



REPUBLIC OF SERBIA
MINISTRY OF AGRICULTURE, FORESTRY AND WATER MANAGEMENT
VETERINARY DIRECTORATE

GUIDE

FOR ON-FARM SLAUGHTERING OF SMALL QUANTITIES OF POULTRY AND LAGOMORPHS

National measures for exemptions from
specific conditions of food hygiene





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FIRST EDITION

Belgrade, 2017

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This Guide was prepared by the Ministry of Agriculture, Forestry and Water Management of the Republic of Serbia in cooperation with the Food and Agriculture Organization of the United Nations (FAO) and implemented by the Center for Rural Development and Agriculture "Agrikultura".

The content, design and printing of the Guide were carried out as part of the project "Improving Food Quality and Safety Standards in Serbia's Meat Sector". The project promotes a more efficient and integrated food production chain in the Republic of Serbia and the improvement of quality and safety measures in the production and processing within the meat sector. The project is part of the support and cooperation provided by the European Bank for Reconstruction and Development (EBRD), co-financed by the Grand Duchy of Luxembourg, and was implemented between April 2015 - December 2017.

Serbian food hygiene legislation now permits the on-farm slaughtering of small quantities of poultry and lagomorphs to be excluded from the scope of regulations on specific hygiene conditions of food of animal origin. However, appropriate conditions for on-farm slaughter facilities or poultry and lagomorphs shall be provided. In addition, the producer has the right to supply small quantities of meat from poultry and lagomorphs slaughtered on-farm directly to the final consumer, or local retail establishments directly supplying such meat to the final consumer.

The Law on Food Safety¹ establishes the legal framework for the *Rulebook on small quantities of primary products supplied directly to the final consumer, activities and derogations related to small food businesses operating with food of animal origin*² and specifies the necessary requirements for performing these activities as well as the exemptions related to small food business operators. These include the hygiene requirements and exemptions for the construction, layout and equipment of facilities for slaughter of small quantities of poultry and lagomorphs on-farm.

Food business operators are not obliged to follow the advice prescribed in this Guide, as other ways of achieving compliance with the requirements of current legislation on food hygiene and safety may be equally valid.

This Guide is an evolving document and will be periodically updated to take into account the experiences and information from scientific bodies, competent authorities and food business operators.

To improve the quality and effectiveness of future editions, all critical analysis, comments and suggestions are welcome.

¹ Official Gazette of the Republic of Serbia, No. 41/09

² Official Gazette of the Republic of Serbia, No. 111/17

PREFACE

What is the objective and purpose of the Guide?

The primary objective of this Guide is to provide information and support to food businesses involved in slaughtering of small quantities of poultry and lagomorphs on-farm. It also offers guidance on how to comply with the requirements through the explanations and recommendations of good production and hygiene practices. Information provided by this Guide should always be used together with the requirements, since compliance is the responsibility of each food business operator.

The Guide cannot replace any of the current laws and regulations governing the production, processing and distribution of food, but should provide an understanding of the way in which regulations should be addressed and how unique criteria could be applied. However, this document does not include explanations of all the provisions of the legislation on food hygiene and safety, but only the most important requirements whose appropriate application can ensure good hygiene, as well as the safety of the meat from poultry and lagomorphs slaughtered on-farm. For special requirements, the producer should seek the interpretation from the competent authority of the implemented legislation.

Operators can use this Guide as a source of information to establish their internal food safety system and control plan. The Guide cannot be used instead of the HACCP plan, but it can serve for better understanding of the way in which the internal control plan is developed and implemented, taking into account the risk assessment.

Who can use this Guide?

This Guide is intended for food operators slaughtering small quantities of poultry and lagomorphs and supplying local consumers and retail establishments. However, other interested parties may also use the Guide.

The Guide should also be considered a source of information where the competent authority (veterinary inspection) can find the minimum information on certain requirements needed when performing official controls in food establishments, and assessing compliance with the general and special requirements for food hygiene, as well as the results of the operator's internal control program.

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ACRONYMS AND ABBREVIATIONS

FBO	Food Business Operator
HACCP	Hazard Analysis and Critical Control Points
GMP	Good Manufacturing Practice
GHP	Good Hygiene Practice
SOP	Standard Operating Procedure
CCP	Critical Control Points

GLOSSARY

The terms used in this Guide have the following meaning:

- **animal raised on the farm** means an animal that producer rears directly on his/her own farm from the moment of its birth or hatching, i.e. animals: pigs, cattle, sheep and goats not less than three months, poultry at least three weeks, the rabbits for at least four weeks;
- **competent authority** means authority competent for veterinary affairs
- **final consumer** means the ultimate consumer of a foodstuff who will not use the food as part of any food business operation or activity;
- **local market** means the area of municipality where the holding is situated and in the adjoining municipalities where producer may put food on the market;
- **local retail establishment** means the establishment dealing with the distribution of food in municipality and in the adjoining municipalities in relation to the site of the holding;
- **local sale by home delivery** means the "door to door" sale in the municipality where the production establishment of producer is located or in the adjoining municipalities;
- **provision of catering services in handicraft activities or on the agritourist household** (hereinafter referred to as: the domestic table) means the services that are associated with rural, scattered farms or rural food or culinary tradition and offering food on the site of the holding in accordance with the Law on tourism
- **retail** means the handling and/or processing, preparation and storage of food at the point of sale or delivery to the final consumer, and includes green markets, shops, supermarkets, institutional catering (canteen, club, public institution, school, hospital, kindergaten) distribution terminals, catering operations, restaurants and other similar food service operations, as well as vehicle or a fixed or mobile stalls and vending machines;
- **site of the holding** means the farmyard or producer's manufacturing place of small quantities of food of animal origin;

- **slaughter on the holding/on-farm** means slaughter of poultry and lagomorphs in appropriate establishment on the holding where the poultry/lagomorphs are raised until the slaughter day (not necessarily hatched on that farm) and where that holding is considered as primary production holding;
- **small quantities of poultry and lagomorphs** means quantities that the producer may directly sell or supply to the final consumer, or to the local retail establishments which will supply it to the final consumer;

REGULATORY FRAMEWORK

The following regulations shall apply to the establishments and activities for slaughtering poultry and lagomorphs on-farm:

- Law on Food Safety (Official Gazette of the Republic of Serbia, No. 41/09);
- Law on Veterinary Matters (Official Gazette of the Republic of Serbia, No. 91/05, 30/10, 93/12);
- Law on Animal Welfare (Official Gazette of the Republic of Serbia, No. 41/09);
- Rulebook on food hygiene conditions (Official Gazette of the Republic of Serbia, No. 73/10);
- Rulebook on small quantities of primary products supplied directly to the final consumer, areas for performing these activities and derogations related to small businesses operating with food of animal origin (Official Gazette of the Republic of Serbia, No. 111/17);
- Rulebook on the quality of drinking water (Official Gazette of the FRY, No. 42/98, 44/99);
- Rulebook on general and specific food hygiene requirements in any phase of food production, processing and trade (Official Gazette of the Republic of Serbia, No. 72/2010);
- Regulation on requirements and means for killing the animals, procedure of animal treatment prior to slaughtering, animal stunning and bleeding procedure, conditions and procedure of animal slaughtering without prior stunning, and program of training on animal welfare during slaughtering (Official Gazette of the Republic of Serbia, No. 14/10);
- Rulebook on establishing of measures for early detection, diagnostics, prevention of spreading, suppression and eradication of poultry infections caused by specific salmonella serotypes (Official Gazette of the Republic of Serbia, No. 7/10, 76/10).

The following regulations are not applied to the facility and activity of slaughtering of small quantities of poultry and lagomorphs on-farm:

- Rulebook on veterinary-sanitary requirements and general and specific conditions of

hygiene of food of animal origin, as well as on the conditions of hygiene of food of animal origin (OG RS No. 25/2011, 27/14);

- Rulebook on the quality of poultry meat (Official Gazette of the SFRY, No. 1/81, 51/88);
- Rulebook on labeling, marking and advertising of food (Official Gazette of the Republic of Serbia, No. 19/17).

THE ON-FARM SLAUGHTER OF SMALL QUANTITIES OF POULTRY AND LAGOMORPHS

Operator's responsibility for food safety

The small food business operator (hereinafter referred to as “the producer”) involved in the slaughtering of poultry and lagomorphs and directly supplying final consumers or the local retail facilities directly supplying final consumers, is obliged to ensure the proper application of the food safety regulations stipulated by the food safety law, and to ensure that the food produced and placed on the market is safe. The producer is obliged to provide and keep data on the origin, i.e. traceability of animals that are slaughtered, sold or delivered, as well as to perform internal controls and to keep appropriate records required by the special regulations.

Approval of establishment

The on-farm slaughter facility from which the producer directly supplies final consumers, or local retail facilities that supply final consumers, must meet the requirements of the *Rulebook on food hygiene conditions*³ and also the provisions of the *Rulebook on small quantities of primary products supplied directly to the final consumer, areas for performing these activities and derogations related to small businesses operating with food of animal origin*.⁴

The facility for slaughtering poultry and lagomorphs on the holding shall be approved in accordance with the procedure stipulated in special regulation governing veterinary matters.

Small quantities of poultry and lagomorphs

Small quantities of poultry and lagomorphs that can be slaughtered in establishments on the holding:

³ Official Gazette of the Republic of Serbia, No. 73/10

⁴ Official Gazette of the Republic of Serbia, No. 111/17

Activity	Quantity*	
	Weekly (max)**	Annually (max)**
Slaughter and sell poultry meat – broilers (pcs.)	100	5.000
Slaughter and sell poultry meat – geese, ducks and turkeys (pcs.)	20	1.000
Slaughter and sell lagomorphs (pcs.)	20	1.000

* Producer may raise poultry and lagomorphs in larger numbers from quantities that are to be slaughtered and sold directly or delivered to final consumers and/or local retail establishments that directly supply final users.

** If business needs require the slaughter of the maximum annual quantities of animals in accordance with the dynamics of primary production or according to seasonal/festive or other needs of the local market, then the weekly maximum quantity cannot be more than 200 pieces of slaughtered broilers or 40 pieces of other categories/species of poultry or lagomorphs. In this case, the producer must provide adequate capacities.

Area and places of direct sale

Small quantities of poultry and lagomorphs slaughtered in a slaughterhouse on the holding, can be sold directly to:

- **final consumers** - at the site of the holding (at the farm's gate), or through the domestic table service and/or on the local green market (within the municipality and in the adjoining municipalities in relation to the site of the holding), or
- **local retail establishments** directly supplying final consumers in the municipality and in the adjoining municipalities in relation to the site of the holding.

The area for advertising, marketing and promotion of the farm engaged in the slaughtering of poultry and lagomorphs on the holding and related activities and services, is not limited.

If the operator's business activities go beyond the limits set out in the *Rulebook on small quantities of primary products supplied directly to the final consumer, areas for performing these activities and derogations related to small businesses operating with food of animal origin*⁵ such as: the origin of the animals (the producer has not raised the animals on his

⁵ Official Gazette of the Republic of Serbia, No. 111/17

own farm), the quantity and the area/place of sale, etc - the competent authority is authorized to undertake the measures in accordance with the regulations governing food safety and veterinary matters.

HYGIENE CONDITIONS IN ESTABLISHMENTS ENGAGED IN SLAUGHTERING OF SMALL QUANTITIES OF POULTRY AND LAGOMORPHS

Prerequisite Programs

"Prerequisite Programs" are all the requirements and procedures necessary for appropriate conditions and controls in the working environment in order to produce safe food.

Prerequisite programs are clearly defined in food hygiene regulations, and the main goal of their implementation is to reduce the risk of potential hazards becoming serious threats to food safety.

Prerequisite Programs are Good Manufacturing Practice (GMP), Good Hygiene Practice (GHP) and Standard Operational Procedures (SOPs).

Prerequisite programs contain principles that should be applied in the same way by all operators that produce, process and sell food on the market. GMP and GHP are not specific to individual manufacturers from the same business context (e.g. slaughterhouse). In contrast, the HACCP plan of a producer is specific to the process and to the product.

Producers in establishments slaughtering poultry and lagomorphs should apply good practices pertaining to facilities, equipment, working procedures, general and personal hygiene.

The application of regulatory requirements and good manufacturing and hygiene practices ensure product safety, consumer confidence and successful business.

Location

The facility for slaughtering poultry and lagomorphs can be constructed at the location of the farm for which the approval of the local self-government authorities has been obtained.

The part of the farmyard located next to the production establishment should be separated from the facilities for raising and keeping animals, from the space where waste material is kept or the manure pit is placed and from collecting trenches and/or open drains. All necessary

preventive measures should be taken to reduce the risk of contamination from the environment (e.g. from neighboring yards).

Part of the yard used for activities related to the production and distribution of food, should be separated by a fence/wall from the part of the yard where the main and auxiliary facilities intended for the primary production are located. If necessary, fencing should enable the passage of people and vehicles and access to all parts of the holding.

Surfaces needed for the movement of people and vehicles around the production facility should be of solid material (e.g. concrete, asphalt, etc.).

Implementation of General Hygiene Requirements

Requirement	Good practice
<p>Floors, walls, ceilings, windows, doors:</p> <ul style="list-style-type: none">- constructed of impervious, non-toxic, non-absorbent and washable materials- in sound condition- easy to clean/wash and disinfect (as necessary)	<p>Floors:</p> <ul style="list-style-type: none">▶ Solid, wear-resistant materials that can be cleaned, washed and disinfected are preferred, e.g. tiles, appropriate coatings for concrete, epoxy resins or other materials which the operator can demonstrate to the competent authority to be appropriate (meet the requirements);<ul style="list-style-type: none">• Earth, wood or bricks are not acceptable flooring materials in a poultry slaughterhouse,• Slippery materials should be avoided;▶ To maintain in good condition (damages and cracks repaired), so that it can be kept clean;<ul style="list-style-type: none">• Worn and damaged surfaces and cracks are not acceptable!▶ To have an adequate slope towards drains;<ul style="list-style-type: none">• Dents and water retaining areas are not acceptable (care is required when carrying out work/repair on floor surfaces);

Requirement

Good practice

Floors, walls, ceilings, windows, doors:

- constructed of impervious, non-toxic, non-absorbent and washable materials

- in sound condition

- easy to clean/wash and disinfect (as necessary)

Walls:

- ▶ To be made of easy to clean, washable and, where necessary, to disinfect surfaces (smooth, impervious), such as e.g. - tiles, panels with a plastic or stainless steel coating, concrete coated with epoxy resins or waterproof paint or other materials. The operator must prove to the competent authority that the material used meets the requirements;
- ▶ Smooth surfaces must be of sufficient height, because of the risk of splash/soil, or of height that enables easy cleaning.
 - A minimum height of 1.8 m or up to the ceiling height is recommended;
- ▶ Maintained in good condition (damages and cracks repaired), so that it can be kept clean:
 - Cracked, damaged and worn-out surfaces of walls are not acceptable,
 - Materials for the outer surfaces that are difficult to clean or that are not moisture resistant should be avoided,
 - Materials that are friable or that peel easily (e.g. an ordinary paint, plaster, peeling laminates or damaged surfaces) may cause contamination and increase maintenance costs over time,
 - Suitable coatings/paints can be used to prevent/reduce mold formation;

Ceilings (or where there is no ceiling, the interior surface of the roof):

- ▶ Appropriate ceiling surfaces are those that are durable, can be cleaned and are resistant to the working environment, e.g. plastic coatings, concrete coatings, etc.);
- ▶ Materials used should prevent/reduce condensation and growth of mold;
- ▶ Materials used or their external protection should be smooth and impervious:
 - Polystyrene ceiling tiles are not suitable for ceilings in food handling premises;
- ▶ Ceilings and overhead fixtures must be kept in good condition and regularly cleaned to prevent the risk of contamination of the product by accumulated impurities or shedding of particles (e.g. old paint, mortar, corrosion particles, fibers, surfaces that are peeled or leaked); poorly built and treated areas increase maintenance costs over time;

Requirement

Good practice

Floors, walls, ceilings, windows, doors:

- constructed of impervious, non-toxic, non-absorbent and washable materials
- in sound condition
- easy to clean/wash and disinfect (as necessary)

Windows:

- ▶ Materials used or the external protection of the window frames should be smooth and impervious and enable maintenance and cleaning, and be made and placed in such a way as to prevent the accumulation of dirt:
 - Constructions/frames can be made of wood, but should be protected with a waterproof coating material (e.g. plastic linings);
- ▶ Windows/frames must be maintained in good condition;
- ▶ Windows that open to the outside environment are to be fitted with insect-proof screens which can be easily removed for cleaning and maintenance;
- ▶ Where open windows would result in contamination or endanger the temperature conditions, windows should remain closed and fixed during production;

Doors:

- ▶ Doors should be of the appropriate width and height to enable easy movement of employees and in accordance with the needs of handling food and equipment;
- ▶ Materials used should be smooth and impervious and enable easy cleaning and, if necessary, disinfection:
 - Door construction may be of wood, but the outer surfaces should be protected with a waterproof coating/paint or material (e.g. plastic linings),
 - Parts of wooden doors that are exposed to the impact of water and/or can be easily damaged, should be protected with stainless steel linings;
- ▶ Doors located in areas with higher temperature differences, i.e. in rooms requiring a certain temperature regime (e.g. cooling), should have adequate thermal insulation;
- ▶ The outer door must be fitted so as to protect the premises from pests and the outside influences:
 - Checking the quality of the door closing: If the outside light around the closed door is visible from the inside (any edge between the wing and the door frame), appropriate repair is required, for example, rubber strips or other repairs,
 - When external doors are frequently used, additional measures can be used to reduce the environmental impact and prevent the entry of pests (e.g. automatic closing mechanisms, air curtains),
 - Doors are not necessary if there is a need for frequent passage between premises in the same temperature regime, where there is no risk or if there is only a minimal risk of contamination of food;

Requirement

Good practice

Equipment and food contact surfaces

- ▶ Surface in areas where food is handled, including the surfaces of equipment that come in contact with food must be:
 - made of suitable materials, e.g. non-toxic, smooth, washable and corrosion resistant,
 - in good condition, and
 - easy to clean/wash and, where necessary, disinfect;
- Recommended materials include:
 - stainless steel (preferred),
 - plastics, allowed for use in the food industry,
 - other materials resistant to corrosion;
- Wood and corroding materials are not recommended, as they can be easily damaged and are difficult to clean and disinfect;
- ▶ Old equipment, which is no longer used, should be removed from production premises;
- ▶ Old equipment should not be used if:
 - it cannot be cleaned,
 - if there is a possibility of foreign body contamination (physical hazard),
 - it is no longer functional;
- Repaired equipment - working surfaces must have welded joints that are smooth, free of screws and rough areas in order to be well cleaned and disinfected;
- ▶ Equipment must be movable or must be mounted/fixed so that it does not limit its proper cleaning and disinfection;

NOTE: The type and equipment characteristics vary depending on the species of animals, capacity and size of the premises.

Sufficient ventilation

Premises without condensation

- ▶ Good ventilation (air exchange) should be provided to reduce air contamination of food (e.g. preventing the formation of water drops), to prevent the increase of temperature and humidity of the environment/space and suppressing of unpleasant odors that can adversely affect the wholesomeness of food;
- ▶ Good ventilation is also needed in the toilets (to prevent the flow of unpleasant odors to the food handling rooms) and wardrobes;
- ▶ The ventilation solution should allow the entry of clean air and prevent the entry of contaminants and pests, as well as prevent the air flowing from unclean / contaminated into the clean spaces of the facility;
- ▶ Individual situation/infrastructure of the building must be taken into account:
 - Natural ventilation is usually sufficient for smaller premises, but artificial/mechanical airflow can be used,
 - Temperature fluctuations should be avoided;

Requirement

Good practice

Sufficient natural or artificial lighting

- ▶ Lighting can be artificial, natural or a combination of both
- ▶ All parts of the food handling premises require adequate lighting intensity that allows:
 - inspection of products, procedures and hygiene conditions,
 - cleaning/sanitation,
 - safe working conditions for employees,
 - working operations and activities;
- ▶ Sources of artificial lighting - bulbs must be protected by suitable covers (protective unbreakable and waterproof lids) to reduce the risk of food contamination by glass pieces in the event of damage/breakage, as well as for easier cleaning;
- ▶ Light sources should be mounted to the ceiling or other surfaces (e.g. walls):
 - It is not recommended to use lights suspended by wires or chains to lower light fittings because they can be a source of contamination;
- ▶ Depending on the nature of the work, the following lighting intensity is recommended:
 - inspection of carcass/offals body - 540 lux,
 - production - 240 lux,
 - other rooms - 110 lux;

Adequate supply of potable water

- ▶ Water supply must be adequate and the water must meet the requirements for drinking water (Rulebook on the hygiene of drinking water, "Official Gazette of FRY", Nos. 42/98 and 44/99);
- ▶ Drinking water must be used for cleaning premises, equipment and surfaces that come in contact with food;
- ▶ For seasonal operation, facility also has to use drinking water;
- ▶ Wells and water tanks must be well covered and protected from contamination;
- ▶ Equipment for water treatment, if used, must be maintained in a good hygienic and functional condition;
- ▶ Water from public supply should be sampled once a year, and water from own wells at least twice a year (the frequency depends on the previous results);
- ▶ Reports on water tests should be kept for 3 years and made available at the request of the competent authority;

Requirement

Hand washing facility with warm and cold running water

Good practice

- ▶ The facility should have at least one wall-mounted hand washing equipment with warm and cold running potable water;
 - Number of hand washing equipment depends on:
 - number of personnel working on the premises,
 - size of the premises, infrastructure and layout
 - applied operational procedures;
- ▶ It is desirable to use hand-held stainless steel hand tools in production, which has:
 - hot and cold water,
 - hand soap (preferred liquid soap),
 - hygienic hand dryers (suitable are disposable paper towels);
- Employees handling unprocessed meat should use hand washing equipment provided with faucets to prevent the spread of contamination (e.g. by pressing by the foot or knees - without touching them by hands, or by automatic activation via the sensor);
- It is desirable that the hand washing equipment is appropriately positioned for the following purposes:
 - toilet/changing facilities,
 - slaughter and slaughter of poultry livestock,
 - removal of internal organs (evisceration),
 - trimming and working with unprocessed meat;
- Where necessary, it is advisable, along with hand washing equipment, to have tools for sanitation of the tools (sterilizer, with hot water temperature of at least 82 °C);
- **Hand washing facilities should not be used for food washing!**

Suitable changing rooms

- ▶ Changing facility must be outside of the premises where the food is handled;
 - Changing room may be located outside of the food establishment, if it is in the immediate vicinity, but should be within the same facility's ground;
 - If the way of use does not endanger the hygiene and food safety, and if appropriate, the dressing room could be away from the production facility, if there are special procedures to prevent direct and indirect contamination of meat;

Requirement

Good practice

Suitable changing rooms

- In some cases, dressing room could be in the residential house of the farm; if the production facility is located next to the house, dressing room from the farmhouse may be used for the needs of the personnel, provided that access to these areas is easy/simple (e.g. close to the entrance) and available during operation;
- When employees use dressing room outside the production facility, they are obliged to apply appropriate and documented procedures for personal hygiene, good practices and measures to prevent the premises from getting dirty (removal/changing of protective clothing and footwear, washing and disinfection of protective footwear, hand washing and disinfection);
- If necessary, the fulfillment of the requirements should be considered with the competent authority in each individual case;

Flush lavatory which does not compromise hygiene and food safety

- ▶ Toilet door must not open directly into a food handling premises;
- It is recommended that there is a separate space with hand-washing facility, so the personnel can remove and hang the protective clothing before using the toilet;
- ▶ Flush lavatories should be directly connected with the sewer system;
- ▶ If the way of use does not compromise the hygiene and food safety, and, if appropriate, the toilet could be away from the production facility, if there are special procedures to prevent direct and indirect contamination of meat;
- In some cases, the toilet could be in the residential house of the farm; if the production facility is located next to the house, toilet from the farmhouse may be used for the needs of the personnel, provided that the access to the toilet is easy/simple (e.g. close to the entrance) and available during operation;
- When employees use the toilet outside the production building, they are obliged to apply the appropriate and documented procedures for personal hygiene, good practices and measures to prevent the premises from getting dirty (removal/changing of protective clothing and footwear, washing and disinfection of protective footwear, hand washing and disinfection);
- ▶ If necessary, the fulfillment of the requirements should be considered with the competent authority in each individual case;

Requirement

Good practice

Drainage system:

- Floors provided with correct sloping towards drainage channels/drains
- Waste water is well connected to the drainage system (does not spread over the floor)
- Appropriate drains

- ▶ When drainage channels are fully or partially open, drainage of waste water must not flow from contaminated/unclean into the clean area;
- ▶ All drains should be trapped and outside drainage openings should have screens;
- ▶ Drains must have water closures, and the outlet holes must have a grid / net;
- ▶ There should be a proper drainage and collection of waste water:
 - from the slaughter line,
 - from sanitary facilities,
 - from atmospheric waste water;
- ▶ Note: Every precaution should be taken to prevent environmental pollution;

Refrigerated space for chilling and storage of poultry/lagomorph carcasses

- ▶ Sufficient handling and storage capacity for slaughtered poultry and lagomorphs at a appropriate temperature, which can be monitored and, if necessary, recorded;
- ▶ Slaughtered poultry must be chilled as soon as possible after the slaughter;
 - Cold chain must be maintained and not interrupted;
 - Carcasses/meat of poultry and lagomorphs must be chilled to a maximum of 4 °C;
- ▶ The hanging carcasses must not come in contact with each other;
 - Contact between carcasses prevents air circulation between them and can cause cross-contamination. It is important that the air can circle around the carcass and so that target temperature can be reached as fast as possible;
 - Proper cooling equipment should be used (strong chilling unit and air circulation) for fast cooling and maintenance of the cold chain, i.e. to avoid/reduce the possibility of condensation;
 - Warm carcasses should never be placed in the same cooling area along with the already chilled meat, as condensation may occur;
 - Space for chilling and storage, depending on the situation (e.g. slaughter rate, number of animals slaughtered, storage time) could be a special chamber or larger or smaller capacity, placed in a separate room or in the evisceration, packaging and delivery room for poultry and lagomorphs;

Requirement

Good practice

Clean establishment and equipment:

- regular cleaning and disinfection of premises and equipment

Rooms:

- ▶ Rooms and equipment must be regularly cleaned and, if necessary, disinfected before and during work, and especially when procedures are in place in the same area that can lead to contamination or cross-contamination of the meat; this includes all spaces, where slaughtering and dressing of poultry/lagomorphs, chilling and further operations are carried out, e.g. packaging, delivery, etc.;
- ▶ Visible dirty/contamination on the surface during operation requires interruption, removal of material and cleaning/washing and disinfection before proceeding the work on the same surface;
- ▶ Floors must be cleaned, washed and disinfected regularly;
- ▶ Drains must be clean and free from clogging;
- ▶ Dirt accumulated on the walls or joints of the floors or ceiling must be cleaned immediately;
- ▶ After each operation, the interior of the used premises must be thoroughly cleaned and, if necessary, disinfected;
- ▶ Waste disposal sites must be maintained properly and cleaned/disinfected daily/regularly;

Equipment:

- ▶ The term "equipment" refers to all items used for poultry/lagomorphs at the reception, during slaughter and further dressing and handling of carcasses; all equipment must be clean and, if necessary, disinfected before use;
 - For example:
 - cages in which live animals are kept,
 - stunning equipment, slaughter and bleeding funnel, scalding vats and their heating units, defeathering devices, vats for chilling by dipping of carcasses, rails, conveyors, tables, shelves, (as appropriate in the individual case),
 - working surfaces, hooks, knives, gambrels etc.
 - containers, boxes, pallets;
 - For seasonal operation, equipment must be thoroughly cleaned before its first use;
 - Equipment that comes into contact with the carcass/meat and tools should be sanitized in hot water at least 82 °C (or other method having the same effect) before and during operation;

Requirement

Good practice

Clean establishment and equipment:

- regular cleaning and disinfection of premises and equipment

IMPORTANT:

There must be a plan/schedule for cleaning of premises, equipment and devices related to the main activity;

There must be a documented procedures that determines the method, place and responsibility for implementation and control of procedures and results of cleaning, washing and disinfection;

In order to maintain a high level of hygiene and appropriate order in an establishment (premises and equipment), it is preferred that each employee, upon completion the work, keeps his job position "clean";

Cleaning equipment and cleaning and disinfection agents

- ▶ The construction of and materials that cleaning equipment is made of, should enable proper cleaning and disinfection;
- ▶ There should be sufficient cleaning facilities available for the size of the premises;
- ▶ Water available on the premises should be of the required temperature for sanitation (at least 82 °C) and washing (according to the manufacturer's instruction);
- ▶ Agents for cleaning and disinfection must be permitted for use in food industry;
- ▶ Cleaning and disinfection agents (chemicals) are not allowed to be stored in food handling areas (a separate room or a lockable separate facility);
- ▶ Special care must be taken to avoid re-contamination during cleaning operations (e.g. no dirty cloths should be used, same brushes/brooms should not be used in unclean and clean part of the establishment). Preventive measure: equipment of different colors to be used for clean and unclean parts of the premises);
- ▶ Appropriate equipment includes:
 - sinks (e.g. for washing small tools and small equipment/containers); double sinks are preferable because they can separate washing and rinsing,
 - hoses (for washing fixed items and larger mobile equipment),
 - thermometer for water temperature control;

Requirement

Good practice

Storage for cleaning agents and disinfectants:

- away from areas where food is handled

- ▶ Cleaners and disinfectants must not be stored in food handling areas;
- ▶ There must be an appropriate storage room or equipment in place far from the food handling area;
- ▶ Storage space for cleaning and disinfecting products may be located outside the workspace, but within the facility's ground;
- ▶ The most important is that the place (premises, equipment) for storing cleaning and disinfecting agents are under permanent control of the operator (locked, handled by the responsible person), so that it does not pose a risk, does not endanger the safety of food, prevents unauthorized access and use, and provides conditions for keeping quality of chemicals;
- ▶ Operator should document and apply good practice procedures on receiving, handling and using of all chemicals;

Adequate personal hygiene

- ▶ All employees must maintain and show a high level of personal hygiene:
 - Clean hands: Hands must be washed before entering the production area, after going to the toilet, after taking food and drink, after handling waste material or dirty items, etc.,
 - Wounds must be covered with waterproof light colored protection,
 - Jewelry should not be worn (except the wedding ring),
 - Protective gloves should be used, as necessary,
 - Employees must refrain from unhygienic habits that could contaminate food (e.g. taking food and drink in production areas, coughing and sneezing over products/meat, etc.),
 - Employees should wear protective clothing and footwear, where necessary,
 - Clean protective clothing, preferably white/light colored, should be changed at least once a day,
 - Hair and beard-coverings (caps, nets) should be easily washed or disposable protective products can be used,
 - Protective footwear should be easily washed and white/light colored are preferable,
 - Protective clothing and footwear that has been in contact with diseased animals or infected meat or other contaminated material should be changed immediately;

Requirement

Good practice

Adequate personal hygiene

NOTES:

- Protective clothing and footwear, as well as hats/shields for hair and beard should be put on at the beginning of work, and washed or disposed (those for single use) at the end of the work,
 - Protective clothing and footwear should not be worn outside the production area. It is desirable to use one set of clothes and footwear in the unclean part (transport/reception of animals and area for slaughter and defeathering of poultry or dehiding the lagomorphs) and the other one in the clean part of the establishments (evisceration, chilling, packaging, delivery) if the same employees work in all parts of the building during the day;
- If an employee is suspected or suffering from diseases which may be a danger to public health (e.g. abdominal signs - vomiting, diarrhea), he/she must terminate the work and apply the doctor's advice regarding attendance/exclusion from work. The operator should document the illness of each employee;

Suitable arrangements and equipment for pests control (rats, mice, insects, wild birds, etc.)

NOTE: Since the slaughterhouse is located on the farm, it is necessary to have a comprehensive approach to pest control.

- There should be awareness of the pests' risk, indication of their presence and the measures to be taken to control pests;
- Food must not be contaminated by pests or domestic animals;
- Appropriate procedures and measures for pest control must be documented and applied;
- Procedures and practices for pest control should include at least the following:
 - entrances and possible access points to the establishment should be protected from rodents,
 - there should be screens for protection from insects and, if necessary, other means of protection (e.g. electronic device for killing insects),
 - there should be a regular program for rodent control, including the plan where the baits are placed and records of the results of controls (e.g. signs of rodent presence - changes in the quantity of bait placed in certain locations, number of dead rodents, inspection observations, etc.),

Requirement

Good practice

Suitable arrangements and equipment for pests control (rats, mice, insects, wild birds, etc.)

- records of the insect control, i.e. the time/season, the type and location of their findings, as well as the results of the application of protective devices (e.g. protective screens, self-closing door devices, air curtains, electric insect killers) should be kept and what other practices are applied: outer doors closing practices, blocking windows and doors during operation and procedures/behavior of employees regarding the pest control procedures;

Collection, storage and disposal of wastes and animal by-products

Handling, storage and organization of the removal of animal by-products not intended for human consumption must not endanger hygiene, food safety and the environment.

Animal by-products (ABPs) and meat that is unfit for human consumption must be separated from the food as soon as possible and collected, stored and disposed of in accordance with special regulations.

- ▶ Ensure that the entire amount of feathers is collected in dedicated containers and regularly removed from the plucking area;
- ▶ Blood should be collected directed into the intended container;
- ▶ Containers for this material must not be overfilled; they must be regularly emptied and removed from the production area;
- ▶ All ABPs must be stored appropriately until removed from the establishment;
- ▶ Containers for storing all ABPs (blood, feathers, heads, intestines, feet, parts unfit for human consumption, etc.) can be made of plastic or other materials that can be easily cleaned, washed and disinfected;
 - Containers must be closed (close-fitting lid is sufficient) in order to avoid attracting pests and spreading the contents
 - Lid on containers used in the production area are not necessary;
- ▶ There must be a documented plan and procedures for cleaning, washing and disinfecting all containers for the collection and storage of the ABPs to ensure that all the inner and outer surfaces of these containers are clean;

Requirement

Good practice

Collection, storage and disposal of wastes and animal by-products

- ▶ The frequency of collection/removal of containers from the production line depends on the quantity of the obtained ABPs and disposal from the establishment depends on the conditions and capacity of the storage facility;
 - Protection against pests can be achieved by:
 - storing in a covered and enclosed area, protected from entry of pests,
 - using well closed bins;
- ▶ Storage of ABPs and other waste materials should be away from the main entrance to the food premises;
 - If the ABPs/waste storage place is outside the building, it should be on a hard standing area and preferable covered;
 - The water supply and hose for cleaning the containers and the surroundings should be adjacent to the storage area;

NOTES:

- It is necessary to have a special contract with the local self-government or with the organization for collection and disposal of ABPs;
- If there is no conditions for longer storage of ABPs and other wastes (insufficient space, lack of cooling/freezing capacity), disposal from the facility must be more frequent;
- The usual carcass yield is about 65% of the live weight of the poultry. This means that about 35% of the live animal are feathers, blood, viscera, feet, head and trimmings (SPZP), which must be collected and removed appropriately:
 - the largest part of the ABPs obtained in the slaughterhouse on the holding is expected to be of Category 3, and should include: heads, feet, feathers, blood and intestines;
 - Category 2 material includes poultry that have died and not slaughtered for human consumption;
 - Category 1 material shall not be obtained in a poultry slaughterhouse on the holding;

Requirement

Appropriate premises and equipment for slaughter and further processing in a hygienic manner

Good practice

► Poultry and lagomorphs can be slaughtered in the same facility only if slaughtering of different animal species are separated in time or space;

► In order to work under hygienic conditions, separate rooms/premises of sufficient size are required for the following activities/operations:

1. Receiving of animals (poultry/lagomorphs)

- There should be a space with adequate protection against weather conditions (shelter) for the reception of animals before slaughter;
- The animal reception area is not necessary if the poultry/lagomorphs farm facility is located in the same yard/ground, or near the slaughterhouse;

2. Restraining - Stunning - Slaughtering - Scalding - removal of feathers (defeathering/plucking), or removal of the skin of lagomorphs

3. Removal of internal organs (evisceration)

- If the room for stunning, slaughtering, scalding and defeathering/plucking is of sufficient size, or there is a sufficient spatial or physical separation, as well as procedures (including organization of work, e.g. work in smaller lots/batches), and measures (e.g. hygiene of the premises and equipment/surfaces, personal hygiene), which ensure that the meat/carcasses is not contaminated, evisceration and further dressing operations (e.g. chilling, packaging, delivery/direct sale) can be performed in the same room, ending the stunning, slaughtering, defeathering and the removal of the skin of the lagomorph, i.e. that unclean and clean operations are separated in time*

* If necessary, the fulfillment of the requirements should be considered with the competent authority in each individual case;

4. Chilling and storage (chilling and maintenance of cold chain)

- Depending on the rate of slaughter and the number of slaughtered animals, i.e. the rate of sale/delivery, the chilling of the carcasses and edible offals must have, or at least one special chiller room (chamber), or at least one chilling device of the appropriate capacity;
- The cooling system and the size of the cooler/chamber should allow fast chilling (air circulation rate, enough space below, above and between the carcasses);

Requirement

Good practice

Appropriate premises and equipment for slaughter and further processing in a hygienic manner

5. Packaging/Delivery

- Packaging and delivery/direct sales of carcasses/poultry meat and lagomorphs can be done, or in a separate room (it is desirable for consumers not to enter the production premises), or in the clean part of the establishment (a part close to the exit/delivery of the products);
- The entry for animals and removal of ABPs should not be used for entry/exit of consumers, or for loading/shipping of chilled carcasses of poultry and lagomorph to retail facilities. However, the same entry and exit for animals, by-products of slaughtering, packaging, direct sale or delivery of packaged poultry meat to retail establishments can be used with appropriate time separation and application of good practices and hygiene measures (cleaning/washing and, if necessary, disinfection; changing protective clothing, setting up of disinfection barrier, etc.);

IMPORTANT

- ▶ Available space in production premises should enable performance of necessary procedures in a hygienic manner;
- ▶ There must be conditions to avoid possible contamination of carcasses/meat and edible offal:
 - Equipment necessary for the hygienic performance of the necessary procedures for slaughtering, further dressing and handling of poultry and lagomorphs in order to prevent contamination of meat,
 - The meat must not come in contact with floors or walls;
- ▶ Layout (scheme) of the holding's situation plan with the production premises and other facilities should be prepared, including the water supply (water lines/location of the entrance into the farm yard and/or the location of own wells and connection with the production facility);
- ▶ Layout (scheme) of the production establishment and the premises related to the slaughtering activities should be prepared, with the most important equipment outlined and the places for performing unclean and clean working operations:
 - Flow of the work process in the establishment/individual premises and spaces should be presented, including the paths of the movement of employees, consumers, animals and cages, animal by-products, carcasses/meat, packaging materials, product deliveries, washing and disinfection facilities (premises and equipment, cages, vehicles) and other important information;
 - Note: Schematic presentation of the paths of movements (e.g. lines in different colors) and the flow of the work processes should document the crossing points (in all stages of slaughter and processing and other activities in and around the establishment) in order to document the implemented measures to prevent contamination and cross-contamination of meat;

Requirement

Good practice

Packaging materials:

- Not source of contamination;
- Storage conditions prevent contamination

- ▶ Wrapping and packaging materials must meet the food grade standards (handy materials such as newspapers are not acceptable);
- ▶ Storage space for packaging materials may be located outside the production building, but inside the establishment's ground;
- ▶ If the location of the storage space for packaging materials requires outdoor movement and the passage of the packaging materials through the open area, the operator should have documented procedures and apply good practice in the handling and protection of packaging materials during the reception, storage and transfer of packaging materials from the warehouse to the place of use in production premises;

Food transport must ensure the protection of hygiene, safety and quality of food

Vehicles for transport of poultry/lagomorph carcasses are clean and, if necessary, chilled

- ▶ Prior to transport, poultry carcasses and lagomorphs must be chilled to a temperature of 0 to 4 °C and that temperature should be maintained during the transport;
 - ▶ The vehicle must be clean before loading, in order to prevent cross-contamination;
 - ▶ All containers used for transport of meat must be made of materials that are easy to clean and disinfect;
 - ▶ For transport of poultry/lagomorphs carcasses a dedicated set of containers should be used - they must not be used for other purposes;
 - ▶ Disposed/unwrapped meat must not come into contact with the floor and the walls of the vehicle;
 - ▶ Carcasses of poultry/lagomorphs must not be transported simultaneously in a vehicle with animals or materials and non-food products:
 - in the case of transport with the other foods at the same time, the meat of poultry/lagomorphs must be adequately pre-packed/wrapped and separated by space in order to avoid contamination;
 - ▶ Place of loading and unloading and the manner of handling should ensure the conditions for quick working procedures, so that food contamination and the negative environmental impact (e.g. dust, smoke, weather conditions, leaves, pests, etc.) are avoided;
 - ▶ Depending on the distance of the delivery point or when several consecutive deliveries/unloadings are expected during one transport, in the vehicles without cooling, thermo-insulated containers can be used:
 - Transport of poultry/lagomorphs carcasses can be done without cooling, but within two hours *
- * Compliance with this requirement may be approved by the competent authority in each individual case.

IMPORTANT:

- ▶ The means of transport used must maintain the cold chain, ensuring the temperature of the meat is not lowered, and is maintained at the established limit. Since there are special temperature requirements for transport of poultry and lagomorph meat (from 0 to 4 oC), vehicles and/or meat transport containers must be cooled or be of such structures, that they maintain a cold chain for a certain period of time, as required for the type of food that is being transported;
- ▶ The vehicle with a cooling device should have good thermal insulation - an inner liner that is waterproof and suitable for maintenance of hygiene (without cracks and sharp corners where dirt can accumulate), air-tight doors, waterproof floor, strong cooling unit and the possibility of continuous or periodic monitoring and, if necessary, recording the temperature during transport;
- ▶ When loading, transporting and unloading, food must be protected from harmful effects of microbiological, physical and chemical hazards, and, when necessary, from the influence of high temperatures. Insufficiently cleaned, poorly maintained and inadequate vehicles and containers, including inadequate separation procedures of packaged from unpackaged products, create conditions for cross-contamination of food during handling and transport;
- ▶ In order to avoid the transmission of contamination between different consignments, the means of transport must be cleaned and disinfected between two transports, within the facility ground or in an authorized service where the operator has a contract. Vehicles and containers should be cleaned using water under pressure and disinfected both from the outside and from the inside. The door of the loading compartment of washed and disinfected vehicle must be kept closed until the new consignment is loaded;
- ▶ Drivers and employees engaged in loading and unloading should be trained on the hazards associated with transport and food safety. It is necessary to explain the procedures for proper cleaning, separation of clean from unclean cargo and packaged from unpackaged food, as well as the importance of keeping the instructions and timely reporting of noncompliances.

Food separation – Disposed/Unpackaged food can be transported:

- in a special vehicle, or
- in the same vehicle with packaged foods, but:
 - at different time; or
 - at the same time, but separated from packaged food by a permanent barrier that can be cleaned and disinfected, or
 - at the same time, if it is protected by an impervious cover.

SLAUGHTER HYGIENE

When operating in a slaughterhouse for small quantities of poultry and lagomorphs producer must insure:

- Before slaughter, the operator must notify the competent veterinary inspector on the date and time of slaughter;
- An animal showing clinical signs of illness or known to be unsafe for human consumption for any reason (e.g. the withdrawal period* is not elapsed, other possible contamination) must not be slaughtered for human consumption;
- Meat from animals that died for some other reason but not as a result of slaughtering, must not be used for human consumption;
- Animal welfare requirements must be met;
- Requirements for by-products of animal origin must be met.

Basic principles of slaughter hygiene:

- Animals brought to the slaughterhouse must be slaughtered immediately, while respecting the welfare of animals;
- Dressing procedures must be carried out quickly and hygienically;
- Measures should be taken to prevent the spillage of digestive tract content during evisceration;
- Carcasses must not be piled at any stage of the slaughter/dressing/chilling process, as this facilitates cross-contamination and prevents carcasses chilling;

Activity

Important for good practice

Poultry and lagomorphs for slaughter

- ▶ The origin of the flock must be known (e.g. the origin of one day-old chicks);
- ▶ Producer must ensure that the National Animal Health Program of Measures is regularly implemented on the holding and the farm (flock or individual farm units) must not be subjected to any prohibition of movement or other restrictions due to the animal health or public health reasons or disease control measures;
- ▶ The flock should be healthy and the tests have not established a positive finding of any condition that would make meat unsafe for human consumption;
- ▶ Producer is obliged to carry out internal control measures in accordance with a special regulation on measures for early detection, diagnosis, prevention of the spreading, suppression and eradication of livestock infections by certain salmonella serotypes;
- ▶ Only healthy poultry and lagomorphs may be delivered to the slaughterhouse;
- ▶ Operator is obliged to treat the animals with the care of a good host, respecting the principles of animal health and welfare;
- ▶ The flock should not be exposed to any avoidable discomfort during placing in crates or loading; special attention should be paid during the collection of individuals;
- ▶ Operator must have data on use and date of the administration of additives and veterinary medicinal products and the withdrawal period*, as well as the date and time of slaughter;
- ▶ At the time of slaughter, the number of individuals in the slaughtering lot should be known;

* The withdrawal period is the time period required after the last administration of the drug to the animals, until the time when the treated animal and its products can be used in the food chain;

Slaughterhouses are an unknown animal environment. Peaceful and short handling time reduces animal distress, as well as the stress of employees and facilitate work safety and better meat quality.

The procedures applied in slaughtering animals must be carried out with care to prevent pain and suffering as much as possible.

If performed properly the stunning of animals does not cause pain or distress and allows slaughter while the animal is still unconscious. An animal must be slaughtered only if it

was stunned before slaughter, except in the case of emergency slaughter (for prevention of suffering and pain caused by an injury, pathological condition or infectious disease), or if the poultry and lagomorphs are slaughtered for operator's own needs.

Activity	Important for good practice
<p>Animal intake before slaughter</p>	<ul style="list-style-type: none"> ▶ It is preferable that the reception area where poultry is handled immediately prior to being slaughter (pulled out of the crates, inspected, suspended or put in the cones, stunned and slaughtered) is sufficiently lit to detect changes in health, but not too much, as this may disturb poultry (preferable blue light). ▶ Slaughterhouses for poultry and lagomorphs may not have: <ul style="list-style-type: none"> • a special room for intake and temporary accommodation of animals for slaughter, since the animals are from the same farm and the animals are slaughtered immediately after the reception to the facility, • a special room for diseased or suspect animals, since the rasing and keeping of animals belong to the farm with known health conditions immediately prior to slaughter; suspect, diseased and dead animals are handled in accordance with the good practice and recommendations of the field veterinary service, ▶ Cleaning, washing and disinfection of means of transportation and crates is done on the farm in accordance with good hygienic practices and recommendations of the field veterinary service;
<p>Restraining, stunning, bleeding/killing</p>	<ul style="list-style-type: none"> ▶ Care must be taken to prevent pain, suffering or injuries that can be avoided; ▶ Poultry must be well restraint, stunned and bled; ▶ Restraining must be done properly and procedures may include manual restraint, cones for slaughtering and bleeding, or shackles: <ul style="list-style-type: none"> • If used, cones should be of appropriate size, and the wings should be folded down before the bird's insertion into the cone in order to avoid wings flapping or backing out of the cone, • Poultry should not be suspended for a long time (maximum 3 minutes for broilers and 6 minutes for turkeys), • When hung, poultry will become excited and flap with their wings. They need some time to calm down before stunning - broilers need about 12 seconds, and turkeys for about 20 seconds to settle;

Activity

Important for good practice

Stunning

Stunning must be carried out in line with the prescribed means and allowed procedures, in accordance with the special regulation on conditions and means for killing animals, the way of handling with the animals before slaughter and the method of stunning and bleeding of animals.

Some methods of killing poultry, such as decapitation (head cutting) and neck dislocation (neck twisting) of poultry must be authorised by the competent authority.

Neck dislocation:

- The procedure must be performed by a qualified person (appropriate training completed), who must ensure that necessary care is taken to avoid pain;
- The method is suitable only for killing a small number of animals and when alternative methods are not available,
- Recommended only for poultry weighing less than 5 kg.

In addition to legal and social demands for stunning, there are other reasons why stunning is a good practice, e.g. better bleed out (an un-stunned animal will struggle, its organs will continue to use blood leading to poorer bleed out), relaxation of the feathers and easier plucking, which makes it easier to slip and possibly less carcass contamination;

Bleeding

► Poultry must be bled out immediately after slaughter and always before the animal comes to consciousness:

- This should be done for a maximum of 15 seconds after stunning;

► The most common method involves cutting the carotid arteries and jugular veins on both sides of the neck:

- It takes about 1 to 3 minutes for poultry to be bled out completely, depending on their size and weight,
- During the bleeding period no additional dressing operations should be carried out for the purpose of maximum bleeding; further dressing operations are permitted upon the completion of bleeding;

Activity	Important for good practice
Scalding	<ul style="list-style-type: none"> • In order to reduce contamination during scalding, attention must be paid to: <ul style="list-style-type: none"> - water temperature, - scalding duration/time; <p>NOTE: Only potable water can be used for scalding and the addition of substances such as detergents should not be used or added to the scalding tank;</p>
Plucking	<ul style="list-style-type: none"> • Scalding process and feather removal/plucking are the main sites of potential cross-contamination in slaughterhouses, • Feathers should be removed manually or mechanically, • For manual plucking, hand washing equipment should be available in the room or in the vicinity, • In case of mechanical removal of feathers, the feathers left behind after the machine must be removed manually;
Carcass washing	<ul style="list-style-type: none"> • Carcass should be rinsed/sprayed with potable water in order to remove any surface contamination before any cut is made;
Head and feet removal	<ul style="list-style-type: none"> • If necessary, head and feet may be removed at this stage of the carcass dressing;

Activities: Poultry intake, slaughtering, scalding and plucking of feathers are considered "dirty" operations and must be separated in space or in time, from subsequent "clean" processing operations.

Stunning, bleeding, scalding and plucking of poultry, or skinning of lagomorphs must be done without delay and in a way to avoid contamination of the meat.

NOTE: If badly bleeding, blood bruises, deviations from normal appearance and body consistency are noticed at this point, they should be separated and disposed of properly, in accordance with the provisions of the regulations on animal by-products.

Activity

Important for good practice

Evisceration

- ▶ Evisceration must be done as soon as possible after stunning;
- ▶ Removal of internal organs involves the removal of materials containing a significant number of microorganisms, which can lead to contamination. Therefore measures must be taken to prevent spillage of digestive tract contents during evisceration:
 - If it is done manually on the table, care should be taken in removal organs to prevent cross- contamination of the carcasses or contamination of workers' hands,
 - Evisceration knives should be washed and sanitized before and after use,
 - Equipment and surfaces that come in contact with the carcass should be washed and regularly sanitised,
 - Each set of intestines must be removed from the table immediately after evisceration, i.e. before starting the operation on the next carcass,
 - If one carcass is contaminated with intestinal contents, it should be thoroughly washed and equipment/tools and working surfaces should be thoroughly washed and disinfected before starting work on the next carcass,
 - Equipment for washing hands and washing equipment must be available in the evisceration room;
- ▶ Special attention should be paid on removal of any visible contamination on the carcass after evisceration, and the operator should check once again each carcass to ensure that it is visually clean;
- ▶ The cavity of each carcass should be checked to ensure that the complete set of intestines with associated organs is completely removed;
- ▶ Carcasses contaminated to a greater extent and/or carcasses showing deviations from the normal state and therefore they are not safe for human consumption should be carefully removed;

Carcass inspection

- ▶ After slaughtering and dressing, the inner and outer surfaces of the carcass and outfit should be inspected;
- ▶ Inspection of carcass should focus on the following:
 - abnormal color and/or odor,
 - obvious signs of any condition or abnormality that may make meat unfit for human consumption,
 - carcass condition,
 - bruises, haemorrhages or discolouration (places/fields with unnatural color),

Activity

Important for good practice

Carcass inspection

- complete - incomplete bleeding,
 - legs and muscles abnormalities,
 - general cleanliness (degree of soiling or contamination),
 - signs of use of veterinary drugs;
- ▶ Whole carcass unfit for further processing (cooling, packaging, delivery) should be removed;
 - ▶ Internal organs and carcasses should be in correlation (connection between each carcass and its associated organs must be ensured);
 - ▶ Poultry carcasses or internal organs that are highly contaminated with faecal material, bile or other impurities (e.g. lubricants for equipment/devices, disinfectants, rubber from defeathering machine) should be removed as unfit for human consumption;
 - ▶ Carcasses that fall on the floor and into other contaminated surfaces should be removed as unfit for human consumption;
 - ▶ Contamination limited to a smaller surfaces should be trimmed in a hygienic way;
 - ▶ Places/areas with damaged skin (e.g. damages caused by the defeathering device) are contaminated parts and must be removed by cutting hygienically;
 - ▶ Any minor skin changes may be hygienically trimmed after evisceration;
 - ▶ Trimming is done before chilling to prevent cross-contamination in the chiller room/cooling device;

Chilling

- ▶ Carcasses of poultry/lagomorphs must be, as soon as possible, chilled and stored at a temperature of **0 to 4 °C**, unless direct sale to the final consumer is carried out no later than one hour after slaughter;
- ▶ Meat of poultry and lagomorphs slaughtered on the holding must not be frozen;
- ▶ In establishments for slaughter of small quantities of livestock and lagomorphs on the holding, it is possible to store fit carcasses and and unfit materials provided that:
 - contamination of carcasses/meat fit for human consumption are prevented,
 - container for condemned material is marked and could be closed:
- solution is not acceptable if the use of premise/container interrupts or endangers the meat chilling process;

Activity	Important for good practice
Meat cutting	<ul style="list-style-type: none"> ▶ It is forbidden to cut and process meat of poultry and lagomorphs slaughtered on the holding, except for the preparation of food for domestic table; ▶ By exemption, chilled carcasses of poultry and lagomorphs intended for sale on the holding can be cut into pieces on a special request and in the presence of the final consumer;
Packaging	<ul style="list-style-type: none"> ▶ Meat can be packaged only after chilling and reaching a temperature of not more than 4 °C; ▶ Unpacked carcasses of poultry and lagomorphs must bear a label, ring/tag, or other marking item clearly indicated: name and address of producer and slaughterhouse approval number; ▶ Packaged carcasses of poultry and lagomorphs must have a label clearly indicated: name and address of producer, slaughter date, product name, shelf life, keeping conditions and slaughterhouse approval number, as well as the statement "Slaughtered on the holding";
Delivery	<ul style="list-style-type: none"> ▶ The transport method of poultry and lagomorphs carcasses to the point of delivery must ensure the protection of hygiene, safety and food quality, as well as the conditions for maintainance of meat temperature between 0 and 4 °C.

Records

Producers directly supplying final consumers or local retail establishments directly supplying final consumers with small quantities of poultry and lagomorphs slaughtered on-farm, must keep records that include at least the following:

- data on poultry and lagomorphs kept on the farm and slaughtered animals (traceability);
- date of slaughter;
- the species and number of slaughtered animals;
- data on retail destinations and date, species, quantity (number of pieces and weight) of delivered chilled carcasses of poultry and lagomorphs.

Producers are not obliged to keep records of poultry and lagomorph meat sold directly to the final consumers.

Producers must keep records of the monitoring of the production process, corrective measures and verification of the internal control system, as well as copies of the documents concerning meat sales to retail establishments for 3 years, and have them available upon request by the competent authority.

INTERNAL CONTROL PLAN FOR OPERATORS

All food business operators must ensure that foods produced under their control are safe for human consumption. In order to achieve this objective, a food safety management system must be established. The Food Safety Law and the specific regulation on the conditions of food hygiene stipulate that each producer (FBO), except on the level of primary production, is obliged to establish, implement and maintain the food safety program and procedures in accordance with the principles of good manufacturing and hygienic practices and Hazard Analysis and Critical Control Points (HACCP).

HACCP is an internationally recognized documented way to ensure that food safety hazards are being managed responsibly and are implemented from the beginning to the end of the working day.

The HACCP system acts preventively - it foresees possible hazards and the way to control them in advance.

Generic Model of an Haccp Plan for Poultry Slaughter

This generic HACCP plan for poultry slaughter includes prerequisite programs and HACCP-based procedures, taking into account the type of activity/production and volume/size of business. The plan is based on a general hazard analysis and points out the hazards and control measures that are common in poultry slaughter facilities which could help in the preparation of the procedures of the producer's internal control system, as well as the appropriate way of keeping records. In doing so, producers should be aware that other hazards may be present (for example, those that are related to the design/layout of the building or with the applied operations). Therefore, the producer should check in their establishment, whether all activities are covered by this generic plan. For additional activities, other procedures based on the HACCP principles should be done.

A brief generic Guide for the preparation of HACCP plan is available at the following website: www.vet.minpolj.gov.rs

In small-volume food business establishments, one person, occasionally assisted by external experts, can perform internal control activities. However, the food business operator must know how the food safety system is applied and the FBO is responsible for its operation, i.e. how to achieve the appropriate results and the level of hygiene and food safety.

In order to facilitate food business, producers operating in facilities slaughtering small quantities of poultry on the holding may use the following procedures and information, including annexes, in order to develop and implement their own HACCP/Self-Control Plan:

1. FBOs DETAILS (Name and address)
2. PROCESS TITLE (to be covered by the plan)
 - **Poultry slaughter** – Specify the species covered by the process (this title includes all dressing operations)
3. PRODUCT DESCRIPTION – Description of all important product characteristics and its intended use (Annex 1)
4. FLOW DIAGRAM of poultry slaughter (Annex 2)
5. PROCESS DESCRIPTION:
 - Operational procedure (Good Manufacturing and Good Hygiene practice) for each step of the process, from the beginning (intake of poultry/lagomorphs for slaughter) to the end of the process/step (product/carcass delivery to the final consumer or the retail establishment, including transport, if it is a part of the product delivery) are given in the Guide, part – **Slaughter Hygiene of poultry and lagomorphs**;
6. TYPE OF FOOD SAFETY HAZARDS AND HAZARD ANALYSIS
 - 1) Identified biological, chemical or physical hazards for food safety are given in Annex 3;
 - 2) **Hazard Analysis:**
 - The **risk of chemical and physical hazards** is assessed as – **low**, and the following control measures are applied;
 - in animal treatment on the holding, good veterinary practice is applied and withdrawal period of administered veterinary medicinal products (e.g. drugs, additives) is followed,
 - other possible sources of contamination with the chemicals are prevented with the implementation of good agricultural practice and animal husbandry (known the origin of animal feed) and good hygiene practices (e.g. good cleaning and disinfection practices of surfaces coming in contact with the carcasses/meat),
 - contamination sources with foreign bodies is prevented by the implementation of good manufacturing and good hygiene practices,
 - visual control and removal of foreign bodies are applied if observed in any phase/step of the process where potential contamination could happen (e.g. feathers);
 - regular preventive maintenance of equipment where there is a risk of physical contamination;

- The **risk of biological hazards** is assessed as - **significant**, and the following control measures are applied;

- risk of biological hazards present in live animals (microorganisms/bacteria) is reduced to an acceptable level by: control/monitoring of the health status of the flocks (implementation of the Program of measures of health protection of poultry at the farm and internal control measures of the flocks), inspection of animals before slaughter, dead animals and inspection of meat (inspection of carcasses and organs after slaughter).

- risk of biological hazards occurring during the slaughtering process or as a result of later microbiological contamination of the meat, can be kept at a low/acceptable level by applying good operational and personal hygiene practices and in particular by fast chilling, as well as by keeping the meat surface dry (efficient ventilation/low humidity) and by maintenance of the cold chain during storage and further steps in the food chain (packaging, loading/unloading, transport);

- 3) **Control measures** (preventive activities or conditions that are used to maintain control over the identified hazard, i.e. to prevent, eliminate or reduce the impact of the hazard to an acceptable level for human/consumer health):

- **Prerequisite programs** (see Guide, parts: **Hygiene conditions in the facility** and **Slaughter hygiene of poultry and lagomorphs**):

- good hygiene practice (regular and good cleaning and disinfection of premises and equipment; regular and good personal hygiene),

- good manufacturing practice (hygienic performance of slaughtering and dressing operations, e.g. no visible contamination after defeathering/skin removal or evisceration, including the procedures for trimming of visible contamination – reduction of contamination to an acceptable level, quick chilling of carcasses/edible offals and maintenance of cold chain),

- standard operating procedures (e.g. program/procedures for cleaning and disinfection of premises/ equipment, personal hygiene),

- fast-chilling and maintenance of the cold chain - prevents the growth of pathogenic microorganisms.

7. CRITICAL CONTROL POINTS

Cooling process and maintenance of cold chain during storage (maintenance of temperature limit values of poultry meat) is a critical control point because it has a key importance for the safety of poultry meat: it prevents the growth of pathogenic microorganisms.

Chilling and maintenance of the cold chain can also be attributed to prerequisite programs, i.e. good manufacturing/hygiene practices, but it is recommended that producer's self-control plan for production of poultry meat should include the chilling and maintenance of temperature during storage as a critical control point:

- Process step: **Chilling and storage** (carcasses) - **CCP 1B** (biological hazard) - Annex 2 – Flow diagram;
- In other steps of slaughter and dressing of poultry/lagomorphs, biological hazards are controlled by good hygiene and good manufacturing practices.

8. CRITICAL LIMITS

Regulatory maximum temperature of chilled poultry/lagomorphs meat is + 4 °C (measured in the depth of the chest muscles - "white meat"). It represents a critical limit to food safety. Also, only after reaching the determined temperature, carcasses of livestock can be put into circulation, and temperatures between 0 and 4 °C must be maintained during transport/distribution.

In addition to the regulatory established maximum temperatures, the operator may specify more stringent levels in his internal control plan (e.g. carcass/meat temperature before delivery – less than +2°C). In this way it can be assured that the carcass/meat temperature will not be exceeded during loading/unloading or at the place of delivery.

Bearing in mind the importance of the temperature in preventing biological hazards in poultry meat, chilling rate and achieving the determined carcass/meat temperature as quickly as possible, should also be included in the control measures. The higher chilling rate of meat (maximum + 4 °C) up to the point which prevents the growth of most pathogenic bacteria (and reduces the growth of meat spoilage microorganisms) is very important for the safety of poultry meat. Care should be taken to finish cooling process as soon as possible (e.g. for broiler carcasses - up to 6 hours from the beginning of cooling).

Based on the chilling conditions the operator determines the speed/duration of the cooling time until the determined carcasses/meat temperature is reached and that period shall be entered as a control measure in the internal control plan.

Note: The producer is entitled to choose the chilling method of poultry carcasses. In the air-chilling process, the cooling rate depends on the size of the chamber, the air temperature, the air circulation/air humidity, the carcass position (hanging or positioned on the grid or other surface/tray), or the space between, above and below the carcasses.

9. MONITORING OF CRITICAL CONTROL POINT

Continuous or intermittent monitoring (observations, measurements) of critical limits/control measures at a critical control point (CCP) is essential part of the self-control procedures (food safety management). Monitoring must enable timely detection of the loss of control in the CCP (critical limits and/or control measures are exceeded/endangered), so that corrective actions can be taken.

Monitoring means real-time collection of information at the phase/step of the process where the control measure is applied (e.g. monitoring of storage temperature).

The producer may also specify stricter limits as an early warning for undertaking actions (target levels/limits) before the determined critical limit is reached.

Alarm systems (sound, light) warning on exceeding/non compliance with a critical limit or that process is approaching the critical limit can be successfully used.

For the monitoring system of critical limits/control measures, the operator should describe: the methods/monitoring procedures (observations, measurements), frequency of monitoring and the volume and the content of the records intended for monitoring data at CCP. Measurements should be done at several places, e.g. to determine the temperature of the carcasses in different parts/heights of the chamber.

For the method and monitoring/verification procedures for each CCP decision, the following information should be written down:

- **how and when** it will be done - monitoring method; manually or automatically (recording time interval);
- **how often** the critical limits will be monitored (on a permanent or occasional basis) - monitoring should be applied so that the time between the two controls is reduced to as much as smaller quantity/number of product units affected by the critical limit deviation in a given period of time;
- **who** will perform the verification (the same staff should not oversee their own work; the exception are low-capacity facilities - a small number of employees);
- **which information** will be recorded, how, and which models/forms and record-keeping method should be used

Corrective measures

Corrective measures are planned and undertaken without delay if there are signs or when the results of the monitoring show that control over the production process is lost.

In case of exceeding the meat temperature (critical limit) or chilling chamber temperature and cooling time, corrective actions are to be taken immediately.

Examples of corrective actions in the cooling process and/or the maintenance of the cold chain:

- 1) When the critical limit is exceeded (e.g. temperature ≥ 5 oC):
 - Lower the product temperature to an acceptable level (e.g. lowering the temperature and/or increasing the air circulation), or extend the cooling process;
 - Move the product to another chiller with appropriate temperature conditions for cooling/storage (e.g. due to failure of the cooling equipment that cannot be repaired in a short time);

- 2) If the deviation has lasted for a long time or there is a suspicion that the food is unsafe, the carcasses/meat should be cooled down and retained until the testing results of the product/lot in question are obtained;
- 3) Always investigate, determine and correct the cause of the deviation in order to prevent its repetition, and take additional corrective actions;
 - Modify the programmed parameters/values of cooling/air circulation, if necessary;
 - Perform extra calibration of measuring equipment;
 - Review/check operating and handling procedures for products/carcasses and cooling process (e.g. opening and closing of the refrigerator door);
 - Review/check and, if necessary, increase the frequency of monitoring/verification;
 - Organize training of staff;

The generic example of the content of control measures, critical limits, monitoring and verification of data and corrective actions at **CCP 1B - Chilling and storage** of poultry/lagomorphs carcasses is given in Annex 4.

10.SAMPLING AND TESTING

According to the *Rulebook on small quantities of primary products supplied directly to the final consumer, areas for performing these activities and derogations related to small businesses operating with food of animal origin*⁵, the producer ensures that at least two samples are taken annually or, where appropriate, once in the production season provided that the safety of the product is not compromised (Annex 7 - Slaughtering poultry and lagomorphs on the holding - Sampling plan).

Exceptionally, the frequency of sampling and testing of carcasses of livestock slaughtered on the holding for the presence of *Salmonella* spp is carried out at least once a year, provided that the slaughtered poultry originate from the flock which is examined at least once a year.

In the case of a positive finding, sampling and testing is repeated until a negative result is obtained.

In order to confirm the effectiveness of the cleaning and disinfection procedures, the producer should take samples from food contact surfaces (swabs) to support the assessment of the process hygiene criteria, especially at the beginning of the application, or after the changes of the process or the cleaning agent and disinfectant. Samples from surfaces that are washed and disinfected are taken by prescribed methods before the start of work the following day.

⁵ Official Gazette of the Republic of Serbia, No. 111/17

A Guide for the application of microbiological criteria for food is available at the following website: www.vet.minpolj.gov.rs

11. RECORDS

In small-volume businesses, type-specific models of documents/records can be used, or the operator can choose another way of keeping records (such as a Diary, or the existing forms, and the way of record-keeping can be included). Models of forms can be used, provided they fully match the intended purpose, or the producer has to adapt the forms to their own conditions.

The producer is obliged to keep records of all data relating to critical control points, i.e. to record or have evidence of the results of monitoring of critical limits and the application and results of the application of other control measures. It is especially important to record the findings of deviations, actions taken to eliminate non-conformances and their outcome, as well as findings and corrective actions based on intermittent checks/verification of the self-control system (Annex 5 - Form - Monitoring and verification of temperature and control measures in CCP 1B).

The operator's records should include at least the following:

- Records on chemicals and cleaning and disinfection of facilities and equipment (Annex 6);
- Records on sampling and results of product testing (poultry/lagomorphs) and hygiene of surfaces (equipment) coming in contact with food (poultry/lagomorphs carcasses).

REFERENCES

- 1) Food Safety Law (Official Gazette of the Republic of Serbia, No. 41/09);
- 2) Rulebook on food hygiene conditions (Official Gazette of the Republic of Serbia, No. 73/10);
- 3) Rulebook on general and specific food hygiene requirements in any phase of food production, processing and trade (Official Gazette of the Republic of Serbia, No. 72/2010);
- 4) Rulebook on small quantities of primary products supplied directly to the final consumer, areas for performing these activities and derogations related to small businesses operating with food of animal origin (Official Gazette of the Republic of Serbia, No. 111/17);
- 5) European Commission - Guidance document on the implementation of certain provisions of Regulation (EC) No 852/2004 on the hygiene of foodstuffs, 2012;
- 6) European Commission - Guidance document on the implementation of certain provisions of Regulation (EC) No 853/2004 on the hygiene of food of animal origin, 2009;
- 7) European Commission - Guidance document on the implementation of procedures based on the HACCP principles, and on the facilitation of the implementation of the HACCP principles in certain food businesses, 2005;
- 8) European Commission - Commission Notice on the implementation of food safety management systems covering prerequisite programs (PRPs) and procedures based on the HACCP principles, including the facilitation/flexibility of the implementation in certain food businesses, 2016/C 278/01;
- 9) Commission Staff Working Document on the understanding of certain provisions on flexibility provided in the Hygiene Package - Frequently Asked Questions - Guidelines for food business operators, 2010;
- 10) Commission Staff Working Document on the understanding of certain provisions on Flexibility provided in the Hygiene Package - Frequently Asked Questions - Guidelines for the competent authorities, 2010;
- 11) Regulation (EC) No 2074/2005 laying down implementing measures for certain products under Regulation (EC) No 853/2004 and for the organisation of official controls under Regulation (EC) No 854/2004 and of the Regulation (EC) No 882/2004, derogating from Regulation (EC) No 852/2004 and amending Regulations (EC) No 853/2004 and (EC) No 854/2004;
- 12) Food Standards Agency (FSA) - Small and low throughput establishments: examples of EU hygiene regulations flexibilities;
- 13) Food Standards Agency (FSA) – Meat Industry Guide, 2009;
- 14) Guidance for On-farm Poultry Slaughter, Food Safety Authority of Ireland, 2011;
- 15) Food Manual, IV edition, Chapter A2 / Hygiene - Guideline for good hygiene practice and application the principles of HACCP at slaughter and cutting of cattle, pigs, sheep, goats and equines as well as in the production of meat products, BMG-75210/0002-II/B/13/2014, Austria;
- 16) State Food and Veterinary Service - Veterinary requirements for meat products and preparations produced for and placed on the domestic market in small quantities, Lithuania;
- 17) Ministry of Rural Development, Regulation for agriculture and village development on conditions for preparation, production and sale of food for small producers, No. 52/2010, (IV.30), Hungary;
- 18) Ministry of Rural Development, Notice on possibilities of small producers for food production, 2nd edition, 2013, Budapest, Hungary.

Annex 1

PRODUCT DESCRIPTION

Product name	“CHICKEN FOR GRILL”
Important product characteristics	Broiler/Chicken slaughtered on the holding/farm (Chilled whole broiler/chicken)
How will it be used: a) Final consumer b) Retail (Retailer, processor)	a) Thermal treatment (roasting, cooking) b₁) Further processing (roasting, cooking) b₂) Further processing – Thermal treatment (kitchen, catering)
Area/site of sale/supply	Local market – Site of holding and retail in municipality and adjacent municipalities
Intended consumer	All consumers
Packaging	(In line with the producer’s specification) • e.g. polyethylene bag
Storage conditions	(In line with the producer’s specification) • 0 - 4 °C
Shelf life	(In line with the producer’s specification) • e.g. less than 3 days (72 hours)
Labeling	(In line with the producer’s specification) • According to the Rulebook/Guide
Transport conditions	(In line with the producer’s specification) • 0 - 4 °C
Processing/Cooking conditions	(In line with the producer’s specification) • e.g. thermal treatment - min 72 °C*/20 мин

* Temperature measured in depth of the chest muscles („white meat“)

POULTRY SLAUGHTER – MAIN HAZARDS

Microbiological hazards in poultry meat

Process category	Generic product examples	Specie	Biological hazards likely to be present and cause foodborne illness marked by “+” (an empty box signifies that no biological hazard is likely to occur; however, an unusually high level of contamination or improper handling and storage may cause one or more of the pathogens to become a hazard)						
			<i>Salmonella</i>	<i>Escherichia coli</i>	<i>Campylobacter</i>	<i>Listeria monocytogenes</i>	<i>Staphylococcus aureus</i>	<i>Clostridium perfringens</i>	<i>Clostridium botulinum</i>
Poultry slaughter	<ul style="list-style-type: none"> ● Carcass ● Parts/pieces 	Poultry	+		+		+		

The occurrence of pathogens such as *Salmonella* in poultry carcasses varies greatly. The overall contamination of poultry carcasses with these pathogens depends not only on the prevalence and numbers of the pathogens on the feathers, skin, and in the intestinal tract of the animal, but is also significantly affected by the degree of cross-contamination occurring during slaughter and dressing.

Raw poultry meat is the major source of *Campylobacter*. Cross-contamination during preparation of raw chicken and the consumption of inadequately cooked poultry meat appear to be a significant source of this human illness.

Meat in pieces

Poultry meat in pieces has the same level of contamination as the carcass. Therefore, the microbial concerns are similar to those for meat after slaughter. In addition, poultry meat in pieces can become contaminated by equipment that has not been properly cleaned and sanitized.

Chemical hazards in poultry meat

Residues of veterinary medicinal products; contaminants (e.g. metals, dioxins); allergens.

Physical hazards in poultry meat

Foreign bodies (e.g. feathers, particles of bones, plastic, metals).

CCP 1B – CHILLING AND STORAGE OF POULTRY/LAGOMORPHS CARCASSES

HAZARDS AND CAUSES	CONTROL MEASURES*	CRITICAL LIMITS	MONITORING PLAN		VERIFICATION PLAN		CORRECTIVE ACTION PLAN
			Procedure/Frequency	Procedure/Frequency	Procedure/Frequency	Procedure/Frequency	
<p>Growth of pathogenic bacteria:</p> <ul style="list-style-type: none"> • Too high temperature during chilling and storage 	<ul style="list-style-type: none"> • Carcass air-chilling from ... 35-38°C up to ... (+4) °C during ... (6) hours • Meat temperature in chilled carcasses maintained below +4 °C • Chiller alarm activated at ... °C 	<ul style="list-style-type: none"> • Chiller temperature below ... °C (e.g. 2 °C) • Carcass temperature less than ... (+4) °C 	<ul style="list-style-type: none"> • Meat temperature measurement in depth of chest muscles (at least ... (3) carcasses in one lot) • Once a day (each chamber; each lot) 	<ul style="list-style-type: none"> • Check monitoring records on temperature during chilling and storage • Once a week * 	<ul style="list-style-type: none"> • Reduce the product temperature to proper level • Transfer the carcasses to another/correct chiller • Investigate the cause • Change/amend the chilling/storage procedure, if necessary • Training, if necessary 		
<p>Growth of pathogenic bacteria:</p> <ul style="list-style-type: none"> • Slow chilling process/long time in chiller (equipment, poor practice, e.g. insufficient space between carcasses) 	<ul style="list-style-type: none"> • Carcasses are stored on adequate equipment (hooks, perforated trays) • Employees trained to apply procedures for chilling and storage (first in-first-out rules; way of hanging and space between the carcasses) 	<ul style="list-style-type: none"> • Carcasses are suspended individually or placed on the perforated trays • No contact between carcasses • Carcass temperature \leq +4 °C during ... (48) hours • Sale/Delivery of chilled lot during ... (2) day after slaughter 	<ul style="list-style-type: none"> • Meat temperature measurement in depth of chest muscles (at least ... (3) carcasses in one lot) • Before each loading 	<ul style="list-style-type: none"> • Check chilling and storage practices and records on carcass temperature on loading • Once a week * 	<ul style="list-style-type: none"> • Spread the carcasses • Change the hanging or stacking of carcasses • Change the equipment (trays, containers) for carcass chilling • Split the compliant and non-compliant carcasses (up to the point when the chilling process is under control) • Sampling and testing non-conforming carcasses, if necessary • Investigate the cause • Change/amend the procedure, if necessary • Training, if necessary 		

* Verification frequency depends on slaughter dynamics and previous monitoring and verification results

NOTE:

In order to prevent cross-contamination of chilled poultry/lagomorphs carcasses (microbiological, chemical and physical contamination) caused by unclean environment and equipment, i.e. contamination of carcasses by pathogenic bacteria, or through employees handling chilled carcasses, the operator must ensure the application of cleaning and disinfection procedures for both the premises (technical maintenance of the facility and equipment), and the staff (ensuring the staff involved in the meat processing are healthy). Staff should be trained to apply and maintain the personal hygiene procedures.

PRODUCER'S NAME _____

SANITATION PLAN

Period:

Form 2

Subject of cleaning/sanitation (premise/equipment/vehicle)	Frequency	Procedure	Agent (name)	Working concentration	Contact time	Equipment and protective devices	Responsible operator and supervisor	Note

PRODUCER'S NAME _____

RECORD ON CHEMICALS FOR CLEANING AND DISINFECTION

Form 3

Chemical agent (commercial name)	Date of receipt	Supplier (name/phone/mail)	Description (type of agent, purpose)	Protection measures

SLAUGHTER OF POULTRY AND LAGOMORPHS ON THE HOLDING – SAMPLING PLAN

Specie	Annual capacity (pcs.)	Number of samples*
Broilers	up to 5.000	1 sample in 6 months (semi annually)
Poultry - geese, ducks и turkeys	up to 1.000	1 sample in 6 months (semi annually)
Lagomorphs	up to 1.000	1 sample in 6 months (semi annually)

*Samples are taken separately for each species

Process hygiene criteria

Food category	Microorganisms	Sampling frequency	Limits	Analytical reference method	Stage where the criterion applies	Action in case of unsatisfactory results
Poultry carcasses (broilers and turkeys)	<i>Salmonella spp.</i>	1 sample in 6 months (semi annually)	Absence in 25 g of a pooled sample of neck skin	EN/ISO 6579	Carcasses after chilling	Improvements in slaughter hygiene; Review of: – process controls; – biosecurity measures in the farm, – additional sampling

Sampling rules for poultry carcasses

When testing for the process hygiene criterion for salmonella in poultry carcasses in slaughterhouses, neck skins from a minimum of 15 poultry carcasses shall be sampled at random after chilling. A piece of approximately 10 g from neck skin shall be taken from each poultry carcass. The neck skin samples from three poultry carcasses from the same flock of origin shall be pooled before examination in order to form 5 x 25 g final samples.

For sampling and preparation of test samples, the relevant standards of the ISO (International Organisation for Standardisation) and the guidelines of the Codex Alimentarius shall be used as reference methods.

Interpretation of the test results

- Satisfactory, if all the values observed indicate the absence of the bacterium *Salmonella spp.*
- Unsatisfactory, if the presence of the *Salmonella spp.* is detected in any of the sample units.

