

Guidance for On-farm Poultry Slaughter

For producers who slaughter small quantities of poultry on-farm and supply the meat direct to local retail establishments or to the final consumer





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1. Background

A Farm to Fork Policy

In 2000, the European Commission published its white paper on food safety which proposed a radical overhaul of the policy on food safety. An action plan on food safety was elaborated. It included the establishment of the European Food Safety Authority (EFSA), the strengthening of the Rapid Alert System for Food and Feed (RASFF), a review of food law and the development of a comprehensive integrated approach to food safety. The principle of an integrated approach in practice meant that food safety should apply throughout the entire food chain (farm to fork), across all food sectors, between Member States, at the external EU frontier and within the EU, and in international fora.

Today, the guiding principle is to apply an integrated approach from farm to table covering all sectors of the food chain, including feed production, primary production, food processing, storage, transport and retail sale.

The package of EU food hygiene regulations introduced in 2006 applies across the entire food chain. In the case of the slaughter of poultry, there is a general requirement that this activity takes place at approved slaughterhouses.

However, the regulations acknowledge the close relationship that exists between consumers and farmers slaughtering small quantities of poultry on-farm for local supply. Hence the regulations exempt the need for formal approval in the case of on-farm poultry slaughter establishments supplying small quantities of poultry directly to the final consumer or to local retail establishments, provided there is adherence to certain criteria. The operator of such a business is however, required to register with the local authority appropriate to the area.

Even though only small quantities of poultry are supplied, the producers are regarded as food business operators. Any food they produce has to meet food safety requirements. This will be achieved by ensuring compliance with relevant requirements of the legislation.

2. Introduction

The document is intended for use by both:

- Local authority veterinary officers
- Food business operators who slaughter small quantities of poultry on the farm and supply the meat direct to local retail establishments or to the final consumer

The purpose of the document is to:

- Outline the scope of activities allowed in a registered on-farm poultry slaughter establishment
- Provide information on relevant food legislation and compliance with the law
- Provide information on recommended good practices (these points are recommendations only and not legal requirements)

NOTE

Small quantities: Less than 10,000 birds slaughtered per year and less than 1,000 birds slaughtered in any given week

On the farm: The slaughter of birds at a suitable establishment on the holding where they are grown and finished but not necessarily hatched, where that holding is the primary production holding

Local retail establishments: Within 100km radius of the farm

Final consumer: The ultimate consumer of a foodstuff who will not use the food as part of any food business operation or activity

If the business activities do not fit the restrictions outlined above, then businesses will need approval from the local authority as laid out in Regulation (EC) No 853/2004 (see Section 4 on Registration).

Note: A more extensive list of definitions is given in Appendix D of this document.

This document **does not** include guidance on farming activity, in this case, the rearing of poultry. Rearing and slaughtering poultry solely for personal or family consumption falls outside the scope of food legislation and this guidance document. However, poultry rearing activities should be registered with the Department of Agriculture, Food and the Marine for animal health and welfare reasons (see Section 4 on Registration).

FURTHER GUIDANCE AND READING

Throughout this document, reference will be made to reading material in FSAI publications, legislation or other websites that can be read in conjunction with this document.

FSAI publications are available through the FSAI website www.fsai.ie The FSAI Advice Line may be contacted at 1890 33 66 77 or email info@fsai.ie.

3. Legislation Overview

Both European Union (EU) and national legislation apply to on-farm poultry slaughter. The main pieces of legislation that apply are:

- Regulation (EC) No 178/2002 (General Food Law)
- Regulation (EC) No 852/2004 (Hygiene of Foodstuffs)
- Food Safety Authority of Ireland Act, 1998 (No. 29 of 1998)
- European Communities (Food and Feed Hygiene) Regulations, 2009 (S.I. No. 432 of 2009)

Regulation (EC) No 178/2002 (General Food Law)

This regulation sets out a range of general principles and obligations that food business operators must adhere to.

Key points of this regulation include:

- The primary responsibility for producing safe food rests with the food business operator
- Food businesses must ensure that food produced meets the requirements of all applicable food law
- The consumer must not be misled, e.g. by labelling or advertising
- Unsafe food must not be placed on the market. Unsafe food includes food that is 'injurious to health' and 'unfit for human consumption'
- Food businesses must maintain a traceability system
- Food businesses must have a system to withdraw or recall any unsafe food from the market. They must inform both consumers and the competent authority (local authority) in such an event

Regulation (EC) No 852/2004 (Hygiene of Foodstuffs)

This regulation lays down general rules on the hygiene of foodstuffs for food business operators.

Food business operators must ensure that all stages of production, processing, and distribution of food under their control comply with the relevant hygiene requirements.

Key points of this regulation requires food business operators to:

- Implement and maintain a food safety management system based on the Hazard Analysis Critical Control Point (HACCP) principles
- Ensure that food handlers have received enough food safety training to allow them to do their job safely
- Comply with the general hygiene requirements as laid down in Annex II of the regulation
- Adopt specific hygiene measures such as:
 - Compliance with temperature control requirements for foodstuffs and maintenance of the cold chain (*meat from slaughtered poultry should be chilled to 4°C or less as soon as possible after slaughter*)
 - Compliance with relevant microbiological criteria (*small scale slaughterhouses may be exempt from these microbiological testing requirements subject to the risk assessment that is undertaken by the supervising local authority veterinary officer*)

Food Safety Authority of Ireland Act, 1998 (No. 29 of 1998)

This legislation provides enforcement powers to local authority veterinary officers.

European Communities (Food and Feed Hygiene) Regulations, 2009 (S.I. No. 432 of 2009)

This legislation transposes European food legislation.

Summary of Legislative Requirements

The following table is a summary of the main legislative requirements applicable to producers who supply small quantities of on-farm slaughtered poultry directly to final consumers, or to local retail establishments. Further details on each of the requirements are outlined in the remaining sections of this document.

| | |
|---|----------------------|
| Requirement for Registration | See Section 4 |
| The food business is registered (or approved, as applicable). | |
| Requirements for Traceability and Withdrawal/Recall | See Section 5 |
| There is an effective traceability system in place | |
| There is an effective withdrawal/recall system in place | |
| Requirements for Hygiene Prerequisites | See Section 6 |
| Walls, floors, doors, ceilings and other surfaces and equipment are in sound condition, easy to clean and constructed of impervious, non-toxic, non-absorbent, washable materials | |
| Sufficient space to operate hygienically | |
| Layout of the premises allows for 'clean' and 'dirty' operations to be kept separate | |
| Pest-proof premises (rodent, insect and other pests) | |
| Refrigerated space to store processed poultry | |
| Flush lavatories that do not open directly into rooms where food is handled | |
| Handwash facilities with hot and cold running water | |
| Staff changing facilities | |
| Floors that are suitably drained | |
| Waste water that is correctly ducted (so it does not flow directly across floors) | |
| Adequate drainage facilities | |
| Sufficient lighting | |
| Sufficient ventilation and rooms that are free from condensation | |
| Clean establishment and equipment including regular cleaning and disinfection of the establishment and equipment | |
| Storage area for equipment, cleaning products, disinfectants, sanitisers that are separate from food areas | |
| Adequate supply of potable water | |
| Adequate collection and storage of waste and animal by-products | |
| Arrangements in place for the correct disposal of waste and animal by-products | |
| Vehicles that transport poultry meat are clean and where necessary, refrigerated | |
| Adequate staff personal hygiene | |
| Requirement for Slaughter Hygiene | See Section 7 |
| The slaughter of poultry takes place in a hygienic manner with due regard for animal welfare | |
| Requirement for the Development of a Food Safety Management System | See Section 8 |
| There is a food safety management system in place which has identified food safety hazards and has put measures in place to deal with them | |

| | |
|---|---------------------------------|
| Requirement for Training | See Section 9 |
| Personnel have completed sufficient food safety training appropriate to their responsibilities within the food business | |
| Requirement for Labelling | See Section 10 |
| Poultry meat produced in the on-farm poultry slaughter establishment is labelled correctly | |
| Requirement for Animal Welfare and Animal by-Products | See Appendices A & B |
| Animal welfare and animal by-product requirements are being adhered to | |

Legislation Referred to in this Document

1. Food Safety Authority of Ireland Act, 1998 (No. 29 of 1998)
2. Council Directive 98/83/EC of 3 November 1998 on the quality of water intended for human consumption
3. Directive 2000/13/EC of the European Parliament and of the Council of 20 March 2000 on the approximation of the laws of the Member States relating to the labelling, presentation and advertising of foodstuffs
4. Regulation (EC) No 178/2002 of the European Parliament and of the Council of 28 January 2002 laying down the general principles and requirements of food law, establishing the European Food Safety Authority and laying down procedures in matters of food safety
5. European Communities (Labelling, Presentation and Advertising of Foodstuffs) Regulations, 2002 (S.I. No. 483 of 2002)
6. Regulation (EC) No 852/2004 of the European Parliament and of the Council of 29 April 2004 on the hygiene of foodstuffs
7. Regulation (EC) No 853/2004 of the European Parliament and of the Council of 29 April 2004 laying down specific hygiene rules for food of animal origin
8. European Communities (Drinking Water) (No. 2) Regulations, 2007 (S.I. No. 278 of 2007)
9. Regulation (EC) No 1069/2009 of the European Parliament and of the Council of 21 October 2009 laying down health rules as regards animal by-products and derived products not intended for human consumption and repealing Regulation (EC) No 1774/2002 (Animal by-products Regulation)
10. European Communities (Food and Feed Hygiene) Regulations, 2009 (S.I. No. 432 of 2009)
11. European Communities (Welfare of Farmed Animals) Regulations, 2010 (S.I. No. 311 of 2010)

This document is intended as a guide to compliance with relevant legislation and is not a substitute for the law.

There is a comprehensive food legislation section on the FSAI website www.fsai.ie. National and European food legislation can be downloaded from here.

Irish legislation can be purchased from:

The Stationery Office
Government Publications
Sun Alliance House
Molesworth Street
Dublin 2

FURTHER INFORMATION

For further information, refer to the FSAI publication *Guide to Food Law for Artisan/Small Food Producers*. This has been written with the small scale producer in mind.

4. Registration

In general, all food business operators must notify an appropriate competent authority (an official government agency) of each establishment under their control, with a view to registration of each such establishment.

For food business operators specifically involved in on-farm poultry slaughter, the official agency and competent authority is the local authority and registration is a legal requirement.

To protect public health, the local authorities must know:

- Who the food business operator is
- Where the food business is located
- The activities carried out by the food business (such as poultry slaughter or the production of delayed eviscerated New York Dressed (NYD) poultry)
- Any other information as required such as giving notice to the supervising veterinary officer when activities are being carried out in an establishment, particularly in the case of disjointed or seasonal slaughter or when the timing of slaughter is not regular

The local authority veterinary officer will be able to advise on the exact scope of activities that may be permitted in a registered on-farm poultry slaughterhouse. This will be based on a risk assessment by the competent authority (the local authority).

NOTE

It is an offence not to:

- Register under European Communities (Food and Feed Hygiene) Regulations, 2009 (S.I. No. 432 of 2009)
- Provide up-to-date information on an establishment including any significant changes in activities that may have taken place, e.g. increasing throughput or changing location/type of operations

Information regarding registration and the documentation required are available from the relevant local authority.

Criteria for Registration

Generally, on-farm poultry slaughtering operations which fit the criteria below will require registration:

- Poultry are slaughtered and sold/supplied/placed on the market
- No more than 10,000 poultry a year are being slaughtered on-farm (with a maximum of 1,000 in any given week)
- Poultry are supplied or are offered for sale within a 100km radius of the farm
- Poultry are supplied:
 - Directly to the final consumer, e.g. at the farm gate
 - Via a local retail establishment, e.g. at a local retail butcher; via a local restaurant; a stall at a farmers market etc (this is not an exhaustive list)

If the businesses' activities do not meet the criteria outlined above, registration will not be sufficient and food businesses will need approval from the local authority as laid down in Regulation (EC) No 853/2004 (Specific Hygiene Rules for Foods of Animal Origin). This regulation **does NOT apply** to registered (as opposed to approved) on-farm poultry slaughterhouses. It contains, among other things, certain prescriptive structural and operational provisions for food businesses that deal with food of animal origin.

The close link that exists between producers and consumers in the case of registered on-farm poultry slaughter establishment is sufficient to ensure a high level of consumer protection without applying the specific provisions of Regulation (EC) No 853/2004.

Requirements for approval

Approval, as laid down in Regulation (EC) No 853/2004, is a more formal and detailed process than registration and compliance with additional food legislation is therefore required.

Activities that would require approval include any of the following:

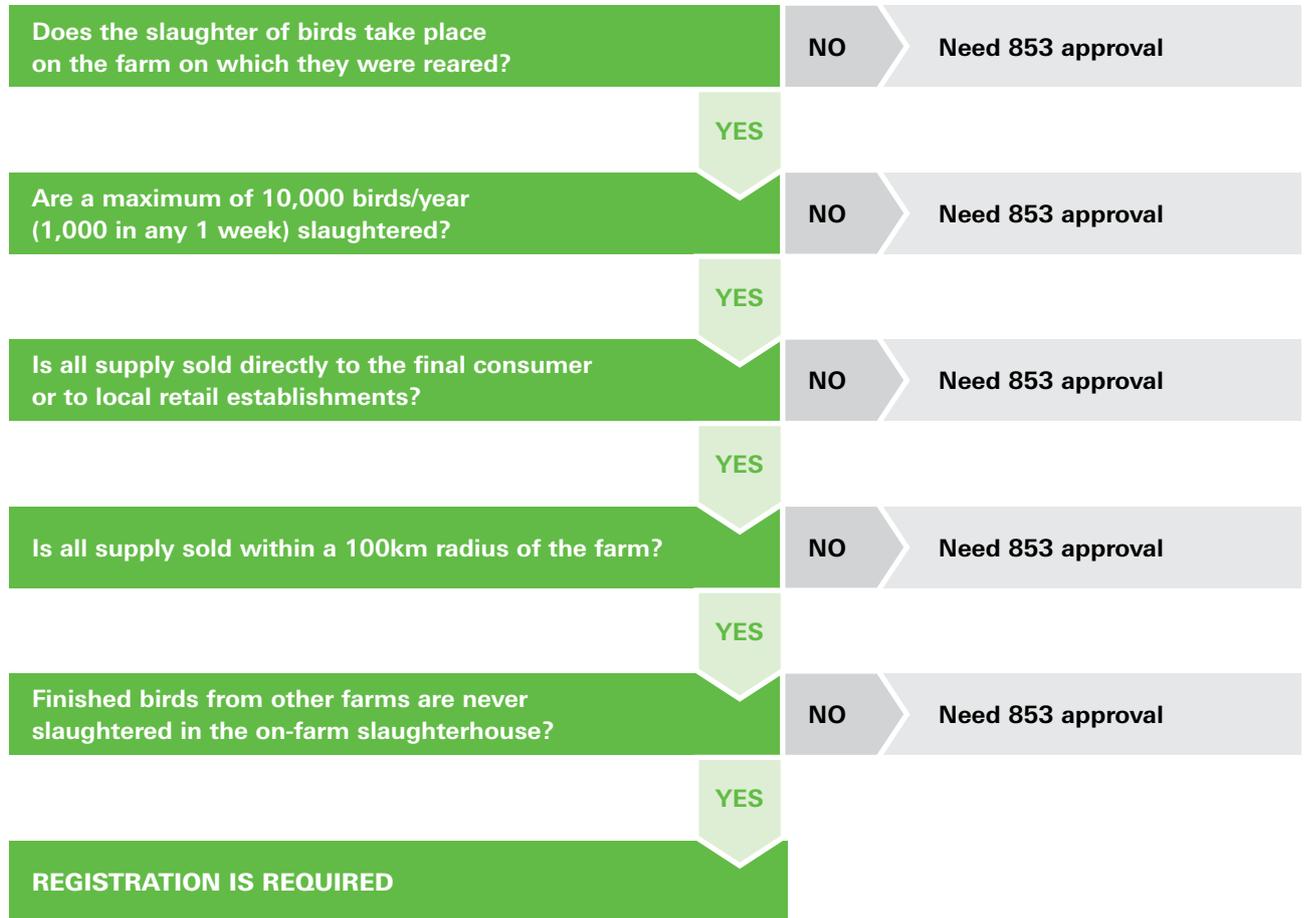
- Slaughtering more poultry than the quantities given above
- Supplying poultry other than as described above
- Slaughtering poultry from other farms/flock owners, e.g. buying a batch of finished poultry from another farmer, slaughtering them on your own farm and placing this poultry on the market
- Slaughtering finished poultry on behalf of somebody else

NOTE

Poultry farmers keeping livestock (in this case, rearing/growing poultry) must also register with the Department of Agriculture, Food and the Marine.

The Department of Agriculture, Food and the Marine needs to have details on all poultry flocks for animal health and welfare reasons, e.g. in the case of an outbreak of notifiable infectious diseases in poultry such as highly pathogenic avian influenza. The Department of Agriculture, Food and the Marine can be contacted via their website www.agriculture.gov.ie or Lo Call 1890 200510/ 01 6072000.

The following diagram is designed to determine whether a poultry slaughter premises requires approval or registration



NOTE
The local authority veterinary officer should be consulted in all cases.

5. Traceability and Withdrawal/Recall

All food business operators are required by law to ensure product traceability. They must keep records relating to both the suppliers and businesses that they supply and be able to make this information available rapidly to the competent authority when required.

Supplier Traceability

The following information should be kept regarding suppliers:

- The supplier's contact details
- The raw material description supplied, e.g. feed, day-old poultry/poultry bought in
- The quantity of products supplied
- The batch number or other identification information (if available)
- The date of transaction

Customer Traceability

The following information should be kept regarding customers to whom produce has been sold. (NOTE: This does not include sales to the final consumer):

- The customer's contact details
- The product description
- The quantity sold
- The batch number(s)
- The date of transaction

Withdrawal/Recall

Procedures must be in place to allow both identification and withdrawal/recall of contaminated batches of poultry produced. The food business operator must be in a position to immediately withdraw/recall unsafe or unfit food that has been placed on the market.

NOTE

- The local authority veterinary officer must be informed of any withdrawals/recalls that have taken place and any corrective action taken.
- The food business operator must also be able to trace any food packaging used.

FURTHER INFORMATION

For further information on traceability, refer to the FSAI publication *Guidance Note 10 Product Recall and Traceability*

6. Hygiene Prerequisites

Food business operators should have good hygiene practices in place relating to structural, operational and personal hygiene. These procedures, or **prerequisites**, are designed to control hazards in a general way.

The following table outlines the legislative and best practice requirements that must be in place to satisfy good hygiene practices. It also details how the food business operator can meet these requirements in an on-farm poultry slaughter establishment. **NOTE:** Best practice recommendations are outlined in *blue/italic font*.

| Requirement | How to Meet the Requirement |
|--|---|
| <p>Walls, floors, doors, ceilings and other surfaces and equipment are:</p> <ul style="list-style-type: none"> • In sound condition • Easy to clean • Constructed of impervious, non-toxic, non-absorbent, washable materials | <p>Floors:</p> <ul style="list-style-type: none"> • Floors must be in good condition. Broken and worn areas are not acceptable • Earth or wood are not satisfactory flooring materials for a poultry processing unit • There must be adequate surface drainage for the collection of blood, in particular • Carcasses/meat must not come into contact with the floor • Drains should be trapped/gridded and drainage lines should lead towards these drains <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Preferred floor options should be a hard wearing surface such as epoxy screed or granolithic cement, i.e. hard wearing concrete</i> • <i>For stairways/steps/platforms, aluminium alloy checkerplate/treadplate is preferable</i> • <i>Floors should be disinfected regularly</i> <p>NOTE: A suitable method of blood collection should be used in small scale operations, e.g. bucket/barrels.</p> <p>Walls:</p> <ul style="list-style-type: none"> • Walls must be in a sound condition (smooth and impervious) • Cracked, damaged or broken walls are not acceptable • A smooth surface must be provided up to a sufficient height <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Use anti-mould paint in areas where fungal/mould growth could be a problem</i> • <i>Possible options for smooth wall surfaces are:</i> <ul style="list-style-type: none"> – <i>Sealed cement walls</i> – <i>Metal sheeting</i> – <i>Plastic cladding</i> • <i>A minimum height of 1.8 meters is recommended, or ceiling height</i> |

| Requirement | How to Meet the Requirement |
|--|--|
| <p>Walls, floors, doors, ceilings and other surfaces and equipment are:</p> <ul style="list-style-type: none"> • In sound condition • Easy to clean • Constructed of impervious, non-toxic, non-absorbent, washable materials | <p>Ceilings (or where there are no ceilings, the interior surface of the roof):</p> <ul style="list-style-type: none"> • Ceilings must be maintained in a good condition and cleaned regularly • Suitable materials must be used to prevent/reduce the build up of condensation • Ceilings must be lined with smooth and impervious materials <p>Windows:</p> <ul style="list-style-type: none"> • Window frames and sills must be maintained in good condition and sills must be sloped (to prevent the accumulation of dirt) • If windows open directly into food handling or storage areas, they must be screened to prevent contamination/infestation • Where open windows would result in contamination, they must be kept closed and fixed during production <p>Doors:</p> <ul style="list-style-type: none"> • Doors must be maintained in a good condition and made from materials that can be easily cleaned and disinfected <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Doors should be self closing and fitted with anti-rodent bristle strip</i> • <i>Preferably, doors should be made from materials that facilitate cleaning and disinfection without the need to paint/varnish</i> <p>Other surfaces:</p> <ul style="list-style-type: none"> • Surfaces in areas where food is handled including the surfaces of equipment and, in particular, those surfaces in contact with food must be: <ul style="list-style-type: none"> – In sound condition – Easy to clean and, where necessary, disinfect – Made of suitable construction, i.e. smooth, washable and corrosion resistant |

| Requirement | How to Meet the Requirement |
|---|--|
| <p>Sufficient space to operate hygienically</p> <p>Layout of the premises allows for 'clean' and 'dirty' operations to be kept separate (see Section 7)</p> | <ul style="list-style-type: none"> • Separate rooms/areas (of sufficient size for activities being undertaken) are generally required for the following operations: <ul style="list-style-type: none"> – Reception – Slaughter/plucking/scalding – Evisceration – Packing/dispatch – Storage (capable of maintaining the cold chain) <p>NOTE: Space/time separation may be adequate for some activities in certain premises and situations (exact requirements should be discussed with the local authority veterinary officer).</p> <ul style="list-style-type: none"> • There must be facilities to avoid possible contamination of meat. Meat must not come in contact with walls or floors. <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>There should be an area with adequate covered shelter for reception of animals before slaughter</i> • <i>A floor plan should be drawn up which indicates a plan of the work flow in the premises</i> • <i>A logical work flow should be documented throughout the different stages of processing to prevent cross contamination</i> • <i>Available space should enable hygienic operations to take place</i> • <i>The position and movement of personnel, poultry, and other stock outside the slaughtering and dressing areas should be considered to avoid any potential contamination</i> • <i>The external yard adjacent to the slaughtering and dressing area should be separated from the animal/poultry houses, the farmyard, slurry pits, ditches, open drains, etc preferably by a sealed hard standing</i> |
| <p>Pest-proof premises (rodent, insect and other pests)</p> | <ul style="list-style-type: none"> • Food must not be contaminated by vermin (rats, mice, insects, wild birds) or domestic animals. • Adequate procedures to control pests must be in place. <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Procedures/practices to control pests should include at least the following:</i> <ul style="list-style-type: none"> – <i>Entrances/access points to the poultry processing unit should be rodent proofed</i> – <i>Insect screens/electronic insect killers should be in place</i> – <i>Regular baiting of the premises should be carried out to control rodents. This can include a bait map and records of the amount of bait control used</i> – <i>Records of insect control should be kept, e.g. maintenance of insectocutors</i> – <i>Doors should be kept closed and other openings should be protected from pests</i> – <i>In order to keep the premises clean and tidy, a 'clean as you go' policy should be in place</i> – <i>Regular inspections for signs of rodents</i> – <i>Awareness of any indication of pest infestation and knowing what to do</i> <p>NOTE: As the processing facility is located on the farm, broader consideration must be given to the control of pests and vermin on-farm. Any pest control program will be of little use if on-farm pest control is not managed correctly.</p> |

| Requirement | How to Meet the Requirement |
|---|--|
| Refrigerated space to store processed poultry | <ul style="list-style-type: none"> • Slaughtered poultry must be chilled as soon as possible after slaughter. The cold chain must be maintained and not interrupted. <p>NOTE: Poultry should be chilled to no more than 4°C.</p> <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>When hanging, poultry should not be in contact with each other. This inhibits air circulation between carcasses and can cause cross contamination. It is important that air can circulate around and between carcasses so that cooling can take place as quickly and efficiently as possible</i> • <i>Suitable equipment (refrigeration/fans) should be used to maintain the cold chain and avoid a build up of condensation</i> • <i>Warm carcasses should not be placed with chilled carcasses in the refrigerator as condensation can result</i> |
| Flush lavatories that do not open directly into rooms where food is handled | <ul style="list-style-type: none"> • Lavatories must not open directly into a work area. |
| Handwash facilities with hot and cold running water | <ul style="list-style-type: none"> • The number of wash hand basins required depends on the: <ul style="list-style-type: none"> – Number of personnel working in the premises – Premises size, infrastructure and layout – Activities undertaken, e.g. dry plucking (Stainless steel wash hand basins are preferable) • Wash hand basins are required in the following areas: <ul style="list-style-type: none"> – Toilet facilities – Poultry processing areas – Dry plucking area if dry plucking is carried out • All wash hand basins must have: <ul style="list-style-type: none"> – Hot and cold water – Materials for cleaning hands (liquid soap from a dispenser is preferable) – Hand drying facilities (disposable paper towels are preferable for hand drying) – Wash hand basins must be designated handwash only <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Wash hand basins for staff handling exposed meat should have taps designed to prevent the spread of contamination</i> |
| Staff changing facilities | <ul style="list-style-type: none"> • A changing area must be located away from the food area. <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>The changing area could be in the farmhouse in some circumstances</i> • <i>Exact requirements should be discussed with the local authority veterinary officer</i> |

| Requirement | How to Meet the Requirement |
|--|--|
| <p>Floors that are suitably drained</p> <p>Waste water that is correctly ducted (so it does not flow directly across floors)</p> <p>Adequate drainage facilities</p> | <ul style="list-style-type: none"> • Where drainage channels are fully or partly open, drainage waste must not flow from a contaminated area to a clean area. • All drains must be trapped and those at the exit must be screened. <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>There should be a separate and adequate drainage and collecting system for waste water, e.g:</i> <ul style="list-style-type: none"> – <i>Effluent water from the processing rooms</i> – <i>Storm water from building surrounds and roof gutters</i> – <i>Sanitary facilities</i> <p>NOTE: Every precaution should be taken to prevent environmental pollution.</p> |
| <p>Sufficient lighting</p> | <ul style="list-style-type: none"> • Lighting may be artificial, natural or a combination of both. • All parts of the food premises require adequate lighting to facilitate: <ul style="list-style-type: none"> – Inspection of foodstuffs – Cleaning – Safe operating conditions – Other relevant operations and activities <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>For artificial lighting:</i> <ul style="list-style-type: none"> – <i>Light fittings should be protected by diffusers/covers/tubes and mounted flush to the ceiling or other surfaces</i> – <i>It is not recommended to use lights suspended by wires/chains as they can be a source of contamination</i> • <i>Depending on the nature of the operation being taken, the following light intensities are recommended:</i> <ul style="list-style-type: none"> – <i>Good in all areas (110 lux)</i> – <i>Very good in food production areas (220 lux)</i> – <i>Excellent in areas where food or equipment is visually inspected (540 lux)</i> |
| <p>Sufficient ventilation</p> <p>Rooms that are free from condensation</p> | <ul style="list-style-type: none"> • Natural ventilation is normally sufficient; however, plant infrastructure must be taken into account. • Temperature fluctuations must be avoided. • Mechanical airflow from a contaminated to a clean area must be avoided. |

| Requirement | How to Meet the Requirement |
|--|---|
| Clean establishment and equipment including regular cleaning and disinfection of the establishment and equipment | <p>Premises:</p> <ul style="list-style-type: none"> • All areas must be clean before the start of operations. This includes the areas for killing, plucking, scalding, evisceration and related operations, e.g. packaging, dispatch, etc. • Any soiling, debris or waste present on any surface must be cleaned away promptly • Floors must be regularly brushed, cleaned and disinfected • Drains must be kept clean and free from blockage • Soiling of walls or fittings must be cleaned promptly • At the end of each work period, the interior must be thoroughly cleaned/disinfected • Waste disposal areas must be kept tidy and brushed clean each day and regularly cleaned/disinfected • All other areas around the premises must be clean and and regularly cleaned/ disinfected <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Cleaning procedures and schedules should be in place for the premises, equipment and amenities</i> <p>Equipment:</p> <ul style="list-style-type: none"> • 'Equipment' relates to any items used for slaughtered poultry or poultry awaiting slaughter. All equipment must be kept clean and if necessary, cleaned before use • For example: (this is not an exhaustive list): <ul style="list-style-type: none"> – Work surfaces: tables, racks – Pluckers, scalders and their heating elements, killing cones, immersion chill troughs, (stunning cabinets, rails, overhead conveyors, if applicable) – Containers: boxes, pallets, dolavs (large plastic containers) – Containers used to hold live poultry – Hooks, knives, gambrels, slaughtering/stunning equipment etc • For seasonal businesses, equipment must be thoroughly cleaned before first use |

| Requirement | How to Meet the Requirement |
|---|---|
| <p>Clean establishment and equipment including regular cleaning and disinfection of the establishment and equipment</p> | <ul style="list-style-type: none"> • Equipment must be cleaned/disinfected regularly throughout the day, but particularly when it becomes visibly soiled or contaminated • Old equipment must not be used when: <ul style="list-style-type: none"> – It cannot be cleaned effectively – There is a possibility of foreign body contamination – It is no longer performing its function adequately • Equipment, work surfaces and fittings must have smooth surfaces, clean welds, an absence of bolts and irregular protuberances for effective cleaning and disinfection • Equipment must be moveable or must be installed in such a way that so it does not inhibit adequate cleaning and disinfection <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Sterilise equipment, such as knives and other tools by using hot water no less than 82°C (or an alternative system having an equivalent effect)</i> • <i>Wood (either sealed or non-sealed) and non-corrosion resistant materials are not recommended, as it is not possible to minimise the risk of contamination</i> • <i>Recommended materials include:</i> <ul style="list-style-type: none"> – <i>Stainless steel (preferable)</i> – <i>Food grade plastics</i> – <i>Other corrosion-resistant materials</i> • <i>Old equipment which is no longer used should be removed from the production area</i> • <i>Each piece of equipment should have a detailed cleaning schedule and a cleaning procedure, if necessary</i> • <i>If heavier items of equipment are bolted/fixed/secured, they should not inhibit cleaning</i> <p>Cleaning equipment requirements:</p> <ul style="list-style-type: none"> • Equipment requires cleaning and facilities must be available to carry this out effectively • There must be sufficient facilities available for the size of the premises • Hot water must be available • Disinfectants/detergents must be food grade¹ and not stored in areas where food is handled • Every effort must be made to avoid re-contamination during the cleaning process, e.g. by not using soiled or dirty cloths <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Suitable equipment includes:</i> <ul style="list-style-type: none"> – <i>Sinks, e.g. for washing knives and small items</i> – <i>Twin sinks are preferable as washing and rinsing can be carried out effectively</i> – <i>Hoses (for fixed items)</i> – <i>Buckets and other cleaning paraphernalia</i> – <i>Sterilising equipment (capable of sterilising knives and other hand tools using hot water at no less than 82°C, or an alternative means with an equivalent effect)</i> <p>NOTE: Equipment requirements vary according to the size of the premises and nature of the activities.</p> |

¹ This should be checked before any disinfectant/detergent is used.

| Requirement | How to Meet the Requirement |
|--|---|
| Storage area for equipment, cleaning products, disinfectants, sanitisers that are separate from food areas | <ul style="list-style-type: none"> • Cleaning agents and disinfectants must not be stored in areas where food is handled. <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>A dedicated storage room/location away from where food is handled is preferable</i> |
| Adequate supply of potable water | <ul style="list-style-type: none"> • The water supply provided must comply with Council Directive 98/83/EC and S.I. No. 278 of 2007. • The water supply must be adequate and potable. • Only this water supply must be used for cleaning surfaces and equipment that come in contact with food. • Seasonal operations must also be connected to a potable water supply. • Wells and water tanks must be properly covered and protected from contamination. • Water treatment equipment must be maintained in good working order. <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Water from a public supply should be sampled once a year. Private well/group scheme supply should be sampled at least once a year</i> • <i>Reports on the microbial status of the plant's water should be retained and made available when required to the local authority veterinary officer.</i> <p>NOTE: Sampling frequency should be related to throughput and type of product produced in the establishment</p> |
| Adequate collection and storage of waste and animal by-products | <p>Animal by-products not intended for human consumption and meat that is unfit for human consumption must be separated from food as soon as possible. It must then be adequately stored and disposed of in accordance with legislative requirements.</p> <ul style="list-style-type: none"> • Refuse containers must not become overfull. They must be regularly emptied and removed from the production area. • Ensure that feathers are collected in containers and cleared from the plucking area regularly. • Viscera must be placed into an appropriate container for disposal and this container should be regularly emptied. • Blood must be channelled directly into a container, e.g. bucket, or collected in some other relevant container, e.g. blood tunnel. • All waste must be removed at the end of the day's kill and stored correctly. • Lids are necessary on waste containers awaiting collection to avoid attracting vermin and scattering the contents of the waste container. • Lids on waste containers used for temporary storage of waste, e.g. in the processing area, are not a necessity. <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Viscera, heads, feet and related animal by-products should be disposed of in plastic bins (to facilitate cleaning) with close-fitting lids (to avoid attracting vermin)</i> • <i>It should be possible to easily clean and disinfect any containers used for waste</i> • <i>There should be cleaning procedures and schedules in place to ensure that waste containers are clean inside and out</i> |

| Requirement | How to Meet the Requirement |
|---|---|
| <p>Arrangements in place for the correct disposal of waste and animal by-products</p> | <ul style="list-style-type: none"> • Provision (for storage and disposal) includes: <ul style="list-style-type: none"> – Frequent removal from the immediate food preparation area – Arrangements for disposal/collection • The frequency of collection will depend upon the volume and type of waste generated and the quality of the storage facilities for waste on-site. • Proofing against pest access can be achieved by: <ul style="list-style-type: none"> – Storing in a covered area (sealed against vermin) – Using close-fitting lids on bins • Outdoor refuse storage must be stored away from the main entrances to the food premises. <p>NB: Special arrangements will need to be made for the collection and disposal of blood and other animal by-products.</p> <p>Disposal of all waste and animal by-products must be carried out in accordance with the relevant legislation.</p> <p>NOTE: During warmer periods of the year, it will be necessary to have more frequent collections of waste.</p> <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Outdoor waste storage should be on a hard standing area and a covered area is preferable</i> • <i>A hose and water supply should be adjacent to the waste storage area in order to clean waste storage equipment and surroundings</i> |

| Requirement | How to Meet the Requirement |
|---|--|
| Vehicles that transport poultry meat are clean and, where necessary, refrigerated | <ul style="list-style-type: none"> • Delivery vehicles must be clean before poultry meat is placed in them. • There must be effective cleaning between loads to avoid cross contamination. • All containers used for the transport of products must be easily cleaned and disinfected. • Food grade cleaning agents and disinfectants must be used. <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>A dedicated set of containers should be used for the transport of poultry meat. These containers should not be used for any other purpose</i> • When poultry carcasses or meat is being transported, the following non-food items must not be transported in the same vehicle at the same time as these materials are likely to result in contamination: <ul style="list-style-type: none"> – Non-food items – Animals – Feed – Other materials • In the case of the transport of other foodstuffs at the same time as poultrymeat, the poultrymeat must be adequately packaged/wrapped and separated from these other materials. Contamination must be avoided. • Packaging materials must be food grade. • Non-food grade materials are not acceptable, e.g. newspapers. <p>Depending on distance travelled and temperature/time involved, the hygienic transport of the carcasses may take place without refrigeration. Exact requirements can be discussed with the local authority veterinary officer.</p> <p>NOTE: Where multiple drop-offs take place or when long journey times are expected, unrefridgerated vehicles may use insulated boxes (cool boxes) in certain situations.</p> |

| Requirement | How to Meet the Requirement |
|---------------------------------|---|
| Adequate staff personal hygiene | <p>All personnel must exhibit a high standard of personal cleanliness:</p> <ul style="list-style-type: none"> • Clean hands: Hands must be washed before entering the production area, after visiting the toilet, after eating or drinking, after handling waste or dirty items, etc. • Wounds must be covered with brightly coloured dressings. • No jewellery must be worn (with the exception of plain wedding bands). • Gloves must be available and used when required. • Food business operators and staff must refrain from unhygienic habits which could contaminate the food, e.g. eating or drinking in production areas, coughing, sneezing over product etc. • Protective clothing should be worn by staff where necessary. • Clothes which have come into contact with diseased or infected meat or other contaminated matter at the processing unit should be changed immediately. <p>If staff are suffering from or suspected of suffering from diseases which may be a danger to public health, e.g. gastroenteritis, they must follow medical advice regarding exclusion from work. The illness should be documented by the owner/occupier who should immediately notify the veterinary inspector.</p> <p>ADDITIONAL GOOD PRACTICES:</p> <ul style="list-style-type: none"> • <i>Clean outer protective clothing, preferably white in colour, should be changed at least once a day</i> • <i>Headgear should be easily cleaned or preferably disposable</i> • <i>Snoods (beard covers) should be worn if necessary</i> • <i>Footwear should be washable and preferably white in colour</i> <p>NOTE: Protective clothing, headgear and footwear should be put on at the start of processing and either washed or disposed of at the end of processing.</p> <p>They should <u>not</u> be worn outside of the processing unit. Preferably, separate clothing and footwear should be worn if going from the intake and slaughter rooms to the evisceration and chill rooms, if personnel are interchanging.</p> |

7. Slaughter Hygiene

Food businesses operating registered poultry slaughterhouses must ensure that:

- Poultry showing clinical signs of disease or known to be contaminated are not slaughtered for human consumption
- Meat from animals that die other than by being slaughtered in the slaughterhouse are not used for human consumption
- Animal welfare requirements are complied with (see Appendix A)
- Animal by-products requirements are complied with (see Appendix B)

The following diagram shows a typical workflow in a poultry slaughtering establishment.



The table below outlines important points that need to be observed during the slaughtering operation.

General principles for slaughter hygiene:

- Animals brought into the slaughter room must be slaughtered immediately
- Dressing operations must be carried out quickly and hygienically, with due regard for animal welfare
- Measures should be taken to prevent the spillage of digestive tract contents during evisceration or during storage pending delayed evisceration
- Poultry carcasses must not be piled at any stage of the slaughter process as this both facilitates cross contamination and inhibits carcass cooling

| | Important Points to Note |
|---------------------------|---|
| Live birds/the flock | <ul style="list-style-type: none"> • The source of the flock should be known. • The flock or holding should not be under any disease control restriction or investigation. • The flock should be healthy and have not tested positive for any condition that would make the meat unfit for human consumption. • The flock should not be subjected to any avoidable stress or discomfort while being crated/loaded. They should be handled carefully at the time of collection. • The withdrawal periods of feed additives/veterinary medicines should be observed. • Other information should be available at the time of slaughter such as the: <ul style="list-style-type: none"> – Number of birds in the batch to be slaughtered – Percentage mortality at 7 days – Percentage mortality by date of slaughter |
| Intake (before slaughter) | <ul style="list-style-type: none"> • The overall health and welfare of each load of birds should be assessed by checking a random sample for: <ul style="list-style-type: none"> – Posture – Wattle colour – Cleanliness etc • Runts and diseased birds caught and crated unintentionally should be humanely dispatched and disposed of as soon as possible. They should not be brought into the food premises. • The area where birds are suspended directly prior to being slaughtered should be sufficiently lit to identify problems but not too bright as this may disturb birds. |
| Restrain/stun/bleed/kill | <ul style="list-style-type: none"> • Care must be taken to prevent avoidable pain, suffering or injury. • Birds must be restrained, stunned and bled effectively (see Appendix A for more details). |
| Scalding | <ul style="list-style-type: none"> • To minimise contamination when using a scalding tank, attention should be given to the: <ul style="list-style-type: none"> – Temperature of the scald tank – Scalding method used – Type of tank used – Duration of scalding <p>NOTE: Only potable water may be used to scald poultry and additional substances such as detergents/quaternary ammonium compounds should not be used or added to the scald tank.</p> |

| | Important Points to Note |
|---|--|
| De-feathering | <ul style="list-style-type: none"> • De-feathering machines and the scalding process are major sites of potential cross contamination in poultry slaughterhouses. • Feathers should be removed either manually or by machine. • For dry plucking, handwash facilities should be available in or close to the dry plucking area. • For mechanical feather removal, any feathers remaining after machine plucking should be removed by hand. |
| Spray wash | <ul style="list-style-type: none"> • Poultry may be rinsed/sprayed with potable water to remove any surface contamination before any incisions are made. |
| Head and feet removal | <ul style="list-style-type: none"> • Where applicable, heads and feet may be removed at this stage |
| <p>The above activities: intake, slaughter, scalding and de-feathering are considered 'dirty' operations and must be physically separated, i.e. in space/time, from later 'clean' processing activities.</p> <p>NOTE: If any badly bled, bruised, abnormal or emaciated carcasses are identified at this point, they should be removed and disposed of correctly, i.e. in accordance with animal by-products legislation (see Appendix B).</p> | |

| | Important Points to Note |
|-----------------|---|
| Evisceration | <p>Evisceration may be performed in a number of different ways, depending on plant size/ capacity. Evisceration involves the removal of material containing considerable numbers of microorganisms; therefore, contamination can easily occur:</p> <ul style="list-style-type: none"> • If performed, table evisceration should be carried out carefully to prevent cross contamination • Care is needed to avoid carcass contamination or contamination of the operator’s hands • Knives or cutting implements used for evisceration should be cleaned and sterilised before and after use • Equipment and food contact surfaces should be rinsed with potable water and disinfected regularly • Each set of viscera must be removed from the table immediately after evisceration and before commencing activities on the next bird • If a carcass becomes contaminated with faecal material, the carcass, equipment and surfaces should be rinsed with potable water before working on further carcasses • Appropriate facilities should be available in the evisceration room for hand washing and the washing of equipment • Poultry intended to be eviscerated should be eviscerated within 1 hour of slaughter (except where it is the intention to produce New York Dressed (NYD) poultry) <p>NOTE: With poultry dressed in this manner (NYD), there is a risk of faeces leaking from the vent area and contaminating the carcass during storage and transport. There could be a risk of cross contamination in the consumer kitchen/cutting plant where it is likely the poultry will be eviscerated. Therefore, it is not a recommended practice.</p> <p>Efforts must be made to remove any visible contamination on the carcass following evisceration. Each carcass should be checked by the food business operator after evisceration to make sure they are visibly clean.</p> <ul style="list-style-type: none"> • The cavity of all birds should be checked to ensure that the intestinal tract and associated organs have been completely removed. • Grossly contaminated carcasses and other abnormal carcasses unfit for human consumption should be correctly disposed of. <p>By-products not intended for human consumption and meat designated unfit for human consumption must be separated from food as soon as possible and adequately stored and disposed of in accordance with animal by-products regulations (see Appendix B for more details).</p> |
| After slaughter | The internal and external carcass surfaces including body cavities and accompanying offal should be examined. |

| | Important Points to Note |
|-------------------------|---|
| Inspection of carcasses | <ul style="list-style-type: none"> • The carcass should be examined for the following: <ul style="list-style-type: none"> – Abnormal colour/odour – Evidence of any condition or abnormality which may make poultry meat unfit for human consumption – Body condition – Bruising, haemorrhage or discolouration – Adequate bleeding – Orthopedic or muscular abnormalities – General soiling or contamination – Indication of the use of animal remedies • Whole birds unsuitable for further processing should be removed and disposed of. • Offal and carcasses should be correlated. • Poultry meat, carcasses or offal that are grossly contaminated with faecal material, bile, or other surface contaminants, e.g. grease, disinfectants, denatured rubber from the plucking machine, should be rejected as unfit for human consumption. • Carcasses that fall on the floor and into contaminated areas, e.g. evisceration trough, should be rejected as unfit for human consumption. • Localised contamination should be trimmed hygienically. • Areas with broken skin, e.g. from the plucking machine, should be considered contaminated and trimmed. • Minor blemishes such as bruising may be trimmed hygienically by the food business operator following evisceration. • Meat may only be trimmed in certain circumstances, e.g. faecal contamination must be trimmed before chilling to avoid cross contamination in the chill. |
| Final spray washing | <ul style="list-style-type: none"> • Carcasses may be spray washed to remove blood and extraneous matter. |
| Chilling | <ul style="list-style-type: none"> • Meat should be chilled to 4°C or less as soon as possible. • Immersion chilling may be permitted in establishments, subject to a risk assessment by the local authority. • When carcasses are subjected to immersion chilling: <ul style="list-style-type: none"> – Potability of water should be demonstrated with laboratory analysis – Every precaution should be taken to avoid contamination of carcasses; taking into account parameters such as carcass weight, water temperature, volume and direction of water flow and chilling time – Equipment should be emptied, cleaned and disinfected whenever this is necessary and at least once a day |

8. Development of a Food Safety Management System

All food business operators must ensure that the food produced by their business is safe to eat. To achieve this, a food safety management system based on the principles of HACCP must be put in place.

To produce food safely, all the important **food safety hazards** associated with the production of poultry meat must be prevented, eliminated or reduced to an acceptable level. HACCP provides a systematic way of identifying food safety hazards and ensures that they are managed correctly.

Food Safety Hazards

A hazard is a **biological, chemical** or **physical** agent with the potential to cause an adverse health effect.

Implementing a food safety management system based on the principles of HACCP involves identifying and controlling food safety hazards, i.e. biological, chemical or physical.

A food safety hazard may be introduced, increased or controlled at each step in the slaughter of poultry. The following are examples of typical hazards associated with poultry.

- **Biological hazards**, i.e. pathogenic microorganisms:

Important/common pathogens associated with poultry include: *Campylobacter* spp., *Salmonella* spp., *Listeria monocytogenes* spp. **and** pathogenic *E. coli*

Key pathogen sources include poultry, other farm livestock, staff, pests and domestic pets, and the environment

- **Chemical hazards** include antibiotic or veterinary drug residues, cleaning chemicals, agro chemicals, oils and lubricants, environmental contaminants etc
- **Physical hazards** include metal and non-metal foreign bodies, paper, wrapping materials, packaging, glass fragments, etc

The majority of these hazards may be controlled by carrying out good hygiene practices (prerequisite requirements) (as outlined in Section 6). The **prerequisite hygiene requirements**, if implemented correctly, will control the majority of hazards.

There may also be hazards specific to the steps of the poultry slaughter process (see page 22 for typical steps) that will not be controlled solely by prerequisite hygiene requirements.

Controlling these hazards involves:

- Identifying the hazards
- Identifying control measures
- Implementing a monitoring and verification system

Food business operators can comply with requirements to have a HACCP based food safety management by either:

- Using a generic HACCP guide (a specific type of guide to good practice where typical hazards and controls are identified). When such guides are used, the food business operator should examine its own process for the possible presence of additional hazards not covered by the guide
- Developing their own food safety management system by applying the 7 principles of HACCP

Food business operators involved in on-farm poultry slaughter need to make sure that:

- The food safety management system is documented
- Physical, chemical and biological hazards are identified
- Good hygiene practices are implemented in order to control these hazards in a general way
- Procedures identified to control hazards at specific steps in the slaughter process are applied effectively
- Adequate records are kept to show that food safety management procedures:
 - Have been established
 - Are being maintained and monitored
 - Demonstrate that corrective action is taken when necessary
- Records of monitoring, corrective actions and verification should be kept for a minimum of 3 years

FURTHER INFORMATION

For further information on HACCP and HACCP flexibility, refer to the following documents available on the FSAI website (www.fsai.ie):

- Commission guidance: Implementation of procedures based on the HACCP principles, and facilitation of the implementation of the HACCP principles in certain food businesses
- FSAI *Guidance Note No. 11: Assessment of HACCP Compliance* also provides assistance in complying with Article 5 of Regulation (EC) No 852/2004

There is general information on HACCP available in this area on the FSAI website:

http://www.fsai.ie/food_businesses/haccp/haccp.html

9. Training

All food handlers, including seasonal staff, are required to be adequately trained/instructed in food hygiene matters to the appropriate level. In addition, it is important to supervise staff to ensure that they implement what they have been instructed/trained to do.

Training could involve the following:

For staff:

- Basic relevant instructions given to staff before commencing work
- Verbal/written instructions should be given as required on topics such as:
 - Personal hygiene
 - Cleaning
 - The avoidance of cross contamination by adhering to work flow plans
 - Evisceration in a hygienic manner
 - Other topics as deemed appropriate

For the food business operator:

- Specific training courses for the food business operator may be available in the area of small scale poultry slaughter
- The local authority veterinary service can provide guidance on what training is considered adequate for each particular food business

FURTHER INFORMATION

Food business operators will need sufficient knowledge of food safety to be able to identify and control the hazards associated with their business.

For further information on training, refer to the FSAI publications *Guide to Food Safety Training, Level 1 Induction Skills, Level 2 Additional Skills* and *Level 3 Food Safety Skills for Management*

10. Labelling

The fundamental rule of labelling is that consumers must not be misled. Information on a label must be:

- Clear and accurate
- Legible and easy to understand
- In English (it can be labelled in other languages in addition to English)

Foods for sale must comply with the **general labelling requirements** outlined in Directive 2000/13/EC which is transposed by S.I. No. 483 of 2002.

Pre-packaged Poultry Meat

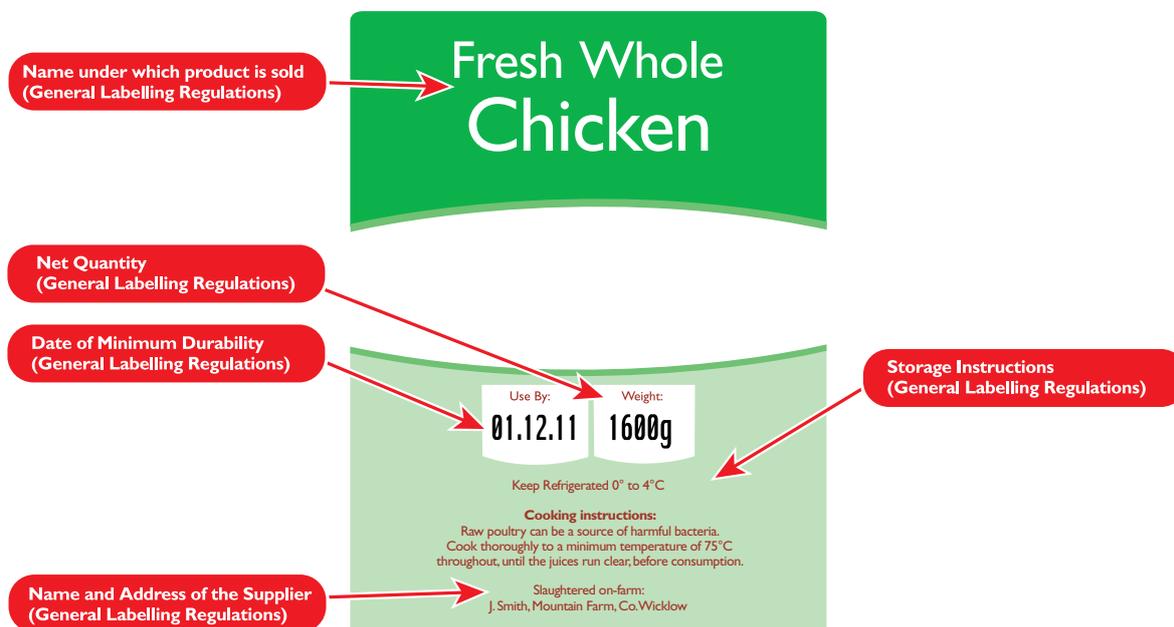
The following information must appear on the packaging of pre-packaged poultry meat or on the attached label:

- The name under which the product is sold, e.g. fresh whole chicken
- List of ingredients, if applicable
- The net quantity, e.g. weight in kgs
- The date of minimum durability ('use-by' date)
- Any special instructions or conditions of use, e.g. keep refrigerated 0 – 4°C
- The name and address of the manufacturer, packager or seller within the EU (name and address of the farmer and farm on which the bird was slaughtered)
- Place of origin of the foodstuff if its absence might mislead the consumer
- Instructions for use, e.g. cooking instructions

NOTE

Poultry meat, in general, is required to have extra information on the label in addition to the general labeling requirements (such as class, or price per unit weight).

This extra additional information **is not** required for poultry produced in a registered poultry slaughterhouse.

Sample Label: Pre-packaged poultry from on-farm poultry slaughter establishments**Loose Poultry Meat**

Products sold loose only need the name of the food, e.g. fresh whole chicken, displayed. This information must appear on the labelling or on a notice displayed in a prominent position near the point-of-sale.

Sample Label: Chicken sold loose in farm shop**Packaging**

There are specific rules for food contact materials, e.g. packaging, containers, utensils etc. Only materials which comply with these rules should be used.

FURTHER INFORMATION

For further information on labelling, refer to the FSAI publication *Guidance Note No. 17 - The Labelling of Meat*

Appendix A. Animal Welfare

It is a legal requirement that all necessary care is taken during movement, lairaging, restraint, stunning, slaughter or killing of an animal to ensure the animal is spared avoidable pain, injury, excitement or suffering.

It is also a requirement to restrain, stun and bleed the animal in on-farm slaughter:

| | |
|-----------|---|
| Restraint | <p>Restraint must be in an appropriate manner. Methods of restraint could include manual restraint, killing cones or shackles.</p> <ul style="list-style-type: none"> • If used, cones should be the correct size and the birds wings should be folded down before the bird's insertion into the cone to avoid wings flapping or backing out of the cone. • Birds should not be suspended for a lengthy period (maximum of 3 minutes for chickens and 6 minutes for turkeys). • Birds will flap and become excited once shackled or hung. They should be given some time to settle before stunning. As a guide, broilers will need 12 seconds to settle while turkeys will require 20 seconds. |
| Stunning | <p>Stunning must be carried out using a permitted method. Some methods of stunning, e.g. neck dislocation are subject to official veterinary authorisation.</p> <p>Neck dislocation:</p> <ul style="list-style-type: none"> • Must be carried out by a qualified person (who has received sufficient training/instruction) who must ensure that necessary care is taken to avoid pain etc. • Is only suitable for the killing of a small number of birds where alternative methods are not available. • Is only recommended for birds under 5kg. <p>Signs of an effective kill include a palpable gap in the vertebrae and loss of the nictitans membrane reflex.</p> <p>Future legislation will limit neck dislocation to no more than 70 birds per day and birds greater than 5kg weight will require stunning by an alternative method to neck dislocation.</p> <p>Apart from the legal and welfare requirements for stunning, there are other reasons why pre-slaughter stunning is a good practice, e.g. better bleed out (an un-stunned bird will struggle, its organs will continue to use blood leading to poorer bleed out) and relaxation of the feathers which leads to easier plucking and possibly less carcass contamination.</p> |

| | |
|---------------------|---|
| Stunning (cont') | <p>The signs of an effective stun are:</p> <ul style="list-style-type: none"> • No rhythmic breathing • Completely limp carcass • Loss of the nictitating membrane (third eyelid) reflex • Dilated pupils <p>For electronarcosis, either a water bath or electrodes, e.g. a hand held electric stunner, can be used.</p> <p>The signs of an effective electrical stun (electroplectic fit) are:</p> <ul style="list-style-type: none"> • Neck arched with head held vertically • No rhythmic breathing (observe the vent region if the bird is suspended) • Rigidly extended legs • Constant, rapid body tremors • Absence of a third eyelid (nictitating membrane) reflex • Wings held tightly against body <p>The hand held stunner must be applied individually; good contact should be maintained between the stunner and the bird's head so that the current is delivered across the bird's brain. The bird's head must be kept still during stunning.</p> <p>The stunning equipment should be in good working order with appropriate methods of back up available in case of equipment failure.</p> |
| Bleeding | <p>Poultry must be bled immediately following slaughter and always before the animal has regained consciousness. This should take place a maximum of 15 seconds post stunning.</p> <p>The most common method involves a deep cut to the carotid arteries and jugular veins on both sides of the neck.</p> <p>It takes 1½ to 3 minutes to fully bleed out poultry, depending on their size and weight. During this time, no further dressing procedures should be carried out to allow for maximum blood drainage. The bird must be allowed to bleed out before further dressing operations are carried out.</p> |

FURTHER INFORMATION

For further information on animal welfare, refer to:

Humane Slaughter Association website: <http://www.hsa.org.uk/index.htm>

Practical Slaughter of Poultry – A guide for the small producer 2nd edition HSA & CJA 2001. ISBN 1871 561 16 7- from the Humane Slaughter Association.

Humane Slaughter Association's Technical Guidance Note 15 Poultry Catching and Handling available from: http://www.hsa.org.uk/Resources/Publications/Technical%20Notes/TN15_poultry%20handling.pdf

Appendix B. Animal By-Products

A designated area should be provided for waste materials to be stored for collection or disposal. This area should be physically separated from the food storage or preparation areas.

A typical broiler carcass yield is approximately 65% of liveweight. This means that approximately 35% of the liveweight of poultry comprises of feathers, blood, viscera, feet, head and trim (collectively known as animal by-products (ABP)) which must be disposed of correctly.

The quantity of by-products produced, e.g. from standard sized broilers in premises with the following throughputs would be:

| Throughput | Amount of ABP produced |
|---------------|------------------------|
| 50 birds/day | 30 kg/day |
| 200 birds/day | 120 kg/day |

By-products not intended for human consumption and meat designated unfit for human consumption must be separated from food as soon as possible and adequately stored and disposed of in accordance with Regulation (EC) No 1069/2009.

By-product material should be handled and disposed of in accordance with legislative requirements. It should follow marked routes in the plant and be contained appropriately.

This containment includes:

- Drains
- Bins: If bins are reusable, they must be cleaned, washed and disinfected after each use and must be dedicated carrying only one category of animal by-product to avoid cross contamination
- Bags
- Skips
- Waste materials should not be left on the floors, swept into a corner or piled outside. Such practice is unhygienic and attracts vermin, wild birds and other wildlife

There are 3 categories of animal by-products described below:

| Throughput | Amount of ABP produced |
|------------|---|
| Category 1 | These animal by-products would not be generated in an on-farm poultry slaughterhouse. |
| Category 2 | <p>This includes, among other things, birds that have died other than being slaughtered for human consumption.</p> <p>Material must be placed in a covered, leak proof container marked Category 2 – not for animal consumption and accompanied by a properly completed commercial document or, where appropriate, health certificate.</p> <p>It must be dispatched to an approved Category 1 or Category 2 facility.</p> |
| Category 3 | <p>Consists of animal by-products from poultry and lagomorphs slaughtered on the farm which did not show any signs of disease communicable to humans or animals.</p> <p>The majority of animal by-products generated in an on-farm poultry slaughterhouse would be expected to fall into this category and will include, among other things, heads, feet, feathers, blood and viscera.</p> <p>Material must be placed in a covered, leak proof container labelled Category 3 – not for human consumption and accompanied by a properly completed commercial document or, where appropriate, a health certificate.</p> <p>It must be dispatched to an approved Category 1, Category 2 or Category 3 facility.</p> |

Animal by-products (ABP) may only be transported in a vehicle by a registered haulier. The Department of Agriculture, Food and the Marine maintains a register of all transporters of ABP. Copies of commercial documents relating to ABP must be maintained for 2 years.

In some cases, ABP may be fed to certain categories of animals² not intended for human consumption, e.g. dogs from a hunting kennel. A meat feeding licence from the Department of Agriculture, Food and the Marine is required for this activity. If ABP is sold or supplied for feeding to animals, a meat seller's licence is required. The ABP must be processed at an authorised collection center before this feeding can take place.

² Zoo animals, circus animals, reptiles and birds of prey other than zoo or circus animals, fur animals, wild animals (the meat of which is not destined for human consumption), dogs from recognised kennels (kennels recognised by a national body/organisation) or packs of hounds (two or more hunting hounds kept for hunting or two or more greyhounds kept by one owner), maggots for fishing bait.

Appendix C. Legislative Requirements Checklist

| Registration/Approval Requirement | Yes/No |
|---|---------------|
| Is the food business registered (or approved, if necessary?) | |
| Traceability Requirements | Yes/No |
| Is there an effective traceability system in place? | |
| Is the food business in a position to recall unsafe food when required? | |
| Hygiene Prerequisites Requirements | Yes/No |
| Are the walls, floors, doors, ceilings, and other surfaces and equipment in sound condition, easy to clean and constructed of impervious, non-toxic, non-absorbent, washable materials? | |
| Is there sufficient space to operate hygienically? | |
| Does the premises layout allow for 'clean' and 'dirty' operations to be kept separate? | |
| Is the premises pest-proof (rodent, insect, and other pests?) | |
| Is there refrigerated space to store processed poultry? | |
| Are there flush lavatories that do not open directly into rooms where food is handled? | |
| Are there handwash facilities with hot and cold running water? | |
| Are there adequate staff changing facilities? | |
| Are floors suitably drained? | |
| Is waste water ducted correctly so that it does not flow directly across floors? | |
| Are there adequate drainage facilities? | |
| Is there sufficient lighting? | |
| Is there sufficient ventilation and are rooms free from condensation? | |
| Is the establishment and equipment clean and is there regular cleaning and disinfection of the establishment and equipment? | |
| Is there a storage area for equipment, cleaning products, disinfectants and sanitisers that is separate from food areas? | |
| Is there an adequate supply of potable water? | |
| Is there adequate collection and storage of waste and animal by-products? | |
| Are there arrangements in place for the correct disposal of waste and animal by-products? | |
| Are all vehicles that transport poultry meat clean and where necessary, refrigerated? | |
| Is there adequate staff personal hygiene? | |

| | |
|--|---------------|
| Slaughter Hygiene Requirement | Yes/No |
| Does slaughter of poultry take place in a hygienic manner giving due regard for animal welfare? | |
| Development of a Food Safety Management System Requirement | Yes/No |
| Is a food safety management system in place that has identified food safety hazards and put measures in place to deal with them? | |
| Training Requirement | Yes/No |
| Have all personnel completed sufficient food safety training appropriate to their responsibilities within the food business? | |
| Labelling Requirement | Yes/No |
| Is the poultry meat produced in the on-farm poultry slaughter establishment labelled correctly? | |
| Animal Welfare and Animal by-Products Requirement | Yes/No |
| Are animal welfare and animal by-product requirements being adhered to? | |

Appendix D. Definitions

Approval: In general, if a food business handles and/or processes foods of animal origin, approval under Regulation (EC) No 853/2004 from the appropriate competent authority is required. However, the regulation exempts the need for approval in the case of on-farm poultry slaughter establishments supplying small quantities of poultry directly to the final consumer or to local establishments, provided there is adherence to certain criteria.

Birds: In this context, means farmed poultry within the meaning of the definition 'poultry'.

Cross contamination: The transfer of micro-organism from a source to the food.

Final consumer: Means the ultimate consumer of a foodstuff who will not use the food as part of any food business operation or activity.

Gambrel: A metal frame for hanging a carcass by its legs.

Local retail establishments: Within 100km of the farm (as the crow flies).

Meat: Means the edible parts of the animal including blood.

New York dressed poultry: This refers to poultry sold uneviscerated and sometimes with the head and feet attached.

On the farm: Slaughter of birds at a suitable establishment on the holding where they are grown and finished but not necessarily hatched, where that holding **is the primary production holding**.

Pre-packaged foodstuff: Means any single item for presentation as such to the ultimate consumer and to mass caterers, consisting of a foodstuff and the packaging into which it was put before being offered for sale, whether such packaging encloses the foodstuff completely or only partially but in any case in such a way that the contents cannot be altered without opening or changing the packaging.

Prerequisites: Hygiene practices and procedures required prior to and during the implementation and ongoing operation of a HACCP system, e.g. premises, equipment, staff training, pest control, waste management.

Poultry: Means farmed birds, including birds that are not considered as domestic but which are farmed as domestic animals with the exception of ratites (flightless birds). In Ireland, this most commonly involves broiler (chicken), goose, turkey and duck production. This definition does not include ostrich or ostrich-like birds.

Primary production: The production, rearing or growing of primary products including harvesting, milking and farmed animal production prior to slaughter. It also includes hunting and fishing and the harvesting of wild products.

Register: A local authority is required to maintain a register of all low throughput poultry slaughtering establishments within its area of responsibility.

Retail: Means the handling and/or processing of food and its storage at the point-of-sale or delivery to the final consumer. This includes distribution terminals, catering establishments, factory canteens, institutional catering, restaurants and other similar food service establishments, shops, supermarket distribution centres and wholesale outlets.

Small quantities: These are defined in the European Communities (Food and Feed Hygiene) Regulations, 2009 (S.I. No. 432 of 2009) as:

- Less than 10,000 birds slaughtered per year
- Less than 1,000 birds slaughtered in any given week

This will allow an average production of up to 200 birds per week with occasional weeks of higher production up to 1,000 birds in any single week, e.g. at Christmas time.

Appendix E. List of Local Authorities

| County | Address | Phone | Email |
|--------------------------------|---|-------------|-------------------------------|
| Carlow County Council | County Offices, Athy Road, Carlow | 059 9170300 | secratar@carlowcoco.ie |
| Cavan County Council | Courthouse, FarnhamStreet, Cavan | 049 4378300 | info@cavancoco.ie |
| Clare County Council | New Road, Ennis, Co Clare | 065 6821616 | secratar@clarecoco.ie |
| Cork County Council | County Hall, Carrigrohane Road, Cork | 021 4276891 | cosec@corkcoco.ie |
| Donegal County Council | Neil T, Blaney Road, Letterkenny | 074 9194200 | letterkennypsc@donegalcoco.ie |
| Galway County Council | County Buildings, Prospect Hill, Galway | 091 509000 | secretary@galwaycoco.ie |
| Kerry County Council | Aras An Chontae, Rathas, Tralee | 066 7183500 | kcc@kerrycoco.ie |
| Kildare County Council | Aras Chill Dara, Devoy Park, Naas, Co Kildare | 045 980200 | secretar@kildarecoco.ie |
| Kilkenny County Council | County Hall, John's Street, Kilkenny | 056 7794000 | secretar@kilkennycoco.ie |
| Laois County Council | County Hall, Portlaoise, Co Laois | 057 8664000 | webans@laoiscoco.ie |
| Leitrim County Council | Courthouse, Carrick-on-Shannon, County Leitrim | 071 9620005 | secretar@leitrimcoco.ie |
| Limerick County Council | County Hall, Dooradoyle, Limerick | 061 49600 | |
| Longford County Council | County Secretary's Office, Great Water Street, Longford | 043 46231 | enterpricse@tinet.ie |
| Louth County Council | Millennium Centre, St.Alphonsus Road, Dundalk | 042 9335457 | info@louthcoco.ie |
| Mayo County Council | Aras An Chontae, The Mall, Castlebar | 094 9024444 | |
| Meath County Council | County Hall, Navan, Co Meath | 046 9097000 | info@meathcoco.ie |
| Monaghan County Council | County Office, The Glen, Monaghan | 047 30500 | info@monaghancoco.ie |
| North Tipperary County Council | Courthouse, Nenagh | 067 31771 | secretary@northtippcoco.ie |
| Offaly County Council | Courthouse, Tullamore | 05793 46800 | cosecretary@offaly.ie |
| Roscommon County Council | Courthouse, Roscommon | 0906637100 | info@roscommoncoco.ie |
| Sligo County Council | Riverside, Sligo | 071 9111111 | info@sligococo.ie |
| South Dublin County Council | Town Centre, Tallaght, Dublin 24 | 01 414 9000 | cccounter@sdublincoco.ie |
| South Tipperary County Council | County Hall, Emmet Street, Clonmel | 05234455 | info@southtippcoco.ie |
| Waterford County Council | Waterford County Civic Offices, Dungarvan | 058 22000 | ccordicnate@waterfordcoco.ie |
| Westmeath County Council | County Buildings, Mullingar | 044 9332000 | |
| Wexford County Council | County Hall, Wexford | 053 9176618 | info@wexfordcoco.ie |
| Wicklow County Council | County Buildings, Wicklow | 0404 20100 | cosec@wicklowcoco.ie |



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