

## Chapter Ag 47

## MEAT INSPECTION

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**History:** Chapter Ag 47 as it existed on December 31, 1967 was repealed and a new chapter Ag 47 was created effective January 1, 1968.

**Ag 47.01 Definitions.** As used in this chapter:

(1) "Department" means the State of Wisconsin, Department of Agriculture.

(2) "Inspector" means an inspector employed by the department.

(3) "Veterinarian" means a licensed veterinarian who is qualified on the basis of training and experience, as determined by the department, to properly perform both ante-mortem and post-mortem inspection of meat and poultry.

(4) "Establishment" means a plant or premises where animals or poultry are slaughtered for human consumption, or a plant or premises where meat or poultry products or meat food products are processed for sale, but shall not include:

(a) Establishments subject to the federal meat inspection act (21 U.S.C. 71 et seq.) or the federal poultry products inspection act (21 U.S.C. 451 et seq.).

(b) Establishments subject to county or municipal meat and poultry inspection if such inspection is conducted pursuant to ordinances and regulations which are substantially equivalent to this section and which are enforced with equal effectiveness, and the inspection service is specifically approved by the department.

(c) Establishments where animals and poultry are slaughtered as a custom service for the owners thereof and no other slaughtering is done.

(d) Premise where animals or poultry are slaughtered by the producer or owner thereof for his own consumption.

(5) "Meat products" and "poultry products" means the carcasses or edible parts of carcasses and poultry.

(6) "Meat food product" means any article intended for use as human food which is derived or prepared in whole or in substantial and definite part from meat products and poultry products.

(7) "Wholesome" means sound, healthful, clean, and otherwise fit for human food.

(8) "Unwholesome" means: (a) Unsound, injurious to health or otherwise rendered unfit for human food.

(b) Consisting in whole or part of any filthy, putrid or decomposed substance.

(c) Processed, prepared, packed or held under unsanitary conditions whereby a carcass or parts thereof, or any meat or poultry product, may have become contaminated with filth or become injurious to human health.

(d) Produced in whole or in part from diseased animals or poultry, except when such disease does not ordinarily render the carcasses of such animals or poultry unfit for human consumption, or from animals or poultry which have died otherwise than by slaughter.

(9) "Official inspection mark" means the symbol formulated under the rules of the department to state that the meat, poultry or product was inspected pursuant to such rules.

(10) "Wis. inspected and passed" means the meats, meat products, poultry products and meat food products so marked have been inspected and passed under the regulations of the Wisconsin department of agriculture and were found to be sound, healthful, wholesome and fit for human food.

(11) "Wis. inspected and condemned" means the carcass, viscera, part of carcass, meat product or poultry product or meat food product so marked or identified is unfit for human food, or that the animal so marked has been found on ante-mortem or post-mortem inspection to be unfit for human food.

(12) "Wis. suspect" means the animal so marked is suspected of being affected with a disease or condition which may require its condemnation, in whole or in part, when slaughtered, and is subject to further examination by an inspector to determine its disposal.

(13) "Wis. retained" means the carcass, viscera, meat product, poultry product, meat food product, or other article so marked is held for further examination by an inspector to determine its disposal.

(14) "Animal" means cattle, sheep, swine, goats, and horses.

(15) "Carcass" means all parts, including the viscera, of slaughtered animals and poultry, that are capable of being used for human food.

(16) "Poultry" means any domesticated fowl, including but not limited to chickens, turkeys, geese, ducks, pigeons, or guineas, but shall not include commercially slaughtered game birds.

(17) "Meat" means the edible part of the muscle of cattle, sheep, swine, goats, or horses which is skeletal or which is found in the tongue, in the diaphragm, in the heart, or in the esophagus, with or without the accompanying and overlying fat, and the portions of bone, skin, sinew, nerve, and blood vessels which normally accompany the muscle tissue and which are not separated from it in the process of dressing. It does not include the muscle found in the lips, ears, or snout.

(18) "Meat by-product" means any edible part other than meat which has been derived from one or more cattle, sheep, swine, goats, or horses.

(19) "Product" means any part or all of the meat, meat by-product, poultry product, or meat food product.

(20) "Person" means natural person, individual, firm, partnership, corporation, company, society, and association, and every officer, agent, or employee thereof. This term shall impart either the singular or the plural, as the case may be.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.

**Ag 47.02 Facilities and sanitation. (1) RESPONSIBILITY.** (a) Every establishment shall be maintained and operated in conformity with the requirements of this section.

(b) Failure to maintain an establishment which complies with the requirements of this chapter shall be grounds for immediate suspension, denial or revocation of license.

(c) Licenses shall be displayed in a conspicuous place on the premises.

(2) **PREMISES.** (a) No establishment or holding pens shall be so located or maintained as to create a nuisance.

(b) All newly constructed establishments shall be so located in accordance with applicable zoning ordinances and shall be constructed in accordance with all applicable state and local building, plumbing, and electrical codes. Plans for construction or alteration shall be submitted to the department for approval.

(c) Grounds surrounding the establishment shall be well drained and kept clean and free of accumulated rubbish or other nuisance, contamination hazard or vermin harborage.

(d) Driveways at receiving and shipping doorways shall be constructed or treated and maintained so as to minimize dust and dirt.

(3) **BUILDINGS.** (a) All establishment buildings shall be so constructed as to prevent the entrance or harboring of vermin and insects. Doors and windows or other openings to the outside shall be provided with screens.

(b) All dogs, cats, other pets and birds shall be excluded.

(c) Floors, walls, ceilings, partitions, posts, doors, and all other construction features of slaughtering rooms, processing rooms, chill rooms, or rooms where edible product is stored, shall be constructed of such material and finish that they may be readily and thoroughly cleaned and shall be kept in a clean and sanitary condition. Floors shall be constructed of hard surface concrete or other impervious materials. Any floor cracks which may develop shall be promptly repaired. Interior construction features consisting of cement blocks or other porous material, in rooms where edible products are handled, shall be treated to render such material impermeable.

(d) Floor drains shall be equipped with traps and grills which shall be so located as to drain all waste liquids. Blood traps or other methods of collecting and disposing of blood shall be provided.

(e) Parts shall be so located that the product does not become contaminated through contact with floors, walls, or other structures.

(4) **FACILITIES.** (a) Establishments shall be provided with a supply of safe, running water. If such supply is from a private source, it shall be tested at least once each year. Effective means shall be provided to prevent back-siphonage of liquids into the potable water supply or steam lines.

(b) Ample supplies of hot and cold running water shall be available for all purposes in the slaughter room and in all processing rooms. Hot water for sanitizing purposes shall be not less than 180° F. at point of usage.

(c) A utility sink with hot and cold running water shall be provided in the slaughter room and in each processing room.

(d) Hand washing facilities, which may be a utility sink with hot and cold running water, soap from dispensers, and single service towels, shall be provided in the slaughter room and in each processing room.

(e) Toilets located within the plant shall be of the flush type, vented to the outside.

(f) Toilet room doors may not open directly into any processing room.

(g) Outdoor toilets shall be equipped with self-closing doors and shall be insect and rodent proof.

(h) Establishments shall be well lighted, well ventilated, and adequately heated, except where refrigeration is required.

(i) A water-tight, covered box, bin or vault shall be provided for storage of manure and stomach contents.

(j) Covered water-tight containers or separate rooms shall be provided for storage of offal.

(k) Refrigerated space adequate for the prevention of spoilage shall be provided to chill and hold carcasses, parts and products, unless there is immediate transportation to another premises where similar refrigeration is provided.

(5) EQUIPMENT AND UTENSILS. (a) All utensils and equipment used in connection with the slaughtering of animals, processing of meat, storing or otherwise handling of meat, shall be of such material and construction that they may be thoroughly cleaned.

(b) Copper and its usual alloys, cadmium, and lead shall not be used in equipment contacting edible products.

(c) Equipment with painted surfaces in the product zone and containers made of enamelware or porcelain shall not be used in the handling and processing of the product.

(d) Plastic materials and resinous castings must be abrasion and heat resistant, shatterproof, nontoxic, and shall not contain a constituent that will migrate to meat or meat product in contact with the material. All such materials shall be approved for food usage.

(e) All gasketing and packing materials must be nontoxic, nonporous, nonabsorbent, and unaffected by food products and cleaning compounds.

(f) Where necessary for proper cleaning and inspection, equipment shall be easily demountable.

(g) All bearings shall be located outside the product zone and shall be constructed with removable seals at the entrance of the shaft into the product zone.

(h) All parts of the product zone shall be free of recesses, open seams, crevices, protruding ledges, inside threads, inside shoulders, inside bolts, or rivets and bead ends.

(i) Where necessary for sanitary maintenance, equipment shall be constructed and installed so as to be completely self-draining.

(j) All safety or gear guards must be readily removable for cleaning and inspection.

(k) All parts of the product zone shall be readily accessible to sight and reach for cleaning and inspection.

(l) A suitable room or designated drained area shall be provided for washing handtrucks, hooks, gambrels, boxes, trays and demountable meat processing equipment.

(m) When in the opinion of the department, use of any equipment which is unclean or unsanitary or improperly constructed could lead to contamination of product, the department may attach a rejected tag to it. No equipment, utensil, or container so tagged shall be used until made acceptable and released by a department representative, or such equipment shall be replaced with acceptable equipment.

(6) PERSONNEL. (a) Employees handling meat or meat products shall keep hands clean and shall wash hands prior to returning to work from the toilet room.

(b) All employees working with or in the vicinity of meat or meat products in open containers shall wear head covers.

(c) Outer clothing and gloves worn by persons who handle meat or meat products shall be made of material which can be readily cleaned and shall be kept clean.

(7) SANITATION. (a) To assure sanitary operation, all equipment, such as scalding tanks, receptacles, tubs, chutes, platforms, racks, tables, knives, saws, trays, cleavers, tools, and machinery used in moving, handling, eviscerating, skinning, dehairing, chopping, cutting, or processing animals and meat, shall be thoroughly cleaned immediately after each day's use, and more frequently if necessary to maintain proper sanitary condition.

(b) Floors in the slaughtering area shall be hosed and cleaned immediately following each day's operation and more frequently if necessary to maintain proper sanitary condition. The hosing and cleaning of floors and walls shall be conducted in such manner and at such time as to avoid splashing of floor liquids on carcass meat.

(c) Hoist chains or cables shall not be permitted to come in contact with meat.

(d) Product containers, either new or reused, shall be protected from any form of insanitary condition during storage and shall not be used for any other purpose.

(e) Properly located sterilizing facilities for cleansing and disinfecting equipment and utensils shall be provided at places in the establishment where operations are likely to result in the contamination of such equipment and utensils.

(f) Meat products shipped from or to establishments shall be covered in such a way that they will be adequately protected against dust, dirt, and insects.

(g) Slack barrels and similar containers and vehicles shall be clean and lined with suitable material that will prevent contamination of meat products. Slack barrels, containers, and vehicles in which any meat product is transported shall be kept in clean and

sanitary condition. Any paper used for covering or lining slack barrels and similar containers and vehicles shall be of a kind that does not tear during use, but remains intact when moistened by the meat product.

(h) The use of burlap as a wrapping for meat is not permitted unless the meat is first wrapped with a good grade of moisture resistant paper or cloth of a kind that will prevent contamination with lint or other foreign matter.

(i) Second-hand tubs, barrels, and boxes may be used as containers of meat or meat products if they do not show any evidence of misuse and are thoroughly cleaned and lined with moisture resistant paper or plastic before being reused.

(8) RESTRICTIONS. (a) Inedible offal and other inedible by-products shall not be rendered, boned, ground, frozen, or otherwise treated with any of the utensils or equipment or stored in rooms used in the slaughtering or processing of edible product, provided the washing of offal in the slaughtering room shall be permitted. The rendering or otherwise treating of inedible product shall be completely segregated in separate rooms, apart from any edible food operation. There shall be no intermingling of inedible and edible food operations.

(b) Dead animals, which have died by means other than slaughter or any parts of such animals, shall not be received or kept on the premises of an establishment. Animals which have died in transit may be unloaded for immediate disposal, but no such animal shall be brought into the establishment, or dismembered or stored on slaughterhouse premises.

(c) No person shall knowingly receive or keep on premises of an establishment any animal which is obviously emaciated or ravaged by disease, or any animal which has been treated by a veterinarian for a diseased condition which may cause the carcass to be unfit for human consumption.

(d) No person shall conduct an inedible rendering operation on premises of an establishment, except to render byproducts of his own slaughtering operation.

(e) Inedible product which closely resembles an edible product shall be rendered or denatured by addition of a substance approved by the department which decharacterizes the color, odor, or taste to such an extent that it can be easily distinguished from a corresponding edible product. Inedible products saved for animal food shall be similarly treated and shall be placed in containers plainly marked "inedible."

(f) Carcass meat or finished product shall not be taken into or through the slaughter room at any time when slaughtering operations are being conducted.

(g) The slaughter room shall not be used as a chill room or as a storage room or for processing.

(h) Manure, offal or other inedible byproduct shall not be permitted to accumulate in or around a slaughterhouse plant.

(i) Spitting or urinating on floors or floor drains shall be prohibited.

(j) Smoking is prohibited in all slaughter areas or other places where meat or meat product is handled in open containers.

(k) No person afflicted with a communicable disease or who has a discharging or infected wound, sore or lesion on hand, arms or other exposed portion of the body shall be permitted in any room or compartment where meat or meat products are slaughtered, processed or handled.

(9) **PLANT ALTERATIONS; TIME LIMIT.** If in the opinion of the department it is necessary that alterations, additions or changes be made in an establishment, or equipment, a written notice shall be given or mailed to the operator of such plant, requiring such alterations, additions, or changes to be made within 60 days; provided, however, that if the required alterations cannot be made with reasonable diligence within 60 days, the department may extend the time not to exceed 180 days from receipt of notice. Failure to comply with such department directive shall be grounds for license revocation or suspension.

(10) **APPLICABILITY.** Slaughterhouses licensed under section 97.07, Wis. Stats., shall also be constructed, maintained and operated in conformity with this section.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.

**Ag 47.03 Ante-mortem inspection.** (1) **SCOPE OF INSPECTION.** All animals shall receive an ante-mortem inspection on the day of slaughter at the establishment where they are to be slaughtered.

(2) **FACILITIES FOR INSPECTION.** (a) Pens where animals are held for inspection shall have adequate natural or artificial light during the hours inspection is performed.

(b) Pens, stocks or chutes shall be provided where individual animals can be examined conveniently and safely.

(c) Establishments shall provide personnel to assist in the handling and restraining of animals being examined.

(3) **SUSPECT ANIMALS.** (a) All animals that, on ante-mortem inspection, do not plainly show but are suspected of being affected with any disease or condition which may cause condemnation in whole or in part on post-mortem inspection, shall be tagged "Suspect" so as to retain their identity until final post-mortem inspection has been made. No animal tagged "Suspect" shall have the tag removed except by a departmental employee or under his supervision.

(b) No animal classified "Suspect" shall be released for a purpose other than slaughter, without prior approval of the department. The reason for requesting release shall be submitted in writing and signed by the owner of the animal.

(4) **ANTE-MORTEM CONDEMNATION.** All animals plainly showing on ante-mortem inspection any disease or condition that would cause the carcass to be unfit for human consumption, shall be condemned. Condemned animals shall be marked "Wis. inspected and condemned" and shall not be slaughtered in the establishment. Such animals shall be disposed of under the supervision of the department.

(5) **ANIMALS SUBJECT TO CONDEMNATION.** (a) Animals received in a dead or dying condition shall be condemned. Causes for con-

demnation on ante-mortem inspection may include, but is not limited to, severe manifestations of the following conditions:

1. Elevated temperature
2. Cripples and downers
3. Malignant neoplasms
4. Multiple abscesses
5. Immaturity
6. Emaciation
7. Icterus
8. Polyarthrititis
9. Central nervous diseases
10. Edema or anasarca

(b) Swine with temperatures 106° F. or higher, and cattle, sheep and goats with temperatures 105° F. or higher, will be condemned or held for a reasonable period of time for observation. Animals not returning to normal temperature ranges will be condemned. Those returning to normal temperatures may be admitted to slaughter at the discretion of the inspector.

(c) Animals that are known reactors to the tuberculin test shall be marked and treated as suspects.

(d) Animals suspected of having been treated or exposed to any substance in a manner which may impart a biological residue or reaction that may make the edible tissues of the animal unwholesome or otherwise unfit for human food, shall be marked "Suspect." The animals shall be held under custody of department employee or other responsible official supervision until it can be expected that metabolic processes have reduced the residue or reaction sufficiently to make the tissues of the animals fit for human food.

(e) Any animals with vesicular condition or other reportable disease shall be reported immediately to state and federal animal health officials. Such animals will be held back from slaughter for further observation and diagnostic tests. Final disposition of these animals shall be dependent upon the identification of the disease.

(6) **EMERGENCY SLAUGHTER.** In all cases of emergency slaughter, the animals shall be inspected immediately before slaughter, whether inspected before or not. When the necessity for emergency slaughter exists, the establishment shall notify the meat inspector so that such inspection may be made. In the absence of a departmental employee, a licensed practicing veterinarian may be called at the establishment's expense and such veterinarian shall submit to the department a written statement of his findings.

(7) **ANIMALS HELD FOR TREATMENT.** Animals with symptoms of disease which appear amenable to treatment may be held for treatment and observation apart from other animals under the supervision of the inspector.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.

**Ag 47.04 Post-mortem inspection, (1) SCOPE OF INSPECTION.** A careful post-mortem examination and inspection shall be made of the carcasses and parts of all animals slaughtered at establishments operating under state meat inspection. Such inspection and examination shall be made at the time of slaughter. All animals and parts

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of animals shall be identified in such manner that the identity of all parts is maintained until after post-mortem inspection has been completed. When whole carcasses are condemned, all parts are condemned.

(2) FACILITIES FOR CONDUCTING POST-MORTEM INSPECTION. Each establishment under state meat inspection shall furnish: (a) Natural or artificial lighting, or a combination may be used. A minimum of 50 foot candles of light shall illuminate the material examined at an inspection point. At least 20 foot candles of illumination shall be supplied elsewhere in an operating room.

(b) Soap from dispensers, hot water, and clean, disposable towels shall be supplied for inspectors' use, conveniently located at inspection points.

(c) Head racks shall be provided for the examination of head lymph nodes, tongue and the muscles attached to the mandible.

(d) Offal carts with pluck pans or other suitable pans or tables shall be provided for the examination of the abdominal and thoracic organs.

(e) Sanitary, water-tight trucks or receptacles for holding and handling diseased carcasses, parts and other inedibles shall be so constructed as to be readily cleaned. Such trucks or receptacles shall be plainly marked "inedible" and shall not be utilized for edible products.

(f) Compartments and receptacles in such number and in such locations as may be required, shall be provided for carcasses and meat products that are held for further inspection. They shall be so constructed and equipped that they may be securely locked with locks furnished by the department, the keys remaining in the custody of the department. Every such compartment or receptacle shall be plainly marked "Wis. Retained."

(g) Locked storage space shall be provided for stamps, brands and other inspection supplies. Desk or suitable table space shall be provided for writing and other clerical duties associated with inspection at the establishment. Each inspector shall be provided with a metal locker at least 15 x 18 x 60 inches for storing clothing and personal effects.

(3) INSPECTION PROCEDURES. (a) The head, tongue, tail, thymus gland, all viscera and all parts, and blood to be used in the preparation of meat food products or medicinal products, shall be held in such manner as to preserve their identity until a post-mortem examination has been completed. Spermatic cords shall be removed from hog carcasses and pizzles shall be removed from all carcasses. The heads of cattle shall be removed in a manner to avoid contamination from paunch contents. The skinned heads shall not be permitted to come in contact with the floor. The horns and all pieces of hide shall be removed before the heads are flushed and washed. All carcasses and parts shall be presented in a manner suitable for inspection.

(b) Each carcass, parts, detached inedible parts and organs, in which any lesion of disease or other condition is found that might render the meat or organ unfit for food purposes, and which for that reason would require a subsequent inspection, shall be retained by the inspector at the time of inspection. The identity of every such

retained carcass, parts, detached inedible part and detached organ shall be maintained until the final inspection has been completed. Retained carcasses shall not be washed or trimmed unless authorized by the inspector.

(c) Such devices and methods as are approved by the department may be used for the temporary identification of retained carcasses, parts, detached inedible parts or organs. In all cases the identification shall be further established by affixing "Wis. Retained" tags as soon as practicable and before final inspection. These tags shall not be removed by any person other than a department employee.

(d) Each carcass or part that is found on final inspection to be unsound, unhealthful, unwholesome or otherwise unfit for human food shall be conspicuously marked "Wis. Inspected and Condemned." Condemned detached organs and parts of such character that they cannot be so marked shall be placed immediately in trucks or receptacles which shall be plainly marked "Condemned." All condemned carcasses and parts for non food use shall be condemned and disposed of under the supervision of a department employee by rendering, denaturing, or other manner as prescribed.

(e) Carcasses and parts found to be sound, healthful, wholesome, and fit for human food shall be marked "Wis. Inspected and Passed."

(f) Carcasses and parts passed for cooking shall be conspicuously marked or tagged "Passed for Cooking."

(g) In all cases where carcasses showing localized lesions are passed for food, the diseased parts shall be removed before the "Wis. Retained" tag is taken from the carcass. Such diseased parts shall be condemned.

(h) Carcasses found before evisceration to be affected with anthrax shall be condemned. Detached inedible parts and organs found to be affected with anthrax shall be condemned. The parts of any carcass contaminated with anthrax-infected material through contact with soiled instruments, or otherwise contaminated, shall be immediately condemned. The scalding vat water through which hog carcasses affected with anthrax have passed, shall be immediately drained into the sewer. All parts of the scalding vat shall be cleaned and disinfected. That portion of the slaughtering department, including bleeding area, scalding vat, gambrelling bench, floors, walls, posts, platforms, saws, cleavers, knives, hoods, and other equipment, as well as employees' boots and aprons, that have become contaminated through contact with anthrax-infected material, shall be cleaned immediately and disinfected. When a disinfectant solution has been applied to equipment that will afterwards contact meat, the equipment shall be rinsed with clean water before again being used.

(i) When a calf carcass is to be dressed with the skin or hide left on, the skin or hide shall be thoroughly washed and cleansed before any incision is made for the purpose of removing any part or for evisceration.

(j) All hair, scurf, dirt, hoofs and claws shall be removed from the hog carcasses, and the carcasses thoroughly washed and cleansed, before any incision is made for inspection or evisceration.

(k) The sternum of each carcass shall be split and spread apart at the time of slaughter, so as to expose the lungs, heart, liver, and thoracic cavity, in order to allow proper inspection and drainage.

(l) Carcasses or parts shall not be inflated with air. Transferring the caul or other fat from a fat to a lean carcass is prohibited.

(m) When only a portion of a carcass is to be condemned because of bruises, bruised portion shall be removed immediately. No carcass shall be stamped "Wis. Inspected & Passed" until the bruised portion has been removed.

(n) All cattle, calf and sheep lungs intended for food purposes shall be inspected to determine whether foreign matter is present in the air passages. The main bronchi and branches shall be slit by the inspector. If ingesta or other objectionable foreign matter has entered these passages, the lung shall be condemned.

(o) Hog lungs shall not be saved as edible meat products.

(p) Lactating mammary glands and diseased mammary glands of cattle, sheep, swine and goats shall be removed without opening the milk ducts or sinuses. If pus or other objectionable material is permitted to come in contact with the carcass, the part thus contaminated shall be removed and condemned. Lactating mammary glands of cattle, sheep, swine and goats shall not be saved for edible purposes.

(q) Tonsils shall be removed and shall not be used as ingredients of meat food products.

(r) Hog blood shall not be used as an ingredient of meat food product. No blood which comes in contact with the surface of the body of an animal or is otherwise contaminated shall be collected for food purposes. Only blood from animals, the carcasses of which are inspected and passed, may be used for meat food products. The defibrination of blood intended for food purposes shall not be performed with the hands.

(s) Clotted blood shall be removed from hog hearts.

(t) Inspectors shall make such incisions or inspections as are essential to determine the presence, character, and extent of any condition that might have a bearing in the disposition of the carcass or any part.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.

**Ag 47.05 Disposal of diseased carcasses and parts. (1) GENERAL.**

(a) Cause for condemnation on post-mortem inspection may include but is not limited to the following conditions:

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|-------------------------------------|---|
| 1. Pyemia                           | 12. Uremia  |
| 2. Bacteremia                       | 13. Sex or other offensive odors                                    |
| 3. Viremia                          | 14. Suffocation or incomplete bleeding                              |
| 4. Toxemia                          | 15. Extensive parasitism, such as cysticercosis or sarcosporidiosis |
| 5. Septicemia                       | 16. Tuberculosis  |
| 6. Generalized anasarca or edema    | 17. Malignant neoplasms   |
| 7. Biological residues or reactions | 18. Emaciation  |
| 8. Extreme hemorrhaging or bruising | 19. Unborn or stillborn animals                                     |
| 9. Polyarthritis                    | 20. Immaturity  |
| 10. Icterus                         | 21. Encephalitis  |
| 11. Anemia                          |   |

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(b) Parts of carcasses may be condemned for:

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|---|---|
| 1. Contamination with filth,<br>hair, chemicals or other<br>offensive materials | 5. Bruises, hemorrhages and<br>fractures                  |
| 2. Abscesses  | 6. Non-malignant neoplasms                                |
| 3. Localized parasitism   | 7. Granuloma  |
| 4. Localized infections, such<br>as chronic pneumonia                           | 8. Cirrhosis, necrosis, or other<br>forms of degeneration |
|   | 9. Pigmentation   |
|   | 10. Dermatitis  |

(2) TUBERCULOSIS. Carcasses of animals affected with tuberculosis shall be disposed of as follows:

(a) The entire carcass shall be condemned if any of the following conditions occur:

1. When the lesions of tuberculosis are generalized. Tuberculosis is considered to be generalized when the lesions are distributed in a manner made possible only by entry of the bacilli into the systemic circulation.
2. When the animal was observed to have a fever on ante-mortem inspection which was found to be associated with an active tuberculous lesion on post-mortem inspection.
3. When there is an associated cachexia.
4. When tuberculous lesions are found in the muscles or inter-muscular tissues, or bones, or joints, or in the body lymph nodes as a result of draining the muscles, bones, or joints.
5. When the lesions are extensive in organs and tissues of either the thoracic or the abdominal cavity.
6. When the lesions are multiple, acute, and actively progressive.
7. When the lesions are more extensive than those described under paragraph (c) of this subsection and the character or extent of the lesions are not indicative of a localized condition.

(b) An edible organ or other part of a carcass affected by localized tuberculosis shall be condemned when it contains lesions of tuberculosis or when the corresponding lymph node contains lesions of tuberculosis.

(c) A distinction shall be made between the disposition of carcasses of cattle and swine affected with tuberculosis.

1. The disease in swine usually affects the digestive system primarily. The carcass may be passed for food after disposal of the affected parts as required by paragraph (b) of this subsection, when the lesions are localized and confined to the primary seats of infection, such as cervical lymph nodes, mesenteric lymph nodes, and hepatic lymph nodes.

2. The disease in cattle usually affects the respiratory system primarily. The carcass may be passed for food after disposal of the affected parts as required by paragraph (b) of this subsection, when the lesions are localized and confined to the primary seats of infection, such as the cervical lymph nodes, the bronchial lymph nodes, and the mediastinal lymph nodes, and have not progressed beyond the mesenteric lymph nodes. In the case of other animals, carcasses demonstrating lesions of tuberculosis shall not be passed for food.

(d) Carcasses which reveal lesions more severe or more numerous than those described in paragraph (c) of this subsection, but not

so severe nor so numerous as the lesions described in paragraph (a) of this subsection, may be passed for cooking.

(3) HOG CHOLERA. The carcasses of all hogs affected with hog cholera shall be condemned.

(4) SWINE INJECTED WITH HOG CHOLERA VIRUS. (a) Carcasses of swine, other than hyperimmune swine, if presented for inspection after 28 days following injection with hog cholera virus, shall be given post-mortem inspection in conformity with this part without reference to the injected virus.

(b) Hyperimmune swine, if presented for inspection after 10 days following hyperimmunization, shall be given post-mortem inspection in conformity with this part without reference to the injected virus.

(5) SWINE ERYSIPELAS. Carcasses affected with swine erysipelas which is acute or generalized, or which show systemic change, shall be condemned.

(6) DIAMOND-SKIN DISEASE. Carcasses of hogs affected with diamond-skin disease when localized and not associated with systemic change may be passed for food after removal and condemnation of the affected parts, provided such carcasses are otherwise in good condition.

(7) ARTHRITIS. (a) Carcasses affected with arthritis which is localized and not associated with systemic change may be passed for food after removal and condemnation of all affected parts. Affected joints with corresponding lymph nodes shall be removed and condemned. In order to avoid contamination of the meat which is passed, a joint capsule shall not be opened until after the affected joint is removed.

(b) Carcasses affected with arthritis shall be condemned when accompanied by evidence of systemic involvement.

(8) ANASARCA OR GENERALIZED EDEMA. (a) Carcasses of cattle found on post-mortem inspection to be affected with anasarca in advanced stages and characterized by an extensive or well-marked generalized edema shall be condemned.

(b) Carcasses of cattle, including their detached parts and organs, found on post-mortem inspection to be affected with anasarca to a lesser extent than in paragraph (a) of this subsection, may be passed for food after removal and condemnation of the affected tissues provided the lesion is localized.

(9) ACTINOMYCOSIS AND ACTINOBACILLOSIS. (a) The definition of generalization as outlined for tuberculosis in subsection (2) (a) shall apply for actinomycosis and actinobacillosis, and carcasses of animals so affected shall be condemned.

(b) Carcasses of animals in a well-nourished condition showing uncomplicated localized lesions of actinomycosis or actinobacillosis may be passed after the infected organs or parts have been removed and condemned, except as provided in paragraphs (c) and (d) of this subsection.

(c) Heads affected with actinomycosis or actinobacillosis, including the tongue, shall be condemned, except that when the disease of the jaw is slight, strictly localized, and without suppuration, fistulous tracts, or lymph node involvement, the tongue, if free from disease.

may be passed, or, when the disease is slight and confined to the lymph nodes, the head, including the tongue, may be passed after the affected nodes have been removed and condemned.

(d) When the disease is slight and confined to the tongue, with or without involvement of the corresponding lymph nodes, the head may be passed after removal and condemnation of the tongue and corresponding lymph nodes.

(10) ANTHRAX, BLACKLEG, OR MALIGNANT EDEMA. Carcasses of animals affected with anthrax, blackleg, or malignant edema shall be condemned.

(11) NEOPLASMS. An individual organ or other part of a carcass affected with a neoplasm shall be condemned. If there is evidence of metastasis or the general condition of the animal has been adversely affected by the size, position or nature of the neoplasm, the entire carcass shall be condemned.

(12) EPITHELIOMA OF THE EYE OF CATTLE. (a) Carcasses of animals affected with epithelioma of the eye, of the orbital region, and/or of the corresponding parotid lymph node, shall be condemned in their entirety if one of the following 3 conditions exists:

1. The affection has involved the osseous structures of the head with extensive infection, suppuration, and necrosis.

2. There is metasis from the eye, the orbital region, and/or the corresponding parotid lymph node to other lymph nodes, internal organs, muscles, skeleton, or other structures, regardless of the extent of the primary tumor; or

3. The affection, regardless of extent, is associated with cachexia or evidence of absorption or secondary changes.

(b) Carcasses of animals affected with epithelioma of the eye, of the orbital region, and/or of the corresponding parotid lymph node to a lesser extent than in paragraph (a) of this subsection, may be passed for food after removal and condemnation of the head, including the tongue, provided the carcass is otherwise in good condition.

(13) PIGMENTARY CONDITION; MELANOSIS, XANTHOSIS, OCHRONOSIS; DISPOSITION OF CARCASSES AND PARTS. Carcasses of animals showing generalized pigmentary deposits shall be condemned. Affected parts of carcasses showing localized pigmentary deposits of such character as to be unwholesome or otherwise unfit for food shall be removed and condemned.

(14) ABRASIONS, BRUISES, ABSCESES, PUS. All slight, well-limited abrasions, when without lymph node involvement, shall be carefully excised, leaving only sound, normal tissue, which may be passed. Any organ part of a carcass which is badly bruised or which is affected by an abscess, or a suppurating sore shall be condemned; and when the lesions are of such character or extent as to affect the whole carcass, the whole carcass shall be condemned. Portions of carcasses which are contaminated by pus or other diseased material shall be condemned.

(15) BRUCELLOSIS. Carcasses affected with localized lesions of brucellosis may be passed for food after the affected parts are removed.

(16) INFECTED CARCASSES. (a) All carcasses of animals so infected that consumption of the products thereof may give rise to food

poisoning shall be condemned. This includes all carcasses showing signs of:

1. Acute inflammation of the lungs, pleura, pericardium, peritoneum or meninges.
2. Septicemia or pyemia, whether puerperal, traumatic, or without any evident cause.
3. Gangrenous or severe hemorrhagic enteritis or gastritis.
4. Acute diffuse metritis or mammatis.
5. Phlebitis of the umbilical veins.
6. Salmonellosis.
7. Septic or purulent traumatic pericarditis.
8. Any acute inflammation, abscess, or suppurating sore, if associated with acute nephritis, fatty and degenerated liver, swollen soft spleen, marked pulmonary hyperemia, general swelling of lymph nodes, diffuse redness of the skin, cachexia, icteric discoloration of the carcass, or the like, either singly or in combination.

(b) Implements contaminated by contact with carcasses affected with any of the diseased conditions mentioned in this section shall be thoroughly cleaned and disinfected. Carcasses or parts of carcasses contaminated by contact with such diseased carcasses shall be condemned unless all contaminated tissues are removed within 2 hours.

(17) **NECROBACILLOSIS, PYEMIA, SEPTICEMIA.** Necrobacillosis may be regarded as a local affection at the beginning, and carcasses in which lesions are so localized may be passed for food if in a good state of nutrition, after removing and condemning those portions affected with necrotic lesions. When emaciation, cloudy swelling of the parenchymatous tissue of organs or enlargement of the lymph nodes is associated with the affection, and the disease has progressed beyond the condition of localization, the entire carcass shall be condemned. When pyemia or septicemia are present, the carcass shall be condemned.

(18) **CASEOUS LYMPHADENITIS.** (a) A thin carcass showing well-marked lesions in the viscera and the skeletal lymph nodes, or such a carcass showing extensive lesions in any part shall be condemned.

(b) A thin carcass showing well-marked lesions in the viscera with only slight lesions elsewhere or showing well-marked lesions in the skeletal lymph nodes with only slight lesions elsewhere, may be passed for cooking:

(c) A thin carcass showing only slight lesions in the skeletal lymph nodes and in the viscera may be passed without restriction.

(d) A well-nourished carcass showing well-marked lesions in the viscera and with only slight lesions elsewhere or showing well-marked lesions confined to the skeletal lymph nodes with only slight lesions elsewhere may be passed without restriction.

(e) A well-nourished carcass showing well-marked lesions in the viscera and the skeletal lymph nodes may be passed for cooking; but where the lesions in a well-nourished carcass are both numerous and extensive, it shall be condemned.

(f) All affected organs and nodes of carcasses passed without restriction or passed for cooking shall be removed and condemned. The term "thin" as used in this section shall not be held applicable to a carcass which is anemic or emaciated.

(19) **ICTERUS.** Carcasses showing any degree of icterus with a parenchymatous degeneration of organs, the result of infection or intoxication, and those which show a pronounced yellow or greenish

yellow discoloration without evidence of infection or intoxication, shall be condemned. Other carcasses affected with icterus-like discoloration which disappears upon chilling, may be passed for food. If the discoloration does not disappear upon chilling, the meat from the carcasses may be passed for use in comminuted meat food product or for rendering.

(20) SEXUAL ODOR OF SWINE. (a) Carcasses of swine which give off a pronounced sexual odor shall be condemned.

(b) The meat of swine carcasses which gives off a sexual odor less than pronounced may be passed for use in comminuted cooked meat food product or for rendering. Otherwise it shall be condemned.

(21) MANGE OR SCAB. Carcasses of animals affected with mange or scab in advanced stages, showing cachexia or extensive inflammation of the flesh, shall be condemned. When the disease is slight, the carcass may be passed after removal of the affected portion.

(22) HOGS AFFECTED WITH URTICARIA, TINEA TONSURANS, DEMODEX, FOLLICULORUM OR ERYTHEMA. Carcasses of hogs affected with urticaria (nettle rash), tinea tonsurans, demodex folliculorum, or erythema may be passed after detaching and condemning the affected skin, if the carcass is otherwise fit for food.

(23) TAPEWORM CYSTS IN CATTLE. (a) Carcasses of cattle affected with tapeworm cysts shall be disposed of as follows:

1. Carcasses of cattle infested with tapeworm cysts shall be condemned if the infestation is excessive or if the meat is watery or discolored. Carcasses shall be considered excessively infested if incisions in various parts of the musculature expose one or more cysts on most of the cut surfaces.

2. Carcasses of cattle in which tapeworm cyst infestation is limited to one dead and degenerated cyst may be passed for food after removal and condemnation of the cyst.

3. Carcasses of cattle showing a slight or moderate tapeworm cyst infestation, as determined by a careful examination of the heart, muscles of mastication, diaphragm and its pillars, tongue, and portions of the carcass rendered visible by the process of dressing, may be passed for food after removal and condemnation of the cysts with surrounding tissue; provided that the carcasses are held in cold storage at a temperature not higher than 15 degrees F. continuously for a period of not less than 10 days; and that boned meat from such carcasses when in boxes, tierces, or other containers, is held at a temperature of not higher than 15 degrees F. continuously for a period of not less than 20 days. As an alternative to retention in cold storage, such carcasses and meat may be heated throughout to a temperature of at least 140 degrees F.

(b) The edible viscera of carcasses passed for food or passed for food after refrigeration or heating may be passed for food without refrigeration or heating if they are found to be free from cysts on final inspection. This shall not include the lungs, fat, muscles of the esophagus and the heart, which shall be subjected to heat or cold as described. The intestines, esophagi, and bladders from beef carcasses affected with tapeworm cysts which have been passed for food or passed for food after refrigeration or heating, may be used for casings.

(24) HOGS AFFECTED WITH TAPEWORM CYSTS (CYSTICERCUS CELLULOSAE). Carcasses of hogs affected with tapeworm cysts (cysticercus



cellulosae) may be passed for cooking, but if the infestation is excessive, the carcass shall be condemned.

(25) PARASITES NOT TRANSMISSIBLE TO MAN; TAPE WORM CYSTS IN SHEEP, HYDATID CYSTS; FLUKES, GID BLADDERWORMS. (a) In the disposal of carcasses, edible organs, and other parts of carcasses infested with parasites not transmissible to man, the following rules shall apply: If lesions are localized and can be completely removed, the non-affected portion of the carcass, organ or other part of the carcass may be passed for food after removal and condemnation of the affected portions. If an organ part of a carcass has numerous lesions caused by parasites, or if the character of the infestation is such that complete extirpation of the parasitic infestation is not possible, the affected part shall be condemned. If parasites are found to be distributed in a carcass in such a manner or to be of such character that their removal and the removal of the lesions caused by them is impracticable, no part of the carcass shall be passed for food.

(b) In the case of sheep carcasses affected with tapeworm cysts (*Cysticercus ovis*, sheep measles) such carcasses may be passed after the removal and condemnation of the affected portions; provided the cysts are not so generally distributed and so numerous that their removal would be impracticable, in which case the entire carcass shall be condemned.

(c) Carcasses found infested with gid bladderworms (*Coenurus cerebralis*, *Multiceps multiceps*) may be passed after condemnation of the affected organ.

(d) Organs or parts of carcasses infested with hydatid cysts (*Echinococcus*) shall be condemned.

(e) Livers infested with flukes or tapeworms shall be condemned.

(26) EMACIATION. Carcasses of animals too emaciated to produce wholesome meat, with serous infiltration of muscle tissues, or serous or mucoid degeneration of the fatty tissue, shall be condemned. A gelatinous change of the fat about the heart and kidneys of well-nourished carcasses and mere leanness shall not be classed as emaciation.

(27) CARCASSES OF YOUNG ANIMALS. Carcasses of young calves, pigs, kids, and lambs are unwholesome and shall be condemned if:

(a) The meat has the appearance of being water-soaked, is loose, flabby, tears easily, and can be perforated with the fingers.

(b) Its color is grayish red.

(c) Good muscular development as a whole is lacking, especially noticeable on the upper shank of the leg, where small amounts of serous infiltrates or small edematous patches are sometimes present between the muscles.

(d) The tissue which later develops as the fat capsule of the kidneys is edematous, dirty yellow, or grayish red, tough, and intermixed with islands of fat.

(28) UNBORN AND STILLBORN ANIMALS. All unborn and stillborn animals shall be condemned and no hide or skin thereof shall be removed from the carcass within a room in which edible products are handled.

(29) ANIMALS SUFFOCATED OR SCALDED ALIVE. All animals which have been suffocated in any way and hogs which have entered the scalding vat alive shall be condemned.

(30) LIVERS. (a) Livers affected with carotenosis shall be condemned.

(b) Cattle livers and calf livers showing the conditions sometimes designated as "telangiectatic," "sawdust," or "spotted" shall be disposed of as follows:

1. When any or all of the conditions are extensive and involve one-half or more of an organ, the whole organ shall be condemned.

2. When any or all of the conditions are slight in an organ, the whole organ shall be passed without restriction.

3. When any or all of the conditions are extensive and involve less than one-half of the organ, while in the remainder of the organ the conditions are slight, the remainder shall be passed without restriction and the other portion shall be condemned.

(31) ANEMIA. Carcasses of animals too anemic to produce wholesome meat shall be condemned.

(32) MUSCULAR CONDITIONS. (a) If muscular lesions are found to be distributed in such a manner or to be of such character that removal is impractical, the carcass shall be condemned.

(b) Lesions localized in such a manner and of such a character that the affected tissues can be removed, the non-affected parts of the carcass may be passed for food after the removal and condemnation of the affected portion.

(33) COCCIDIOIDAL GRANULOMA. (a) Carcasses which are affected with generalized coccidoidal granuloma or which show systemic changes because of such disease shall be condemned.

(b) Carcasses affected with localized lesions of this disease may be passed for food after the affected parts are removed and condemned.

(34) ODORS, FOREIGN AND URINE. (a) Carcasses which give off a pronounced odor of medicinal, chemical, or other foreign substance shall be condemned.

(b) Carcasses which give off a pronounced urine odor shall be condemned.

(c) Carcasses, organs or parts affected by odor to a lesser degree than that described in paragraphs (a) and (b) of this subsection and in which the odor can be removed by trimming or chilling may be passed for food.

(35) RADIATION. Meat from animals to which radioactive material has been administered for research, experimental or veterinary purposes shall be condemned if any radioactive material retained in the meat has not decayed to the normal radiation background level. The normal radiation background level shall mean the radiation background of similar samples of meat from animals to which radioactive material has not been administered when measured in the same manner as the meat from the animal to which radioactive material has been administered.

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Register, December, 1967, No. 144

**Ag 47.06 Prescribed treatment of pork and products containing pork to destroy trichinae.** (1) **PRODUCTS.** Products named in this subsection and products of the character thereof, containing pork muscle tissue (including hearts, pork stomachs, and pork livers), or the pork muscle tissue which forms an ingredient of such products, shall be effectively heated, refrigerated, or cured to destroy any possible live trichinae: bologna; frankfurts; viennas; smoked sausage, knoblauch sausage; mortadella; all forms of summer or dried sausage, including mettwurst; ground meat mixtures containing pork and beef, veal, lamb, mutton or goat meat and prepared in such a manner that they might be eaten rare or without thorough cooking; flavored pork sausage such as those containing wine or similar flavoring materials; cured pork sausage; sausage containing cured and/or smoked pork; cooked loaves; roasted, baked, boiled, or cooked hams; pork shoulders, or pork shoulder picnics; Italian-style hams; Westphalia-style hams; smoked boneless pork shoulder butts; cured meat rolls, capocollo (capicola, capacola); coppa; fresh or cured boneless pork shoulder butts, hams, loins, shoulders, shoulder picnics, and similar pork cuts, in casings or other containers in which ready-to-eat delicatessen articles are customarily enclosed (excepting Scotch-style hams); breaded pork products, cured boneless pork loins; boneless back bacon; smoked pork cuts such as hams, shoulders, loins and pork shoulder picnics (excepting smoked hams and smoked pork shoulder picnics which are specially prepared for distribution in tropical climates or smoked hams delivered to the armed services). Cured boneless pork loins shall be subjected to prescribed treatment for destruction of trichinae prior to being shipped from the establishment where cured.

(2) **TREATMENT.** Treatment shall consist of heating, refrigeration, curing, as follows:

(a) *Heating.* 1. All parts of the pork muscle tissue shall be heated to a temperature not lower than 137° F., and the method used shall be one known to insure such a result. On account of differences in methods of heating and in weights of products undergoing treatment it is impracticable to specify details of procedures for all cases.

2. Procedures which insure that proper heating of all parts of the product shall be adopted. It is important that each piece of sausage, each ham, and other product treated by heating in water be kept entirely submerged throughout the heating period; and that the largest pieces in a lot, the innermost links of bunched sausage or other massed articles, and pieces placed in the coolest part of a heating cabinet or compartment or vat be included in the temperature tests.

(b) *Refrigerating.* 1. At any stage of preparation and after preparatory chilling to a temperature of not above 40° F. or preparatory freezing, all parts of the muscle tissue of pork or pork product containing such tissue shall be subjected continuously to a temperature not higher than one of those specified in Table 1, the duration of such refrigeration at the specified temperature being dependent on the thickness of the meat or inside dimensions of the container.

TABLE 1—REQUIRED PERIOD OF FREEZING AT TEMPERATURE INDICATED

°F.	Temperature	Group 1 Days	Group 2 Days
5	-----	20	30
-10	-----	10	20
-20	-----	6	12

2. Group 1 comprises product in separate pieces not exceeding 6 inches in thickness, or arranged on separate racks with the layers not exceeding 6 inches in depth, or stored in crates or boxes not exceeding 6 inches in depth, or stored as solidly frozen blocks not exceeding 6 inches in thickness.

3. Group 2 comprises product in pieces, layers, or within containers, the thickness of which exceeds 6 inches but not 27 inches, and product in containers including tierces, barrels, kegs, and cartons having a thickness not exceeding 27 inches.

4. The product undergoing such refrigeration or the containers thereof shall be so spaced while in the freezer as will insure a free circulation of air between the pieces of meat, layers, blocks, boxes, barrels, and tierces in order that the temperature of the meat throughout will be promptly reduced to not higher than 5° F., -10° F., or -20° F., as the case may be.

(c) *Curing.* 1. Sausage. Sausage may be stuffed in animal casings, hydrocellulose casings, or cloth bags. During any stage of treating the sausage for the destruction of live trichinae, except as provided in Method 5, these coverings shall not be coated with paraffin or like substance, nor shall any sausage be washed during any prescribed period of drying. In the preparation of sausage, one of the following methods may be used:

a. Method No. 1. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than 3¼ pounds of salt to each hundred weight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After being stuffed, sausage having a diameter not exceeding 3½ inches, measured at the time of stuffing, shall be held in a drying room not less than 20 days at a temperature not lower than 45° F., except that in sausage of the variety known as pepperoni, if in casings not exceeding 1¾ inches in diameter measured at the time of stuffing, the period of drying may be reduced to 15 days. In no case, however, shall the sausage be released from the drying room in less than 25 days from the time the curing materials are added, except that sausage of the variety known as pepperoni, if in casings not exceeding the size specified, may be released at the expiration of 20 days from the time the curing materials are added. Sausage in casings exceeding 3½ inches, but not exceeding 4 inches, in diameter at the time of stuffing, shall be held in a drying room not less than 35 days at a temperature not lower than 45° F., and in no case shall the sausage be released from the drying room in less than 40 days from the time the curing materials are added to the meat.

b. Method No. 2. The meat shall be ground or chopped into pieces

not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than  $3\frac{1}{2}$  pounds of salt to each hundred weight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After being stuffed, the sausage having a diameter not exceeding  $3\frac{1}{2}$  inches, measured at the time of stuffing, shall be smoked but not less than 40 hours at a temperature not lower than  $80^{\circ}$  F., and finally held in a drying room not less than 10 days at a temperature not lower than  $45^{\circ}$  F. In no case, however, shall the sausage be released from the drying room in less than 18 days from the time the curing materials are added to the meat. Sausage exceeding  $3\frac{1}{2}$  inches, but not exceeding 4 inches, in diameter at the time of stuffing, shall be held in a drying room, following smoking as above indicated, not less than 25 days at a temperature not lower than  $45^{\circ}$  F., and in no case shall the sausage be released from the drying room in less than 33 days from the time the curing materials are added to the meat.

c. Method No. 3. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than  $3\frac{1}{2}$  pounds of salt to each hundred-weight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After admixture with the salt and other curing materials and before stuffing, the ground or chopped meat shall be held at a temperature not lower than  $34^{\circ}$  F. for not less than 36 hours. After being stuffed the sausage shall be held at a temperature not lower than  $34^{\circ}$  F. for an additional period of time sufficient to make a total of not less than 144 hours from the time the curing materials are added to the meat, or the sausage shall be held for the time specified in a pickle-curing medium of not less than 50° strength (salometer reading) at a temperature not lower than  $44^{\circ}$  F. Finally, the sausage having a diameter not exceeding  $3\frac{1}{2}$  inches, measured at the time of stuffing, shall be smoked for not less than 12 hours. The temperature of the smokehouse during this period at no time shall be lower than  $90^{\circ}$  F.; and for 4 consecutive hours of this period the smokehouse shall be maintained at a temperature not lower than  $128^{\circ}$  F. Sausage exceeding  $3\frac{1}{2}$  inches, but not exceeding 4 inches, in diameter at the time of stuffing shall be smoked, following the prescribed curing, for not less than 15 hours. The temperature of the smokehouse during the 15-hour period shall at no time be lower than  $90^{\circ}$  F., and for 7 consecutive hours of this period the smokehouse shall be maintained at a temperature not lower than  $128^{\circ}$  F. In regulating the temperature of the smokehouse for the treatment of sausage under this method, the temperature of  $128^{\circ}$  F. shall be attained gradually during a period not less than 4 hours.

d. Method No. 4. The meat shall be ground or chopped into pieces not exceeding one-fourth of an inch in diameter. A dry-curing mixture containing not less than  $2\frac{1}{2}$  pounds of salt to each hundred weight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After admixture with the salt and other curing materials and before stuffing, the ground or chopped sausage shall be held as a compact mass, not more than 6 inches in depth, at a temperature not lower than  $36^{\circ}$  F., for not less than 10 days. At the termination of the holding period, the sausage shall be stuffed in casings or cloth bags not exceeding  $3\frac{1}{2}$  inches in diameter, meas-

ured at the time of stuffing. After being stuffed, the sausage shall be held in a drying room at a temperature not lower than 45° F. for the remainder of a 35-day period, measured from the time the curing materials are added to the meat. At any time after stuffing, if a concern deems it desirable, the product may be heated in a water bath for a period not to exceed 3 hours at a temperature not lower than 85° F., or subjected to smoking at a temperature not lower than 80° F., or the product may be both heated and smoked as specified. The time consumed in heating and smoking, however, shall be in addition to the 35-day holding period specified.

e. Method No. 5. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than 3½ pounds of salt to each hundredweight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After being stuffed the sausage shall be held for not less than 65 days at a temperature not lower than 45° F. The coverings for sausage prepared according to this method may be coated at any stage of the preparation before or during the holding period with paraffin or other substance approved by the director of the division.

2. Capocollo (capicola, capacola). Boneless pork butts for capocollo shall be cured in a dry-curing mixture containing not less than 4½ pounds of salt per hundredweight of meat for a period of not less than 25 days at a temperature not lower than 36° F. If the curing materials are applied to the butts by the process known as churning, a small quantity of pickle may be added. During the curing period the butts may be overhauled according to any of the usual processes of overhauling, including the addition of pickle or dry salt, if desired. The butts shall not be subjected during or after curing to any treatment designed to remove salt from the meat, except that superficial washing may be allowed. After being stuffed, the product shall be smoked for a period of not less than 30 hours at a temperature not lower than 80° F., and shall finally be held in a drying room not less than 20 days at a temperature not lower than 45° F.

3. Coppa. Boneless pork butts for coppa shall be cured in a dry-curing mixture containing not less than 4½ pounds of salt per hundredweight of meat for a period of not less than 18 days at a temperature not lower than 36° F. If the curing mixture is applied to the butts by the process known as churning, a small quantity of pickle may be added. During the curing period the butts may be overhauled according to any of the usual processes of overhauling, including the addition of pickle or dry salt if desired. The butts shall not be subjected during or after curing to any treatment designed to remove salt from the meat, except that superficial washing may be allowed. After being stuffed, the product shall be held in a drying room not less than 35 days at a temperature not lower than 45° F.

4. Hams. In the curing of hams either of the following methods may be used:

a. Method No. 1. The hams shall be cured by a dry-salt curing process not less than 40 days at a temperature not lower than 36° F. The hams shall be laid down in salt, not less than 4 pounds to each hundredweight of hams, the salt being applied in a thorough manner

to the lean meat of each ham. When placed in cure, the hams may be pumped with pickle if desired. At least once during the curing process the hams shall be overhauled and additional salt applied, if necessary, so that the lean meat of each ham is thoroughly covered. After removal from cure the hams may be soaked in water at a temperature not higher than 70° F. for not more than 15 hours, during which time the water may be changed once; but they shall not be subjected to any other treatment designed to remove salt from the meat, except that superficial washing may be allowed. The hams shall finally be dried or smoked not less than 10 days at a temperature not lower than 95° F.

b. Method No. 2. The hams shall be cured by a dry-salt curing process at a temperature not lower than 36° F., for a period of not less than 3 days for each pound of weight (green) of the individual hams. The time of cure of each lot of hams placed in cure should be calculated on a basis of the weight of the heaviest ham of the lot. Hams cured by this method, before they are placed in cure, shall be pumped with pickle solution of not less than 100° strength (salometer), about 4 ounces of the solution being injected into the shank and a like quantity along the flank side of the body bone (femur). The hams shall be laid down in salt, not less than 4 pounds of salt to each hundredweight of hams, the salt being applied in a thorough manner to the lean meat of each ham. At least once during the curing process the hams shall be overhauled and additional salt applied, if necessary, so that the lean meat of each ham is thoroughly covered. After removal from the cure the hams may be soaked in water at a temperature not higher than 70° F. for not more than 4 hours, but shall not be subjected to any other treatment designed to remove salt from the meat, except that superficial washing may be allowed. The hams shall then be dried or smoked not less than 48 hours at a temperature not lower than 80° F., and finally, shall be held in a drying room not less than 20 days at a temperature not lower than 45° F.

5. Boneless pork loins and loin ends. In lieu of heating or refrigerating to destroy trichinae in boneless loins, the loins shall be cured for a period of not less than 25 days at a temperature not lower than 36° F. by the use of one of the following methods:

a. Method No. 1. A dry-salt curing mixture containing not less than 5 pounds of salt to each hundredweight of meat.

b. Method No. 2. A pickle solution of not less than 80° strength (salometer) on the basis of not less than 60 pounds of pickle to each hundredweight of meat.

c. Method No. 3. A pickle solution added to the approved dry-salt cure provided the pickle solution is not less than 80° strength (salometer).

6. After removal from cure, the loins may be soaked in water for not more than 1 hour at a temperature not higher than 70° F. or washed under a spray but shall not be subjected, during or after the curing process, to any other treatment designed to remove salt.

7. Following curing, the loins shall be smoked for not less than 12 hours. The minimum temperature of the smokehouse during this period at no time shall be lower than 100° F., and for 4 consecutive

hours of this period the smokehouse shall be maintained at a temperature not lower than 125° F.

8. Finally, the product shall be held in a drying room for a period of not less than 12 days at a temperature not lower than 45° F.

(3) GENERAL INSTRUCTIONS. When necessary to comply with these instructions, the smokehouses, drying rooms, and other compartments used in the treatment of pork to destroy trichinae shall be suitably equipped, by the establishment, with accurate automatic recording thermometers. Inspectors in charge are authorized to approve for use in sausage smokehouses, drying rooms, and other compartments, such automatic recording thermometers as are found to give satisfactory service.

(4) This section shall also apply to slaughterhouses licensed under section 97.07, Wis. Stats.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.

**Ag 47.07 Canning with heat processing and hermetically sealed containers; cleaning containers; closure; code marking; heat processing; incubation.** (1) Containers shall be cleaned thoroughly immediately before filling, and precaution must be taken to avoid soiling the inner surfaces subsequently.

(2) Containers of metal, glass, or other material shall be washed in an inverted position with running water at a temperature of at least 180° F. The container-washing equipment shall be provided with a thermometer to register the temperature of the water used for cleaning the containers. In lieu of cleaning with hot water the use of efficient jet-vacuum type equipment for cleaning cans and jars is permitted before filling.

(3) Nothing less than perfect closure is acceptable for hermetically sealed containers. Heat processing shall follow promptly after closing.

(4) Careful inspection shall be made of the containers by competent establishment employees immediately after closing, and containers which are defectively filled, defectively closed or those showing inadequate vacuum, shall not be processed until the defect has been corrected. The containers shall again be inspected by establishment employees when they have cooled sufficiently for handling after processing by heating. The contents of defective containers shall be condemned unless correction of the defect is accomplished within 6 hours following the sealing of the containers or completion of the heat processing, as the case may be, except that if the defective condition is discovered during an afternoon run the cans of product may be held in coolers at a temperature not exceeding 38° F. under conditions that will promptly and effectively chill them until the following day when the defect may be corrected; short vacuum or overstuffed cans of product which have not been handled in accordance with the above may be incubated under division supervision, after which the cans shall be opened and the sound product passed for food; and short vacuum or overstuffed cans of product of a class permitted to be labeled, "Perishable, keep under refrigeration," and which have been kept under adequate refrigeration since processing may be opened and the sound product passed for food.

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(5) Canned products shall not be passed unless after cooling to atmospheric temperature, they show the external characteristics of sound cans; that is, the cans shall not be overfilled; they shall have concave sides, excepting the seam side, and all ends shall be concave; there shall be no bulging; the sides and ends shall conform to the product; and there shall be no slack or loose tin.

(6) All canned products shall be plainly and permanently marked on the containers by code or otherwise with the identity of the contents and date of canning. The code used and its meaning shall be on record in the office of the inspector in charge.

(7) Canned product must be processed at such temperature and for such period of time as will assure keeping without refrigeration under usual conditions of storage and transportation when heating is relied on for preservation, with the exception of those canned products which are processed without steam-pressure cooking by permission of the meat inspection division of the department, and labeled "Perishable, keep under refrigeration."

(8) Lots of canned product shall be identified during their handling preparatory to heat processing by tagging the baskets, cages or cans with a tag which will change color on going through the heat processing or by other effective means so as to positively preclude failure to heat process after closing.

(9) Facilities shall be provided to incubate at least representative samples of the product of fully processed canned product. The incubation shall consist of holding the canned product for at least 10 days at about 98° F.

(a) The extent to which incubation tests shall be required depends on conditions such as the record of the establishment in conducting canning operations, the extent to which the establishment furnishes competent supervision and inspection in connection with the canning operations, the character of the equipment used, and the degree to which such equipment is maintained at maximum efficiency. Such factors shall be considered by the inspector in charge in determining the extent of incubation testing at a particular establishment.

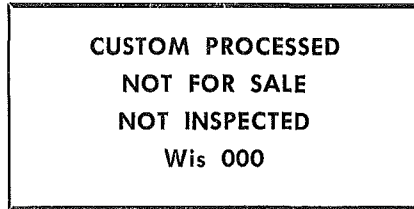
(b) In the event of failure by an establishment to provide suitable facilities for incubation of test samples, the inspector in charge may require holding of the entire lot under such conditions and for such period of time as may, in his discretion, be necessary to establish the stability of the product.

(c) The inspector in charge may permit lots of canned product to be shipped from the establishment prior to completion of sample incubation when he has no reason to suspect unsoundness in the particular lots, and under circumstances which will assure the return of the product to the establishment for reinspection should such action be indicated by the incubation results.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.

**Ag 47.08 Custom slaughter, farm slaughter, horse slaughter, game, meat animals not defined.** (1) **CUSTOM SLAUGHTER.** (a) Establishments doing custom slaughter or custom processing shall do so on designated hours or days from the regular inspection schedule. All primal parts of carcasses of animals and poultry as defined in section 97.20, Wis. Stats., custom slaughtered, shall be plainly marked by the estab-

lishment with the establishment number and the words, "Custom Processed, Not for Sale, Not Inspected."



All boxes, cartons, or containers containing meat or meat products custom processed, leaving the establishment, shall be similarly marked. Stamps, brands and marks for this purpose shall be approved by the department. Original brands shall be furnished by the department. All additional brands shall be furnished by the establishment.

(b) Any carcasses or parts shipped from the establishment for animal food shall be plainly marked "inedible" and shall have been decharacterized or denatured in a manner prescribed by the department.

(c) Any meat or parts, such as head meat, tongues, hearts, fat, trimmings, saved from non-inspected, custom slaughtered or processed animals, shall not be offered for sale for human consumption, or combined with inspected products that are offered for sale.

(2) RECORDS. Establishments doing custom slaughter or custom processing shall keep records and submit reports as required by the department.

(3) FARM SLAUGHTER AND GAME ANIMALS. Animals slaughtered on the farm, and game animals or other animals used for meat, may be processed at establishments under the same provisions as Custom Slaughter, provided they are clean, apparently wholesome, and are handled, stored, and prepared so as to prevent the contamination of other food products handled, stored, or prepared at the establishment.

(4) REQUEST FOR INSPECTION. When inspection is requested for custom slaughter, a request in writing by the owner shall be submitted to the establishment. When inspection is furnished for custom slaughter, it shall be done at regularly scheduled times. Any other inspection shall be done at the overtime rate and shall be charged to the establishment. Custom animals inspected shall be subject to all other regulations in this chapter.

(5) HORSE SLAUGHTER AND MEAT FOOD PRODUCTS THEREOF. The slaughter of horses and the preparation and handling of the meat and meat food product thereof shall be conducted separate and apart from the slaughter and preparation of other meat or meat food products. All horse carcasses, parts, meat and meat food products thereof shall be conspicuously labeled, marked, branded, or tagged "Horse Meat" or "Horse Meat Product" by a method approved by the department.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.

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**Ag 47.09 Inspection marks and establishment numbers.** (1) **ESTABLISHMENT NUMBER.** An official number shall be assigned to each establishment where state meat inspection is conducted. Such numbers shall be used to identify all meat and meat products inspected and passed. Two or more establishments under the same ownership may be granted the same official numbers, provided a serial letter is added in each case to identify each establishment and the products thereof.

(2) **INSPECTION MARKS.** (a) All meat animal carcasses that have been inspected and found to be sound, healthful, wholesome, and fit for human food shall be marked, "Wis. Inspected and Passed."



Each primal part of a carcass, beef cod fat, beef kidney fat, each liver, beef tongue and beef heart shall be so marked.

(b) Meat animal carcasses or parts that have been inspected and found to be fit for human food or use only after cooking shall be tagged and/or marked, "Passed for Cooking."

(c) Meat animal carcasses or parts that have been inspected and found to be suitable for human food or other use only after proper refrigeration shall be tagged or marked, "Retained for Refrigeration."

(d) Meat animal carcasses, parts or meat products that have been inspected and found to be unfit for human food shall be marked or tagged, "Wis. Insp'd and CONDEMNED."

**WIS. INSP'D AND  
CONDEMNED**

(e) Meat animal carcasses, parts, viscera or meat products held for further examination by an inspector to determine its disposal shall be tagged, "Wis. Retained."

(f) Only harmless ink approved by the department shall be used in marking carcasses or parts thereof.

(3) **PROCESSED PRODUCTS.** All processed products shall plainly bear a legible inspection mark and the establishment number on the label.



Labels within the meaning of this subsection shall include any printing, lithographing, embossing, or other marking on labels, stickers, seals, wrappers, or receptacles.

(4) CONTROL AND USE OF BRANDS AND MARKING DEVICES FURNISHED BY DEPARTMENT. All brands and devices, except custom processed brands, furnished by the department for marking articles with the inspection legend shall be used only under the supervision of a department employee, and when not in use for marking, shall be kept locked in properly equipped lockers or compartments, the keys of which shall not leave the possession of a department employee.

(5) INSPECTION MARKS; FORGING, COUNTERFEITING, IMPROPER USE AND HANDLING. No person shall forge, counterfeit, simulate, or falsely represent, or without proper authority, use, detach, or knowingly or wrongfully alter, deface, or destroy any of the marks, stamps, tags, labels, or other identification devices provided for herein.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.

**Ag 47.10 Time of inspection.** (1) DAYS AND HOURS. Each establishment shall notify the department in writing of the days and hours of the week that slaughter is conducted. After due consideration the department shall assign such slaughter hours as will be in the best interests of the state and the establishment. There shall be no deviation from the schedule without prior approval from the department.

(2) OVERTIME INSPECTION. (a) Each establishment requiring inspection on hours that are considered overtime shall reimburse the department at the rate of \$4.10 per hour.

(b) "Overtime" for the purposes of this rule means any time when meat inspection personnel are requested to work in an establishment, as follows:

1. Each Saturday or Sunday.
2. New Year's Day, Memorial Day, Independence Day, Labor Day, Thanksgiving Day, Christmas Day. If any such holiday falls on Sunday, the succeeding Monday shall be a holiday.
3. The afternoons before Christmas and New Year's Day.
4. Good Friday— $\frac{1}{2}$  day.
5. Before 6 a.m. or after 6 p.m.

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6. In excess of 40 hours of "straight time" in any calendar week.

7. At any time other than a regularly scheduled slaughter period.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.

**Ag 47.11 County and municipal inspection.** Counties and municipalities desiring to enter into a cooperative agreement pursuant to section 97.20 (5) Wis. Stats., for approved county or municipal inspection shall make application to the department in writing. The department shall investigate and evaluate the county or municipal meat inspection and enforcement program. If in the opinion of the department the county or municipal inspection and enforcement programs are in substantial accord with inspection carried on by the department, a cooperative agreement may be approved.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.

**Ag 47.12 Appeals.** The operator of any establishment may request that a final inspection by a veterinarian employed by the department be conducted on any carcass, part, or product thereof condemned by an inspector. Appeals from any decision of any department employee shall be made to the meat inspection division of the department.

**History:** Cr. Register, December, 1967, No. 144, eff. 1-1-68.