Incise	—	—	—	—	—	—
Tongue	Palpate	—	—	—	—	Palpate	—
Gutteral pouch	—	—	—	—	—	Palpate	—
Other tissues	Tongue roots in cattle, buffalo and horses observed when recovered for human consumption.						

Equivalent procedures

Note #1 **All animals** – Other than cattle, buffalo, horses and animals subject to conditional slaughter or emergency slaughter, an equivalent procedure is to remove and discard the head without inspection where tissues, including tongue, are not recovered for human consumption.

Note #2 **Cattle and buffalo** – Incise submaxillary, parotid and retropharyngeal lymph nodes or, for animals in an area in relation to which the relevant Commonwealth, state or territory controlling authority requires minimal risk inspection for tuberculosis (other than animals subject to conditional slaughter or emergency slaughter), equivalent procedures are:

- a) observe only, or
- b) excise and discard these nodes without inspection.

Note #3 **Cattle and buffalo** – Other than animals subject to conditional slaughter or emergency slaughter, for animals in an area in relation to which the relevant Commonwealth, state or territory controlling authority requires minimal risk inspection for tuberculosis, an equivalent procedure is to discard the head without inspection when tissues, including tongue, are not recovered for human consumption.

Note #4 **Pigs** – Incise and observe submaxillary and cervical lymph nodes or, other than animals subject to conditional slaughter or emergency slaughter, equivalent procedures are:

- a) observe only, or
- b) excise and discard these nodes without inspection.

Table 4. Additional post-mortem inspection procedures when specific diseases are detected or suspected

Disease	Inspection procedure
Tuberculosis in cattle and buffalo	Incise atlantal, prescapular, prepectoral, suprasternal, superficial inguinal, iliacs, ischiatic, precrural, portal and mesenteric lymph nodes. Incise popliteal lymph node where necessary to determine the extent of infection. All viscera, serous membranes, spinal cord and severed vertebral column inspected by observation, palpation and, where necessary, incision. Udders incised and observed.
Tuberculosis in pigs	Incise retropharyngeal, parotid, bronchial, mediastinal, portal, gastric, mesenteric, superficial inguinal, lumbar, precrural, prescapular and deep inguinal lymph nodes. Viscera and serous membranes inspected as above for cattle.
Tuberculosis in horses	As for cattle and buffalo.
Tuberculosis in deer	Incise submaxillary, retropharyngeal, parotid, bronchial, mediastinal, mesenteric, portal, superficial inguinal, iliac, ischiatic and suprasternal lymph nodes. Incise popliteal lymph node where necessary to determine the extent of infection. Viscera and serous membranes inspected as above for cattle.
<i>Cysticercus bovis</i> in cattle, buffalo and deer	Incise masseter and heart muscles, tongue and diaphragm after removal of serous membranes and observe all exposed muscle surfaces.
<i>Cysticercus cellulosae</i> in pigs	As above for <i>C. bovis</i> .
Sparganosis in pigs	Observe retro-peritoneal tissues after removal of the peritoneum. Where further evidence of infestation revealed, also observe main muscle seams of the hind limbs. Incise as necessary to determine extent of infection.

SCHEDULE 3 – ANTE-MORTEM AND POST-MORTEM DISPOSITIONS

Column 1	Column 2
Diseases and other abnormalities	Dispositions for animals, carcasses and carcase parts. The symbol [1] means carcase or carcase parts unfit for human consumption may be recovered for animal food subject to heat sterilisation. The symbol [2] means carcase or carcase parts unfit for human consumption may be saved either for animal food subject to heat sterilisation or for animal food subject to staining.
1 General findings	
Abnormal odour caused by metabolic conditions, feedstuff, chemicals or sexual odour <ul style="list-style-type: none"> • Pronounced odour • Slight odour 	Carcase and all its carcase parts condemned [1]. Retain for further disposition after chilling.
Advanced chronic conditions with generalised signs such as cachexia or loathsome appearance	Animal condemned.
Dead animal	Animal condemned. If anthrax suspected see 2.1.
Dying animal or animal in moribund state with subnormal temperature, weak pulse and disturbed senses	Animal condemned.
Excitement, exhaustion without signs of acute disease	Animal withheld from slaughter and ante-mortem repeated after adequate rest.
Fever, debility and general signs indicating acute disease	Animal condemned. Alternatively, withhold the animal from slaughter until it has recovered and provided there is no risk of spread of disease, no undue suffering and recovery is considered likely with treatment. When detected at post-mortem, carcase and all its carcase parts condemned.
Foetuses and undeveloped neonatal animals	Carcase and all its carcase parts condemned.
Generalised disease conditions such as emaciation, anaemia, oedema or degeneration of organs	Carcase and all its carcase parts condemned.
Injury or accidental trauma during transport to or while in vicinity of the abattoir	Animal subject to emergency slaughter or condemned.
Septicaemia, pyaemia or toxaemia	Carcase and all its carcase parts condemned.

2 Aetiological listing	
2.1 Bacterial and related diseases	
<p>Actinomycosis and actinobacillosis:</p> <ul style="list-style-type: none"> • Localised in head • Evidence of generalisation such as lesions in lungs or other viscera, or other signs such as extreme loss of condition 	<p>Head and tongue condemned.</p> <p>Carcase and all its carcase parts condemned.</p>
<p>Anaplasmosis and babesiosis:</p> <ul style="list-style-type: none"> • Acute with intense jaundice and other signs of systemic involvement including fever, liver enlargement and kidney congestion • Sub-acute with mild jaundice that dissipates within 24 hours of slaughter 	<p>Carcase and all its carcase parts condemned.</p> <p>Carcase parts condemned.</p>
<p>Anthrax</p>	<p>Affected animals should not be admitted to an abattoir. When detected at ante-mortem, affected animal condemned. Companion animals isolated and withheld from slaughter. When detected at post-mortem, affected carcase and all its parts condemned.</p>
<p>Blackleg</p>	<p>Carcase and all its carcase parts condemned.</p>
<p>Botryomycosis:</p> <ul style="list-style-type: none"> • Severe cases with evidence of systemic effects such as cachexia • Less severe cases 	<p>Carcase and all its carcase parts condemned.</p> <p>Affected carcase parts condemned.</p>
<p>Botulism</p>	<p>Carcase and all its carcase parts condemned.</p>
<p>Caseous lymphadenitis:</p> <ul style="list-style-type: none"> • Generalised involvement in carcase and viscera with evidence of systemic effects such as cachexia • Less extensive forms of the disease 	<p>Carcase and all its carcase parts condemned.</p> <p>Affected organs or carcase parts condemned.</p>
<p>Corynebacterial infections in submaxillary and cervical lymph nodes in pigs</p>	<p>Affected nodes condemned.</p>
<p>Enterotoxaemia</p>	<p>Carcase and all its carcase parts condemned.</p>
<p>Eperythrozoonosis:</p> <ul style="list-style-type: none"> • Acute with intense jaundice and other signs of systemic involvement including fever, liver enlargement and kidney congestion • Sub-acute with mild jaundice that dissipates within 24 hours of slaughter 	<p>Carcase and all its carcase parts condemned.</p> <p>Carcase parts condemned.</p>
<p>Foot rot:</p> <ul style="list-style-type: none"> • Acute with secondary infection of organs or extreme loss of condition • Chronic with encapsulated abscess in liver or lungs 	<p>Carcase and all its carcase parts condemned.</p> <p>Affected organs condemned.</p>

Infectious ovine epididymitis (<i>B. ovis</i>)	Affected testicles condemned.
Johne's disease	Intestines and mesentery condemned.
Leptospirosis: <ul style="list-style-type: none"> • Acute • Chronic, localised 	Carcase and all its carcase parts condemned. Affected kidneys condemned.
Listeriosis	Carcase and all its carcase parts condemned.
Malignant oedema	Carcase and all its carcase parts condemned.
Melioidosis	Carcase and all its carcase parts condemned.
Necrobacillosis: <ul style="list-style-type: none"> • Acute with lesions in a number of sites or evidence of systemic involvement • Localised lesion in liver or other organ 	Carcase and all its carcase parts condemned. Affected liver or organ condemned.
Purpura haemorrhagica	Affected carcase parts condemned.
Salmonellosis	Carcase and all its carcase parts condemned.
Strangles	Affected carcase parts condemned.
Swine erysipelas: <ul style="list-style-type: none"> • Acute • Localised arthritis or endocarditis without signs of systemic effects • Cutaneous lesions 	Carcase and all its carcase parts condemned. Affected joint and associated lymph node condemned; when affected, heart condemned. Affected areas of skin condemned.
Tuberculosis:	
In <i>cattle</i> and <i>buffalo</i> <ul style="list-style-type: none"> • Generalised with evidence of systemic involvement; more than one organ affected; miliary lesions in any organ; evidence of active infection or extensive infection of peritoneum or pleura. • Localised infection 	Carcase and all its carcase parts condemned. Affected carcase part, including drained part, condemned; or affected organ condemned.
In <i>pigs</i> <ul style="list-style-type: none"> • Generalised • Localised in submaxillary or mesenteric lymph nodes (avian type) 	Carcase and all its carcase parts condemned. Affected carcase part condemned.
In <i>horses</i> and <i>deer</i>	Carcase and all its carcase parts condemned.
White scours, omphalophlebitis, polyarthritis and other septicaemic conditions of newborn animals	Carcase and all its carcase parts condemned.

2.2 Parasitic conditions	
<p><i>Cysticercus bovis</i>:</p> <ul style="list-style-type: none"> • General infestation • Light infestation, small number of degenerated cysticerci 	<p>Carcase and all its carcass parts condemned.</p> <p>Affected viscera condemned. Cysts and surrounding tissue trimmed from carcass and condemned. Remainder of carcass and parts passed conditionally fit for human consumption subject to treatment by freezing (no warmer than -12°C deep muscle temperature for not less than 10 days in carcasses and 20 days in boned meat).</p>
<p><i>Cysticercus cellulosae</i>:</p> <ul style="list-style-type: none"> • General infestation • Light infestation, small number of degenerated cysticerci 	<p>Carcass and all its carcass parts condemned.</p> <p>Affected viscera condemned. Cysts and surrounding tissue trimmed from carcass and condemned. Remainder of carcass and parts passed conditionally fit for human consumption subject to treatment by freezing (no warmer than -12°C deep muscle temperature for not less than five days in carcasses or boned meat).</p>
<p><i>Cysticercus ovis</i>:</p> <ul style="list-style-type: none"> • General infestation (more than five cysts found in musculature) • Light infestation, small number of degenerated cysticerci 	<p>Carcass and all its carcass parts condemned.</p> <p>Affected viscera condemned. Cysts and surrounding tissue trimmed from carcass and condemned.</p>
<i>Cysticercus tenuicollis</i>	Cysts and affected serous membranes trimmed from carcass or carcass part and condemned.
Echinococcosis	Affected organs condemned.
Myiasis	Animal condemned in severe cases with sepsis or necrosis. Otherwise withhold from slaughter for treatment and resubmit for ante-mortem after recovery.
<i>Oestrus ovis</i> infestation in sheep	Infestation removed or affected parts condemned.
Onchocerciasis	Lesions and affected tissues trimmed from carcass and condemned.
Pulmonary and gastrointestinal strongylosis	Affected organs condemned (in case of lungs [1]).
<p>Sparganosis:</p> <ul style="list-style-type: none"> • General infestation • Light infestation 	<p>Carcass and all its carcass parts condemned.</p> <p>Tissue trimmed from carcass and condemned. Remainder of carcass and parts passed conditionally fit for human consumption subject to treatment by freezing (no warmer than -12°C deep muscle temperature for not less than five days in carcasses or boned meat).</p>
<i>Stephanurus dentatus</i>	Affected carcass parts condemned.

2.3 Protozoan diseases	
Coccidiosis	Affected intestines condemned.
Sarcosporidiosis	Affected carcass parts condemned.
2.4 Viral diseases	
Bovine leucosis: <ul style="list-style-type: none"> • Multiple lesions or lesions in multiple organs • Localised lesion (e.g. mesentery) 	Carcass and all its carcass parts condemned. Affected gastrointestinal tract or other organs condemned.
Bovine para-influenza	Affected lungs condemned.
Bovine virus diarrhoea/mucosal disease: <ul style="list-style-type: none"> • Acute infection with evidence of systemic involvement • Chronic infection with lesions localised to alimentary tract 	Carcass and all its carcass parts condemned. Affected intestines condemned.
Ephemeral fever	Animals withheld from slaughter for treatment. Resubmitted for ante-mortem after recovery.
2.5 Fungal diseases	
Aflatoxicosis: <ul style="list-style-type: none"> • Acute with generalised signs including jaundice, swelling of liver, ascites and mesenteric oedema • Sub-acute 	Carcass and all its carcass parts condemned. Affected liver and kidneys condemned.
Epizootic lymphangitis	Affected skin and related tissues condemned. Any affected organs condemned.
2.6 Non-infectious conditions	
Delay in evisceration: <ul style="list-style-type: none"> • Evidence of deterioration or putrefaction • Localised changes in viscera 	Carcass and all its carcass parts condemned. Viscera condemned.
Ecchymosis	Affected carcass parts condemned [2].
Foreign objects, including grass seeds: <ul style="list-style-type: none"> • Accompanied by generalised signs such as fever or sepsis • No evidence of generalised signs 	Carcass and all its carcass parts condemned. Foreign object removed; affected tissues trimmed from carcass and condemned.

<p>Jaundice:</p> <ul style="list-style-type: none"> • Haemolytic or toxic • Obstructive (slight, dissipates within 24 hours of slaughter) • Obstructive (severe) 	<p>Carcase and all its carcass parts condemned. Carcass parts condemned.</p> <p>Carcase and all its carcass parts condemned.</p>
<p>Metabolic disorders (e.g. transit tetany, ketosis)</p>	<p>Animal condemned in severe cases. Withheld from slaughter in milder cases and resubmitted for ante-mortem after recovery.</p>
<p>Residues in excess of nationally established maximum limits</p>	<p>Carcase and all its carcass parts condemned. Companion animals and carcasses tested for residue levels.</p>
<p>Tumours:</p> <ul style="list-style-type: none"> • Circumscribed benign tumours, neurofibromas of intercostal nerves and nerve plexes • Malignant tumours (carcinoma, sarcoma) • Multiple tumours (evidence of metastasis or multiple lesions in different organs) 	<p>Depending on extent, lesion trimmed and condemned or affected carcass part condemned [1].</p> <p>Carcase and all its carcass parts condemned [1].</p> <p>Carcase and all its carcass parts condemned [1].</p>
<p>3 Topographic listing</p>	
<p>3.1 Nervous system</p>	
<p>Acute encephalitis and meningitis</p>	<p>Carcase and all its carcass parts condemned.</p>
<p>Brain abscesses:</p> <ul style="list-style-type: none"> • Associated with pyaemia • Localised lesion 	<p>Carcase and all its carcass parts condemned. Affected brain condemned.</p>
<p>3.2 Cardiovascular system</p>	
<p>Acute pericarditis with accumulation of exudate, septicaemia, degenerative changes in organs or abnormal odour</p>	<p>Carcase and all its carcass parts condemned.</p>
<p>Chronic pericarditis</p>	<p>Affected heart and pericardium condemned.</p>
<p>Endocarditis</p> <ul style="list-style-type: none"> • Associated with generalised signs • Without complications 	<p>Carcase and all its carcass parts condemned. Affected heart condemned.</p>
<p>Heart lesions of non-infectious nature</p>	<p>Affected heart condemned.</p>
<p>Worm aneurisms in horses:</p> <ul style="list-style-type: none"> • Infarction confined to hind leg • Peritonitis, circulatory disturbances in mesentery and intestines 	<p>Affected quarter condemned. Carcase and all its carcass parts condemned.</p>

3.3 Respiratory system	
Atelectasis, emphysema, pigmentation, aspiration of blood, scalding water or ingesta	Affected lungs condemned [1].
Bronchitis	Affected lungs condemned.
Multiple pulmonary abscesses	Carcase and all its carcase parts condemned.
Periacute pneumonia such as severe purulent bronchopneumonia, gangrene of the lungs or necrotic pneumonia	Carcase and all its carcase parts condemned.
Pneumonia or bronchopneumonia	Affected lungs condemned [1].
Sinusitis	Affected head condemned.
3.4 Pleura	
Adhesions and patches of fibrinous tissue	Affected serous membranes stripped and affected parts condemned.
Diffuse serofibrinous, suppurative or gangrenous pleurisy	Carcase and all its carcase parts condemned.
3.5 Gastrointestinal tract	
Acute enteritis: <ul style="list-style-type: none"> • Septic, diphtheritic or haemorrhagic enteritis enlargement of spleen or degeneration of organs • With congested mesenteric lymph nodes without other signs 	<p>Carcase and all its carcase parts condemned.</p> <p>Affected intestines condemned.</p>
Chronic gastro-intestinal catarrh	Affected intestines condemned.
Emphysema of mesentery in pigs	Affected mesentery and intestines condemned.
3.6 Peritoneum	
Adhesions and patches of fibrinous tissue, localised encapsulated abscesses	Affected parts condemned.
Peritonitis: <ul style="list-style-type: none"> • Acute, diffuse or extensive • Localised 	<p>Carcase and all its carcase parts condemned.</p> <p>Affected serous membranes stripped and affected parts condemned.</p>
3.7 Liver	
Abscesses	Affected liver condemned.
Fatty infiltration, parenchymatous infiltration	Affected liver condemned [1].

Hepatitis of toxic, parasitic or non-specific nature	Affected liver condemned (for parasitic and non-specific causes [1]).
Miliary necrosis of liver in calves	Carcase and all its carcase parts condemned.
Parasitic lesions/nodules	Affected parts of liver trimmed and condemned.
Telangiectasis, cyst formation	Affected liver or part of liver condemned [1].
3.8 Kidney	
Bladder rupture	Carcase and all its carcase parts condemned.
Calculi, cyst formation, pigmentation	Affected kidneys condemned [1].
Nephritis (including parasitic nephritis): <ul style="list-style-type: none"> • Acute with evidence of uraemia, oedema or abnormal odour of urine • Chronic with no systemic effects 	Carcase and all its carcase parts condemned. Affected kidneys condemned.
3.9 Genital tract	
Inflammation of uterus: <ul style="list-style-type: none"> • Acute metritis (septic or necrotic, putrefied foetus) • Chronic metritis 	Carcase and all its carcase parts condemned. Affected uterus condemned.
Orchitis/epididymitis	Affected organ condemned.
Prolapse, torsion or rupture of uterus accompanied by fever or peritonitis	Carcase and all its carcase parts condemned.
Retention of placenta: <ul style="list-style-type: none"> • Accompanied by fever or evidence of other systemic effects • With no signs of systemic effects 	Carcase and all its carcase parts condemned. Affected uterus condemned.
3.10 Udder	
Mastitis <ul style="list-style-type: none"> • Septic, gangrenous • No signs of systemic involvement 	Carcase and all its carcase parts condemned. Udder condemned.
Oedema	Udder condemned.
3.11 Musculoskeletal system	
Abnormal pigmentation	Affected parts condemned [1].
Arthritis: <ul style="list-style-type: none"> • Acute infectious • Non-infectious, chronic with no systemic effects 	Carcase and all its carcase parts condemned. Affected part condemned.

<p>Fractures:</p> <ul style="list-style-type: none"> • Uncomplicated (recent or healing) • Infected with signs of generalised effects 	<p>Fracture trimmed from carcase and condemned. Carcase and all its carcase parts condemned.</p>
<p>Myositis and muscular dystrophy</p>	<p>Affected parts condemned [1].</p>
<p>Osteomyelitis:</p> <ul style="list-style-type: none"> • Gangrenous, suppurative or accompanied by metastasis • Localised 	<p>Carcase and all its carcase parts condemned. Affected part trimmed from carcase and condemned.</p>
<p>3.12 Skin</p>	
<p>Bruising:</p> <ul style="list-style-type: none"> • Generalised or secondary changes in carcase • Localised 	<p>Carcase and all its carcase parts condemned [2]. Affected tissue trimmed from carcase and condemned for trimmings [2].</p>
<p>Burns:</p> <ul style="list-style-type: none"> • With extensive oedema or systemic signs such as fever • Localised 	<p>Carcase and all its carcase parts condemned. Affected tissue trimmed from carcase and condemned [1].</p>
<p>Eczema and chronic dermatitis in pigs</p>	<p>Affected skin trimmed from carcase and condemned.</p>
<p>Erythema and acute dermatitis (e.g. photosensitisation):</p> <ul style="list-style-type: none"> • With systemic effects such as fever • No evidence of systemic involvement 	<p>Carcase and all its carcase parts condemned. Affected skin trimmed from carcase and condemned [1].</p>
<p>Wounds and cellulitis:</p> <ul style="list-style-type: none"> • Infected wounds and discharging lesions accompanied by generalised signs such as fever or sepsis • Granulating wounds or no evidence of generalised signs 	<p>Carcase and all its carcase parts condemned. Affected tissues trimmed from carcase and condemned.</p>